Catalogue
.BENDING

BENDING: compatibility

R1 TOOLS TYPE
Compatible with press brakes: Accurl, Accurpress, ACL, Adira, Albermachinery, Alpmac, 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, Lag, LFK, Metfab, MVD, Oriance, Pinette, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yawei,...

R2-R3 TOOLS TYPE
Compatible with press brakes: Darley, LVD, Safan, Trumpf and press brakes with NSCL system, Bystronic Beyeler RFA, RF, R, S

R4 TOOLS TYPE
Compatible with press brakes: LVD

R5 TOOLS TYPE
Compatible with press brakes: American

R6 TOOLS TYPE
Compatible with press brakes: Hämmerle-Bystronic

R7 TOOLS TYPE
Compatible with press brakes:Colly

R8 TOOLS TYPE
Compatible with press brakes: Colgar

R9 TOOLS TYPE
Compatible with press brakes: Gasparini (axial)

R10 TOOLS TYPE
Compatible with press brakes: Ajial Axial

RX TOOLS TYPE
Compatible with press brakes: EHT, Ursviken and Weinbrenner

CLAMPING SYSTEMS, INTERMEDIATES AND ADAPTERS
Compatible with all types of press brakes

ROLLA-V AND SPECIAL DIES
Compatible with all types of press brakes

MARK FREE BENDING AND ACCESSORIES
Compatible with all types of press brakes

ROLLERI TECH, MODIFICATIONS AND SERVICES

OTHER ROLLERI PRODUCTS

.punching tools

.laser consumables

.panel bending tools

.shear blades

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.R1 punches 4
.punches: content explanation >> 5
.punches TOP series >> 7
.hemming tools TOP Series >> 9
.radius tools TOP Series >> 11
.punches CLASSIC Series >> 12
.movable horns >> 24
.joggle tools >> 25
.radius tools >> 26
.punches A series >> 28
.punches CFH series >> 32

.R1 dies 34
.dies: content explanation >> 35
.2-V self centering dies CLASSIC Series >> 37
.supports >> 40
.T dies CLASSIC Series >> 41
.1-V dies CLASSIC Series >> 48
.multi-V dies CLASSIC Series >> 51
.hemming dies CLASSIC Series >> 53
.spring-loaded hemming dies CLASSIC Series >> 55
.pneumatic hemming dies CLASSIC Series >> 57
.pneumatic hemming table with 59
interchangeable V CLASSIC Series >> 59
.2-V dies A series >> 61
.1-V dies A series >> 67
.dies CFH series >> 72

.R2 punches 76
.punches: content explanation >> 77
.punches TOP Series >> 80
.punches CLASSIC Series >> 81
.hemming tools TOP Series >> 87
.joggle tools >> 89
.radius tools >> 90

.R3 punches 92
.punches: content explanation >> 93
.punches RFA series >> 95
.hemming tools RFA series >> 97
.joggle tools >> 98
.radius tools >> 100

.R2-R3 dies 102
.dies: content explanation >> 103
.dies >> 105
.hemming dies >> 124
.hemming dies for movable table >> 126

.R4 punches 128
.punches: content explanation >> 129
.punches NEW W series >> 131
.hemming punches >> 133
.radius tools >> 134

.R4 dies 136
.dies: content explanation >> 137
.dies >> 138
.hemming dies >> 145

.Rolla-V 146
.rolla-v: content explanation >> 147
.RVS series >> 149
.RVP series >> 149
.RVT55-60 series >> 150
.RVT100 series >> 150
.RVM series >> 151
.RVT90 series >> 151
.adjustable dies series >> 153
.XT series >> 156
.accessories >> 157

.adjustable dies and dies with rollers 158
.rolleri VARIO >> 159
.adjustable dies >> 160
.dies with rollers >> 163

.mark free bending 164
.rollprime >> 165
.rolfilm >> 166
.polyurethane inserts and holders >> 167
.synthetinc dies >> 169

.accessories 172
.tooling cabinets: explanation >> 173
.tooling cabinets: STANDARD series >> 174
.tooling cabinets: TOP series >> 177
.tooling trolley >> 179
.sheet metal positioning >> 180
.press brake Easy Press >> 182
.bending box >> 183

.intermediates, clamps and adapters 184
.intermediates >> 185
.clamps >> 189
.upper adapters >> 191
.screwed upper adapters >> 198
.lower adapters and die holders >>202

.fast clamping systems 208
.ROL GRIP >> 209
.ROL TOUCH >>214
.ROL 200 >> 215
.ROL 4 >> 217
.FAST CLAMP1 >> 218
.FAST CLAMP3 >> 219
.EASY CLAMP >> 220
.ROL2 >> 221
.ST50S >> 222
.W ROL >> 223
.AXIAL MANUAL >> 226
.W ROL2 >> 227
.A ROL >> 228
.UNIVERSAL FAST CLAMP >> 230
.ROL3 >> 231
.ROL3/2 >> 233
.crowning tables >> 234
.hemming tables with crowning >> 238
.crowning table with manual crowning 240
with independent wedges >> 240
.power units >> 241

.index

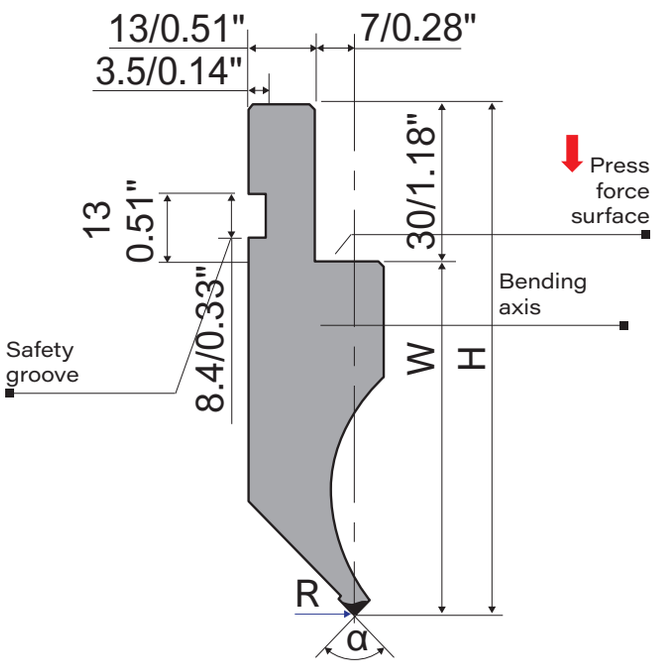
.R1 punches

Compatible with press brakes: Accurl, Accurpress, ACL, Adira, Albermachinery, Alpmac, 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, Lag, LFK, Metfab, MVD, Oriance, Pinette, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yawei,...

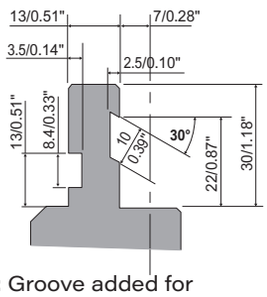
.punches: content explanation >>

.standard tang

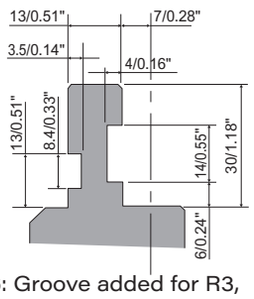
Punches are standardized with a 8.4 x 3.5 mm 0.33 x 1.37" safety groove, which keeps the tool from falling out. Depending on the clamping system, horizontal or vertical tool change is possible.



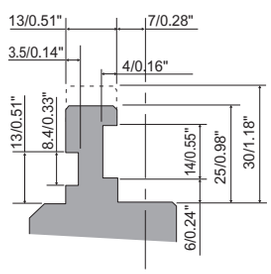
.safety grooves modification



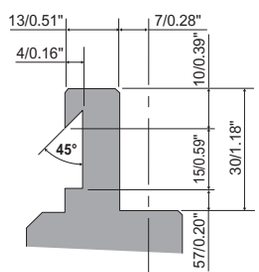
A1: Groove added for pneumatic system further to 8.4 x 3.5 mm - *0.33 x 1.37"* groove



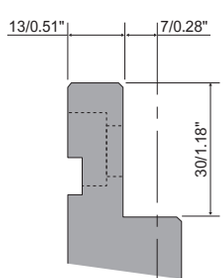
A6: Groove added for R3, Bystronic-Beyeler Euro and Safan tang further to 8.4 x 3.5 mm - *0.33 x 1.37"* groove



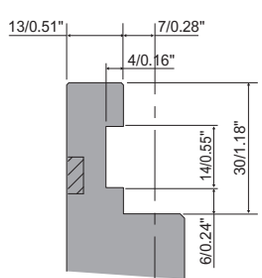
A7: Groove added and tang modified for R3 Bystronic-Beyeler Euro and Safan tang further to 8.4 x 3.5 mm - *0.33 x 1.37"* groove



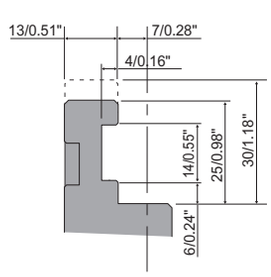
A8: Groove for Gasparini hydraulic clamping system



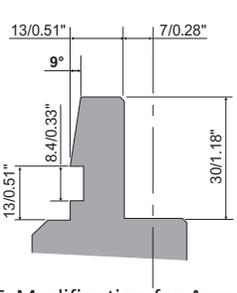
A9: AW supports tang



A41: Groove modified for R3, Bystronic-Beyeler Euro and Safan tang



A42: Groove modified and tang modified for R3, Bystronic-Beyeler Euro and Safan tang



OT: Modification for Amada fast clamping system

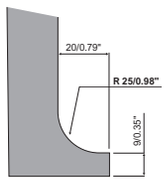
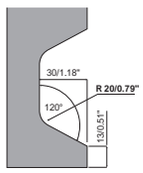
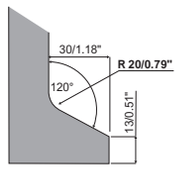
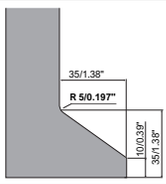
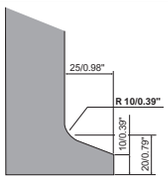
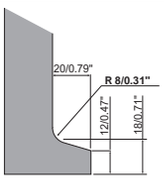
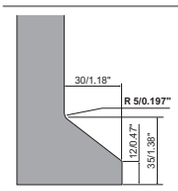
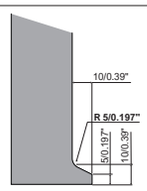
.standard lengths

	TOP Series	CLASSIC Series	A Series	CFH Series
500 mm | *19.68"*	○			
522 mm | *20.55"*	○			
525 mm | *20.67"*	●			
415 mm | *16.34"*		●	●	●
835 mm | *32.87"*		●	●	●
900 mm | *35.43"*		○		

○ available for some tool models only

.horn types

Check the standard horn in each code. All the other horns are available on request based on the Series of the tool - check the feasibility with sales@rolleri.it

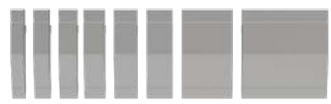
	TOP	CLASSIC	A	CFH
 1		●	●	●
 2	●			
 2/a	●			
 3		●	●	●
 4		●	●	●
 5		●	●	
 6		●	●	
 7		●	●	

.segmentation

Customised sectioning is also available on request. sales@rolleri.it to know more about price and availability.

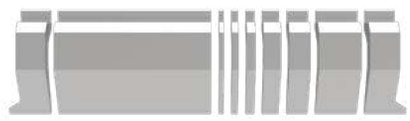
◁ = left horn ▷ = right horn

FA: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84



FB: 500 mm - *19.68"*
mm: ◁ 100-300-100 ▷
in: ◁ 3.94-11.81-3.94 ▷

F: 805 mm - *31.69"*
mm: ◁ 100-370-10-15-20-40-50-100-100 ▷
in: ◁ 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94 ▷

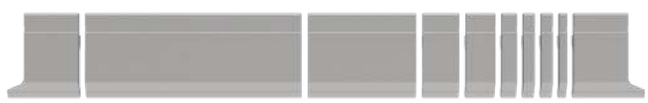


FC: 800 mm - *31.50"*
mm: ◁ 100-10-15-20-40-50-165-300-100 ▷
in: ◁ 3.94-0.39-0.59-0.78-1.57-1.97-6.49-11.81-3.94 ▷

FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

FCA: 835 mm - *32.87"*
mm: 100-10-15-20-40-50-200-300-100
in: 3.94-0.39-0.59-0.78-1.57-7.87-11.81-3.94

F: 800 mm - *31.49"*
mm: ◁ 100-300-150-50-40-20-15-15-10-100 ▷
in: ◁ 3.94-11.81-5.90-1.96-1.57-0.79-0.59-0-59-0.39-3.94 ▷



TOP.175.85.R08

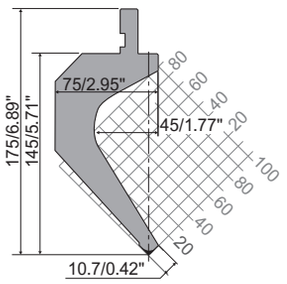
42Cr: 900-1150 N/mm² **900 kN/m max.**

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

W=145 | H=175 | R=0.8 mm
W=5.71 | H=6.89 | R=0.031 in

85°>

.HORN 2



TOP.175.85.R2

42Cr: 900-1150 N/mm² **900 kN/m max.**

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

W=144.30 | H=174.30 | R=2 mm
W=5.71 | H=6.89 | R=0.031 in

85°

.HORN 2

TOP.175.85.R08.S

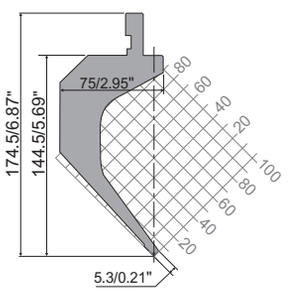
42Cr: 900-1150 N/mm² **200 kN/m max.**

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

W=144.5 | H=174.5 | R=0.8 mm
W=5.69 | H=6.87 | R=0.031 in

85°

.HORN 2



TOP.205.85.R08

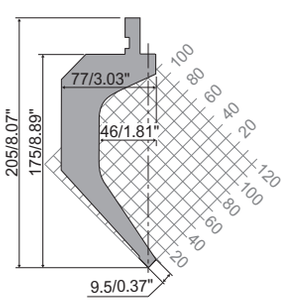
42Cr: 900-1150 N/mm² **700 kN/m max.**

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

W=175 | H=205 | R=0.8 mm
W=6.89 | H=8.07 | R=0.031 in

85°

.HORN 2



TOP.205.85.R2

42Cr: 900-1150 N/mm² **700 kN/m max.**

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

W=174.30 | H=204.30 | R=2 mm
W=6.86 | H=8.04 | R=0.079 in

85°

.HORN 2

TOP.175.75.R08

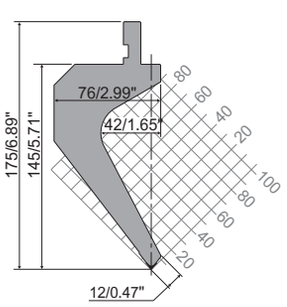
42Cr: 900-1150 N/mm² **700 kN/m max.**

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

W=145 | H=175 | R=0.8 mm
W=5.71 | H=6.89 | R=0.031 in

75°>

.HORN 2



TOP.175.75.R2

42Cr: 900-1150 N/mm² **700 kN/m max.**

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

W=144.20 | H=174.30 | R=2 mm
W=5.68 | H=6.86 | R=0.079 in

75°

.HORN 2

FA: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84

FB: 500 mm - *19.68"*
mm: ⊲ 100-300-100 ⊳
in: ⊲ 3.94-11.81-3.94 ⊳

TOP.175.60.R08

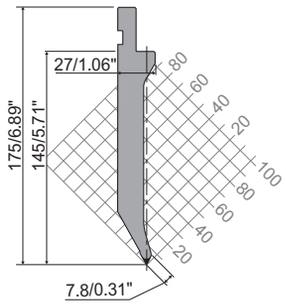
42Cr: 900-1150 N/mm² **800 kN/m max.**

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

W=145 | H=175 | R=0.8 mm
W=5.71 | H=6.89 | R=0.031 in

60°>

.HORN 2



TOP.175.60.R2

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

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

W=143.80 | H=173.80 | R=2 mm
W=5.66 | H=6.84 | R=0.079 in

60°

.HORN 2

TOP.175.60.R5

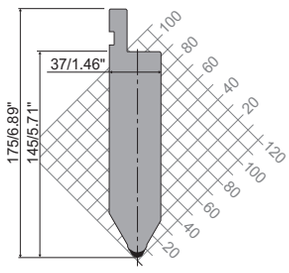
42Cr: 900-1150 N/mm² **1600 kN/m max.**

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

W=145 | H=175 | R=5 mm
W=5.71 | H=6.89 | R=0.20 in

60°

.HORN 2



TOP.175.26.R08

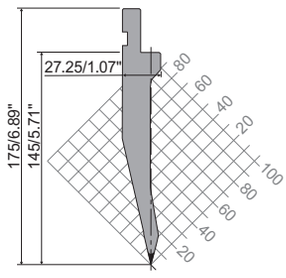
42Cr: 900-1150 N/mm² **950 kN/m max.**

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

W=145 | H=175 | R=0.8 mm
W=5.71 | H=6.89 | R=0.031 in

26°>

.HORN 2



TOP.205.26.R08

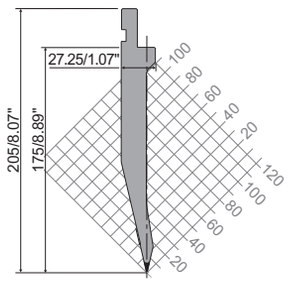
42Cr: 900-1150 N/mm² **950 kN/m max.**

525 mm	*20.67"*	15.6 kg	
495 mm	*19.49"*	16.7 kg	FA
500 mm	*19.68"*	16.8 kg	FB

W=175 | H=205 | R=0.8 mm
W=6.89 | H=8.07 | R=0.031 in

26°

.HORN 2



FA: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84

FB: 500 mm - *19.68"*
mm: ◁ 100-300-100 ▷
in: ◁ 3.94-11.81-3.94 ▷

TOP.250.26.R1

42Cr: 900-1150 N/mm²

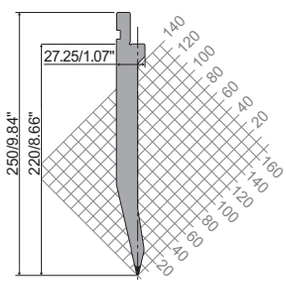
1000 kN/m max.

525 mm	*20.67"*	17.7 kg	
495 mm	*19.49"*	17.7 kg	FA
500 mm	*19.68"*	17.7 kg	FB

W=220 | H=250 | R=1 mm
W=8.66 | H=9.84 | R=0.039 in

26°

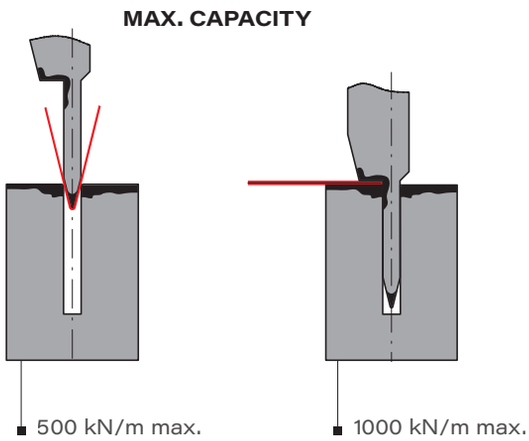
.HORN 2



.hemming tools TOP Series >>

Hemming tools are used to prebend and afterwards flatten a sheet metal edge by using the same tool set.
Thanks to this operation you can strengthen sheet metal edges and avoid burr on their external side. For this reason, this operation is especially used for safety reason, in order to avoid operators'
accidental injuries which may occur to those who have to handle sheet metal parts.
The maximum sheet metal thickness usually recommended for this operation is 3mm mild steel and 2mm stainless steel. However, for thicker sheet metal special solutions can be proposed, which consider the necessary bending force involved to flatten.
There are 2 types of flattening: partial flattening and total flattening.
Partial flattening is a kind of flattening which doesn't win against the sheet metal springback. For this reason, if you measure the flattened point, it won't be twice the sheet metal thickness but a bigger measure; for example, if you flatten 1.5mm partially, the flattened point will be about 4mm. This dimension depends on the bending force only. Hence, if you want to flatten 1.5mm mild steel and get 3mm high flattened point, you have to increase the tonnage. In the table below you can check the necessary tonnage according to sheet metal thickness and type.
The choice of hemming tools should be influenced by the sheet metal type to be flattened; 35° punch and dies are recommended to flatten aluminium and mild steel, which have small springback, whereas more resitant sheet metal types like stainless steel require at least 30°, or better 26°, punch and die.
Springback control is fundamental to win against sheet metal resistance during the flattening phase. In fact, if the angle obtained during the pre-bending phase is too wide, sheet metal will slip towards the operator during the flattening phase.
The choice of TOP series hemming tools with dies with U shape opening has to take into consideration the fact that the U opening of the die has to match perfectly with the punch tip width. These toolsare 525mm long and the sectioned set is also available.

MAX. CAPACITY



S mm	S *in*	A mm	A *in*	R.420 N/ mm² kN/m	R.700 N/ mm² kN/m
0.60	*0.02*	3.0	*0.12*	90	150
0.80	*0.03*	3.0	*0.12*	120	200
1.00	*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
0.60	*0.02*	1.2	*0.05*	230	350
0.80	*0.03*	1.6	*0.06*	320	500
1.00	*0.04*	1.0	*0.04*	400	600
1.25	*0.05*	2.5	*0.10*	500	800

FA: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84

FB: 500 mm - *19.68"*
mm: ◁ 100-300-100 ▷
in: ◁ 3.94-11.81-3.94 ▷

TOP150.30.R12

C45: 560-710 N/mm²

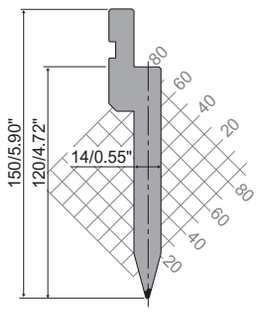
1000 kN/m max.

500 mm	*19.68"*	8.75 kg	
550 mm	*21.65"*	9.62 kg	FW

W=120 | H=150 | R=1.2 mm
W=4.72 | H=5.90 | R=0.047 in

30°>

TO USE WITH:
SM55.14.30/C
SM55.12.30/C



TOP.SP.134.28.8

42Cr: 900-1150 N/mm²

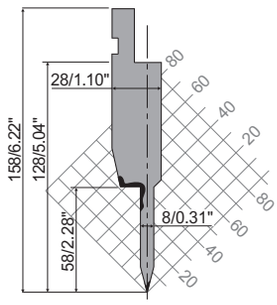
800 kN/m max.

525 mm	*20.67"*	12.0 kg	
495 mm	*19.49"*	11.3 kg	FA

W=128 | H=158 | R=0.6 mm
W=5.04 | H=6.22 | R=0.024 in

28°>

TO USE WITH:
TOP.SM-134.28.8



TOP.SP.134.24.8

42Cr: 900-1150 N/mm²

800-1000 kN/m max.

525 mm	*20.67"*	11.0 kg	
495 mm	*19.49"*	10.3 kg	FA

W=128 | H=158 | R=0.6 mm
W=5.04 | H=6.22 | R=0.024 in

24°>

TO USE WITH:
TOP.SM-134.24.8

TOP.SP.134.24.10

42Cr: 900-1150 N/mm²

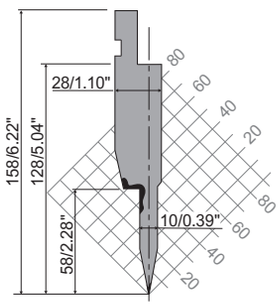
800-1000 kN/m max.

525 mm	*20.67"*	11.0 kg	
495 mm	*19.49"*	10.3 kg	FA

W=128 | H=158 | R=0.6 mm
W=5.04 | H=6.22 | R=0.024 in

24°

TO USE WITH:
TOP.SM-134.24.10



TOP.SP.134.24.12

42Cr: 900-1150 N/mm²

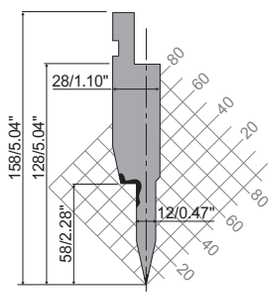
800-1000 kN/m max.

525 mm	*20.67"*	11.6 kg	
495 mm	*19.49"*	11.0 kg	FA

W=128 | H=158 | R=0.6 mm
W=5.04 | H=6.22 | R=0.024 in

24°

TO USE WITH:
TOP.SM-134.24.12



FA: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84

FW: 550 mm - *21.65"*
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

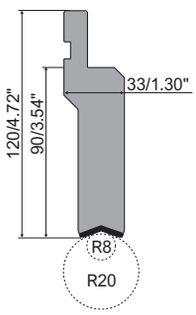
TOP.PC.120-08

42Cr: 900-1150 N/mm²

1000 kN/m max.

522 mm	*20.55"*	11.0 kg	
495 mm	*19.49"*	10.5 kg	FA

W=90 | H=120 mm
W=3.54 | H=4.72 in



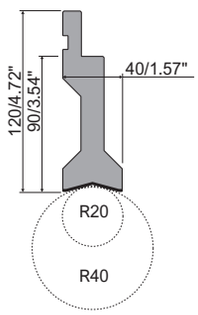
TOP.PC.120-20

42Cr: 900-1150 N/mm²

1000 kN/m max.

522 mm	*20.55"*	10.5 kg	
495 mm	*19.49"*	10.0 kg	FA

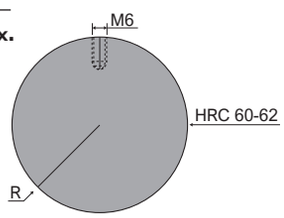
W=90 | H=120 mm
W=3.54 | H=4.72 in



RADIUS TOOLS: R08-R40

C53: 610 -760 N/mm²

1000 kN/m max.



	R mm	*R in*	525 mm *20.67 in*	FA
TOP.C08	8.0	*0.31*	0.8 kg	0.8 kg
TOP.C09	9.0	*0.35*	1.0 kg	1.0 kg
TOP.C10	10.0	*0.39*	1.3 kg	1.2 kg
TOP.C11	11.0	*0.43*	1.6 kg	1.5 kg
TOP.C12.5	12.5	*0.49*	2.0 kg	1.9 kg
TOP.C14	14.0	*0.55*	2.5 kg	2.4 kg
TOP.C15	15.0	*0.59*	2.9 kg	2.7 kg
TOP.C16	16.0	*0.63*	3.3 kg	3.1 kg
TOP.C17.5	17.5	*0.69*	4.0 kg	3.7 kg
TOP.C19	19.0	*0.75*	4.7 kg	4.4 kg
TOP.C20	20.0	*0.79*	5.2 kg	4.9 kg
TOP.C21	21.0	*0.83*	5.7 kg	5.4 kg
TOP.C22.5	22.5	*0.88*	6.6 kg	6.2 kg
TOP.C24	24.0	*0.94*	7.5 kg	7.0 kg
TOP.C25	25.0	*0.98*	8.1 kg	7.6 kg
TOP.C27.5	27.5	*1.08*	9.8 kg	9.2 kg
TOP.C30	30.0	*1.18*	11.6 kg	11.0 kg
TOP.C32.5	32.5	*1.28*	13.7 kg	12.9 kg
TOP.C35	35.0	*1.14*	15.9 kg	14.9 kg
TOP.C37.5	37.5	*1.47*	18.2 kg	17.2 kg
TOP.C40	40.0	*1.57*	20.7 kg	19.5 kg

BENDING HANDBOOK
The Bending handbook target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.
Visit rolleriools.com to find out more about the handbook

FA: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84

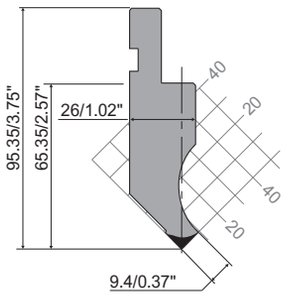
P.95.88.R3

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.5 kg	
795 mm	*31.29"*	10.5 kg	FX
805 mm	*31.69"*	10.6 kg	F

W=65.35 | H=95.35 | R=3 mm
W=2.57 | H=3.75 | R=0.12 in

88°>



.HORN 1

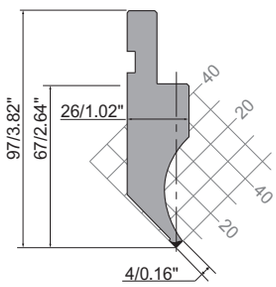
P.97.88.R06

C45: 560-710 N/mm² **350 kN/m max.**

835 mm	*32.87"*	9.5 kg	
415 mm	*16.34"*	5.0 kg	
795 mm	*31.29"*	9.2 kg	FX
805 mm	*31.69"*	9.5 kg	F
900 mm	*35.43"*	11.0 kg	

W=67.00 | H=97.00 | R=0.6 mm
W=2.64 | H=3.82 | R=0.024 in

88°



.HORN 1

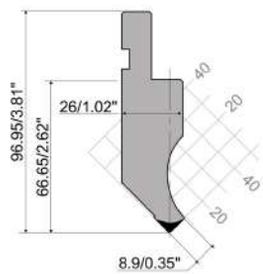
P.97.88.R08

42Cr: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	11.1 kg	
415 mm	*16.34"*	5.5 kg	
795 mm	*31.29"*	10.6 kg	FX
805 mm	*31.69"*	10.7 kg	F

W 66.6 | H=96.9 | R=0.8 mm
W=2.62 | H=3.81 | R=0.031 in

88°



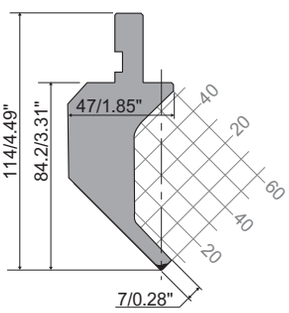
P.114.88.R06

42Cr: 900-1150 N/mm² **200 kN/m max.**

835 mm	*32.87"*	15.6 kg	
415 mm	*16.34"*	7.7 kg	
795 mm	*31.29"*	14.8 kg	FX
805 mm	*31.69"*	15.0 kg	F

W=84.20 | H=114 | R=0.6 mm
W=3.31 | H=4.49 | R=0.024 in

88°



.HORN 1

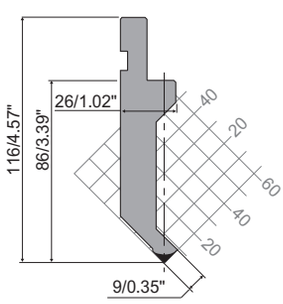
P.116.88.R08

C45: 560-710 N/mm² **400 kN/m max.**

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

W=86 | H=116 | R=0.8 mm
W=3.39 | H=4.57 | R=0.031 in

88°



.HORN 1

FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

PS.120.88.R08

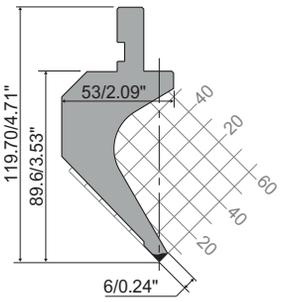
C45: 560-710 N/mm² **450 kN/m max.**

835 mm	*32.87"*	16.4 kg	
415 mm	*16.34"*	8.2 kg	
795 mm	*31.29"*	15.6 kg	FX
805 mm	*31.69"*	15.8 kg	F

W=89.70 | H=119.70 | R=0.8 mm
W=3.53 | H=4.71 | R=0.031 in

88°

.HORN 1



P.125.88.R025

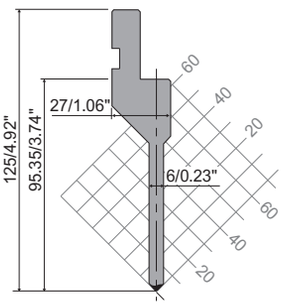
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	9.1 kg	
415 mm	*16.34"*	4.5 kg	
795 mm	*31.29"*	8.7 kg	FX
805 mm	*31.69"*	8.8 kg	F

W=95.35 | H=125 | R=0.25 mm
W=3.74 | H=4.92 | R=0.010 in

88°

.HORN 1



P.120.88.R08

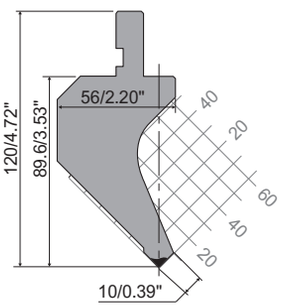
C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	21.4 kg	
415 mm	*16.34"*	10.7 kg	
795 mm	*31.29"*	20.5 kg	FX
805 mm	*31.69"*	20.7 kg	F

W=89.65 | H=120.00 | R=0.8 mm
W=3.53 | H=4.72 | R=0.031 in

88°

.HORN 1



P.130.88.R06

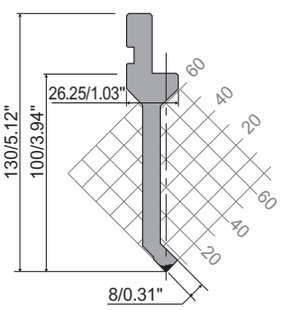
42Cr: 900-1150 N/mm² **350 kN/m max.**

835 mm	*32.87"*	9.8 kg	
415 mm	*16.34"*	4.9 kg	
795 mm	*31.29"*	9.3 kg	FX
805 mm	*31.69"*	9.4 kg	F
900 mm	*35.43"*	10.6 kg	

W=100 | H=130 | R=0.6 mm
W= 3.94 | H=5.12 | R=0.024 in

88°

.HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

P.130.88.R08

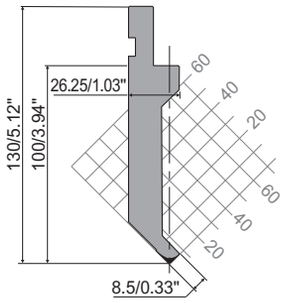
C45: 560-710 N/mm² **400 kN/m max.**

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

W=100.0 | H=130.0 | R=0.8 mm
W=3.94 | H=5.12 | R=0.031 in

88°

.HORN 1



P.135.88.R08

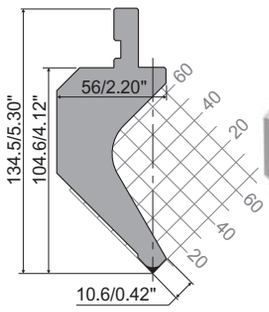
C45: 560-710 N/mm² **500 kN/m max.**

835 mm	*32.87"*	22.7 kg	
415 mm	*16.34"*	11.3 kg	
795 mm	*31.29"*	21.7 kg	FX
805 mm	*31.69"*	22.0 kg	F

W=104.6 | H=134.5 | R=0.8 mm
W=4.12 | H=5.30 | R=0.031 in

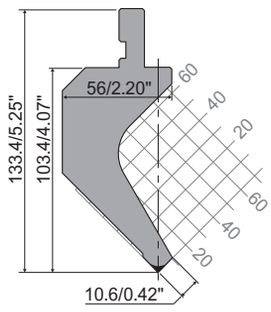
88°

.HORN 1



P.135.88.R3

C45: 560-710 N/mm² **500 kN/m max.**



835 mm	*32.87"*	22.7 kg	
415 mm	*16.34"*	11.3 kg	
795 mm	*31.29"*	21.7 kg	FX
805 mm	*31.69"*	22.0 kg	F

W=103.4 | H=133.45 | R=0.8 mm
W=4.07 | H=5.25 | R=0.031 in

88°

.HORN 1

PS.135.88.R08

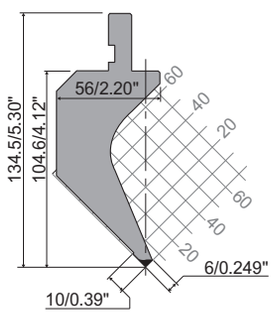
C45: 560-710 N/mm² **450 kN/m max.**

835 mm	*32.87"*	22.2 kg	
415 mm	*16.34"*	11.0 kg	
795 mm	*31.29"*	21.1 kg	FX
805 mm	*31.69"*	21.4 kg	F

W=104.6 | H=134.5 | R=0.8 mm
W=4.12 | H=5.30 | R=0.031 in

88°

.HORN 1



P.150.88.R08

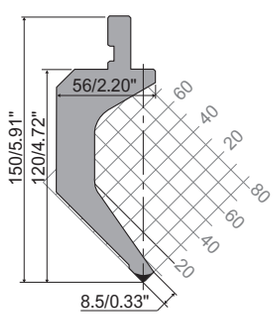
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	21.2 kg	
415 mm	*16.34"*	10.6 kg	
795 mm	*31.29"*	20.2 kg	FX
805 mm	*31.69"*	20.5 kg	F
900 mm	*35.43"*	22.9 kg	

W=120.0 | H=150.0 | R=0.8 mm
W=4.72 | H=5.91 | R=0.031 in

88°

.HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

P.150.88.R06

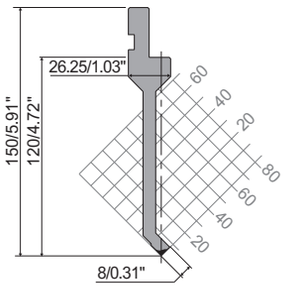
42Cr: 900-1150 N/mm² **350 kN/m max.**

835 mm	*32.87"*	10.9 kg	
415 mm	*16.34"*	5.4 kg	
795 mm	*31.29"*	10.3 kg	FX
805 mm	*31.69"*	10.4 kg	F
900 mm	*35.43"*	11.7 kg	

W=120.0 | H=150.0 | R=0.6 mm
W=4.72 | H=5.91 | R=0.024 in

88°

.HORN 1



P.150.88.R025

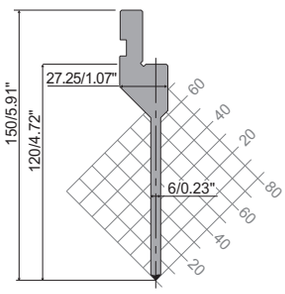
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	10.2 kg	
415 mm	*16.34"*	5.0 kg	
795 mm	*31.29"*	9.7 kg	FX
805 mm	*31.69"*	9.8 kg	F

W=120 | H=150 | R=0.25 mm
W= 4.72 | H=5.91 | R=0.010 in

88°

.HORN 1



P.175.88.R08

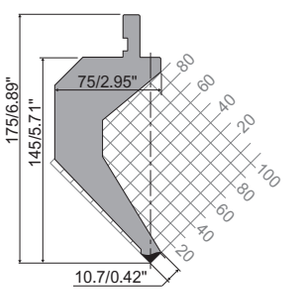
C45: 560-710 N/mm² **500 kN/m max.**

835 mm	*32.87"*	35.7 kg	
415 mm	*16.34"*	17.7 kg	
795 mm	*31.29"*	34.0 kg	FX
805 mm	*31.69"*	34.4 kg	F

W=145.0 | H=175.0 | R=0.8 mm
W=5.71 | H=6.89 | R=0.031 in

88°

.HORN 1



P.196.88.R06

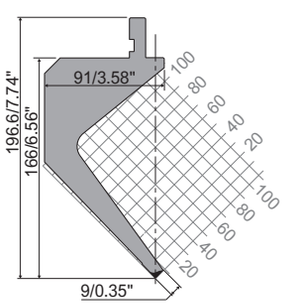
C45: 560-710 N/mm² **300 kN/m max.**

835 mm	*32.87"*	42.0 kg	
415 mm	*16.34"*	20.8 kg	
795 mm	*31.29"*	40.0 kg	FX
805 mm	*31.69"*	40.4 kg	F
900 mm	*35.43"*	45.2 kg	

W=166.6 | H=196.6 | R=0.6 mm
W=6.56 | H=7.74 | R=0.024 in

88°

.HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

P.97.85.R08

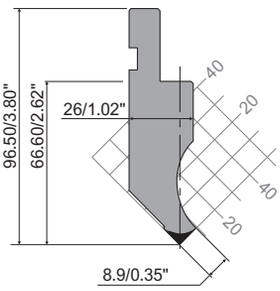
C45: 560-710 N/mm² **1000 kN/m max.**

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

W=66.60 | H=96.50 | R=0.8 mm
W=2.62 | H=3.80 | R=0.031 in

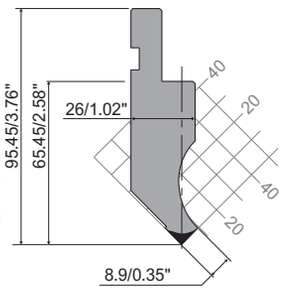
85°>

.HORN 1



PK.95.85.R3

C45: 560-710 N/mm² **1000 kN/m max.**



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

W=65.45 | H=95.45 | R=3 mm
W=2.58 | H=3.76 | R=0.118 in

88°

.HORN 1

P.120.85.R1

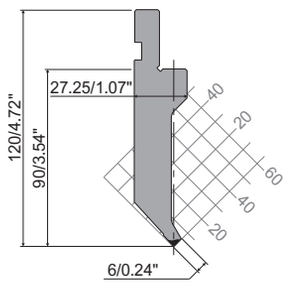
42Cr: 900-1150 N/mm² **800 kN/m max.**

835 mm	*32.87"*	13.5 kg	
415 mm	*16.34"*	6.7 kg	
795 mm	*31.29"*	12.9 kg	FX
805 mm	*31.69"*	19.0 kg	F

W=90.0 | H=120.0 | R=1 mm
W=3.54 | H=4.72 | R=0.039 in

85°

.HORN 1



P.130.85.R025

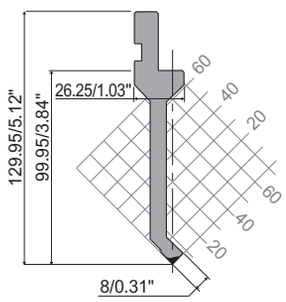
42Cr: 900-1150 N/mm² **350 kN/m max.**

835 mm	*32.87"*	9.8 kg	
415 mm	*16.34"*	4.9 kg	
795 mm	*31.29"*	9.3 kg	FX
805 mm	*31.69"*	9.4 kg	F

W=99.95 | H=129.95 | R=0.25 mm
W=3.84 | H=5.12 | R=0.010 in

85°

.HORN 1



P.130.85.R08

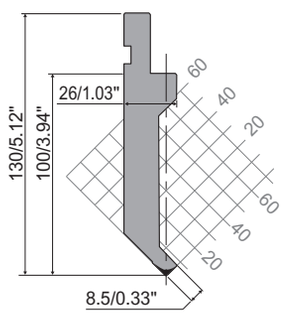
C45: 560-710 N/mm² **400 kN/m max.**

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

W=100 | H=130 | R=0.8 mm
W= 3.94 | H=5.12 | R=0.031 in

85°

.HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

PK.135.85.R08

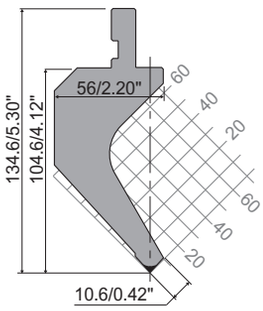
C45: 560-710 N/mm² **500 kN/m max.**

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

W=104.6 | H=134.6 | R=0.8 mm
W=4.12 | H=5.30 | R=0.031 in

85°

.HORN 1



P.135.85.R08

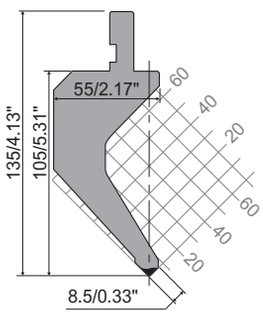
42Cr: 900-1150 N/mm² **800 kN/m max.**

835 mm	*32.87"*	20.9 kg	
415 mm	*16.34"*	10.4 kg	
795 mm	*31.29"*	19.2 kg	FX
805 mm	*31.69"*	20.2 kg	F

W=105 | H=135 | R=0.8 mm
W=5.31 | H=4.13 | R=0.031 in

85°

.HORN 1



PS.135.85.R08

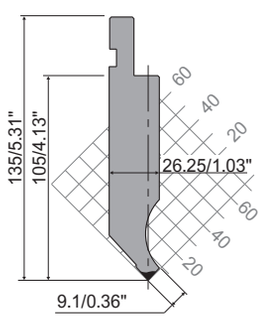
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	17.7 kg	
415 mm	*16.34"*	8.8 kg	
795 mm	*31.29"*	16.9 kg	FX
805 mm	*31.69"*	17.1 kg	F

W=105 | H=135 | R=0.8 mm
W=4.13 | H=5.31 | R=0.031 in

85°

.HORN 1



P.145.85.R08

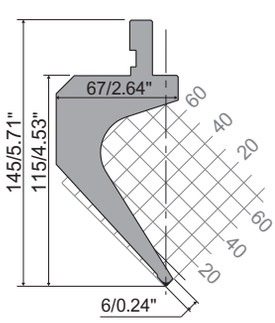
42Cr: 900-1150 N/mm² **600 kN/m max.**

835 mm	*32.87"*	22.6 kg	
415 mm	*16.34"*	11.2 kg	
795 mm	*31.29"*	21.5 kg	FX
805 mm	*31.69"*	21.8 kg	F

W=115 | H=145 | R=0.8 mm
W=4.53 | H=5.71 | R=0.031 in

85°

.HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

P.150.85.R1

C45: 560-710 N/mm²

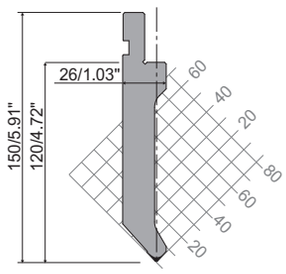
700 kN/m max.

835 mm	*32.87"*	17.5 kg	
415 mm	*16.34"*	8.7 kg	
795 mm	*31.29"*	16.6 kg	FX
805 mm	*31.69"*	16.6 kg	F

W=120 | H=150 | R=1.0 mm
W=4.72 | H=5.91 | R=0.039 in

85°

.HORN 1



P.250.85.R15

42Cr: 900-1150 N/mm²

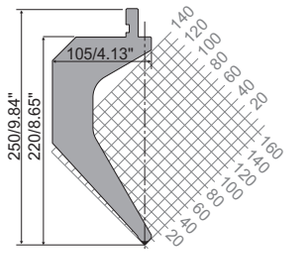
850 kN/m max.

415 mm	*16.34"*	33.1 kg	
795 mm	*31.29"*	63.3 kg	FX

W=220.0 | H=250.0 | R=1.5 mm
W=8.65 | H=9.84 | R=0.059 in

85°

.HORN 1



P.135.75.R08

42Cr: 900-1150 N/mm²

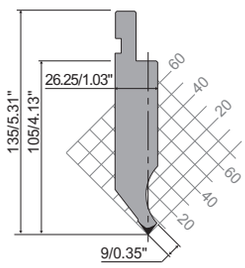
1000 kN/m max.

835 mm	*32.87"*	17.5 kg	
415 mm	*16.34"*	8.7 kg	
795 mm	*31.29"*	16.7 kg	FX
805 mm	*31.69"*	16.9 kg	F

W=105 | H=135 | R=0.8 mm
W= 4.13 | H=5.31 | R=0.031 in

75°

HORN 1



P.97.75.R08

42Cr: 900-1150 N/mm²

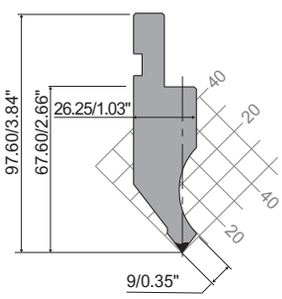
1000 kN/m max.

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.4 kg	
795 mm	*31.29"*	10.4 kg	FX
805 mm	*31.69"*	10.6 kg	F

W=67.60 | H=97.60 | R=0.8 mm
W=2.66 | H=3.84 | R=0.031 in

75°>

HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

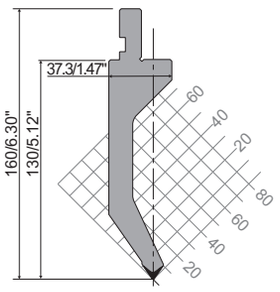
P.160.70.R08

42Cr: 900-1150 N/mm² **450 kN/m max.**

835 mm	*32.87"*	18.0 kg	
415 mm	*16.34"*	8.9 kg	
795 mm	*31.29"*	17.0 kg	FX
805 mm	*31.69"*	17.3 kg	F

W=130 | H=160 | R=0.8 mm
W=5.12 | H=6.30 | R=0.031 in

70°>



.HORN 1

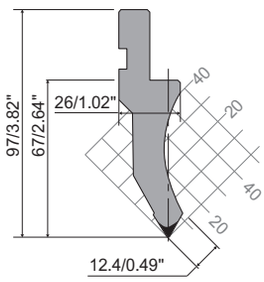
P.97.60.R08

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	9.0 kg	
415 mm	*16.34"*	4.5 kg	
795 mm	*31.29"*	8.5 kg	FX
805 mm	*31.69"*	8.7 kg	F

W=67 | H=97 | R=0.8 mm
W=2.64 | H=3.82 | R=0.031 in

60°>



.HORN 1

P.97.60.R2

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	9.0 kg	
415 mm	*16.34"*	4.5 kg	
795 mm	*31.29"*	8.5 kg	FX
805 mm	*31.69"*	8.7 kg	F

W=67 | H=97 | R=2.0 mm
W=2.64 | H=3.82 | R=0.079 in

60°

.HORN 1

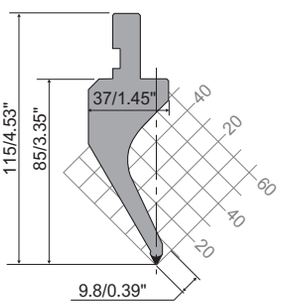
P.115.60.R08

42Cr: 900-1150 N/mm² **400 kN/m max.**

835 mm	*32.87"*	11.9 kg	
415 mm	*16.34"*	5.9 kg	
795 mm	*31.29"*	10.3 kg	FX
805 mm	*31.69"*	10.4 kg	F

W=85 | H=115 | R=0.8 mm
W=3.35 | H=4.53 | R=0.031 in

60°



.HORN 1

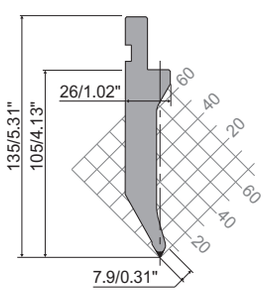
P.135.60.R08

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

835 mm	*32.87"*	14.0 kg	
415 mm	*16.34"*	6.9 kg	
795 mm	*31.29"*	13.3 kg	FX
805 mm	*31.69"*	13.5 kg	F

W=105 | H=135 | R=0.8 mm
W=4.13 | H=5.31 | R=0.031 in

60°



.HORN 1

FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

PG.135.60.R08

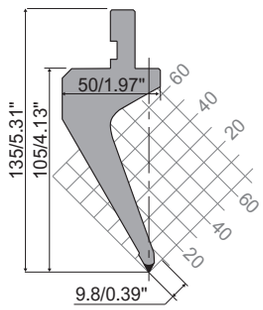
42Cr: 900-1150 N/mm² **700 kN/m max.**

835 mm	*32.87"*	16.5 kg	
415 mm	*16.34"*	8.2 kg	
795 mm	*31.29"*	15.7 kg	FX
805 mm	*31.69"*	15.9 kg	F

W=105 | H=135 | R=0.8 mm
W=4.13 | H=5.31 | R=0.031 in

60°

.HORN 1



P.145.60.R08

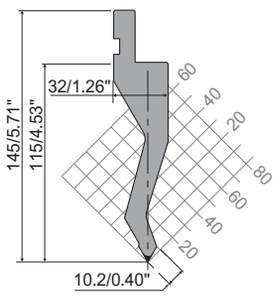
42Cr: 900-1150 N/mm² **700 kN/m max.**

835 mm	*32.87"*	15.1 kg	
415 mm	*16.34"*	7.5 kg	
795 mm	*31.29"*	14.3 kg	FX
805 mm	*31.69"*	14.5 kg	F

W=115.0 | H=145.0 | R=0.8 mm
W=4.53 | H=5.71 | R=0.031 in

60°

.HORN 1



P.190.60.R08

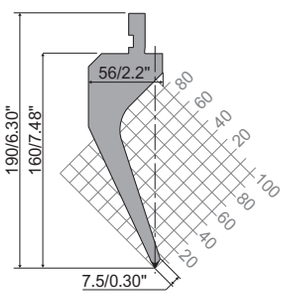
C45: 560-710 N/mm² **400 kN/m max.**

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

W=160 | H=190 | R=0.8 mm
W=7.48 | H=6.30 | R=0.031 in

60°

.HORN 1



P.95.45.R08

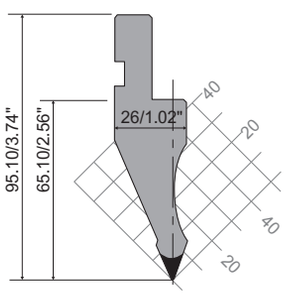
C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	9.3 kg	
415 mm	*16.34"*	4.6 kg	
795 mm	*31.29"*	8.9 kg	FX
805 mm	*31.69"*	9.0 kg	F

W=65.10 | H=95.10 | R=0.8 mm
W=2.56 | H=3.74 | R=0.031 in

45°>

.HORN 1



P.95.45.R15

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	9.3 kg	
415 mm	*16.34"*	4.6 kg	
795 mm	*31.29"*	8.9 kg	FX
805 mm	*31.69"*	9.0 kg	F

W=65.10 | H=95.10 | R=1.5 mm
W=2.56 | H=3.74 | R=0.059 in

45°

.HORN 1

FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

P.130.45.R6

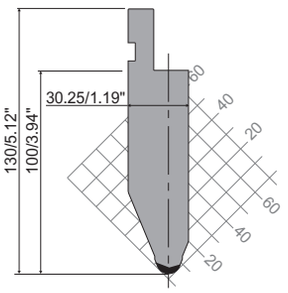
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	19.5 kg	
415 mm	*16.34"*	9.6 kg	
795 mm	*31.29"*	18.6 kg	FX
805 mm	*31.69"*	18.8 kg	F

W=100 | H=130 | R=6 mm
W=3.94 | H=5.12 | R=0.24 in

45°

.HORN 1



P.97.45.R05

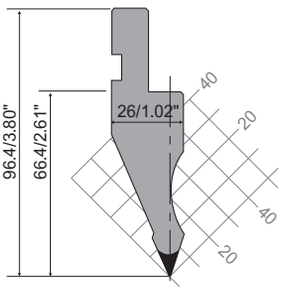
C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	10.2 kg	
415 mm	*16.34"*	5.1 kg	
795 mm	*31.29"*	9.7 kg	FX
805 mm	*31.69"*	9.8 kg	F
900 mm	*35.43"*	10.9 kg	

W=66.4 | H=96.4 | R=0.5 mm
W=2.61 | H=3.80 | R=0.020 in

45°

.HORN 1



P.95.35.R5

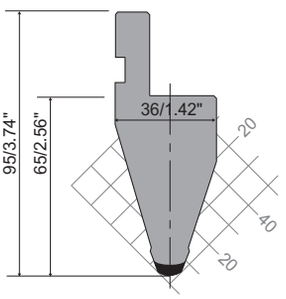
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	12.8 kg	
415 mm	*16.34"*	6.3 kg	
795 mm	*31.29"*	12.2 kg	FX
805 mm	*31.69"*	12.3 kg	F

W=65 | H=95 | R=5 mm
W=2.56 | H=3.74 | R=0.20 in

35°>

.HORN 1



PU.85.35.R08

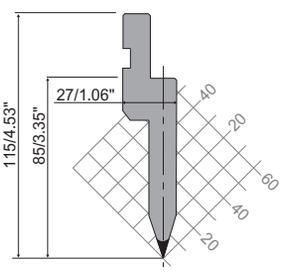
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.5 kg	
795 mm	*31.29"*	10.5 kg	FX
805 mm	*31.69"*	10.6 kg	F

W=85 | H=115 | R=0.8 mm
W=3.35 | H=4.53 | R=0.031 in

35°

.HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

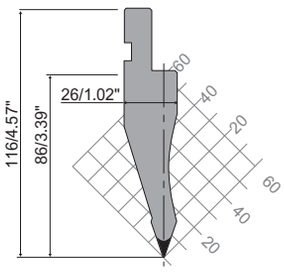
P.116.35.R08

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	10.7 kg	
415 mm	*16.34"*	5.3 kg	
795 mm	*31.29"*	10.2 kg	FX
805 mm	*31.69"*	10.3 kg	F

W=86 | H=116 | R=0.8 mm
W=3.39 | H=4.57 | R=0.031 in

35°



.HORN 1

P.116.35.R15

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	10.7 kg	
415 mm	*16.34"*	5.3 kg	
795 mm	*31.29"*	10.2 kg	FX
805 mm	*31.69"*	10.3 kg	F

W=86 | H=116 | R=1.5 mm
W=3.39 | H=4.57 | R=0.059 in

35°

.HORN 1

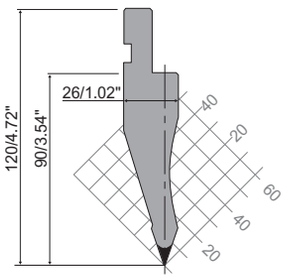
P.120.35.R08

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	12.3 kg	
415 mm	*16.34"*	6.1 kg	
795 mm	*31.29"*	11.7 kg	FX
805 mm	*31.69"*	11.9 kg	F

W=90 | H=120 | R=0.8 mm
W=3.54 | H=4.72 | R=0.031 in

35°



.HORN 1

P.120.35.R15

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	12.3 kg	
415 mm	*16.34"*	6.1 kg	
795 mm	*31.29"*	11.7 kg	FX
805 mm	*31.69"*	11.9 kg	F

W=90 | H=120 | R=1.5 mm
W=3.54 | H=4.72 | R=0.059 in

35°

.HORN 1

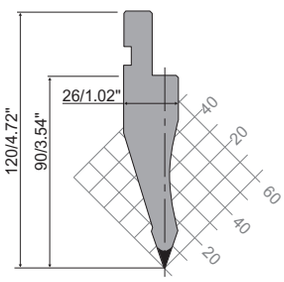
P.120.35.R3

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	12.3 kg	
415 mm	*16.34"*	6.1 kg	
795 mm	*31.29"*	11.7 kg	FX
805 mm	*31.69"*	11.9 kg	F

W=90 | H=120 | R=3 mm
W=3.54 | H=4.72 | R=0.018 in

35°



.HORN 1

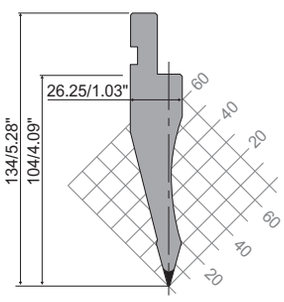
PS.134.30.R08

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	13.3 kg	
415 mm	*16.34"*	6.6 kg	
795 mm	*31.29"*	12.7 kg	FX
805 mm	*31.69"*	12.8 kg	F

W=104 | H=134 | R=0.8 mm
W=4.09 | H=5.28 | R=0.031 in

30°>



.HORN 1

FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

P.110.30.R06

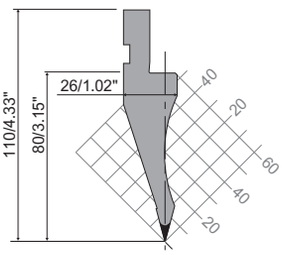
C45: 560-710 N/mm² **500 kN/m max.**

835 mm	*32.87"*	10.5 kg	
415 mm	*16.34"*	5.2 kg	
795 mm	*31.29"*	10.0 kg	FX
805 mm	*31.69"*	10.1 kg	F

W=80 | H=110 | R=0.6 mm
W=3.15 | H=4.33 | R=0.024 in

30°

.HORN 1



P.147.26.R08

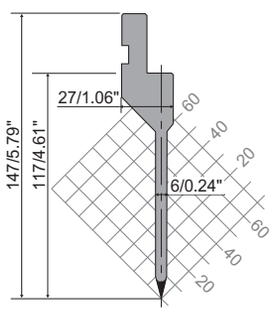
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	9.9 kg	
415 mm	*16.34"*	4.9 kg	
795 mm	*31.29"*	9.4 kg	FX
805 mm	*31.69"*	9.6 kg	F

W=117 | H=147 | R=0.8 mm
W=4.61 | H=5.79 | R=0.031 in

26°>

.HORN 1



PU.117.26.R08

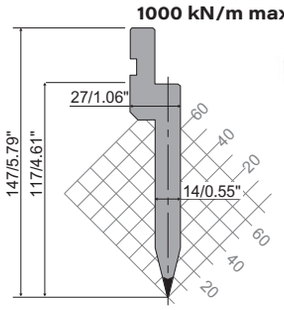
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	13.6 kg	
415 mm	*16.34"*	6.7 kg	
795 mm	*31.29"*	12.9 kg	FX
805 mm	*31.69"*	13.1 kg	F

W=117.0 | H=147.0 | R=0.8 mm
W=4.61 | H=5.79 | R=0.031 in

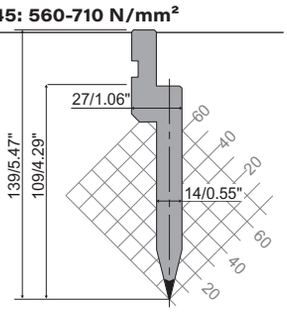
26°

.HORN 1



PU.117.26.R3

C45: 560-710 N/mm² **1000 kN/m max.**



835 mm	*32.87"*	13.6 kg	
415 mm	*16.34"*	6.7 kg	
795 mm	*31.29"*	12.9 kg	FX
805 mm	*31.69"*	13.1 kg	F

W=109.0 | H=139.0 | R=3 mm
W=4.29 | H=5.47 | R=0.118 in

26°

.HORN 1

PU.150.26.R08.L

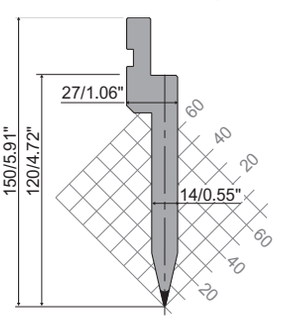
C45: 560-710 N/mm² **1000 kN/m max.**

900 mm	*35.43"*	15.2 kg	
415 mm	*16.34"*	7.0 kg	
795 mm	*31.29"*	13.4 kg	FX
805 mm	*31.69"*	13.6 kg	F

W=120 | H=150 | R=0.8 mm
W=4.72 | H=5.91 | R=0.031 in

26°

.HORN 1



FX: 795 mm - *31.29"*
mm: ◁ 100-250-20-25-30-35-40-45-50-100-100 ▷
in: ◁ 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94 ▷

F: 805 mm - *31.69"*
mm: 100-370-10-15-20-40-50-100-100
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94

.movable horns >>

Movable horns are equipped with a swivel pin, which enables the rotation of the horn tip downwards and consequently reduces its length.
During the bending process keep movable horn closed and activate the swivel pin only to remove the bent profile easily and quickly.

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				

SCA.M.88.R08

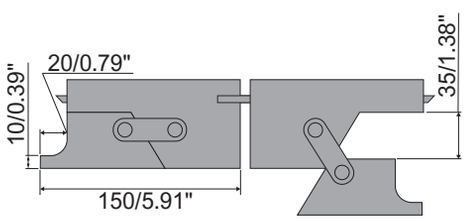
C45: 560-710 N/mm² **150 kN/m max.**

Per pair	3.5 kg

H=66.35 | R=0.8 mm
H=2.61 | R=0.031 in

88°>

1 PAIR L/R COMPATIBLE WITH **P.97.88.R08**



.joggle tools >>

Joggle tools can make two bends at the same time, so the bending process is extremely quick.
Furthermore, it is very flexible and convenient, as by using the same CPZ holder you can produce 15 different joggles by changing inserts only. By using CEZ inserts, the bending result is guaranteed.

Z dimensions and angles mentioned in the above table are valid only to bend mild steel with max. tensile strength 420 N/mm2.
If you have to bend other sheet metal types, please contact our technical department at tecnico@rolleri.it

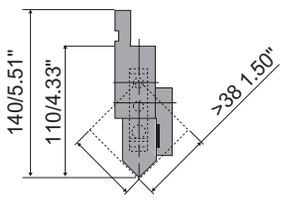
SPE.11

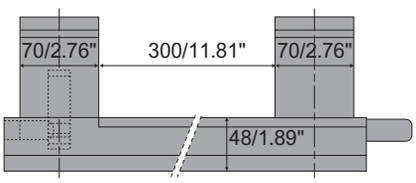
42Cr: 900-1150 N/mm² **150 kN/m max.**

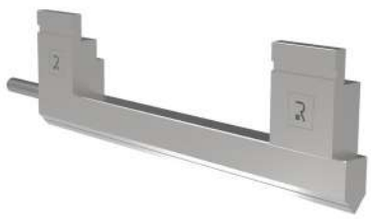
7.0 kg

W=110 | H=140 | R=0.8 mm
W=4.33 | H=5.51 | R=0.031 in

88°>



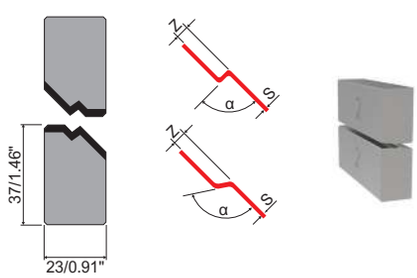


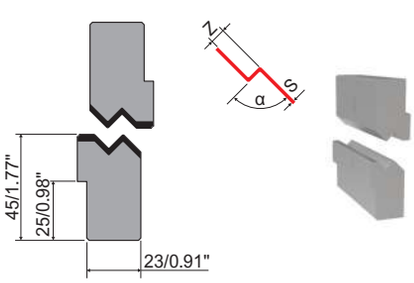


JOGGLE TOOL INSERTS

C45: 560-710 N/mm² **1000 kN/m max.**

	Z mm	Z in	α	Thickness ! mm	Thickness ! in	835 mm 32.87 in	415 mm 16.34 in	
CEZ 1.0	1	*0.04*	160°	1.2	*0.05*	11 kg	5.5 kg	160°
CEZ 1.5	1.5	*0.06*	160°	1.5	*0.06*	11 kg	5.5 kg	
CEZ 2.0	2	*0.08*	150°	1.4	*0.06*	11 kg	5.5 kg	150°
CEZ 2.5	2.5	*0.10*	140°	1.3	*0.05*	11 kg	5.5 kg	140°
CEZ 1.0/90	1	*0.04*	90°	0.3	*0.01*	11 kg	5.5 kg	
CEZ 1.5/90	1.5	*0.06*	90°	0.3	*0.01*	11 kg	5.5 kg	
CEZ 2.0/90	2	*0.08*	90°	0.4	*0.02*	11 kg	5.5 kg	
CEZ 2.5/90	2.5	*0.10*	90°	0.5	*0.02*	11 kg	5.5 kg	
CEZ 3.0	3	*0.12*	90°	1.0	*0.04*	10.3 kg	5.1 kg	
CEZ 3.5	3.5	*0.14*	90°	1.0	*0.04*	10 kg	5.0 kg	
CEZ 4.0	4	*0.16*	90°	1.2	*0.05*	10 kg	5.0 kg	
CEZ 4.5	4.5	*0.18*	90°	1.2	*0.05*	10 kg	5.0 kg	90°
CEZ 5.0	5	*0.20*	90°	1.3	*0.05*	10 kg	5.0 kg	
CEZ 5.5	5.5	*0.22*	90°	1.4	*0.06*	10 kg	5.0 kg	
CEZ 6.0	6	*0.24*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 6.5	6.5	*0.26*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 7.0	7	*0.28*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 7.5	7.5	*0.30*	90°	1.6	*0.06*	10 kg	5.0 kg	
CEZ 8.0	8	*0.31*	90°	1.6	*0.06*	10 kg	5.0 kg	
CEZ 9.0	9	*0.35*	90°	1.8	*0.07*	13.5 kg	6.5 kg	
CEZ 10.0	10	*0.39*	90°	1.8	*0.07*	13.5 kg	5.0 kg	
CEZ 11.0	11	*0.43*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 12.0	12	*0.47*	90°	2	*0.08*	13.5 kg	5.0 kg	90°
CEZ 13.0	13	*0.51*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 14.0	14	*0.55*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 15.0	15	*0.59*	90°	2.3	*0.09*	13.5 kg	5.0 kg	



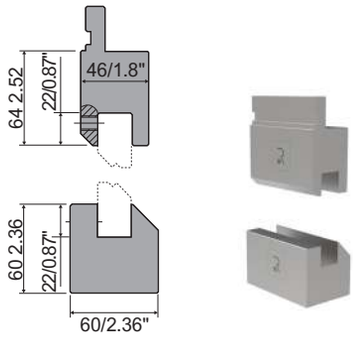


CPZ

C45: 560-710 N/mm²

1000 kN/m max.

835 mm	*32.87"*	37.5 kg
415 mm	*16.34"*	18.7 kg



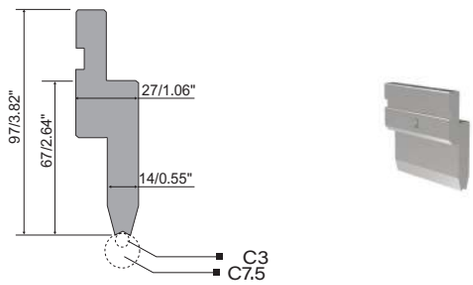
PU.67.14-S

C45: 560-710 N/mm²

400 kN/m max.

830 mm	*32.68"*	9.7 kg
410 mm	*16.14"*	5.0 kg

W=67 | H=97 mm
W=2.64 | H=3.82 in

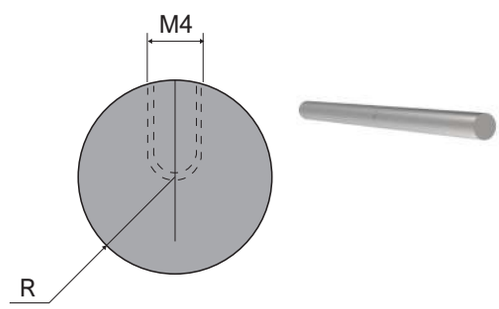


C3 - C7.5

C45: 560-710 N/mm²

400 kN/m max.

	R mm	*R in*	835 mm *32.87 in*	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

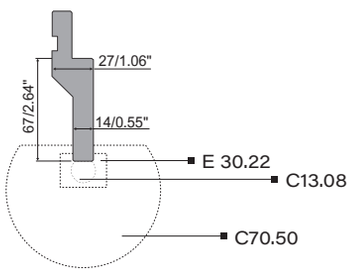


The same holder can be equipped with different radius tools and, in case of PU67.14 and PU105.14, also with E30.22 flat hemming insert to flatten thick sheet metal.
Radius profiles bent with radius tools show a more regular shape and therefore they aesthetically look better.
PU holders and C radius tools have been designed to guarantee the maximum flexibility thanks to the wide range of different radius tools which can be used. For specific needs the same concept can be used for special shapes like U shapes, omega etc..
The assembly system has been studied in order to be flexible and to guarantee the easy and quick radius tool change.

PU.67.14

C45: 560-710 N/mm² **800 kN/m max.**

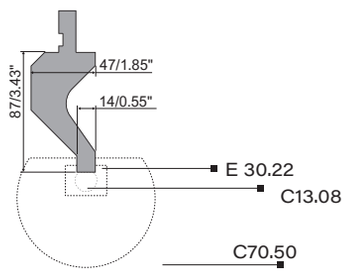
830 mm	*32.68"*	9.0 kg
410 mm	*16.14"*	5.0 kg



PU.87.14

C45: 900-1150 N/mm² **500 kN/m max.**

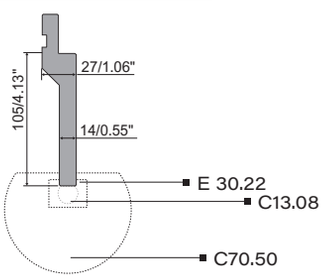
830 mm	*32.68"*	9.0 kg
410 mm	*16.14"*	4.5 kg



PU.105.14

C45: 560-710 N/mm² **800 kN/m max.**

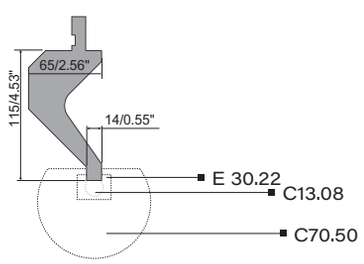
830 mm	*32.68"*	12.0 kg
410 mm	*16.14"*	6.0 kg



PU.115.14

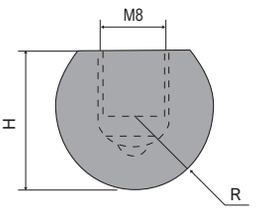
C45: 560-710 N/mm² **500 kN/m max.**

830 mm	*32.68"*	26.0 kg
410 mm	*16.14"*	13.0 kg



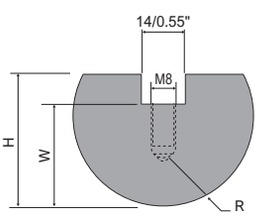
RADIUS TOOLS Ø 16 - 20

	R	*R*	H	*H*	A	*A*	835 mm	415 mm
	mm	*in*	mm	*in*	mm	*in*	*32.87 in*	*16.34 in*
C13.08	8	*0.31*	13	*0.51*	-	-	2.0 kg	1.0 kg
C13.09	9	*0.35*	16	*0.63*	-	-	2.0 kg	1.0 kg
C16.10	10	*0.39*	16	*0.63*	-	-	2.0 kg	1.0 kg



RADIUS TOOLS Ø 25 - 100

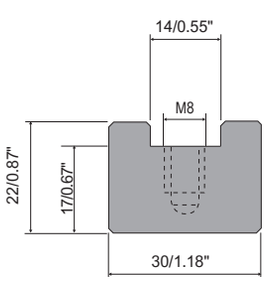
	R	*R*	W	*W*	H	*H*	835 mm	415 mm
	mm	*in*	mm	*in*	mm	*in*	*32.87 in*	*16.34 in*
C17.12	12.5	*0.49*	17	*0.67*	22	*0.87*	2.5 kg	1.2 kg
C20.15	15	*0.59*	20	*0.79*	27	*1.06*	3.7 kg	1.8 kg
C22.17	17.5	*0.69*	22	*0.87*	32	*1.26*	5.0 kg	2.4 kg
C24.20	20	*0.79*	24	*0.94*	34	*1.33*	7.0 kg	3.5 kg
C25.22	22.5	*0.89*	25	*0.98*	35	*1.38*	7.5 kg	3.8 kg
C29.25	25	*0.98*	29	*1.14*	39	*1.53*	10.0 kg	4.7 kg
C34.27	27.5	*1.08*	34	*1.33*	44	*1.73*	12.4 kg	6.2 kg
C34.30	30	*1.18*	34	*1.33*	44	*1.73*	13.5 kg	6.7 kg
C37.32	32.5	*1.28*	37	*1.46*	47	*1.85*	15.9 kg	7.9 kg
C45.35	35	*1.38*	45	*1.77*	55	*2.16*	20.3 kg	10.0 kg
C42.37	37.5	*1.48*	42	*1.65*	52	*2.04*	20.5 kg	10.3 kg
C45.40	40	*1.57*	45	*1.77*	55	*2.16*	23.0 kg	11.5 kg
C60.45	45	*1.77*	60	*2.36*	70	*2.75*	34.0 kg	17.0 kg
C70.50	50	*1.97*	70	*2.75*	80	*3.15*	43.5 kg	21.7 kg



HEMMING TOOL E30.22

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	3.5 kg
415 mm	*16.38"*	1.7 kg



00402

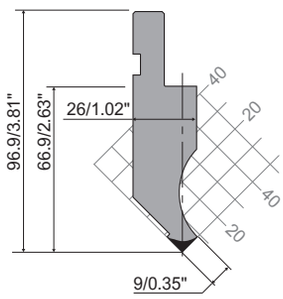
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.5 kg	
835 mm	*32.87"*	11.0 kg	FCA

W=66.9 | H=96.9 | R=0.2 mm
W=2.63 | H=3.81 | R=0.008 in

88°

.HORN 3



00430

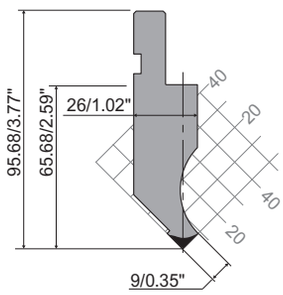
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.5 kg	
835 mm	*32.87"*	11.0 kg	FCA

W=65.68 | H=95.68 | R=3 mm
W=2.59 | H=3.77 | R=0.118 in

88°

.HORN 3



11700

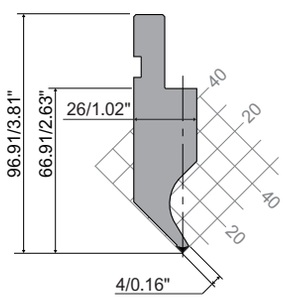
42Cr: 900-1150 N/mm² **200 kN/m max.**

835 mm	*32.87"*	10.7 kg	
415 mm	*16.34"*	5.3 kg	
835 mm	*32.87"*	10.3 kg	FCA

W=66.91 | H=96.91 | R=0.2 mm
W=2.63 | H=3.81 | R=0.008 in

88°

.HORN 7



04502

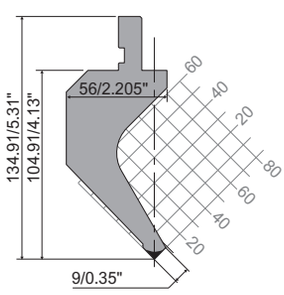
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	22.0 kg	
415 mm	*16.34"*	10.9 kg	
835 mm	*32.87"*	22.0 kg	FCA

W=104.91 | H=134.91 | R=0.2 mm
W=4.13 | H=5.31 | R=0.008 in

88°

.HORN 3



FCA: 835 mm - *32.87"*
mm: ◁ 100-10-15-20-40-50-200-300-100 ▷
in: ◁ 3.94-0.39-0.59-0.78-1.57-7.87-11.81-3.94 ▷

45202

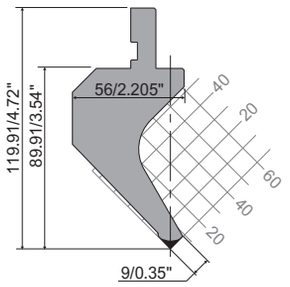
42Cr: 900-1150 N/mm² **700 kN/m max.**

835 mm	*32.87"*	19.6 kg	
415 mm	*16.34"*	9.7 kg	
835 mm	*32.87"*	19.6 kg	FCA

W=89.91 | H=119.91 | R=0.2 mm
W=3.54 | H=4.72 | R=0.008 in

88°

.HORN 3



04702

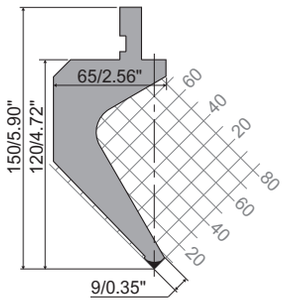
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	25.8 kg	
415 mm	*16.34"*	12.9 kg	
835 mm	*32.87"*	25.8 kg	FCA

W=120 | H=150 | R=0.2 mm
W=4.72 | H=5.90 in | R=0.008 in

88°

.HORN 3



45302

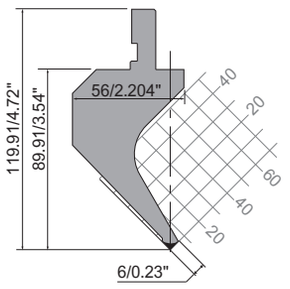
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	18.6 kg	
415 mm	*16.34"*	9.3 kg	
835 mm	*32.87"*	18.6 kg	FCA

W=89.91 | H=119.91 | R=0.2 mm
W=3.54 | H=4.72 | R=0.008 in

88°

.HORN 7



20000

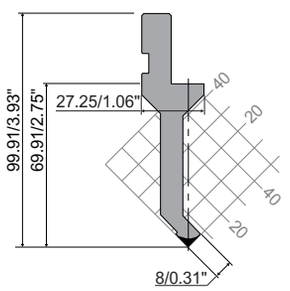
42Cr: 900-1150 N/mm² **300 kN/m max.**

835 mm	*32.87"*	7.9 kg	
415 mm	*16.34"*	3.9 kg	
835 mm	*32.87"*	7.5 kg	FCA

W=69.91 | H=99.91 | R=0.2 mm
W=2.75 | H=3.93 in | R=0.008 in

88°

.HORN 4



FCA: 835 mm - *32.87"*
mm: ◁ 100-10-15-20-40-50-200-300-100 ▷
in: ◁ 3.94-0.39-0.59-0.78-1.57-7.87-11.81-3.94 ▷

20200

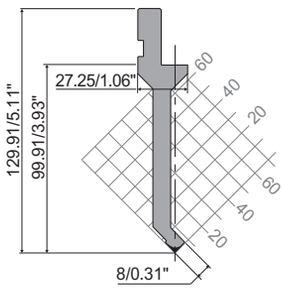
42Cr: 900-1150 N/mm² **300 kN/m max.**

835 mm	*32.87"*	10.0 kg	
415 mm	*16.34"*	5.0 kg	
835 mm	*31.50"*	9.6 kg	FCA

W=99.91 | H=129.91 | R=0.2 mm
W=3.93 | H=5.11 | R=0.008 in

88°

.HORN 4



00480

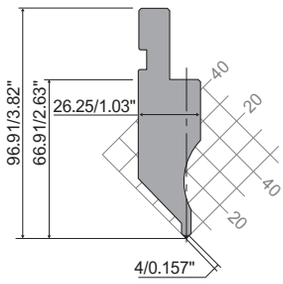
C45: 560-710 N/mm² **400 kN/m max.**

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.5 kg	
835 mm	*31.50"*	11.0 kg	FCA

W=66.91 | H=96.91 | R=0.2 mm
W=2.63 | H=3.82 | R=0.008 in

88°

.HORN 3



00490

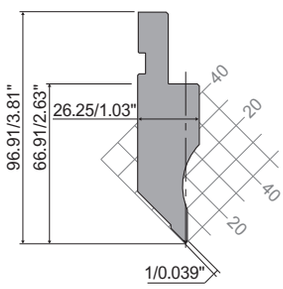
C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.5 kg	
835 mm	*31.50"*	11.0 kg	FCA

W=66.91 | H=96.91 | R=0.2 mm
W=2.63 | H=3.82 | R=0.008 in

88°

.HORN 3



10900

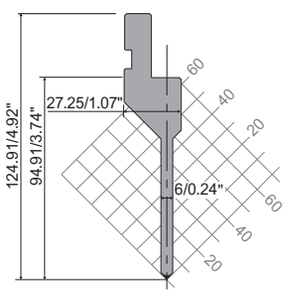
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	9.0 kg	
415 mm	*16.34"*	4.5 kg	
835 mm	*31.50"*	9.0 kg	FCA

W=94.91 | H=124.91 | R=0.2 mm
W=3.74 | H=4.92 | R=0.008 in

88°

.HORN 4



FCA: 835 mm - *32.87"*
mm: ◁ 100-10-15-20-40-50-200-300-100 ▷
in: ◁ 3.94-0.39-0.59-0.78-1.57-7.87-11.81-3.94 ▷

10906

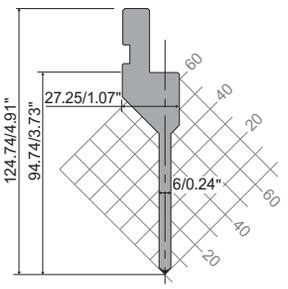
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	9.0 kg	
415 mm	*16.34"*	4.5 kg	
835 mm	*31.50"*	9.0 kg	FCA

W=94.74 | H=124.74 | R=0.6 mm
W=3.73 | H=4.91 | R=0.024 in

88°

.HORN 4



00300

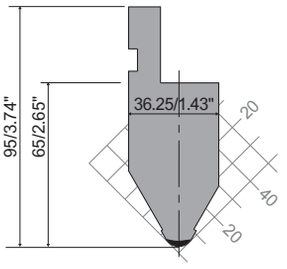
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	15.0 kg	
415 mm	*16.34"*	7.5 kg	
835 mm	*31.50"*	15.0 kg	FCA

W=65 | H=95 | R=6 mm
W=2.56 | H=3.74 in | R=0.002 in

60°

.HORN 6



00800

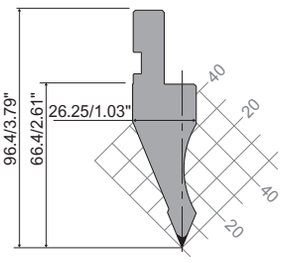
C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	9.3 kg	
415 mm	*16.34"*	4.6 kg	
835 mm	*31.50"*	9.3 kg	FCA

W=66.4 | H=96.4 | R=0.37 mm
W=2.61 | H=3.79 | R=0.015 in

45°

.HORN 5



21000

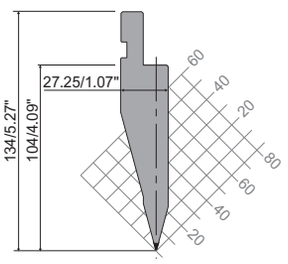
42Cr: 900-1150 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	15.3 kg	
415 mm	*16.34"*	7.6 kg	
835 mm	*31.50"*	14.6 kg	FCA

W=104 | H=134 | R=0.65 mm
W=4.09 | H=5.27 | R=0.025 in

30°>

.HORN 5



FCA: 835 mm - *32.87"*
mm: ◁ 100-10-15-20-40-50-200-300-100 ▷
in: ◁ 3.94-0.39-0.59-0.78-1.57-7.87-11.81-3.94 ▷

10300

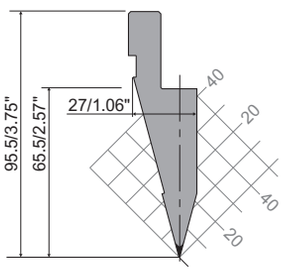
42Cr: 900-1150 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	11.0 kg	
415 mm	*16.34"*	5.5 kg	
835 mm	*31.50"*	10.5 kg	FCA

W=65.5 | H=95.5 | R=0.52 mm
W=2.57 | H=3.75 | R=0.020 in

30°

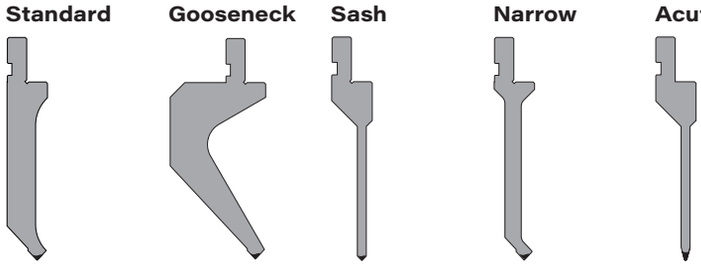
.HORN 5



.punches CFH 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.

Standard **Gooseneck** **Sash** **Narrow** **Acute**



CFH.150.86.R02-STD

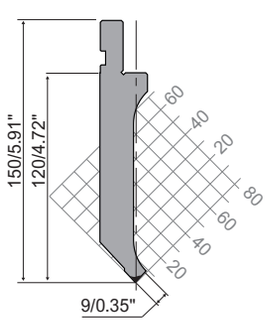
42Cr: 900-1150 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	17.5 kg	
415 mm	*16.34"*	8.7 kg	
800 mm	*31.49"*	16.8 kg	F

W=120 | H=150 | R=0.2 mm
W=4.72 | H=5.91 | R=0.008 in

86°>

.HORN 1



F: 800 mm - *31.49"*
mm: ◁ 100-300-150-50-40-20-15-15-10-100 ▷
in: ◁ 3.94-11.81-5.90-1.96-1.57-0.79-0.59-0-59-0.39-3.94 ▷

CFH.150.86.R02-GNK

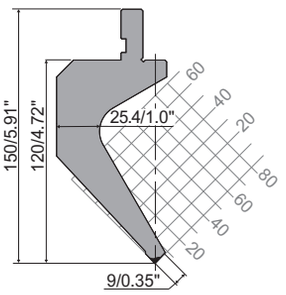
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	25.2 kg	
415 mm	*16.34"*	12.5 kg	
800 mm	*31.49"*	24.2 kg	F

W=120 | H=150 | R=0.2 mm
W=4.72 | H=5.91 | R=0.008 in

86°

.HORN 1



CFH.150.86.R02-SSH

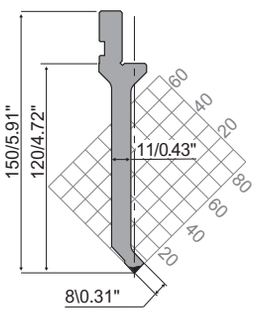
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	11.8 kg	
415 mm	*16.34"*	5.9 kg	
800 mm	*31.49"*	11.3 kg	F

W=120 | H=150 | R=0.2 mm
W=4.72 | H=5.91 | R=0.008 in

86°

.HORN 1



CFH.150.88.R025

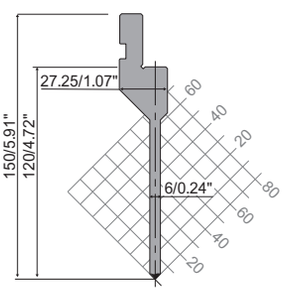
42Cr: 900-1150 N/mm² **500 kN/m max.**

835 mm	*32.87"*	17.5 kg	
415 mm	*16.34"*	8.7 kg	
800 mm	*31.49"*	16.9 kg	F

W=120 | H=150 | R=0.37 mm
W=4.72 | H=5.91 | R=0.015 in

88°>

.HORN 1



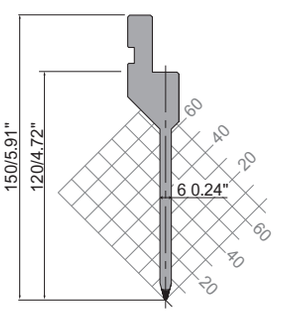
CFH.150.30.R08

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

835 mm	*32.87"*	17.5 kg	
415 mm	*16.34"*	8.7 kg	
800 mm	*31.49"*	16.9 kg	F

W=120 | H=150 | R=0.8 mm
W=4.72 | H=5.91 | R=0.031 in

30°>



.HORN 1

F: 800 mm - *31.49"*

mm: ◁ 100-300-150-50-40-20-15-15-10-100 ▷

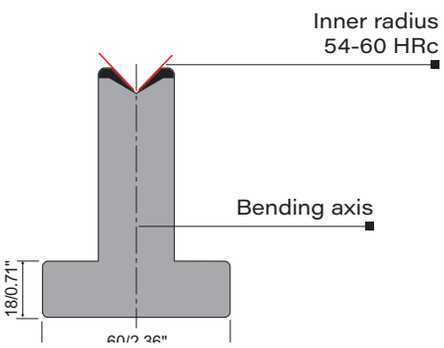
in: ◁ 3.94-11.81-5.90-1.96-1.57-0.79-0.59-0-59-0.39-3.94 ▷

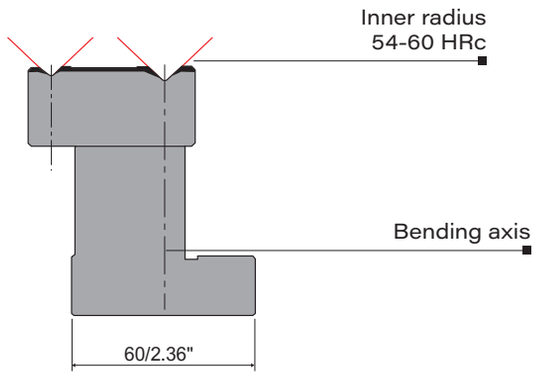
.R1 dies

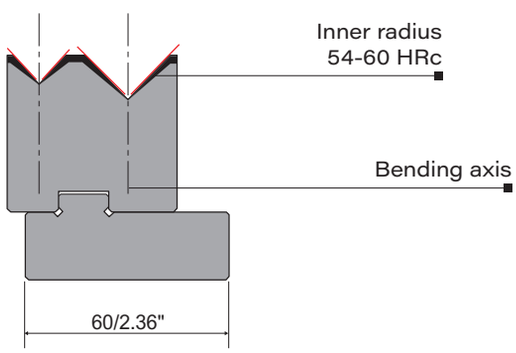
Compatible with press brakes: Accurl, Accurpress, ACL, Adira, Albermachinery, Alpmac, Amada, Atlantic, Baykal, BL, Boschert, Boutillon, Bystronic Beyeler, Euro-B, Coastone, Colgar, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gecko, Gilardi, Gizelis, Haco, Hindustan, HPM, Iturrospe,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

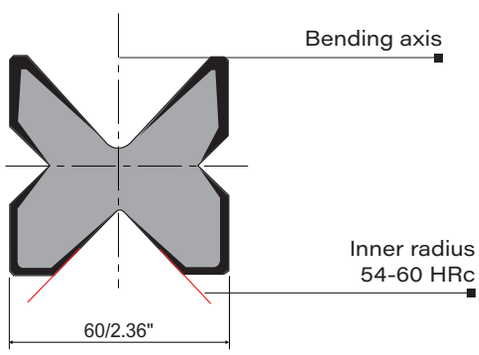
.standard tang

All dies R1 have base 60-90-120 mm *2.36"-3.54"-4.72".*









.standard length

	TOP Series	CLASSIC Series	A Series	CFH Series
525 mm | *20.67"*	●			
415 mm | *16.34"*		●	●	●
835 mm | *32.87"*		●	●	●
900 mm | *35.43"*		○	○	

○ available for some tool models only

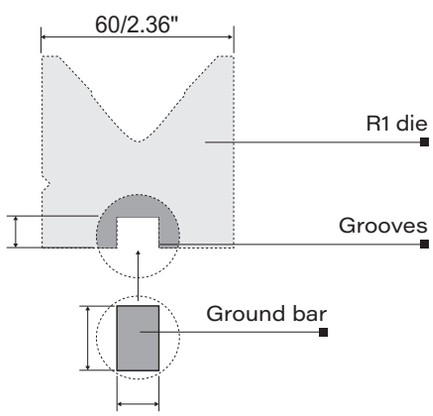
Rolleri BLACKFIRE is a surface treatment against steel oxidation. This chemical treatment is a longterm solution against oxidation and rust.

Rolleri FREEZINC is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation and you don't need to clean them anymore.

.modifications wedge/bar tail

To use R1 dies, a 10 mm *0.39"* groove is milled where a ground bar is mounted.

Wedge/ Bar Tail (W x H)	System	
13 x 30 mm ***0.51" x 1.18"***	R2 R3	Bystronic-Beyeler, Safan, Trumpf,...
55 x 55 mm ***2.16" x 2.16"***	RX	EHT
12.7 x 29 mm ***0.5" x 1.14"***	R4	LVD
35 x 55 mm ***1.37" x 2.16"***	RX	Weinbrenner



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.segmentation

Customised sectioning is also available on request. Check the feasibility with sales@rolleri.it

FC: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84

F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

FC (A series): 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94 -7.87-15.75

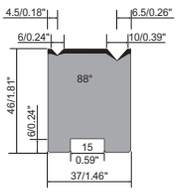
F: 800 mm - *21.49"*
mm: 100-10-15-15-20-40-50-150-400
in: 3.94-0.39-0.59-0.59-0.79-1.57-1.97-5.90-15.74

46.11.88

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	10.3 kg	
415 mm	*16.34"*	5.2 kg	
795 mm	*31.29"*	9.9 kg	FX
805 mm	*31.69"*	10.3 kg	F

H=46 | R=0.4 | V=6 mm
H=46 | R=0.6 | V=10 mm
H=1.81 | R=0.016 | V=0.24 in
H=1.81 | R=0.024 | V=0.39 in



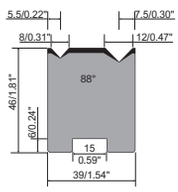
88°>

46.13

C45: 560-710 N/mm² **800 kN/m max.**

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

H=46 | R=0.5 | V=8 mm
H=46 | R=0.8 | V=12 mm
H=1.81 | R=0.020 | V=0.31 in
H=1.81 | R=0.031 | V=0.47 in



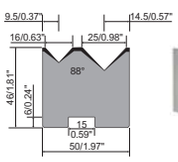
88°

46.16

C45: 560-710 N/mm² **800 kN/m max.**

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

H=46 | R=1.5 | V=16 mm
H=46 | R=1.75 | V=25 mm
H=1.81 | R=0.059 | V=0.63 in
H=1.81 | R=0.069 | V=0.98 in



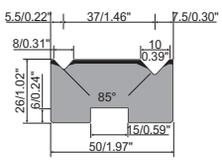
88°

M26.85.02

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

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

H=26 | R=0.5 | V=8 mm
H=26 | R=0.8 | V=12 mm
H=1.02 | R=0.020 | V=0.31 in
H=1.02 | R=0.031 | V=0.47 in



PM50+HOLDER NEEDED

85°

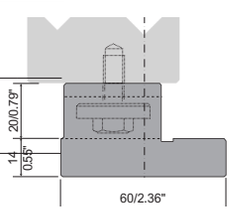
SU034

Support

C45: 560-710 N/mm²

830 mm	*32.67"*	9.0 kg
415 mm	*16.34"*	4.5 kg

H=34 mm
H=1.34 in



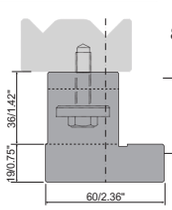
SU055

Support

C45: 560-710 N/mm²

830 mm	*32.67"*	14.0 kg
415 mm	*16.34"*	7.2 kg

H=55 mm
H=2.17 in



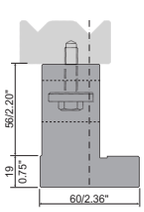
SU075

Support

C45: 560-710 N/mm²

830 mm	*32.67"*	20.5 kg
415 mm	*16.34"*	10.0 kg

H=75 mm
H=2.95



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

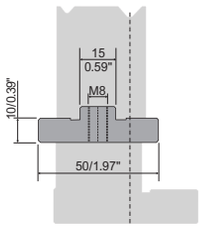
PM50

SUPPORT

C45: 560-710 N/mm²

835 mm	*32.87"*	4.0 kg
415 mm	*16.34"*	3.7 kg

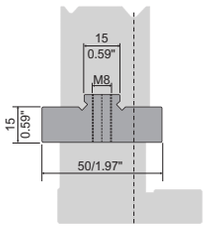
H=15 mm
H=0.59 in



PM50.20

SUPPORT

C45: 560-710 N/mm²



835 mm	*32.87"*	5.4 kg
415 mm	*16.34"*	2.6 kg

H=20 mm
H=0.79 in

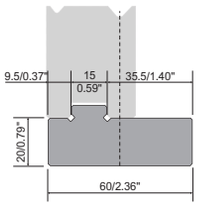
PM60

SUPPORT

C45: 560-710 N/mm²

835 mm	*32.87"*	7.5 kg
415 mm	*16.34"*	3.7 kg

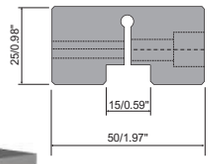
H=25 mm
H=0.98 in



PB60

SUPPORT

Fe37: 370-470 N/mm²



0.2 kg

H=25 mm
H=0.98 in

SU61F

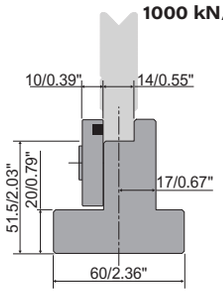
SUPPORT

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	16.0 kg
415 mm	*16.34"*	7.3 kg

H=61.5 mm

H=2.42 in



08000

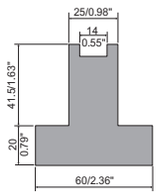
SUPPORT

C45: 560-710 N/mm² **950 kN/m max.**

1050 mm	*41.34"*	14.0 kg

H=61.5 mm

H=2.42 in



08100

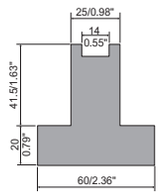
SUPPORT

C45: 560-710 N/mm² **950 kN/m max.**

1260 mm	*49.61"*	14.0 kg

H=61.5 mm

H=2.42 in



BENDING HANDBOOK

The Bending handbook target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.
Visit rolleriools.com to find out more about the handbook

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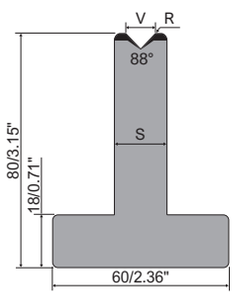
H=80 MM - *3.15"*

C45: 560-710 N/mm² **1000 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T80.06.88	6 mm	*0,24"*	0.4 mm	*0.015"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
TR80.06.88	6 mm	*0,24"*	2.75 mm	*0.108"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.88	8 mm	*0,31"*	0.5 mm	*0.019"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
TR80.08.88	8 mm	*0,31"*	2.75 mm	*0.108"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.10.88	10 mm	*0,39"*	0.8 mm	*0.031"*	18 mm	*0.71"*	14.2 kg	7.1 kg	13.5 kg	13.7 kg
TR80.10.88	10 mm	*0,39"*	2.75 mm	*0.108"*	18 mm	*0.71"*	15.0 kg	7.5 kg	15.0 kg	15.0 kg
T80.12.88	12 mm	*0,47"*	2.75 mm	*0.108"*	18 mm	*0.71"*	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.16.88	16 mm	*0,63"*	2.75 mm	*0.108"*	24 mm	*0.94"*	16.6 kg	8.3 kg	15.8 kg	16.0 kg
T80.20.88	20 mm	*0,79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	18.5 kg	9.2 kg	17.6 kg	17.8 kg
T80.25.88	25 mm	*0,98"*	3.0 mm	*0.118"*	35 mm	*1.38"*	20.2 kg	10.0 kg	19.2 kg	19.5 kg

88°>

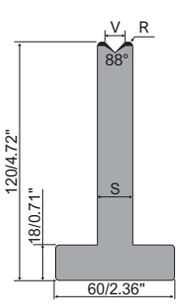


H=120 MM - *4.72"*

C45: 560-710 N/mm² **1000 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T120.06.88	6 mm	*0,24"*	0.4 mm	*0.015"*	14 mm	*0.55"*	16.5 kg	8.2 kg	15.7 kg	15.9 kg
TR120.06.88	6 mm	*0,24"*	2.75 mm	*0.108"*	14 mm	*0.55"*	16.0 kg	8.0 kg	15.2 kg	16.0 kg
T120.08.88	8 mm	*0,31"*	0.5 mm	*0.019"*	14 mm	*0.55"*	16.5 kg	8.2 kg	15.7 kg	15.9 kg
TR120.08.88	8 mm	*0,31"*	2.75 mm	*0.108"*	14 mm	*0.55"*	16.0 kg	8.0 kg	15.2 kg	16.0 kg
T120.10.88	10 mm	*0,39"*	0.8 mm	*0.031"*	18 mm	*0.71"*	19.0 kg	9.4 kg	18.1 kg	18.3 kg
TR120.10.88	10 mm	*0,39"*	2.75 mm	*0.108"*	18 mm	*0.71"*	18.0 kg	9.0 kg	18.0 kg	18.0 kg
T120.12.88	12 mm	*0,47"*	2.75 mm	*0.108"*	18 mm	*0.71"*	18.9 kg	9.4 kg	18.1 kg	18.3 kg
T120.16.88	16 mm	*0,63"*	2.75 mm	*0.108"*	24 mm	*0.94"*	22.0 kg	10.9 kg	20.9 kg	21.2 kg
T120.20.88	20 mm	*0,79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	27.0 kg	13.4 kg	25.7 kg	26.0 kg
T120.25.88	25 mm	*0,98"*	3.0 mm	*0.118"*	35 mm	*1.38"*	30.0 kg	14.9 kg	28.6 kg	28.9 kg

88°



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

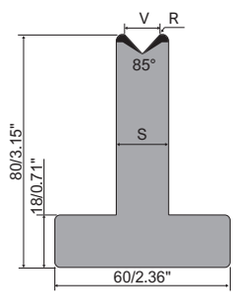
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

H=80 MM - *3.15"*

C45: 560-710 N/mm² **1000 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T80.06.85	6 mm	*0.24"*	2.75 mm	*0.108"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.85	8 mm	*0.31"*	2.75 mm	*0.108"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.10.85	10 mm	*0.39"*	2.75 mm	*0.108"*	18 mm	*0.71"*	14.2 kg	7.1 kg	13.5 kg	13.7 kg
T80.12.85	12 mm	*0.47"*	2.75 mm	*0.108"*	18 mm	*0.71"*	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.16.85	16 mm	*0.63"*	2.75 mm	*0.108"*	24 mm	*0.94"*	16.6 kg	8.3 kg	15.8 kg	16.0 kg
T80.20.85	20 mm	*0.79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	18.5 kg	9.2 kg	17.6 kg	17.8 kg
T80.25.85	25 mm	*0.98"*	3.0 mm	*0.118"*	35 mm	*1.38"*	20.2 kg	10.0 kg	19.2 kg	19.5 kg

85°>

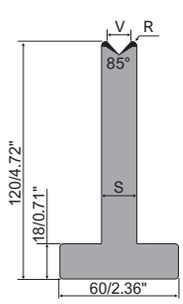


H=120 MM - *4.72"*

C45: 560-710 N/mm² **1000 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T120.06.85	6 mm	*0.24"*	2.75 mm	*0.108"*	14 mm	*0.55"*	16.3 kg	8.1 kg	15.7 kg	15.7 kg
T120.08.85	8 mm	*0.31"*	2.75 mm	*0.108"*	14 mm	*0.55"*	16.3 kg	8.1 kg	15.7 kg	15.7 kg
T120.10.85	10 mm	*0.39"*	2.75 mm	*0.108"*	18 mm	*0.71"*	19.0 kg	9.5 kg	19.0 kg	19.0 kg
T120.12.85	12 mm	*0.47"*	2.75 mm	*0.108"*	18 mm	*0.71"*	18.9 kg	9.4 kg	18.2 kg	18.2 kg
T120.16.85	16 mm	*0.63"*	2.75 mm	*0.108"*	24 mm	*0.94"*	22.7 kg	11.3 kg	21.9 kg	21.9 kg
T120.20.85	20 mm	*0.79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	26.4 kg	13.0 kg	25.5 kg	25.5 kg
T120.25.85	25 mm	*0.98"*	3.0 mm	*0.118"*	35 mm	*1.38"*	30.0 kg	15.0 kg	30.0 kg	30.0 kg

85°



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

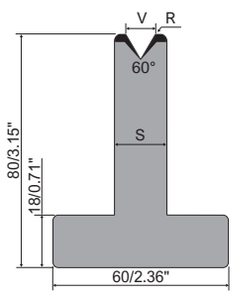
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

H=80 MM - *3.15"*

C45: 560-710 N/mm² **600 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T80.06.60	6 mm	*0,24"*	0.5 mm	*0.019"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
TR80.06.60	6 mm	*0,24"*	1.5 mm	*0.59"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.60	8 mm	*0,31"*	0.8 mm	*0.031"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
TR80.08.60	8 mm	*0,31"*	1.5 mm	*0.59"*	14 mm	*0.55"*	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.10.60	10 mm	*0,39"*	0.8 mm	*0.031"*	18 mm	*0.71"*	14.9 kg	7.4 kg	14.2 kg	14.4 kg
TR80.10.60	10 mm	*0,39"*	2.75 mm	*0.108"*	18 mm	*0.71"*	15.0 kg	7.5 kg	15.0 kg	15.0 kg
T80.12.60	12 mm	*0,47"*	0.8 mm	*0.031"*	18 mm	*0.71"*	14.9 kg	7.4 kg	14.2 kg	14.4 kg
TR80.12.60	12 mm	*0,47"*	2.75 mm	*0.108"*	18 mm	*0.71"*	15.0 kg	7.5 kg	15.0 kg	15.0 kg
T80.16.60	16 mm	*0,63"*	2.75 mm	*0.108"*	24 mm	*0.94"*	16.1 kg	8.0 kg	15.3 kg	15.5 kg
T80.20.60	20 mm	*0,79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T80.25.60	25 mm	*0,98"*	3.0 mm	*0.118"*	35 mm	*1.38"*	19.5 kg	9.7 kg	18.6 kg	18.8 kg

60°>

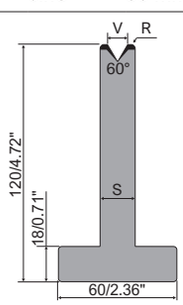


H=120 MM - *4.72"*

C45: 560-710 N/mm² **600 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T120.06.60	6 mm	*0,24"*	0.5 mm	*0.019"*	14 mm	*0.55"*	16.0 kg	8.0 kg	15.2 kg	15.4 kg
TR120.06.60	6 mm	*0,24"*	1.5 mm	*0.59"*	14 mm	*0.55"*	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.60	8 mm	*0,31"*	0.8 mm	*0.031"*	14 mm	*0.55"*	16.0 kg	8.0 kg	16.0 kg	16.0 kg
TR120.08.60	8 mm	*0,31"*	1.5 mm	*0.59"*	14 mm	*0.55"*	16.0 kg	8.0 kg	16.0 kg	16.0 kg
T120.10.60	10 mm	*0,39"*	0.8 mm	*0.031"*	18 mm	*0.71"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
TR120.10.60	10 mm	*0,39"*	2.75 mm	*0.108"*	18 mm	*0.71"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T120.12.60	12 mm	*0,47"*	0.8 mm	*0.031"*	18 mm	*0.71"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
TR120.12.60	12 mm	*0,47"*	2.75 mm	*0.108"*	18 mm	*0.71"*	18.0 kg	9.0 kg	17.1 kg	17.4 kg
T120.16.60	16 mm	*0,63"*	2.75 mm	*0.108"*	24 mm	*0.94"*	22.4 kg	11.1 kg	21.3 kg	21.6 kg
T120.20.60	20 mm	*0,79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	26.0 kg	12.9 kg	24.8 kg	25.1 kg
T120.25.60	25 mm	*0,98"*	3.0 mm	*0.118"*	35 mm	*1.38"*	28.5 kg	14.2 kg	27.1 kg	27.5 kg

60°



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

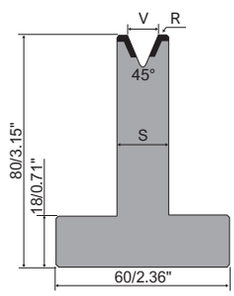
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

H=80 MM - *3.15"*

C45: 560-710 N/mm² **500 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T80.06.45	6 mm	*0.24"*	0.8 mm	*0.031"*	14 mm	*0.55"*	12.6 kg	6.3 kg	12.0 kg	12.1 kg
T80.08.45	8 mm	*0.31"*	1.0 mm	*0.039"*	18 mm	*0.55"*	14.2 kg	7.1 kg	13.5 kg	13.7 kg
T80.10.45	10 mm	*0.39"*	1.2 mm	*0.047"*	18 mm	*0.55"*	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.12.45	12 mm	*0.47"*	1.6 mm	*0.062"*	24 mm	*0.94"*	16.2 kg	8.1 kg	15.4 kg	15.6 kg
T80.16.45	16 mm	*0.63"*	2.75 mm	*0.108"*	26 mm	*1.02"*	16.6 kg	8.3 kg	15.8 kg	16.0 kg
T80.20.45	20 mm	*0.79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T80.25.45	25 mm	*0.98"*	3.0 mm	*0.118"*	37 mm	*1.45"*	20.0 kg	9.9 kg	19.0 kg	19.3 kg

45°>

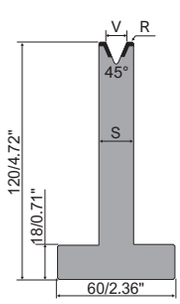


H=120 MM - *4.72"*

C45: 560-710 N/mm² **500 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T120.06.45	6 mm	*0.24"*	0.8 mm	*0.031"*	14 mm	*0.55"*	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.45	8 mm	*0.31"*	1.0 mm	*0.039"*	18 mm	*0.55"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T120.10.45	10 mm	*0.39"*	1.2 mm	*0.047"*	18 mm	*0.55"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T120.12.45	12 mm	*0.47"*	1.6 mm	*0.062"*	24 mm	*0.94"*	22.9 kg	11.4 kg	21.8 kg	22.1 kg
T120.16.45	16 mm	*0.63"*	2.75 mm	*0.108"*	26 mm	*1.02"*	25.0 kg	12.4 kg	23.8 kg	24.1 kg
T120.20.45	20 mm	*0.79"*	3.0 mm	*0.118"*	30 mm	*1.18"*	26.0 kg	12.9 kg	24.8 kg	25.1 kg
T120.25.45	25 mm	*0.98"*	3.0 mm	*0.118"*	37 mm	*1.45"*	30.0 kg	14.9 kg	28.6 kg	28.9 kg

45°



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

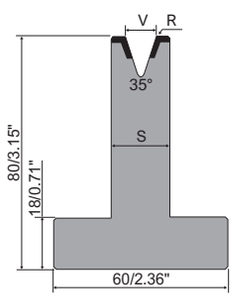
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

H=80 MM - *3.15"*

C45: 560-710 N/mm²

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	kN/m max.	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T80.06.35	6 mm	*0,24"*	0.8 mm	*0.031"*	14 mm	*0.55"*	**350**	12.5 kg	6.2 kg	11.9 kg	12.1 kg
T80.08.35	8 mm	*0,31"*	1.0 mm	*0.039"*	16 mm	*0.63"*	**350**	13.0 kg	6.5kg	12.4 kg	12.5 kg
T80.10.35	10 mm	*0,39"*	1.2 mm	*0.047"*	20 mm	*0.78"*	**400**	14.7 kg	7.3 kg	14.0 kg	14.2 kg
T80.12.35	12 mm	*0,47"*	1.6 mm	*0.062"*	22 mm	*0.86"*	**400**	15.5 kg	7.7 kg	14.8 kg	14.9 kg
T80.16.35	16 mm	*0,63"*	3.0 mm	*0.118"*	30 mm	*1.18"*	**450**	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T80.20.35	20 mm	*0,79"*	3.0 mm	*0.118"*	35 mm	*1.37"*	**500**	19.3 kg	9.6 kg	18.4 kg	18.6 kg
T80.25.35	25 mm	*0,98"*	3.0 mm	*0.118"*	40 mm	*1.57"*	**500**	20.0 kg	9.0 kg	19.0 kg	19.3 kg

35°>

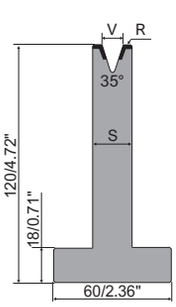


H=120 MM - *4.72"*

C45: 560-710 N/mm²

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	kN/m max.	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T120.06.35	6 mm	*0,24"*	0.8 mm	*0.031"*	14 mm	*0.55"*	**350**	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.35	8 mm	*0,31"*	1.0 mm	*0.039"*	16 mm	*0.63"*	**350**	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T120.10.35	10 mm	*0,39"*	1.2 mm	*0.047"*	20 mm	*0.78"*	**400**	19.9 kg	9.9 kg	18.9 kg	19.2 kg
T120.12.35	12 mm	*0,47"*	1.6 mm	*0.062"*	22 mm	*0.86"*	**400**	21.0 kg	10.4 kg	20.0 kg	20.2 kg
T120.16.35	16 mm	*0,63"*	3.0 mm	*0.118"*	30 mm	*1.18"*	**450**	25.8 kg	12.8 kg	24.6 kg	24.9 kg
T120.20.35	20 mm	*0,79"*	3.0 mm	*0.118"*	35 mm	*1.37"*	**500**	28.0 kg	13.9 kg	26.7 kg	27.0 kg
T120.25.35	25 mm	*0,98"*	3.0 mm	*0.118"*	40 mm	*1.57"*	**500**	30.5 kg	15.2 kg	29.0 kg	29.4 kg

35°



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

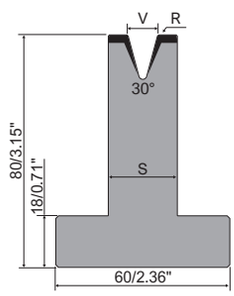
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

H=80 MM - *3.15"*

C45: 560-710 N/mm²

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	kN/m max.	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T80.06.30	6 mm	*0.24"*	0.6 mm	*0.023"*	14 mm	*0.55"*	**350**	12.4 kg	6.2 kg	11.8 kg	12.0 kg
T80.08.30	8 mm	*0.31"*	0.8 mm	*0.031"*	18 mm	*0.55"*	**350**	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.10.30	10 mm	*0.39"*	1.0 mm	*0.039"*	24 mm	*0.94"*	**500**	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T80.12.30	12 mm	*0.47"*	1.5 mm	*0.059"*	24 mm	*0.94"*	**400**	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T80.16.30	16 mm	*0.63"*	2.0 mm	*0.078"*	30 mm	*1.18"*	**450**	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T80.20.30	20 mm	*0.79"*	2.5 mm	*0.098"*	35 mm	*1.37"*	**500**	19.0 kg	9.4 kg	18.1 kg	18.3 kg
T80.25.30	25 mm	*0.98"*	3.0 mm	*0.118"*	40 mm	*1.57"*	**500**	19.6 kg	9.7 kg	18.7 kg	18.9 kg

30°>

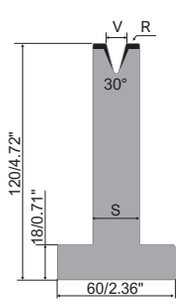


H=120 MM - *4.72"*

C45: 560-710 N/mm²

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	kN/m max.	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T120.06.30	6 mm	*0.24"*	0.6 mm	*0.023"*	14 mm	*0.55"*	**350**	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.30	8 mm	*0.31"*	0.8 mm	*0.031"*	18 mm	*0.55"*	**350**	19.0 kg	9.4 kg	18.1 kg	18.3 kg
T120.10.30	10 mm	*0.39"*	1.0 mm	*0.039"*	18 mm	*0.55"*	**500**	22.0 kg	10.9 kg	20.9 kg	21.2 kg
T120.12.30	12 mm	*0.47"*	1.5 mm	*0.059"*	24 mm	*0.94"*	**400**	22.0 kg	10.9 kg	20.9 kg	21.2 kg
T120.16.30	16 mm	*0.63"*	2.0 mm	*0.078"*	26 mm	*1.02"*	**450**	25.8 kg	12.8 kg	24.6 kg	24.9 kg
T120.20.30	20 mm	*0.79"*	2.5 mm	*0.098"*	30 mm	*1.18"*	**500**	28.0 kg	13.9 kg	26.7 kg	27.0 kg
T120.25.30	25 mm	*0.98"*	3.0 mm	*0.118"*	37 mm	*1.45"*	**500**	30.5 kg	15.2 kg	29.0 kg	29.4 kg

30°



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

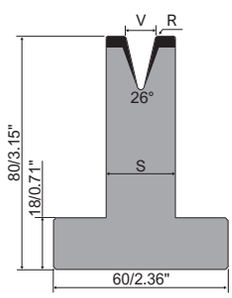
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

H=80 MM - *3.15"*

C45: 560-710 N/mm² **200 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T80.06.26	6 mm	*0,24"*	0.8 mm	*0.031"*	16 mm	*0.63"*	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.08.26	8 mm	*0,31"*	1.0 mm	*0.039"*	20 mm	*0.78"*	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.10.26	10 mm	*0,39"*	1.2 mm	*0.047"*	24 mm	*0.94"*	15.5 kg	7.7 kg	14.8 kg	14.9 kg
T80.12.26	12 mm	*0,47"*	1.6 mm	*0.062"*	26 mm	*1.02"*	16.6 kg	8.3 kg	15.8 kg	16.0 kg

26°>

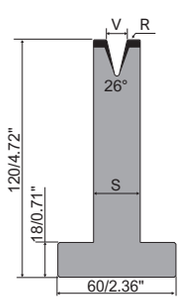


H=120 MM - *4.72"*

C45: 560-710 N/mm² **200 kN/m max.**

	V [mm]	*V ["]*	R [mm]	*R ["]*	S [mm]	S ["]	835 mm *32.87"*	415 mm *16.34"*	FX 795 mm *31.29"*	F 805 mm *31.69"*
T120.06.26	6 mm	*0,24"*	0.8 mm	*0.031"*	16 mm	*0.63"*	18.0 kg	8.9 kg	17.1 kg	17.4 kg
T120.08.26	8 mm	*0,31"*	1.0 mm	*0.039"*	20 mm	*0.78"*	19.0 kg	9.4 kg	18.1 kg	18.3 kg
T120.10.26	10 mm	*0,39"*	1.2 mm	*0.047"*	24 mm	*0.94"*	22.0 kg	10.9 kg	20.9 kg	21.2 kg
T120.12.26	12 mm	*0,47"*	1.6 mm	*0.062"*	26 mm	*1.02"*	23.4 kg	11.6 kg	22.3 kg	22.6 kg

26°



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

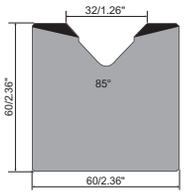
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

M60.85.32

C45: 560-710 N/mm² **1000 kN/m max.**

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

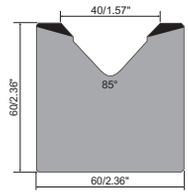
H=60 | R=4 | V=32 mm
H=2.36 | R=0.157 | V=1.26 in



85°>

M60.85.40

C45: 560-710 N/mm² **1000 kN/m max.**



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

H=60 | R=4 | V=40 mm
H=2.36 | R=0.157 | V=1.57 in

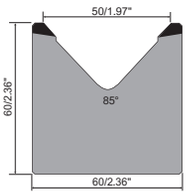
85°

M60.85.50

C45: 560-710 N/mm² **1000 kN/m max.**

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

H=60 | R=4 | V=50 mm
H=2.36 | R=0.157 | V=1.97 in



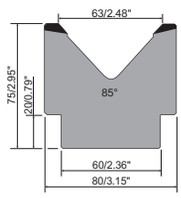
85°

M75.85.63

C45: 560-710 N/mm² **1000 kN/m max.**

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

H=75 | R=5 | V=63 mm
H=2.36 | R=0.197 | V=2.48 in



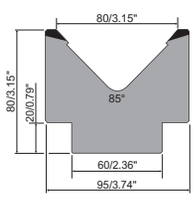
85°

M80.85.80

C45: 560-710 N/mm² **1000 kN/m max.**

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

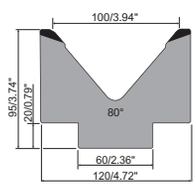
H=60 | R=6 | V=80 mm
H=2.36 | R=0.236 | V=3.15 in



85°

M95.80.100

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



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

H=60 | R=8 | V=100 mm
H=2.36 | R=0.315 | V=3.94 in

80°>

FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

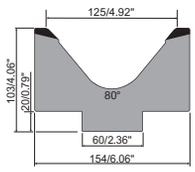
MK103.80.125

C45: 560-710 N/mm² **700 kN/m max.**

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

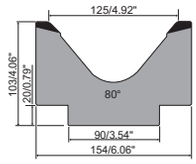
H=103 | R=15 | V=125 mm
H=4.06 | R=0.591 | V=4.92 in

80°



M103.80.125

C45: 560-710 N/mm² **1000 kN/m max.**



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

H=103 | R=15 | V=125 mm
H=4.06 | R=0.591 | V=4.92 in

80°

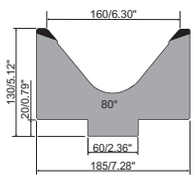
MK130.80.160

C45: 560-710 N/mm² **700 kN/m max.**

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

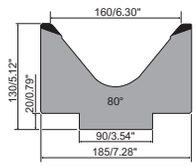
H=130 | R=10 | V=160 mm
H=5.12 | R=0.394 | V=6.30 in

80°



M130.80.160

C45: 560-710 N/mm² **1000 kN/m max.**



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

H=130 | R=10 | V=160 mm
H=5.12 | R=0.394 | V=6.30 in

80°

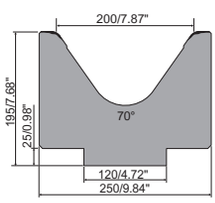
M195.70.200

42Cr: 900-1150 N/mm2 **1800 kN/m max.**

415 mm	*16.34"*	104.0 kg

H=195 | R=15 | V=200 mm
H=7.68 | R=0.591 | V=7.87 in

70°>



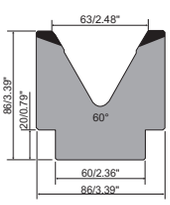
M86.60.63

C45: 560-710 N/mm² **1000 kN/m max.**

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

H=85 | R=5 | V=63 mm
H=3.39 | R=0.197 | V=2.48 in

60°>



FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

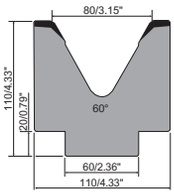
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

M110.60.80

C45: 560-710 N/mm² **1000 kN/m max.**

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

H=110 | R=6 | V=80 mm
H=4.33 | R=0.236 | V=3.15 in



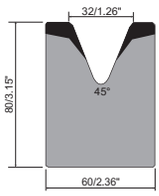
60°

M80.45.32

C45: 560-710 N/mm² **1000 kN/m max.**

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

H=80 | R=4 | V=32 mm
H=3.15 | R=0.157 | V=1.26 in



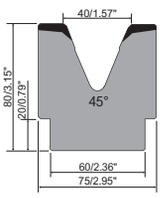
45°>

M80.45.40

C45: 560-710 N/mm² **1000 kN/m max.**

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

H=80 | R=4 | V=40 mm
H=3.15 | R=0.157 | V=1.57 in



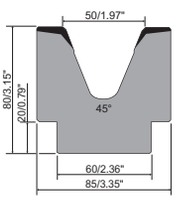
45°

M80.45.50

C45: 560-710 N/mm² **950 kN/m max.**

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

H=80 | R=4 | V=50 mm
H=3.15 | R=0.157 | V=1.97 in



45°

FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

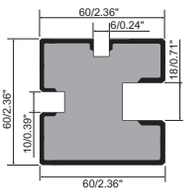
F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

M.360.R

C45: 560-710 N/mm² **1000 kN/m max.**

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

R=1.5 | V=6 mm	*R=0.059 | V=0.24 in*
R=2 | V=10 mm	*R=0.079 | V=0.39 in*
R=2 | V=18 mm	*R=0.118 | V=0.71 in*



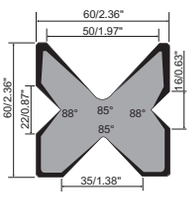
90°

M.460

C45: 560-710 N/mm² **800 kN/m max.**

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

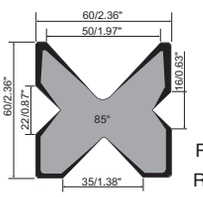
85° R=2 | V=35 mm	*R=0.079 | V=1.38 in*
85° R=3 | V=50 mm	*R=0.118 | V=1.97 in*
88° R=2 | V=16 mm	*R=0.079 | V=0.63 in*
88° R=3 | V=22 mm	*R=0.079 | V=2.36 in*



90°

M.460.R

C45: 560-710 N/mm² **800 kN/m max.**



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

R=2 | V=16 mm	*R=0.079 | V=0.63 in*
R=2 | V=35 mm	*R=0.079 | V=1.38 in*
R=2 | V=60 mm	*R=0.079 | V=2.36 in*
R=3 | V=22 mm	*R=0.118 | V=1.97 in*

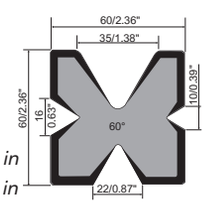
85°

M.460.60

C45: 560-710 N/mm² **600 kN/m max.**

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

R=1.5 | V=10 mm	*R=0.059 | V=0.39 in*
R=2.0 | V=16 mm	*R=0.079 | V=0.63 in*
R=2.5 | V=22 mm	*R=0.098 | V=0.87 in*
R=3.0 | V=35 mm	*R=0.118 | V=1.38 in*



85°

FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

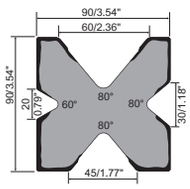
M.490

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	38.9 kg	
415 mm	*16.34"*	20.0 kg	
795 mm	*31.29"*	37.0 kg	FX
805 mm	*31.69"*	37.5 kg	F

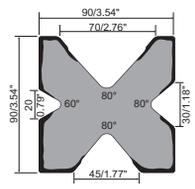
60° R=2 | V=20 mm *R=0.079 | V=0.79 in*
80° R=4 | V=30 mm *R=0.157 | V=1.18 in*
80° R=4 | V=45 mm *R=0.157 | V=1.77 in*
80° R=5 | V=60 mm *R=0.020 | V=2.36 in*

80°
60°



M.490.70

C45: 560-710 N/mm² **600 kN/m max.**



835 mm	*32.87"*	35.8 kg	
415 mm	*16.34"*	17.9 kg	
795 mm	*31.29"*	34.0 kg	FX
805 mm	*31.69"*	35.0 kg	F

60° R=2 | V=20 mm *R=0.079 | V=0.79 in*
80° R=4 | V=30 mm *R=0.157 | V=1.18 in*
80° R=4 | V=45 mm *R=0.157 | V=1.77 in*
80° R=5 | V=70 mm *R=0.020 | V=2.76 in*

80°
60°

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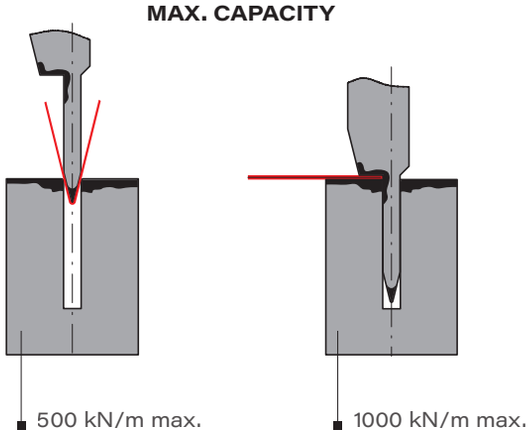
FX: 795 mm - *31.29"*
mm: 100-250-20-25-30-35-40-45-50-200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

F: 805 mm - *31.69"*
mm: 200-50-40-20-15-10-370-100
in: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

.hemming dies CLASSIC Series >>

Hemming tools are used to prebend and afterwards flatten a sheet metal edge by using the same tool set.
Thanks to this operation you can strengthen sheet metal edges and avoid burr on their external side. For this reason, this operation is especially used for safety reason, **in order to avoid operators' accidental injuries which may occurr to those who have to handle sheet metal parts**.
The maximum sheet metal thickness usually recommended for this operation is 3mm mild steel and 2mm stainless steel. However, for thicker sheet metal special solutions can be proposed, which consider the necessary bending force involved to flatten.
There are 2 types of flattening: partial flattening and total flattening.
Partial flattening is a kind of flattening which doesn't win against the sheet metal springback. For this reason, if you measure the flattened point, it won't be twice the sheet metal thickness but a bigger measure; for example, if you flatten 1.5mm partially, the flattened point will be about 4mm. This dimension depends on the bending force only. Hence, if you want to flatten 1.5mm mild steel and get 3mm high flattened point, you have to increase the tonnage. In the table below you can check the necessary tonnage according to sheet metal thickness and type.
The choice of hemming tools should be influenced by the sheet metal type to be flattened; 35° punch and dies are recommended to flatten aluminium and mild steel, which have small springback, whereas more resitant sheet metal types like stainless steel require at least 30°, or better 26°, punch and die.
Springback control is fundamental to win against sheet metal resistance during the flattening phase. In fact, if the angle obtained during the pre-bending phase is too wide, sheet metal will slip towards the operator during the flattening phase.
In case you want to flatten sheet metal by using spring-loaded or pneumatic hemming dies, the chosen punch must have exactly the same angle of the die. Such dies are available in 835mm and 415mm length and they cannot be sectioned.
The choice of TOP Series hemming tools with dies with U shape opening has to take into consideration the fact that the U opening of the die has to match perfectly with the punch tip width. These tools are 525mm long and the sectioned set is also available.

MAX. CAPACITY



S mm	S *in*	A mm	A *in*	R.420 N/ mm² kN/m	R.700 N/ mm² kN/m
0.60	*0.02*	3.0	*0.12*	90	150
0.80	*0.03*	3.0	*0.12*	120	200
1.00	*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
0.60	*0.02*	1.2	*0.05*	230	350
0.80	*0.03*	1.6	*0.06*	320	500
1.00	*0.04*	1.0	*0.04*	400	600
1.25	*0.05*	2.5	*0.10*	500	800

BENDING HANDBOOK
The Bending handbook target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.
Visit rolleriools.com to find out more about the handbook

TOP.SM-134.28.8

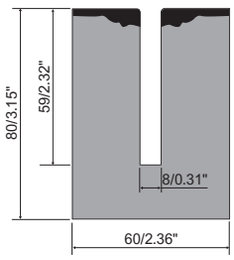
42Cr: 900-1150 N/mm2 **500-1000 kN/m max.**

525 mm	20.67"	17.5 kg	
495 mm	19.49"	16.5 kg	FC

H=80 | R=1 | V=8 mm

H=3.15 | R=0.039 | V=0.31 in

TO USE WITH:
TOP.SP.134.28.8



TOP.SM-134.24.8

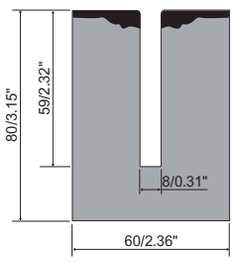
42Cr: 900-1150 N/mm2 **500-1000 kN/m max.**

525 mm	20.67"	16.5 kg	
495 mm	19.49"	16.5 kg	FC

H=80 | R=1 | V=8 mm

H=3.15 | R=0.039 | V=0.31 in

TO USE WITH:
TOP.SP.134.24.8



TOP.SM-134.24.10

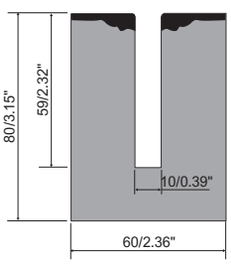
42Cr: 900-1150 N/mm2 **500-1000 kN/m max.**

525 mm	20.67"	18.0 kg	
495 mm	19.49"	16.9 kg	FC

H=80 | R=1 | V=10 mm

H=3.15 | R=0.039 | V=0.39 in

TO USE WITH:
TOP.SP.134.24.10



TOP.SM-134.24.12

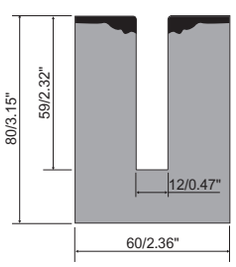
42Cr: 900-1150 N/mm2 **500-1000 kN/m max.**

525 mm	20.67"	16.8 kg	
495 mm	19.49"	15.9 kg	FC

H=80 | R=1 | V=12 mm

H=3.15 | R=0.039 | V=0.47 in

TO USE WITH:
TOP.SP.134.24.12



FC: 495 mm - *19.48"*
mm: 25-30-35-40-45-50-100-170
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84

.spring-loaded hemming dies CLASSIC Series >>

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
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.420 N/ mm² kN/m	R.700 N/ mm² kN/m
0.6	*0.02*	3.0	*0.12*	230	350
0.8	*0.03*	3.0	*0.12*	320	500
1.0	*0.04*	3.5	*0.14*	400	600
1.25	*0.05*	3.5	*0.14*	500	800
1.5	*0.06*	4.6	*0.18*	630	950
2.0	*0.08*	5.5	*0.22*	800	1300
2.5	*0.10*	6.5	*0.26*	900	-
3.0	*0.12*	8.0	*0.31*	1000	-

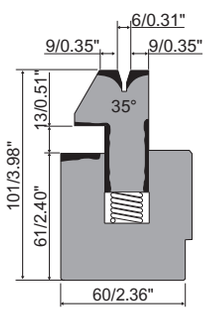
S101.35.06

C45: 560-710 N/mm² **600 kN/m max.**

835 mm *32.87"* 30.0 kg
415 mm *16.34"* 15.4 kg

H=101 | R=1 | V=6 mm
H=3.98 | R=0.039 | V=0.24 in

35°>



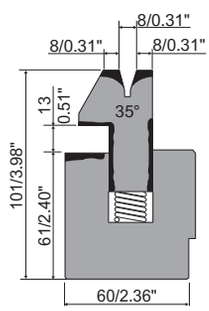
S101.35.08

C45: 560-710 N/mm² **600 kN/m max.**

835 mm *32.87"* 30.0 kg
415 mm *16.34"* 15.4 kg

H=101 | R=1 | V=8 mm
H=3.98 | R=0.039 | V=0.31 in

35°



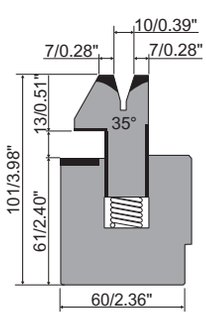
S101.35.10

C45: 560-710 N/mm² **600 kN/m max.**

835 mm *32.87"* 30.0 kg
415 mm *16.34"* 15.5 kg

H=101 | R=1 | V=10 mm
H=3.98 | R=0.039 | V=0.39 in

35°



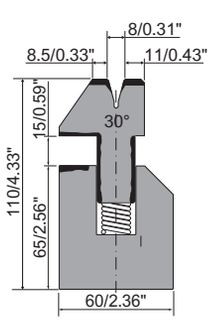
S110.30.08

C45: 560-710 N/mm² **800 kN/m max.**

835 mm *32.87"* 30.0 kg
415 mm *16.34"* 15.4 kg

H=110 | R=1.5 | V=8 mm
H=4.33 | R=0.059 | V=0.31 in

30°>



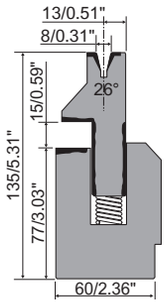
S135.26.08

42Cr: 900-1150 N/mm2 **400 kN/m max.**

835 mm	*32.87"*	39.8 kg
415 mm	*16.34"*	21.0 kg

H=135 | R=1.5 | V=8 mm
H=5.31 | R=0.059 | V=0.31 in

26°>



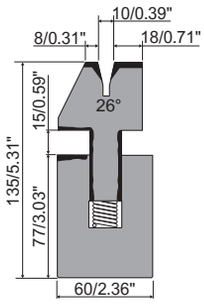
S135.26.10

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	41.5 kg
415 mm	*16.34"*	20.7 kg

H=135 | R=1.5 | V=10 mm
H=5.31 | R=0.059 | V=0.39 in

26°



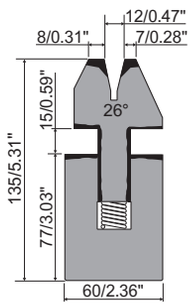
SA135.26.12

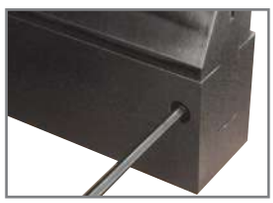
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	41.0 kg
415 mm	*16.34"*	20.5 kg

H=135 | R=2 | V=12 mm
H=5.31 | R=0.079 | V=0.47 in

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.

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
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.420 N/ mm² kN/m	R.700 N/ mm² kN/m
0.6	0.02	3.0	0.12	230	350
0.8	0.03	3.0	0.12	320	500
1.0	0.04	3.5	0.14	400	600
1.25	0.05	3.5	0.14	500	800
1.5	0.06	4.6	0.18	630	950
2.0	0.08	5.5	0.22	800	1300
2.5	0.10	6.5	0.26	900	-
3.0	0.12	8.0	0.31	1000	-

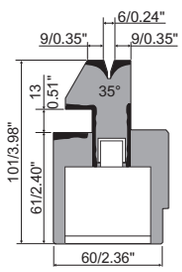
S101PN.35.06

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	30.0 kg
415 mm	*16.34"*	15.5 kg

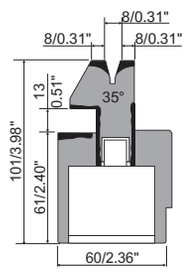
H=101 | R=1 | V=6 mm
H=3.98 | R=0.039 | V=0.24 in

35°>



S101PN.35.08

C45: 560-710 N/mm² **600 kN/m max.**



835 mm	*32.87"*	31.0 kg
415 mm	*16.34"*	15.5 kg

H=101 | R=1 | V=8 mm
H=3.98 | R=0.039 | V=0.31 in

35°

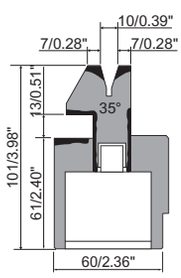
S101PN.35.10

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	29.0 kg
415 mm	*16.34"*	15.5 kg

H=101 | R=1 | V=10 mm
H=3.98 | R=0.039 | V=0.39 in

35°



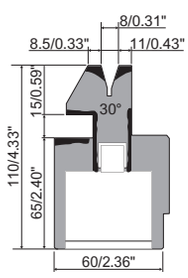
S110PN.30.08

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	30.0 kg
415 mm	*16.34"*	15.0 kg

H=110 | R=1.5 | V=8 mm
H=4.33 | R=0.059 | V=0.31 in

30°



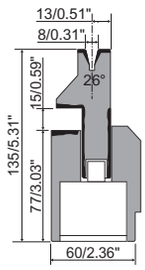
S135PN.26.08

42Cr:900-1150 N/mm2 **400 kN/m max.**

835 mm	*32.87"*	39.8 kg
415 mm	*16.34"*	21.2 kg

H=135 | R=1.5 | V=8 mm
H=5.31 | R=0.059 | V=0.31 in

26°>



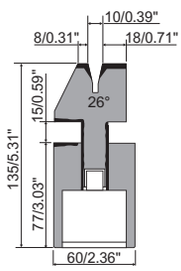
S135PN.26.10

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	41.5 kg
415 mm	*16.34"*	20.7 kg

H=135 | R=1.5 | V=10 mm
H=5.31 | R=0.059 | V=0.39 in

26°



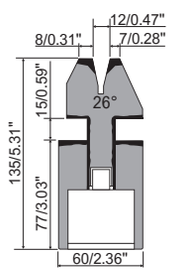
SA135PN.26.12

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	41.5 kg
415 mm	*16.34"*	20.5 kg

H=135 | R=2 | V=12 mm
H=5.31 | R=0.079 | V=0.47 in

26°



KPN

1 kg

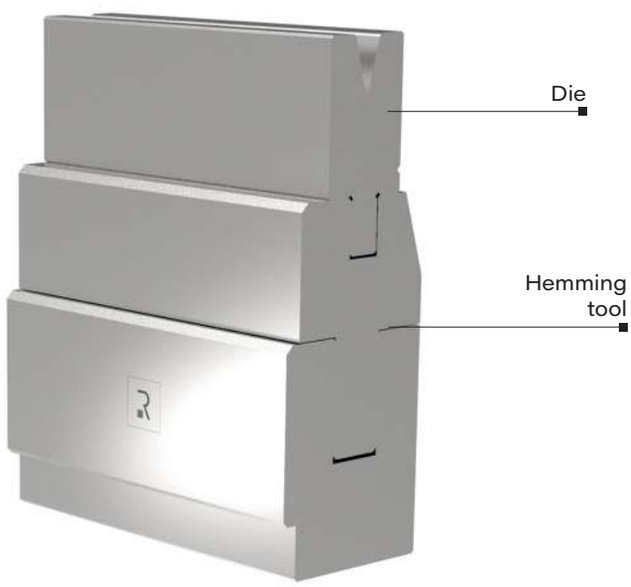
KPN kit for pneumatic hemming dies is a device which opens and closes the hemming die automatically. KPN contains an electrovalve which receives the impulse directly by the press brake CNC and, according to the impulse, it opens and closes air supply to the system.
Such feature is very important as it enables operators to improve the bending sequence safely and time-saving.

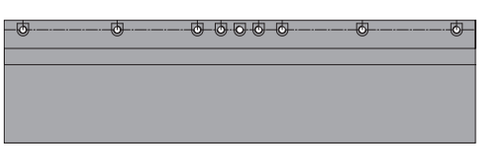
.pneumatic hemming table with interchangeable V CLASSIC Series >>

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
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.420 N/ mm² kN/m	R.700 N/ mm² kN/m
0.6	*0.02*	3.0	*0.12*	230	350
0.8	*0.03*	3.0	*0.12*	320	500
1.0	*0.04*	3.5	*0.14*	400	600
1.25	*0.05*	3.5	*0.14*	500	800
1.5	*0.06*	4.6	*0.18*	630	950
2.0	*0.08*	5.5	*0.22*	800	1300
2.5	*0.10*	6.5	*0.26*	900	-
3.0	*0.12*	8.0	*0.31*	1000	-

The new system TOP.SC.130 and TOP.SC.130PN has been designed to flatten sheet metal thicker than 2mm, depending on press brake force.
Dies SM55.12.30 and SM55.14.30 can be used with this new system, as they are made of 42CrMo4, have a wider body and can bear up to 1000kN/m. Flattening with close counterbends has never been so easy.
Dies are interchangeable and have R2 13mm tang.
All standard dies can be mounted with TOP.SC.130.
They are fixed by screws positioned on the operator's side.
A very important feature is hemming die opening: being 18mm, prebent sheet metal can be easily positioned and flattened without any risk to be slided out. Standard length is 500mm and hemming dies are available in 2 versions: manual with springs or pneumatic and press brake CNC driven.
The ideal punch to be used with this system is TOP150.30.R12.





KPN kit for pneumatic hemming dies is a device which opens and closes the hemming die automatically. KPN contains an electrovalve which receives the impulse directly by the press brake CNC and, according to the impulse, it opens and closes air supply to the system. Such feature is very important as it enables operators to improve the bending sequence safely and time-saving.

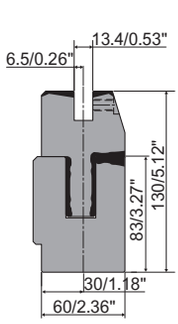
TOP.SC.130

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

500 mm *19.68"* 39.8 kg

H=130 mm
H=5.12 in

SPRING-LOADED HEMMING DIES TO USE WITH:
TOP150.30.R12



TOP.SC.130PN

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

500 mm *19.68"* 39.8 kg

H=130 mm
H=5.12 in

PNEUMATIC HEMMING DIES TO USE WITH:
TOP150.30.R12

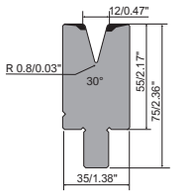
SM55.12.30/C

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

1000 mm	*39.37"*	16.0 kg	
500 mm	*19.68"*	8.0 kg	
1100 mm	*43.31"*	17.6 kg	F

30°>

TO USE WITH:
TOP.SC.130
TOP.SC.130PN



SM55.14.30/C

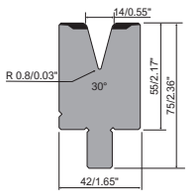
42Cr:900-1150 N/mm2 **600 kN/m max.**

1000 mm	*39.37"*	19.0 kg	
500 mm	*19.68"*	9.5 kg	
1100 mm	*43.31"*	20.9 kg	F

W=55 | H=75 | R=3.0 | V=14 mm
W=2.17 | H=2.36 | R=0.12 | V=0.55 in

30°

TO USE WITH:
TOP.SC.130
TOP.SC.130PN



BMR55.06.30/C

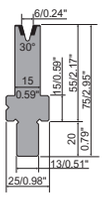
42Cr:900-1150 N/mm2 **350 kN/m max.**

500 mm *19.68"* 4.0 kg

W=55 | H=75 | R=0.6 | V=6 mm
W=2.17 | H=2.36 | R=0.024 | V=0.24 in

30°

TO USE WITH:
TOP.SC.130
TOP.SC.130PN



BMR55.08.30/C

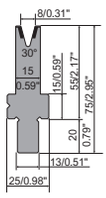
42Cr:900-1150 N/mm2 **200 kN/m max.**

500 mm *19.68"* 4.0 kg

W=55 | H=75 | R=0.8 | V=8 mm
W=2.17 | H=2.36 | R=0.031 | V=0.31 in

TO USE WITH:
TOP.SC.130
TOP.SC.130PN

30°



BMR55.10.30/C

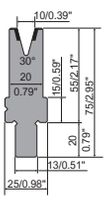
42Cr:900-1150 N/mm2 **350 kN/m max.**

500 mm *19.68"* 5.0 kg

W=55 | H=75 | R=1.0 | V=10 mm
W=2.17 | H=2.36 | R=0.039 | V=0.39 in

30°

TO USE WITH:
TOP.SC.130
TOP.SC.130PN



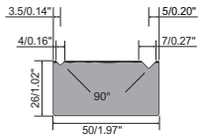
F: 1100 mm - *43.31"*
mm: 400-200-100-100-75-60-50-40-30-20-15-10
in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

12100

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	8.4 kg
415 mm	*16.34"*	4.2 kg

H=26 | R=0.4 | V=4 mm
H=26 | R=0.4 | V=7 mm
H=1.02 | R=0.016 | V=0.16 in
H=1.02 | R=0.016 | V=0.28 in



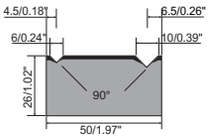
90°>

12300

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	8.0 kg
415 mm	*16.34"*	3.9 kg

H=26 | R=0.4 | V=6 mm
H=26 | R=0.6 | V=10 mm
H=1.02 | R=0.016 | V=0.24 in
H=1.02 | R=0.024 | V=0.39 in



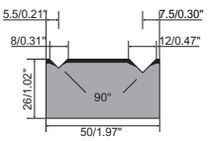
90°

12400

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	8.0 kg
415 mm	*16.34"*	3.9 kg

H=26 | R=0.5 | V=8 mm
H=26 | R=0.8 | V=12 mm
H=1.02 | R=0.020 | V=0.31 in
H=1.02 | R=0.031 | V=0.47 in



90°

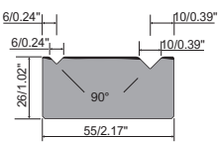
R1A Series dies have the same standard dimensions of Amada style dies. V opening and radii match exactly the parameters set in press brake CNC, so working programs don't need any change or correction.

31100

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	9.1 kg
415 mm	*16.34"*	4.5 kg

H=26 | R=1.5 | V=6 mm
H=26 | R=2.5 | V=10 mm
H=1.02 | R=0.06 | V=0.24 in
H=1.02 | R=0.098 | V=0.39 in



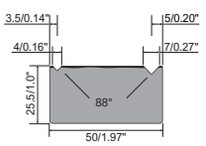
90°

12106

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	8.4 kg
415 mm	*16.34"*	4.2 kg

H=25.5 | R=0.4 | V=4 mm
H=25.5 | R=0.4 | V=7 mm
H=1.00 | R=0.016 | V=0.16 in
H=1.00 | R=0.016 | V=0.28 in



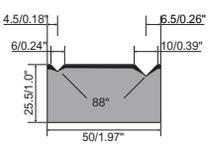
88°

12306

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	8.0 kg
415 mm	*16.34"*	3.9 kg

H=25.5 | R=0.4 | V=6 mm
H=25.5 | R=0.6 | V=10 mm
H=1.00 | R=0.016 | V=0.24 in
H=1.00 | R=0.024 | V=0.39 in



88°

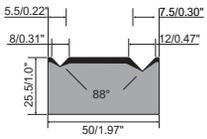
12406

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	8.4 kg
415 mm	*16.34"*	7.8 kg

H=25.5 | R=0.5 | V=8 mm
H=25.5 | R=0.8 | V=12 mm
H=1.00 | R=0.020 | V=0.31 in
H=1.00 | R=0.031 | V=0.47 in

88°



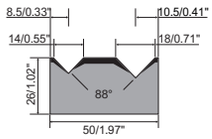
12500

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	7.7 kg
415 mm	*16.34"*	3.8 kg

H=26 | R=0.5 | V=14 mm
H=26 | R=0.5 | V=18 mm
H=1.02 | R=0.020 | V=0.55 in
H=1.02 | R=0.020 | V=0.71 in

88°



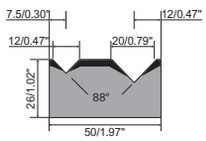
12600

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	7.5 kg
415 mm	*16.34"*	3.7 kg

H=26 | R=0.5 | V=12 mm
H=26 | R=0.5 | V=20 mm
H=1.02 | R=0.020 | V=0.47 in
H=1.02 | R=0.020 | V=0.79 in

88°



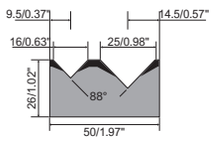
12700

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	7.0 kg
415 mm	*16.34"*	3.4 kg

H=26 | R=0.8 | V=16 mm
H=26 | R=0.8 | V=25 mm
H=1.02 | R=0.031 | V=0.63 in
H=1.02 | R=0.031 | V=0.98 in

88°



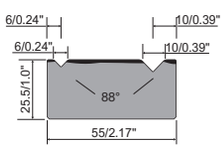
31106

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	8.9 kg
415 mm	*16.34"*	4.4 kg

H=25.5 | R=1.5 | V=6 mm
H=25.5 | R=2.5 | V=10 mm
H=1.00 | R=0.06 | V=0.24 in
H=1.00 | R=0.098 | V=0.39 in

88°



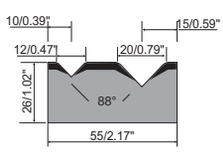
31400

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	7.5 kg
415 mm	*16.34"*	3.7 kg

H=26 | R=3 | V=12 mm
H=26 | R=4 | V=20 mm
H=1.02 | R=0.118 | V=0.47 in
H=1.02 | R=0.157 | V=0.79 in

88°

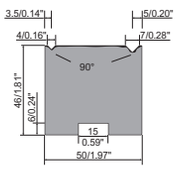


30148

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	14.2 kg	
415 mm	*16.34"*	7.1 kg	
835 mm	*32.87"*	13.7 kg	FCA

H=46 | R=0.4 | V=4 mm
H=46 | R=0.4 | V=7 mm
H=1.81 | R=0.016 | V=0.16 in
H=1.81 | R=0.016 | V=0.28 in



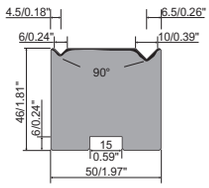
90°>

30248

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	14.2 kg	
415 mm	*16.34"*	7.1 kg	
835 mm	*32.87"*	13.7 kg	FCA

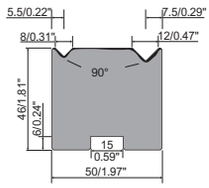
H=46 | R=0.4 | V=6 mm
H=46 | R=0.6 | V=10 mm
H=1.81 | R=0.016 | V=0.24 in
H=1.81 | R=0.023 | V=0.39 in



90°

30348

C45: 560-710 N/mm² **700 kN/m max.**



835 mm	*32.87"*	14.2 kg	
415 mm	*16.34"*	7.1 kg	
835 mm	*32.87"*	13.7 kg	FCA

H=46 | R=0.5 | V=8 mm
H=46 | R=0.8 | V=12 mm
H=1.81 | R=0.016 | V=0.31 in
H=1.81 | R=0.016 | V=0.47 in

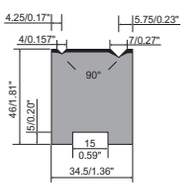
90°

50190

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	9.7 kg	
415 mm	*16.34"*	4.8 kg	
835 mm	*32.87"*	9.4 kg	FCA

H=46 | R=0.4 | V=4 mm
H=46 | R=0.4 | V=7 mm
H=1.81 | R=0.016 | V=0.16 in
H=1.81 | R=0.016 | V=0.28 in



90° **SELF CENTERING**

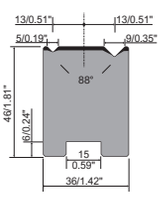
R1A self centering dies are designed to be mounted with 33000 Series holders.
Hole pitch is standard.
Such 1-V dies align the V opening with the punch tip axis autonomously, so the press brake upper beam has to go down without sheet metal to position the dies properly. Afterwards, the operator can screw the dies to their holder and keep the same alignment.

50790

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	10.0 kg	
415 mm	*16.34"*	5.0 kg	
835 mm	*32.87"*	9.7 kg	FCA

H=46 | R=0.4 | V=5 mm
H=46 | R=0.6 | V=9 mm
H=1.81 | R=0.016 | V=0.196 in
H=1.81 | R=0.023 | V=0.35 in



90° **SELF CENTERING**

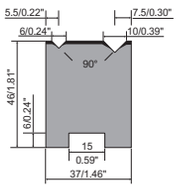
FCA: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94-7.87-15.75

50290

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	10.3 kg	
415 mm	*16.34"*	5.2 kg	
835 mm	*32.87"*	10.1 kg	FCA

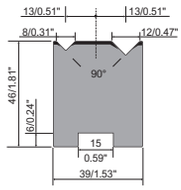
H=46 | R=0.4 | V=6 mm
H=46 | R=0.6 | V=10 mm
H=1.81 | R=0.016 | V=0.24 in
H=1.81 | R=0.024 | V=0.39 in



90° **SELF CENTERING**

50390

C45: 560-710 N/mm² **700 kN/m max.**



835 mm	*32.87"*	10.7 kg	
415 mm	*16.34"*	5.3 kg	
835 mm	*32.87"*	10.7 kg	FCA

H=46 | R=0.5 | V=8 mm
H=46 | R=0.8 | V=12 mm
H=1.81 | R=0.019 | V=0.31 in
H=1.81 | R=0.031 | V=0.47 in

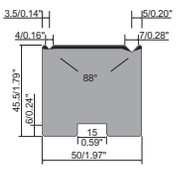
SELF CENTERING **90°**

30147

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	14.2 kg	
415 mm	*16.34"*	7.1 kg	
835 mm	*32.87"*	13.7 kg	FCA

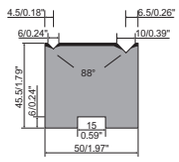
H=45.5 | R=0.4 | V=4 mm
H=45.5 | R=0.4 | V=7 mm
H=1.79 | R=0.016 | V=0.16 in
H=1.79 | R=0.016 | V=0.27 in



88°>

30247

C45: 560-710 N/mm² **700 kN/m max.**



835 mm	*32.87"*	14.0 kg	
415 mm	*16.34"*	8.4 kg	
835 mm	*32.87"*	16.4 kg	FCA

H=45.5 | R=0.4 | V=6 mm
H=45.5 | R=0.6 | V=10 mm
H=1.79 | R=0.016 | V=0.24 in
H=1.79 | R=0.024 | V=0.39 in

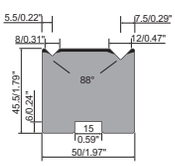
88°

30347

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	14.2 kg	
415 mm	*16.34"*	7.1 kg	
835 mm	*32.87"*	13.7 kg	FCA

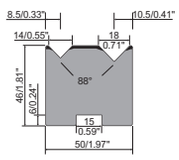
H=45.5| R=0.5 | V=8 mm
H=45.5 | R=0.8 | V=12 mm
H=1.79 | R=0.019 | V=0.31 in
H=1.79 | R=0.031 | V=0.47 in



88°

30448

C45: 560-710 N/mm² **1000 kN/m max.**



835 mm	*32.87"*	13.5 kg	
415 mm	*16.34"*	6.7 kg	
835 mm	*32.87"*	13.7 kg	FCA

H=46 | R=0.5 | V=14 mm
H=46 | R=0.5 | V=18 mm
H=1.81 | R=0.019 | V=0.55 in
H=1.81 | R=0.019 | V=0.71 in

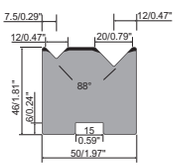
88°

30548

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	13.5 kg	
415 mm	*16.34"*	6.7 kg	
835 mm	*32.87"*	13.7 kg	FCA

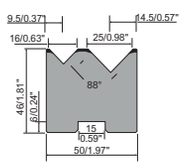
H=46 | R=0.5 | V=12 mm
H=46 | R=0.5 | V=20 mm
H=1.81 | R=0.019 | V=0.47 in
H=1.81 | R=0.019 | V=0.79 in



88°

30648

C45: 560-710 N/mm² **1000 kN/m max.**



835 mm	*32.87"*	12.9 kg	
415 mm	*16.34"*	6.4 kg	
835 mm	*32.87"*	13.7 kg	FCA

H=46 | R=0.8 | V=16 mm
H=46 | R=0.8 | V=25 mm
H=1.81 | R=0.031 | V=0.63 in
H=1.81 | R=0.031 | V=0.98 in

88°

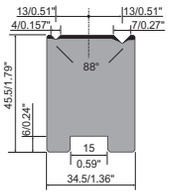
FCA: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94-7.87-15.75

50196

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	9.5 kg	
415 mm	*16.34"*	4.8 kg	
835 mm	*32.87"*	9.5 kg	FCA

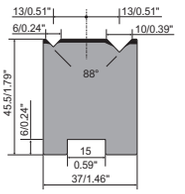
H=45.5 | R=0.4 | V=4 mm
H=45.5 | R=0.4 | V=7 mm
H=1.79 | R=0.016 | V=0.16 in
H=1.79 | R=0.016 | V=0.28 in



88° **SELF CENTERING**

50296

C45: 560-710 N/mm² **700 kN/m max.**



835 mm	*32.87"*	10.4 kg	
415 mm	*16.34"*	5.2 kg	
835 mm	*32.87"*	10.4 kg	FCA

H=45.5 | R=0.4 | V=6 mm
H=45.5 | R=0.6 | V=10 mm
H=1.76 | R=0.016 | V=0.24 in
H=1.76 | R=0.023 | V=0.39 in

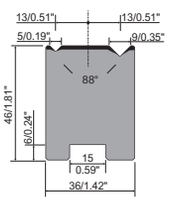
SELF CENTERING **88°**

50796

C45: 560-710 N/mm² **600 kN/m max.**

835 mm	*32.87"*	10.0 kg	
415 mm	*16.34"*	5.0 kg	
835 mm	*32.87"*	9.5.0 kg	FCA

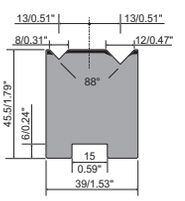
H=45.5 | R=0.4 | V=5 mm
H=45.5 | R=0.6 | V=9 mm
H=1.79 | R=0.016 | V=0.2 in
H=1.79 | R=0.024 | V=0.35 in



88° **SELF CENTERING**

50396

C45: 560-710 N/mm² **700 kN/m max.**



835 mm	*32.87"*	10.8 kg	
415 mm	*16.34"*	5.3 kg	
835 mm	*32.87"*	10.8 kg	FCA

H=45.5 | R=0.5 | V=8 mm
H=45.5 | R=0.8 | V=12 mm
H=1.79 | R=0.019 | V=0.31 in
H=1.79 | R=0.019 | V=0.47 in

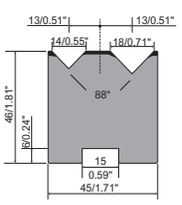
SELF CENTERING **88°**

50490

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	12.0 kg	
415 mm	*16.34"*	5.3 kg	
835 mm	*32.87"*	10.8 kg	FCA

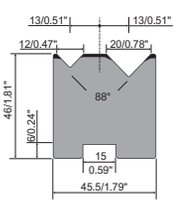
H=46 | R=0.5 | V=14 mm
H=46 | R=0.5 | V=18 mm
H=1.81 | R=0.019 | V=0.55 in
H=1.81 | R=0.019 | V=0.71 in



88° **SELF CENTERING**

50590

C45: 560-710 N/mm² **700 kN/m max.**



835 mm	*32.87"*	12.2 kg	
415 mm	*16.34"*	6.1 kg	
835 mm	*32.87"*	12.2 kg	FCA

H=46 | R=0.5 | V=12 mm
H=46 | R=0.5 | V=20 mm
H=1.81 | R=0.019 | V=0.47 in
H=1.81 | R=0.019 | V=0.78 in

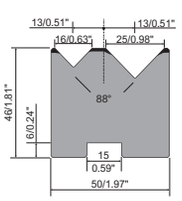
SELF CENTERING **88°**

50690

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	13.0 kg	
415 mm	*16.34"*	6.5 kg	
835 mm	*32.87"*	12.6 kg	FCA

H=46 | R=0.8 | V=16 mm
H=46 | R=0.8 | V=25 mm
H=1.81 | R=0.031 | V=0.63 in
H=1.81 | R=0.031 | V=0.98 in



R1A self centering dies are designed to be mounted with 33000 Series holders.
Hole pitch is standard.
Such 1-V dies align the V opening with the punch tip axis autonomously, so the press brake upper beam has to go down without sheet metal to position the dies properly. Afterwards, the operator can screw the dies to their holder and keep the same alignment.

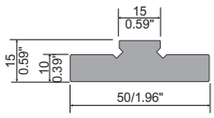
88° **SELF CENTERING**

FCA: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94-7.87-15.75

30000

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	3.7 kg
415 mm	*16.34"*	1.9 kg

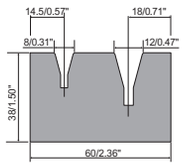


33700

42Cr:900-1150 N/mm2 **300 kN/m max.**

835 mm	*32.87"*	13.3 kg
415 mm	*16.34"*	5.6 kg

R=1 | V=8 mm
R=1 | V=12 mm
R=0.039 | V=0.31 in
R=0.039 | V=0.47 in



BENDING HANDBOOK
The Bending handbook target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.
Visit rolleriools.com to find out more about the handbook

Create your account on www.rolleritools.com. You can use our website to ask for offers, keep you up to date on the latest news, check prices and place orders online.

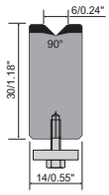
32000

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	3.0 kg
415 mm	*16.34"*	1.5 kg

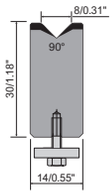
H=30 | R=1.5 | V=6 mm
H=1.18 | R=0.059 | V=0.24 in

90°>



32100

C45: 560-710 N/mm² **950 kN/m max.**



835 mm	*32.87"*	3.0 kg
415 mm	*16.34"*	1.5 kg

H=30 | R=1.5 | V=8 mm
H=1.18 | R=0.059 | V=0.31 in

90°

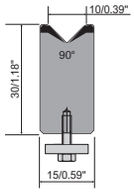
32300

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	3.0 kg
415 mm	*16.34"*	1.5 kg

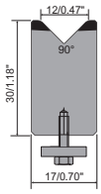
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in

90°



32600

C45: 560-710 N/mm² **1000 kN/m max.**



835 mm	*32.87"*	2.9 kg
415 mm	*16.34"*	1.5 kg

H=30 | R=2.5 | V=12 mm
H=1.18 | R=0.098 | V=0.47 in

90°

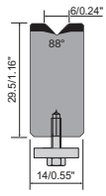
32006

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	3.0 kg
415 mm	*16.34"*	1.5.0 kg

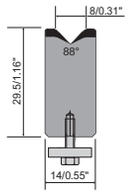
H=29.5 | R=1.5 | V=6 mm
H=1.16 | R=0.059 | V=0.24 in

88°



32106

C45: 560-710 N/mm² **950 kN/m max.**



835 mm	*32.87"*	3.0 kg
415 mm	*16.34"*	1.5 kg

H=29.5 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

88°

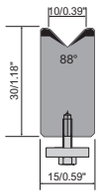
32200

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	3.0 kg
415 mm	*16.34"*	1.5 kg

H=30 | R=2 | V=10 mm
H=1.18 | R=0.079 | V=0.39 in

88°



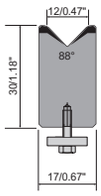
32400

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	3.0 kg
415 mm	*16.34"*	1.5 kg

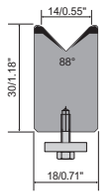
H=30 | R=2.5 | V=12 mm
H=1.18 | R=0.098 | V=0.47

88°



32500

C45: 560-710 N/mm² **1000 kN/m max.**



835 mm	*32.87"*	3.3 kg
415 mm	*16.34"*	1.6 kg

H=60 | R=2.5 | V=14 mm
H=2.36 | R=0.098 | V=0.55

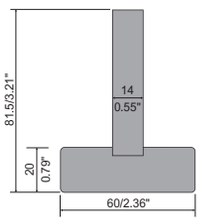
88°

33000

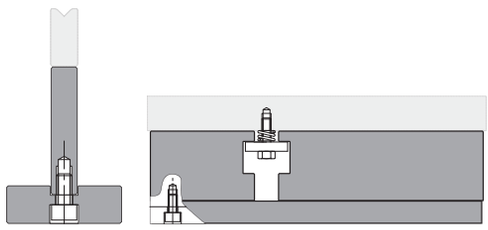
C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	12.7 kg
415 mm	*16.34"*	6.3 kg

88°



EXAMPLE OF APPLICATION



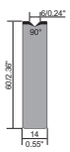
07000

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	5.5 kg	
415 mm	*16.34"*	2.7 kg	
835 mm	*32.87"*	5.5 kg	FCA

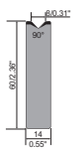
H=60 | R=1.5 | V=6 mm
H=2.36 | R=0.059 | V=0.24 in

90°>



07100

C45: 560-710 N/mm² **950 kN/m max.**



835 mm	*32.87"*	5.5 kg	
415 mm	*16.34"*	2.7 kg	
835 mm	*32.87"*	5.5 kg	FCA

H=60 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

90°

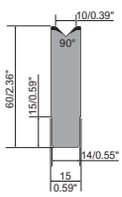
07300

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	6.0 kg	
415 mm	*16.34"*	3.0 kg	
835 mm	*32.87"*	6.0 kg	FCA

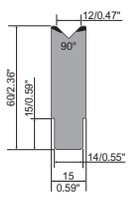
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in

90°



07500

C45: 560-710 N/mm² **950 kN/m max.**



835 mm	*32.87"*	6.1 kg	
415 mm	*16.34"*	3.0 kg	
835 mm	*32.87"*	6.1 kg	FCA

H=60 | R=2.5 | V=12 mm
H=2.36 | R=0.098 | V=0.47 in

90°

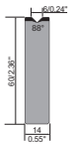
FCA: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94-7.87-15.75

07006

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	5.5 kg	
415 mm	*16.34"*	2.7 kg	
835 mm	*32.87"*	5.5 kg	FCA

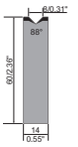
H=60 | R=1.5 | V=6 mm
H=2.36 | R=0.059 | V=0.24 in



88°>

07106

C45: 560-710 N/mm² **950 kN/m max.**



835 mm	*32.87"*	6.0 kg	
415 mm	*16.34"*	3.0 kg	
835 mm	*32.87"*	6.0 kg	FCA

H=60 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

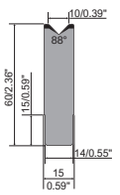
88°

07200

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	6.0 kg	
415 mm	*16.34"*	3.0 kg	
835 mm	*32.87"*	6.0 kg	FCA

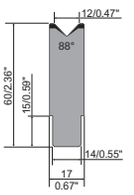
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in



88°

07400

C45: 560-710 N/mm² **950 kN/m max.**



835 mm	*32.87"*	6.0 kg	
415 mm	*16.34"*	3.0 kg	
835 mm	*32.87"*	6.0 kg	FCA

H=60 | R=2.5 | V=12 mm
H=2.36 | R=0.098 | V=0.31 in

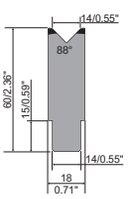
88°

07600

C45: 560-710 N/mm² **950 kN/m max.**

835 mm	*32.87"*	6.1 kg	
415 mm	*16.34"*	3.0 kg	
835 mm	*32.87"*	6.1 kg	FCA

H=60 | R=2.5 | V=14 mm
H=2.36 | R=0.098 | V=0.55 in



88°

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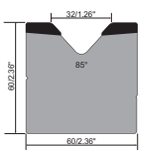
03500

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	21.7 kg	
415 mm	*16.34"*	10.8 kg	
835 mm	*32.87"*	21.7 kg	FCA

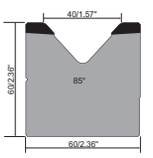
H=60 | R=4 | V=32 mm
H=2.36 | R=0.157 | V=1.26 in



85°>

03600

C45: 560-710 N/mm² **1000 kN/m max.**



835 mm	*32.87"*	20.5 kg	
415 mm	*16.34"*	10.2 kg	
835 mm	*32.87"*	20.5 kg	FCA

H=60 | R=4 | V=40 mm
H=2.36 | R=0.157 | V=1.57 in

85°

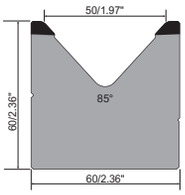
FCA: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94-7.87-15.75

03700

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	18.9 kg	
415 mm	*16.34"*	9.4 kg	
835 mm	*32.87"*	18.9 kg	FCA

H=60 | R=4 | V=50 mm
H=2.36 | R=0.157 | V=1.97 in



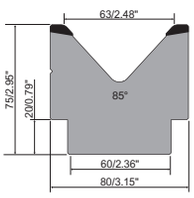
85°

03800

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	29.2 kg	
415 mm	*16.34"*	14.5 kg	
835 mm	*32.87"*	29.2 kg	FCA

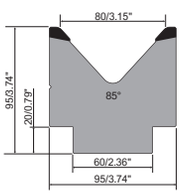
H=75 | R=5 | V=63 mm
H=2.95 | R=0.196 | V=2.48 in



85°

01360

C45: 560-710 N/mm² **700 kN/m max.**



835 mm	*32.87"*	42.6 kg	
415 mm	*16.34"*	21.2 kg	
835 mm	*32.87"*	42.6 kg	FCA

H=95 | R=6 | V=80 mm
H=3.74 | R=0.236 | V=3.15 in

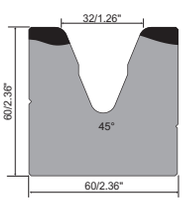
85°

34200

C45: 560-710 N/mm² **400 kN/m max.**

835 mm	*32.87"*	19.2 kg	
415 mm	*16.34"*	9.6 kg	
835 mm	*32.87"*	19.2 kg	FCA

H=60 | R=5 | V=32 mm
H=2.36 | R=0.196 | V=1.26 in



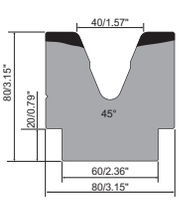
45°>

34300

C45: 560-710 N/mm² **700 kN/m max.**

835 mm	*32.87"*	32.7 kg	
415 mm	*16.34"*	16.2 kg	
835 mm	*32.87"*	32.7 kg	FCA

H=80 | R=5 | V=40 mm
H=3.15 | R=0.196 | V=1.57 in



45°

FCA: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94-7.87-15.75

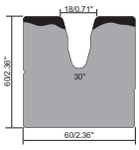
34000

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	21.5 kg	
415 mm	*16.34"*	10.7 kg	
835 mm	*32.87"*	21.5 kg	FCA

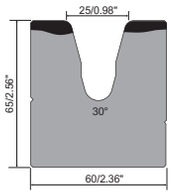
H=60 | R=3 | V=18 mm
H=2.36 | R=0.118 | V=0.71 in

30°>



34100

C45: 560-710 N/mm² **600 kN/m max.**



835 mm	*32.87"*	21.7 kg	
415 mm	*16.34"*	10.8 kg	
835 mm	*32.87"*	21.7 kg	FCA

H=65 | R=4 | V=25 mm
H=2.56 | R=0.0.157 | V=0.98 in

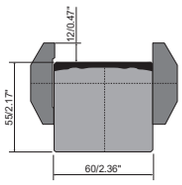
30°

05500

SUPPORT

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	21.7 kg
415 mm	*16.34"*	10.8 kg



FCA: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94-7.87-15.75

.dies CFH series >>

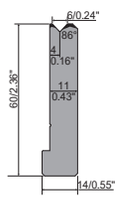
CFH dies are designed to complete the range of CFH tools and guarantee the same dimensions of Amada style tools. Two models, on at 86° and one at 30° with standard lengths of 835mm-32.87″ and 415mm-16.34″, and sectioning of 800mm.
Furthermore, in order to meet all bending requirements, they are made of 42CrMo4 tool steel and undergo a specific heating treatment to reach certain hardness level which can improve the tool operational life.

CFH60.06.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**

835 mm	*32.87″*	5.1 kg	
415 mm	*16.34″*	2.5 kg	
800 mm	*31.50″*	4.8 kg	F

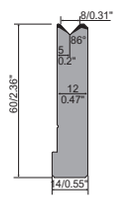
H=60 | R=1.5 | V=6 mm
H=2.36 | R=0.059 | V=0.23 in



86°>

CFH60.08.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**



835 mm	*32.87″*	5.1 kg	
415 mm	*16.34″*	2.5 kg	
800 mm	*31.50″*	4.8 kg	F

H=60 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

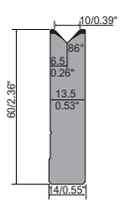
86°

CFH60.10.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**

835 mm	*32.87″*	5.3 kg	
415 mm	*16.34″*	2.6 kg	
800 mm	*31.50″*	5.0 kg	F

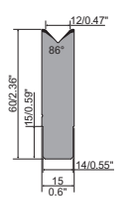
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in



86°

CFH60.12.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**



835 mm	*32.87″*	5.5 kg	
415 mm	*16.34″*	2.7 kg	
800 mm	*31.50″*	5.2 kg	F

H=60 | R=2.5 | V=12 mm
H=2.36 | R=0.098 | V=0.47 in

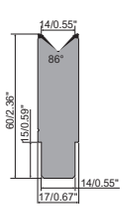
86°

CFH60.14.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**

835 mm	*32.87″*	6.2 kg	
415 mm	*16.34″*	3.0 kg	
800 mm	*31.50″*	5.8 kg	F

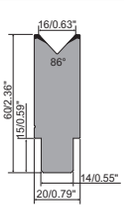
H=60 | R=2.5 | V=14 mm
H=2.36 | R=0.098 | V=0.55 in



86°

CFH60.16.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**



835 mm	*32.87″*	7.0 kg	
415 mm	*16.34″*	3.4 kg	
800 mm	*31.50″*	6.6 kg	F

H=60 | R=2.5 | V=16 mm
H=2.36 | R=0.098 | V=0.63 in

86°

F: 800 mm - *21.49″*
mm: 100-10-15-15-20-40-50-150-400
in: 3.94-0.39-0.59-0.59-0.79-1.57-1.97-5.90-15.74

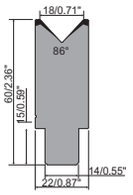
CFH60.18.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	7.4 kg	
415 mm	*16.34"*	3.6 kg	
800 mm	*31.50"*	7.0 kg	F

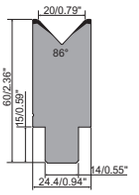
H=60 | R=2.5 | V=18 mm
H=2.36 | R=0.098 | V=0.71 in

86°



CFH60.20.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**



835 mm	*32.87"*	8.0 kg	
415 mm	*16.34"*	3.9 kg	
800 mm	*31.50"*	7.5 kg	F

H=60 | R=3 | V=20 mm
H=2.36 | R=0.118 | V=0.79 in

86°

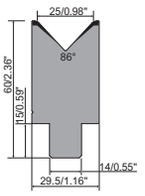
CFH60.25.86

42Cr:900-1500 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	9.5 kg	
415 mm	*16.34"*	4.6 kg	
800 mm	*31.50"*	9.0 kg	F

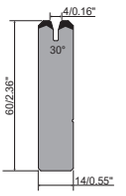
H=60 | R=3 | V=25 mm
H=2.36 | R=0.118 | V=0.98 in

86°



CFH60.04.30

42Cr:900-1500 N/mm2 **300 kN/m max.**



835 mm	*32.87"*	5.8 kg	
415 mm	*16.34"*	2.9 kg	
800 mm	*31.50"*	5.6 kg	F

H=60 | R=1 | V=4 mm
H=2.36 | R=0.039 | V=0.16 in

30°>

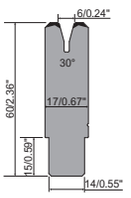
CFH60.06.30

42Cr:900-1500 N/mm2 **300 kN/m max.**

835 mm	*32.87"*	6.3 kg	
415 mm	*16.34"*	3.1 kg	
800 mm	*31.50"*	6.0 kg	F

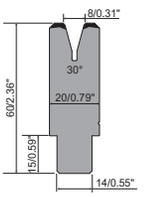
H=60 | R=1 | V=6 mm
H=2.36 | R=0.039 | V=0.24 in

30°



CFH60.08.30

42Cr:900-1500 N/mm2 **350 kN/m max.**



835 mm	*32.87"*	6.8 kg	
415 mm	*16.34"*	3.4 kg	
800 mm	*31.50"*	6.6 kg	F

H=60 | R=1.5 | V=8 mm
H=3.15 | R=0.059 | V=0.31 in

30°

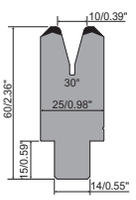
CFH60.10.30

42Cr:900-1500 N/mm2 **350 kN/m max.**

835 mm	*32.87"*	8.0 kg	
415 mm	*16.34"*	3.9 kg	
800 mm	*31.50"*	7.7 kg	F

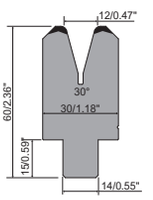
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in

30°



CFH60.12.30

42Cr:900-1500 N/mm2 **350 kN/m max.**



835 mm	*32.87"*	9.2 kg	
415 mm	*16.34"*	4.6 kg	
800 mm	*31.50"*	8.8 kg	F

H=60 | R=2.5 | V=12 mm
H=3.15 | R=0.098 | V=0.47 in

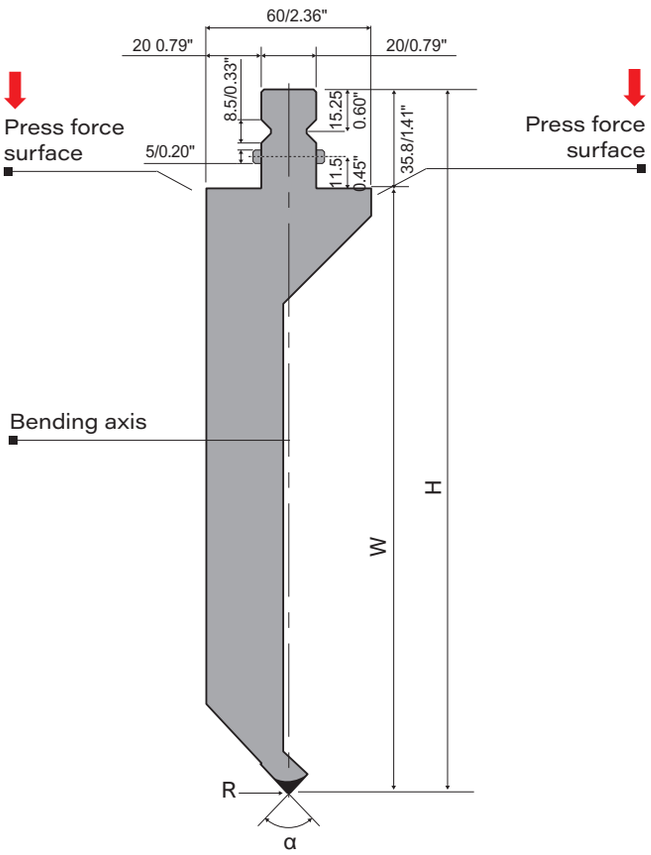
30°

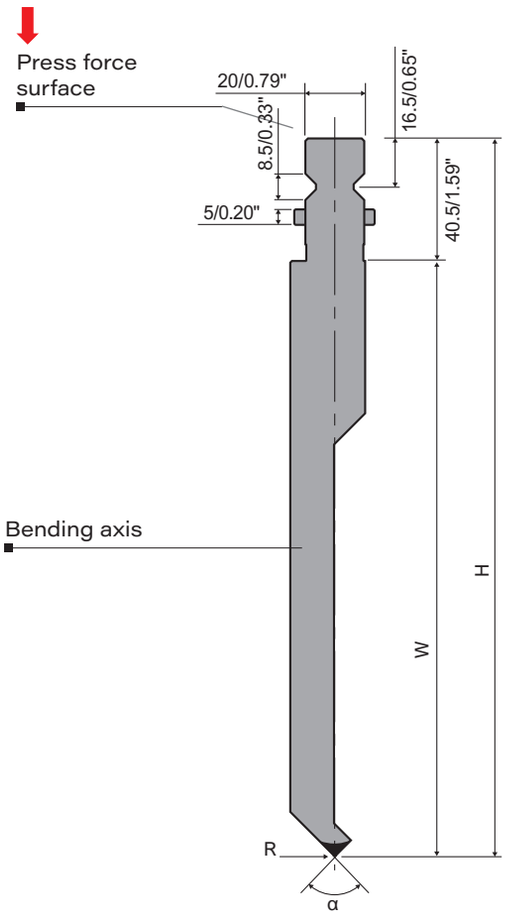
F: 800 mm - *21.49"*
mm: 100-10-15-15-20-40-50-150-400
in: 3.94-0.39-0.59-0.59-0.79-1.57-1.97-5.90-15.74

.R2 punches

Compatible with press brakes: Darley, LVD, Safan, Trumpf and press brakes with NSCL system

.standard tang





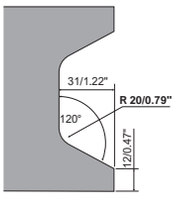
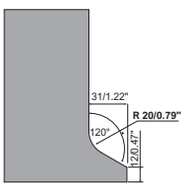
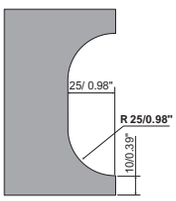
.standard length

	TOP Series	CLASSIC Series
250 mm | 9.84"	○	●
415 mm | 16.34"		○
500 mm | 19.68"	○	○
515 mm | 20.28"	○	○
525 mm | 20.67"		○
835 mm | 32.87"		○

○ available for some tool models only

.horn types

Check the standard horn in each code. All the other horns are available on request based on the series of the tool - check the feasibility with sales@rolleri.it

		Serie TOP	Serie CLASSIC
	1		●
	1/A	●	
	2	●	

Rolleri BLACKFIRE is a surface treatment against steel oxidation. After such treatment tools become black and laser marking golden.

Rolleri FREEZINC is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation.

Create your account on www.rolleritools.com. You can use our website to ask for offers, keep you up to date on the latest news, check prices and place orders online.

.segmentation

Customised sectioning is also available on request. sales@rolleri.it to know more about price and availability.

◁ = left horn ▷ = right horn

FW: 550 mm - *21.65"*

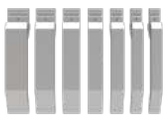
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷

in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

FC: 250 mm - *9.84"*

mm: 50-45-40-35-30-25-25

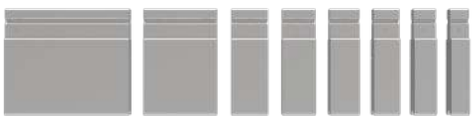
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98



F: 495 mm - *19.49"*

mm: 170 - 100 - 50 - 45 - 40 - 35 - 30 - 25

in: 1.70-3.94-1.97-1.77-1.57 -1.37-1.18-0.98



Available on request:

FA mm: 1250-2050-2550-3050-4050

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

Length		25	30	35	40	45	50	100	100	100
mm	*in*	*0.98*	*1.18*	*1.18*	*1.18*	*1.18*	*1.97*	*3.94*	*3.94*	*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

FB mm: 1250-2050-2550-3050-4050

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

Length		25	30	35	40	45	50	100	100	100	200	300	500
mm	*in*	*0.98*	*1.18*	*1.18*	*1.18*	*1.18*	*1.97*	*3.94*	*3.94*	*3.94*	*7.87*	*11.81*	*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

.clamping systems

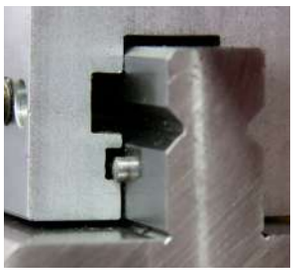
QuickLock - Standard

- Vertical tool change
- Easy handling
- Reduced setup time and costs
- Standard for tooling weight <12.5kg and segmented sets
- According to local regulation about weight limit to be lifted manually, QL can be applied with extra charge. For further information contact tecnico@rolleri.it

QL

Safety pins - Standard

- Orizontal tool change



S

Scan the QRCode or click on it and watch the video to discover more about QuickLock system.

TOPW237.85.R08

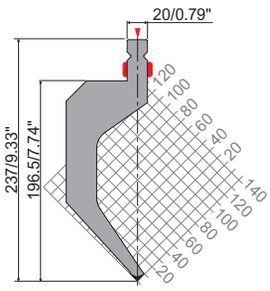
42Cr: 900-1150 N/mm² **800 kN/m max.**

515 mm	*20.82"*	33.5 kg	
250 mm	*9.84"*	16.3 kg	
550 mm	*21.65"*	35.8 kg	FW

W=196.5 | H=237 | R=0.8 mm
W=7.74 | H=9.33 | R=0.031 in

85°>

.HORN 1



TOPW200.85.R08

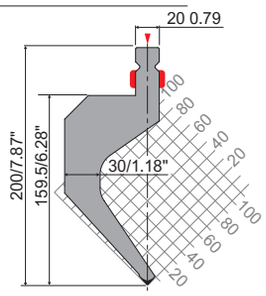
42Cr: 900-1150 N/mm² **800 kN/m max.**

515 mm	*19.68"*	28.3 kg	
250 mm	*9.84"*	13.8 kg	
550 mm	*21.65"*	30.3 kg	FW

W= 159.5 | H=200 | R=0.8 mm
W=6.28 | H=7.87 | R=0.031 in

85°

.HORN 1



TOPW.200.26.R08

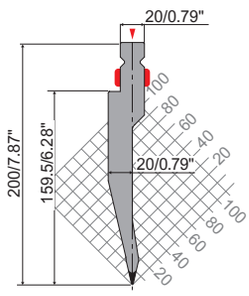
42Cr: 900-1150 N/mm² **1000 kN/m max.**

515 mm	*19.68"*	13.9 kg	
250 mm	*9.84"*	6.8 kg	
550 mm	*21.65"*	14.9 kg	FW

W=159.5 | H=200 | R=0.8 mm
W=6.28 | H=7.87 | R=0.031 in

26°>

.HORN 1



TOPW237.26.R08

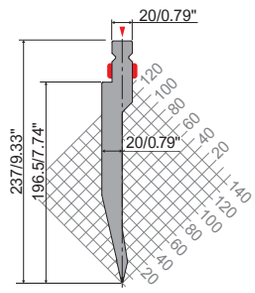
42Cr: 900-1150 N/mm² **1000 kN/m max.**

515 mm	*19.68"*	17.5 kg	
250 mm	*9.84"*	8.5 kg	
550 mm	*21.65"*	18.7 kg	FW

W=196.5 | H=237 | R=0.8 mm
W=7.74 | H=9.33 | R=0.031 in

26°

.HORN 1



QL FW: 550 mm - *21.65"*
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR237.90.R06

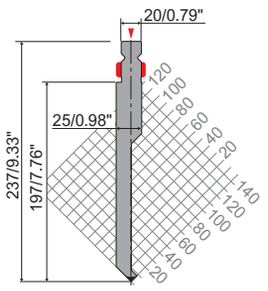
42Cr: 900-1150 N/mm² **600 kN/m max.**

515 mm	*20.82"*	17.5 kg	
250 mm	*9.84"*	8.5 kg	
550 mm	*21.65"*	18.7 kg	FW

W=197 | H=237 | R=0.6 mm
W=7.76 | H=9.33 | R=0.024 in

90°>

.HORN 2



TPR237.90.R12

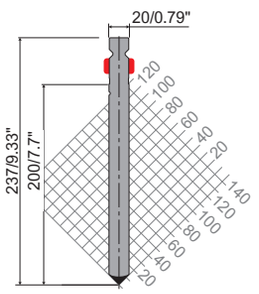
42Cr: 900-1150 N/mm² **1000 kN/m max.**

515 mm	*20.82"*	19.0 kg	
250 mm	*9.84"*	9.2 kg	
550 mm	*21.65"*	20.3 kg	FW

W=200 | H=237 | R=1.2 mm
W=7.87 | H=9.33 | R=0.047 in

90°

.HORN 2



TPR135.86.R1

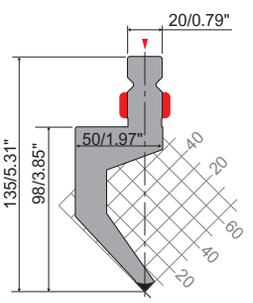
42Cr: 900-1150 N/mm² **650 kN/m max.**

515 mm	*20.82"*	12.3 kg	
250 mm	*9.84"*	6.0 kg	
550 mm	*21.65"*	13.1 kg	FW

W=98 | H=135 | R=1 mm
W=3.85 | H=5.31 | R=0.039 in

86°>

.HORN 1/A



TPR157.86.R1

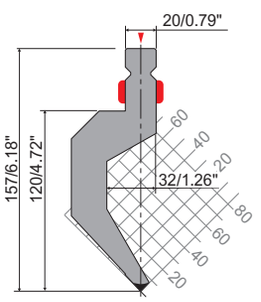
42Cr: 900-1150 N/mm² **800 kN/m max.**

500 mm	*19.68"*	14.0 kg	
250 mm	*9.84"*	7.5 kg	FC
550 mm	*21.65"*	15.0 kg	FW

W=120 | H=157 | R=1 mm
W=4.72 | H=6.18 | R=0.039 in

86°

.HORN 1/A



QL **FW: 550 mm - *21.65"***
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL **FC: 250 mm - *9.84"***
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR157.86.R1-A

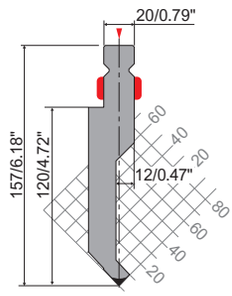
42Cr: 900-1150 N/mm² **800 kN/m max.**

500 mm	*19.68"*	12.5 kg	
250 mm	*9.84"*	6.2 kg	FC
550 mm	*21.65"*	12.5 kg	FW

W=120 | H=157 | R=1 mm
W=4.72 | H=6.18 | R=0.039 in

86°

.HORN 1/A



TPR200.86.R1

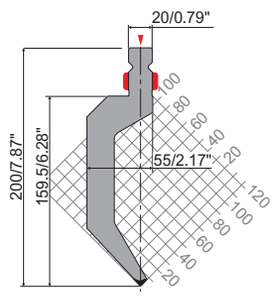
42Cr: 900-1150 N/mm² **500 kN/m max.**

515 mm	*20.82"*	19.1 kg	
250 mm	*9.84"*	6.1 kg	
550 mm	*21.65"*	20.4 kg	FW

W=159.5 | H=200 | R=1 mm
W=6.28 | H=7.87 | R=0.039 in

86°

.HORN 2



TPR237.86.R1

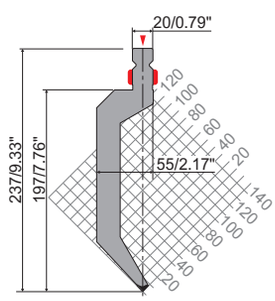
42Cr: 900-1150 N/mm² **500 kN/m max.**

515 mm	*20.82"*	23.0 kg	
250 mm	*9.84"*	11.2 kg	
550 mm	*21.65"*	24.6 kg	FW

W=197 | H=237 | R=1 mm
W=7.76 | H=9.33 | R=0.039 in

86°

.HORN 2



TPR256.86.R1

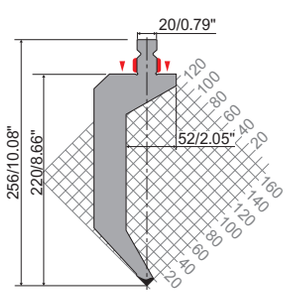
42Cr: 900-1150 N/mm² **800 kN/m max.**

500 mm	*19.68"*	33.0 kg	
250 mm	*9.84"*	16.5 kg	FC
550 mm	*21.65"*	33.0 kg	FW

W=220 | H=256 | R=1 mm
W=8.66 | H=10.08 | R=0.039 in

86°

.HORN 1



QL FW: 550 mm - *21.65"*
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR256.86.R1-A

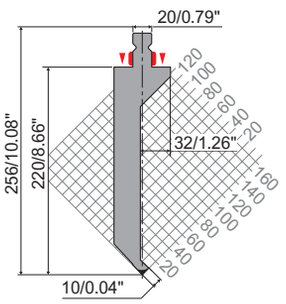
42Cr: 900-1150 N/mm² **800 kN/m max.**

500 mm	*19.68"*	28.5 kg	
250 mm	*9.84"*	12.5 kg	FC
550 mm	*21.65"*	28.5 kg	FW

W=220 | H=256 | R=1 mm
W=8.66 | H=10.08 | R=0.039 in

86°

.HORN 1



PW200.85.R08

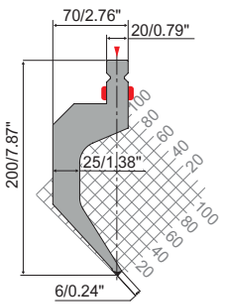
42Cr: 900-1150 N/mm² **600 kN/m max.**

515 mm	*19.68"*	22.1 kg	
250 mm	*9.84"*	10,7 kg	
550 mm	*21.65"*	23.6 kg	FW

W=159.5 | H=200 | R=0.8 mm
W=6.28 | H=7.87 | R=0.031 in

85°>

.HORN 1



TPR200.80.R1

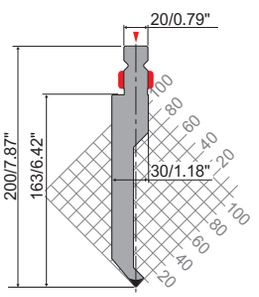
42Cr: 900-1150 N/mm² **800 kN/m max.**

515 mm	*20.82"*	19.0 kg	
250 mm	*9.84"*	9.2 kg	
550 mm	*21.65"*	21 kg	FW

W=163 | H=200 | R=1 mm
W=6.42 | H=7.87 | R=0.039 in

80°>

.HORN 2



TPR237.80.R1

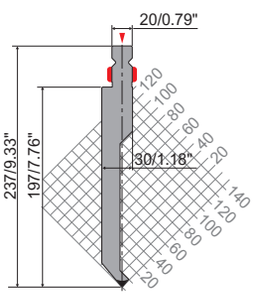
42Cr: 900-1150 N/mm² **800 kN/m max.**

515 mm	*20.82"*	19.7 kg	
250 mm	*9.84"*	9.6 kg	
550 mm	*21.65"*	21.0 kg	FW

W=197 | H=237 | R=1 mm
W=7.76 | H=9.33 | R=0.039 in

80°

.HORN 2



QL **FW: 550 mm - *21.65"***
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL **FC: 250 mm - *9.84"***
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR157.60.R1

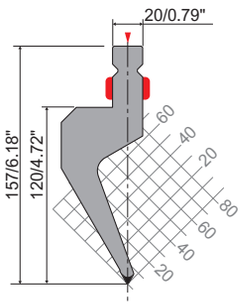
42Cr: 900-1150 N/mm² **700 kN/m max.**

500 mm	*19.68"*	15.0 kg	
250 mm	*9.84"*	7.5 kg	FC
550 mm	*21.65"*	16.5 kg	FW

W=120 | H=157 | R=1 mm
W=4.72 | H=6.18 | R=0.039 in

60°>

.HORN 1/A



TPR157.60.R4

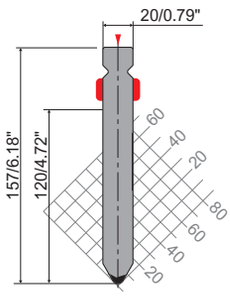
42Cr: 900-1150 N/mm² **1600 kN/m max.**

500 mm	*19.68"*	12.0 kg	
250 mm	*9.84"*	6.0 kg	FC
550 mm	*21.65"*	12.0 kg	FW

W=120 | H=157 | R=4 mm
W=4.72 | H=6.18 | R=0.157 in

60°

.HORN 1/A



TPR237.60.R1

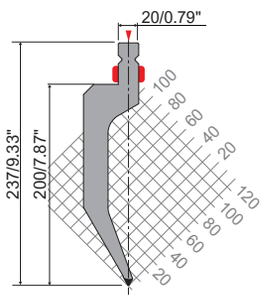
42Cr: 900-1150 N/mm² **700 kN/m max.**

500 mm	*19.68"*	21.6 kg	
250 mm	*9.84"*	10.8 kg	FC
550 mm	*21.65"*	23.8 kg	FW

W=200 | H=237 | R=1 mm
W=7.87 | H=9.33 | R=0.039 in

60°

.HORN 2



TPR200.60.R1

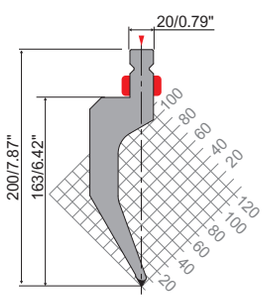
42Cr: 900-1150 N/mm² **700 kN/m max.**

500 mm	*19.68"*	18.3 kg	
250 mm	*9.84"*	9.2 kg	FC
550 mm	*21.65"*	20.2 kg	FW

W=163 | H=200 | R=1 mm
W=6.42 | H=7.87 | R=0.039 in

60°

.HORN 2



QL **FW: 550 mm - *21.65"***
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL **FC: 250 mm - *9.84"***
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR200.60.R3

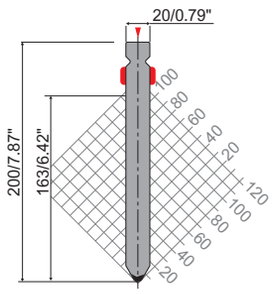
42Cr: 900-1150 N/mm² **1600 kN/m max.**

515 mm	*20.82"*	15.6 kg	
250 mm	*9.84"*	7.6 kg	
550 mm	*21.65"*	16.7 kg	FW

W=163 | H=200 | R=3 mm
W=6.42 | H=7.87 | R=0.118 in

60°

.HORN 2



TPR237.60.R3

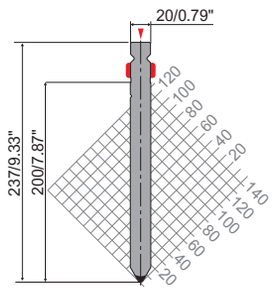
42Cr: 900-1150 N/mm² **1600 kN/m max.**

515 mm	*20.82"*	18.8 kg	
250 mm	*9.84"*	9.1 kg	
550 mm	*21.65"*	20.1 kg	FW

W=200 | H=237 | R=3 mm
W=7.87 | H=9.33 | R=0.118 in

60°

.HORN 2



TPR256.60.R4

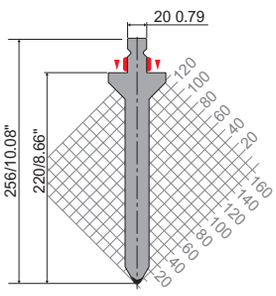
42Cr: 900-1150 N/mm² **2500 kN/m max.**

500 mm	*19.68"*	26.1 kg	
250 mm	*9.84"*	13.5 kg	FC
550 mm	*21.65"*	28.7 kg	FW

W=220 | H=256 | R=4 mm
W=8.66 | H=10.08 | R=0.157 in

60°

.HORN 1



TPR157.28.R1

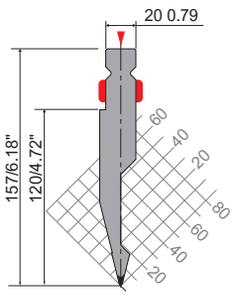
42Cr: 900-1150 N/mm² **600 kN/m max.**

500 mm	*19.68"*	10.0 kg	
250 mm	*9.84"*	5.0 kg	FC
550 mm	*21.65"*	10.0 kg	FW

W=120 | H=157 | R=1 mm
W=4.72 | H=6.18 | R=0.039 in

28°>

.HORN 1/A



QL **FW: 550 mm - *21.65"***
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL **FC: 250 mm - *9.84"***
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR176.28.R1

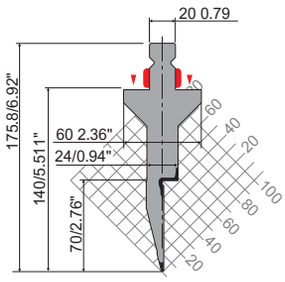
42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	7.5 kg	
250 mm	*9.84"*	15.0 kg	FC
550 mm	*21.65"*	10.0 kg	FW

W=140 | H=175.8 | R=1 mm
W=5.51 | H=6.92 | R=0.039 in

28°

.HORN 1/A



TPR200.28.R1

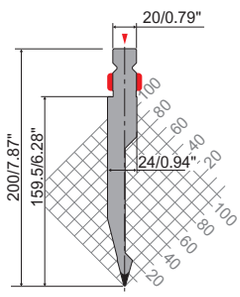
42Cr: 900-1150 N/mm² **600 kN/m max.**

515 mm	*20.82"*	12.6 kg	
250 mm	*9.84"*	6.1 kg	
550 mm	*21.65"*	13.5 kg	FW

W=159.5 | H=200 | R=1 mm
W=6.28 | H=7.87 | R=0.039 in

28°

.HORN 2



TPR237.28.R1

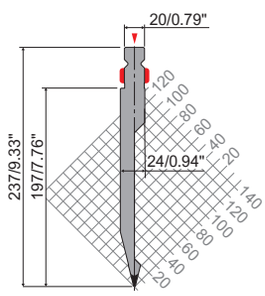
42Cr: 900-1150 N/mm² **600 kN/m max.**

515 mm	*20.82"*	15.0 kg	
250 mm	*9.84"*	7.3 kg	
550 mm	*21.65"*	16.0 kg	FW

W=197 | H=237 | R=1 mm
W=7.76 | H=9.33 | R=0.039 in

28°

.HORN 2



TPR256.28.R1

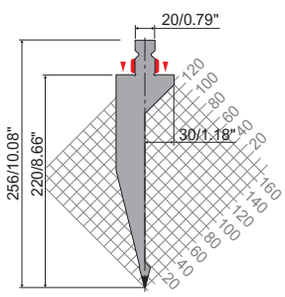
42Cr: 900-1150 N/mm² **600 kN/m max.**

500 mm	*19.68"*	25.0 kg	
250 mm	*9.84"*	12.5 kg	FC
550 mm	*21.65"*	28.0 kg	FW

W=220 | H=256 | R=1 mm
W=8.66 | H=10.08 | R=0.039 in

28°

.HORN 1



QL **FW: 550 mm - *21.65"***
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL **FC: 250 mm - *9.84"***
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR276.28.R1

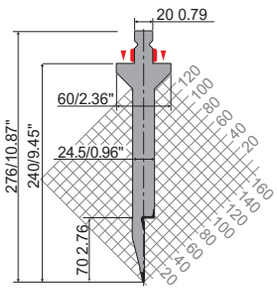
42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	24.0 kg	
250 mm	*9.84"*	12.0 kg	FC
550 mm	*21.65"*	26.4 kg	FW

W=240 | H=276 | R=1 mm
W=9.45 | H=10.87 | R=0.039 in

28°

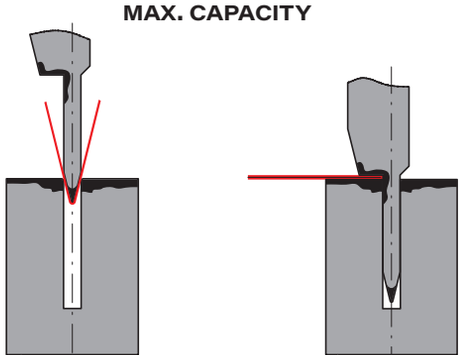
.HORN 1



.hemming tools TOP Series >>

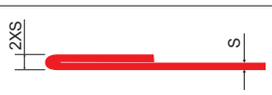
Hemming tools are used to prebend and afterwards flatten a sheet metal edge by using the same tool set.
Thanks to this operation you can strengthen sheet metal edges and avoid burr on their external side. For this reason, this operation is especially used for safety reason, i**n order to avoid operators' accidental injuries which may occurr to those who have to handle sheet metal parts.**
The maximum sheet metal thickness usually recommended for this operation is 3mm mild steel and 2mm stainless steel. However, for thicker sheet metal special solutions can be proposed, which consider the necessary bending force involved to flatten.
There are 2 types of flattening: partial flattening and total flattening.
Partial flattening is a kind of flattening which doesn't win against the sheet metal springback. For this reason, if you measure the flattened point, it won't be twice the sheet metal thickness but a bigger measure; for example, if you flatten 1.5mm partially, the flattened point will be about 4mm. This dimension depends on the bending force only. Hence, if you want to flatten 1.5mm mild steel and get 3mm high flattened point, you have to increase the tonnage. In the table below you can check the necessary tonnage according to sheet metal thickness and type.
The choice of hemming tools should be influenced by the sheet metal type to be flattened; 35° punch and dies are recommended to flatten aluminium and mild steel, which have small springback, whereas more resitant sheet metal types like stainless steel require at least 30°, or better 26°, punch and die.
Springback control is fundamental to win against sheet metal resistance during the flattening phase. In fact, if the angle obtained during the pre-bending phase is too wide, sheet metal will slip towards the operator during the flattening phase.
The choice of TOP series hemming tools with dies with U shape opening has to take into consideration the fact that the U opening of the die has to match perfectly with the punch tip width. These tools are 525mm long and the sectioned set is also available.

MAX. CAPACITY



500 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
0.60	*0.02*	3.0	*0.12*	90	150
0.80	*0.03*	3.0	*0.12*	120	200
1.00	*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
0.60	*0.02*	1.2	*0.05*	230	350
0.80	*0.03*	1.6	*0.06*	320	500
1.00	*0.04*	1.0	*0.04*	400	600
1.25	*0.05*	2.5	*0.10*	500	800

QL **FW: 550 mm - *21.65"***
mm: ◁ 100-100-50-45-40-35-30-25-25-100 ▷
in: ◁ 3.94-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98-3.94 ▷

QL **FC: 250 mm - *9.84"***
mm: 50-45-40-35-30-25-25
in: 1.97-1.77-1.57-1.37-1.18-0.98-0.98

TPR.SP.195.28.8

42Cr: 900-1150 N/mm²

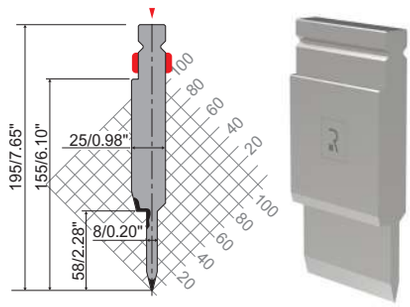
800-1000 kN/m max.

525 mm	*20.67"*	15.1 kg	
495 mm	*19.49"*	8.9 kg	F

W=155 | H=195 | R=0.6 mm
W=6.10 | H=7.68 | R=0.024 in

28°>

TO USE WITH:
TPR.SM.195.28.8
TPR.SM.195.24.8



TPR.SP.195.24.8

42Cr: 900-1150 N/mm²

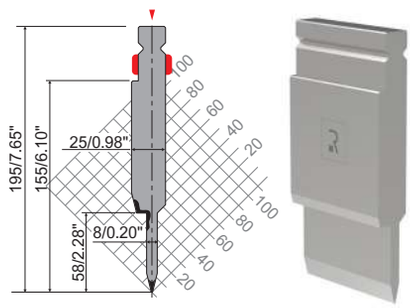
800-1000 kN/m max.

525 mm	*20.67"*	15.0 kg	
495 mm	*19.49"*	8.9 kg	F

W=155 | H=195 | R=0.6 mm
W=6.10 | H=7.68 | R=0.024 in

24°>

TO USE WITH:
TPR.SM.195.28.8
TPR.SM.195.24.8



TPR.SP.195.24.10

42Cr: 900-1150 N/mm²

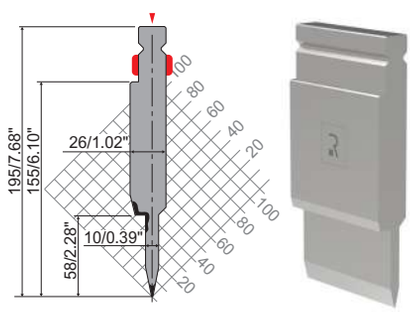
800-1000 kN/m max.

525 mm	*20.67"*	15.5 kg	
495 mm	*19.49"*	9.3 kg	F

W=155 | H=195 | R=0.6 mm
W=6.10 | H=7.68 | R=0.024 in

24°

TO USE WITH:
TPR.SM.195.24.10



TPR.SP.195.24.12

42Cr: 900-1150 N/mm²

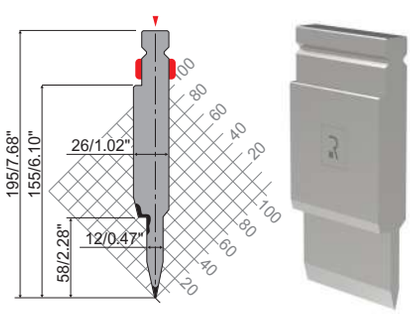
950 kN/m max.

525 mm	20.67"	16.0 kg	
495 mm	19.49"	9.5 kg	F

W=155 | H=195 | R=0.6 mm
W=6.10 | H=7.68 | R=0.024 in

24°

TO USE WITH:
TPR.SM.195.24.12

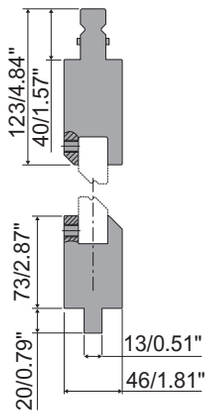


QL **F: 495 mm - *19.49"***
mm: 170-100-50-45-40-35-30-25
in: 1.70-3.94-1.97-1.77-1.57 -1.37-1.18-0.98

TPZ

C45: 900-1150 N/mm² **1000 kN/m max.**

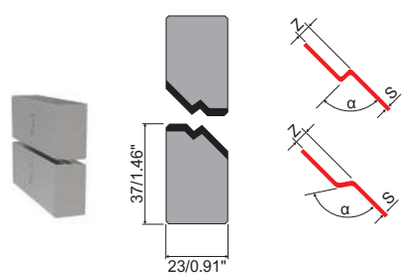
835 mm	*32.87"*	46.7 kg
415 mm	*16.34"*	23.2 kg

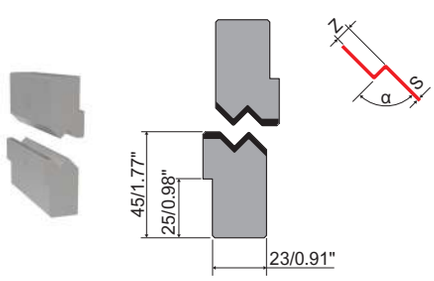


JOGGLE TOOLS INSERTS

C45: 560-710 N/mm² **1000 kN/m max.**

	Z mm	Z *in*	α	Thickness ! mm	Thickness ! *in*	835 mm *32.87 in*	415 mm *16.34 in*	
CEZ 1.0	1	*0.04*	160°	1.2	*0.05*	11 kg	5.5 kg	160°
CEZ 1.5	1.5	*0.06*	160°	1.5	*0.06*	11 kg	5.5 kg	
CEZ 2.0	2	*0.08*	150°	1.4	*0.06*	11 kg	5.5 kg	150°
CEZ 2.5	2.5	*0.10*	140°	1.3	*0.05*	11 kg	5.5 kg	140°
CEZ 1.0/90	1	*0.04*	90°	0.3	*0.01*	11 kg	5.5 kg	
CEZ 1.5/90	1.5	*0.06*	90°	0.3	*0.01*	11 kg	5.5 kg	
CEZ 2.0/90	2	*0.08*	90°	0.4	*0.02*	11 kg	5.5 kg	
CEZ 2.5/90	2.5	*0.10*	90°	0.5	*0.02*	11 kg	5.5 kg	
CEZ 3.0	3	*0.12*	90°	1.0	*0.04*	10.3 kg	5.1 kg	
CEZ 3.5	3.5	*0.14*	90°	1.0	*0.04*	10 kg	5.0 kg	
CEZ 4.0	4	*0.16*	90°	1.2	*0.05*	10 kg	5.0 kg	
CEZ 4.5	4.5	*0.18*	90°	1.2	*0.05*	10 kg	5.0 kg	90°
CEZ 5.0	5	*0.20*	90°	1.3	*0.05*	10 kg	5.0 kg	
CEZ 5.5	5.5	*0.22*	90°	1.4	*0.06*	10 kg	5.0 kg	
CEZ 6.0	6	*0.24*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 6.5	6.5	*0.26*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 7.0	7	*0.28*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 7.5	7.5	*0.30*	90°	1.6	*0.06*	10 kg	5.0 kg	
CEZ 8.0	8	*0.31*	90°	1.6	*0.06*	10 kg	5.0 kg	
CEZ 9.0	9	*0.35*	90°	1.8	*0.07*	13.5 kg	6.5 kg	
CEZ 10.0	10	*0.39*	90°	1.8	*0.07*	13.5 kg	5.0 kg	
CEZ 11.0	11	*0.43*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 12.0	12	*0.47*	90°	2	*0.08*	13.5 kg	5.0 kg	90°
CEZ 13.0	13	*0.51*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 14.0	14	*0.55*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 15.0	15	*0.59*	90°	2.3	*0.09*	13.5 kg	5.0 kg	





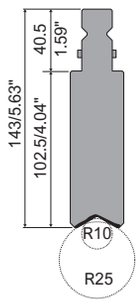
Joggle tools can make two bends at the same time, so the bending process is extremely quick, as during the bending process sheet metal overturn is not necessary.
Furthermore,by using the same CPZ holder you can produce 15 different joggles by changing inserts only and bending result is guaranteed.
Z dimensions and angles mentioned in the above table are valid only to bend mild steel with max. tensile strength 420 N/mm2. If you have to bend other sheet metal types, please contact our technical department at **sales@rolleri.it**

TPR143.10

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

525 mm	*20.67"*	18.0 kg	
495 mm	*19.49"*	17.0 kg	F

W=102.5 | H=143 mm
W=4.04 | H=5.63 in

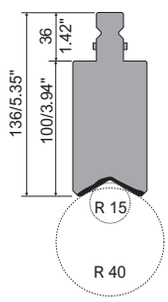


TPR136.15

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

525 mm	*20.67"*	25.0 kg	
495 mm	*19.49"*	23.7 kg	F

W=100 | H=136 mm
W=3.94 | H=5.35 in

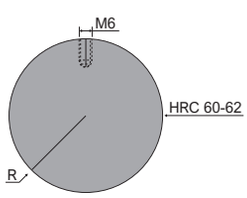


RADIUS TOOLS: R10-R40

C45: 560-710 N/mm² **1000 kN/m max.**

	R mm	*R in*	525 mm *20.67 in*	FA
TOP.C10	10.0	*0.39*	1.3 kg	1.2 kg
TOP.C11	11.0	*0.43*	1.6 kg	1.5 kg
TOP.C12.5	12.5	*0.49*	2.0 kg	1.9 kg
TOP.C14	14.0	*0.55*	2.5 kg	2.4 kg
TOP.C15	15.0	*0.59*	2.9 kg	2.7 kg
TOP.C16	16.0	*0.63*	3.3 kg	3.1 kg
TOP.C17.5	17.5	*0.69*	4.0 kg	3.7 kg
TOP.C19	19.0	*0.75*	4.7 kg	4.4 kg
TOP.C20	20.0	*0.79*	5.2 kg	4.9 kg
TOP.C21	21.0	*0.83*	5.7 kg	5.4 kg
TOP.C22.5	22.5	*0.88*	6.6 kg	6.2 kg
TOP.C24	24.0	*0.94*	7.5 kg	7.0 kg
TOP.C25	25.0	*0.98*	8.1 kg	7.6 kg
TOP.C27.5	27.5	*1.08*	9.8 kg	9.2 kg
TOP.C30	30.0	*1.18*	11.6 kg	11.0 kg
TOP.C32.5	32.5	*1.28*	13.7 kg	12.9 kg
TOP.C35	35.0	*1.14*	15.9 kg	14.9 kg
TOP.C37.5	37.5	*1.47*	18.2 kg	17.2 kg
TOP.C40	40.0	*1.57*	20.7 kg	19.5 kg

The same holder can be equipped with different radius tools and, in case of TPR140-14, also with E30.22 flat hemming insert to flatten thick sheet metal.
Radius profiles bent with radius tools show a more regular shape and therefore they aesthetically look better.
PU holders and C radius tools have been designed to guarantee the maximum flexibility thanks to the wide range of different radius tools which can be used. For specific needs the same concept can be used for special shapes like U shapes, omega etc..
The assembly system has been studied in order to be flexible and to guarantee the easy and quick radius tool change.



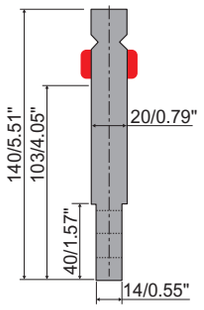
QL **F: 495 mm - *19.49"***
mm: 170-100-50-45-40-35-30-25
in: 1.70-3.94-1.97-1.77-1.57 -1.37-1.18-0.98

TPR140-14

C45: 560-710 N/mm2 **800 kN/m max.**

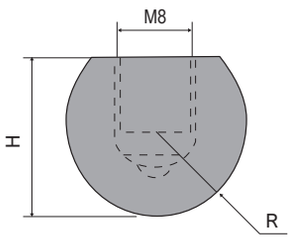
830 mm	*32.69"*	17.0 kg
412 mm	*16.22"*	9.0 kg

W=103 | H=140 mm
W=4.05 | H=5.51 in



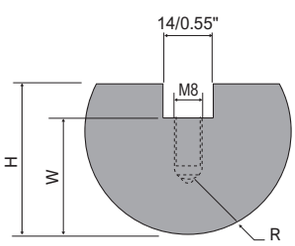
RADIUS TOOLS Ø 16 - 20

	R	*R*	H	*H*	A	*A*	835 mm	415 mm
	mm	*in*	mm	*in*	mm	*in*	*32.87 in*	*16.34 in*
C13.08	8	*0.31*	13	*0.51*	-	-	2.0 kg	1.0 kg
C13.09	9	*0.35*	16	*0.63*	-	-	2.0 kg	1.0 kg
C16.10	10	*0.39*	16	*0.63*	-	-	2.0 kg	1.0 kg



RADIUS TOOLS Ø 25 - 100

	R	*R*	H	*H*	A	*A*	835 mm	415 mm
	mm	*in*	mm	*in*	mm	*in*	*32.87 in*	*16.34 in*
C17.12	12.5	*0.49*	17	*0.67*	22	*0.87*	2.5 kg	1.2 kg
C20.15	15	*0.59*	20	*0.79*	27	*1.06*	3.7 kg	1.8 kg
C22.17	17.5	*0.69*	22	*0.87*	32	*1.26*	5.0 kg	2.4 kg
C24.20	20	*0.79*	24	*0.94*	34	*1.33*	7.0 kg	3.5 kg
C25.22	22.5	*0.89*	25	*0.98*	35	*1.38*	7.5 kg	3.8 kg
C29.25	25	*0.98*	29	*1.14*	39	*1.53*	10.0 kg	4.7 kg
C34.27	27.5	*1.08*	34	*1.33*	44	*1.73*	12.4 kg	6.2 kg
C34.30	30	*1.18*	34	*1.33*	44	*1.73*	13.5 kg	6.7 kg
C37.32	32.5	*1.28*	37	*1.46*	47	*1.85*	15.9 kg	7.9 kg
C45.35	35	*1.38*	45	*1.77*	55	*2.16*	20.3 kg	10.0 kg
C42.37	37.5	*1.48*	42	*1.65*	52	*2.04*	20.5 kg	10.3 kg
C45.40	40	*1.57*	45	*1.77*	55	*2.16*	23.0 kg	11.5 kg
C60.45	45	*1.77*	60	*2.36*	70	*2.75*	34.0 kg	17.0 kg
C70.50	50	*1.97*	70	*2.75*	80	*3.15*	43.5 kg	21.7 kg

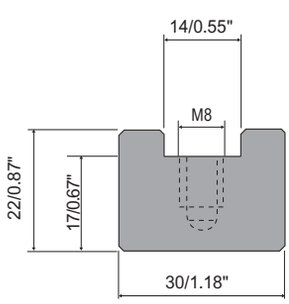


E30.22

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	3.5 kg
415 mm	*16.34"*	1.7 kg

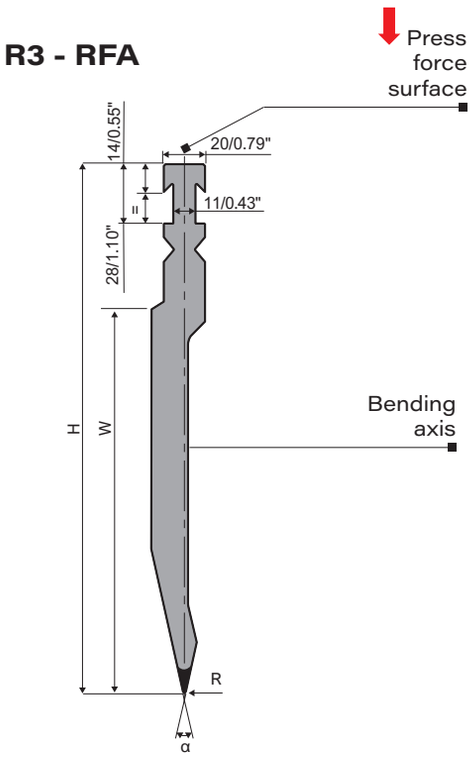
HEMMING TOOLS



.R3 punches

Compatible with press brakes: Bystronic Beyeler RFA.

.standard tang



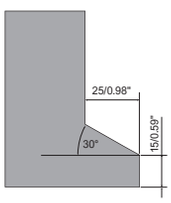
.standard length

	RFA series
415 mm | *16.24"*	O
500 mm | *19.68"*	O
508 mm | *20.00"*	O
525 mm | *20.67"*	O
835 mm | *32.87"*	O
1000 mm | *39.37"*	O

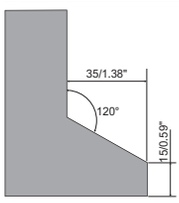
O available for some tool models only

.horn types

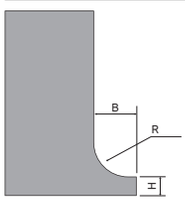
Check the standard horn in each code. All the other horns are available on request based on the series of the tool - check the feasibility with sales@rolleri.it



1 - R3 BP



2 - R3 BPR



X - customized horn on your indication

Create your account on www.rolleritools.com. You can use our website to ask for offers, keep you up to date on the latest news, check prices and place orders online.

.segmentation

Customised sectioning is also available on request. Check the feasibility with sales@rolleri.it

◁ = left horn ▷ = right horn

F-BP: 1100 mm - *43.30"*

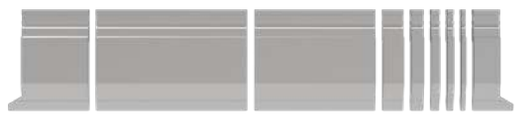
mm: ◁ 100-300-200-100-75-60-50-40-30-20-15-10-100 ▷

in: ◁ 3.94-11.81-7.87-3.94-2.95-2.36-1.97-1.57-1.18-0.79-0.59-0.39-3.94 ▷

F-BPR: 1100 mm - *43.30"*

mm: ◁ 200-375-300-50-30-20-15-10-100 ▷

in:◁ 7.87-14.76-11.81-1.97-1.18-0.79-0.59-0.39-3.94 ▷



F: 495 mm - *19.48"*

mm: 170-100-50-45-40-35-30-25

in: 7.87-3.94-1.97-1.77-1.57-1.38-1.18-0.98

Rolleri BLACKFIRE is a surface treatment against steel oxidation. After such treatment tools become black and laser marking golden.

Rolleri FREEZINC is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation.

BP.175.88.R1-A-RFA

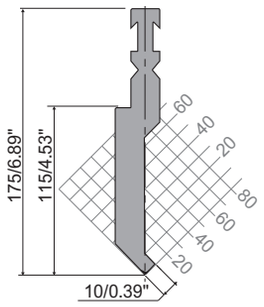
42Cr: 900-1150 N/mm² **1000 kN/m max.**

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

W=115 | H=175 | R=1.0 mm
W=4.53 | H=6.89 | R=0.039 in

88°>

.HORN 1



BP.175.88.R1-B-RFA

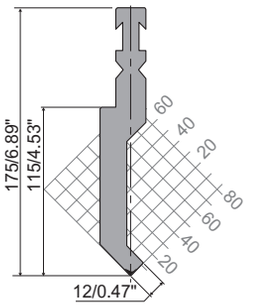
42Cr: 900-1150 N/mm² **1000 kN/m max.**

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

W=115 | H=175 | R=1.0 mm
W=4.53 | H=6.89 | R=0.039 in

88°

.HORN 1



BP.175.88.R15-RFA

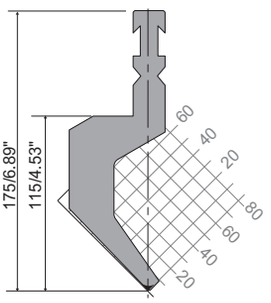
42Cr: 900-1150 N/mm² **500 kN/m max.**

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

W=115 | H=175 | R=1.5 mm
W=4.53 | H=6.89 | R=0.059 in

88°

.HORN 1



BPR.250.P3-RFA

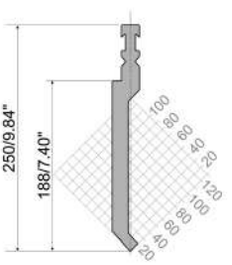
42Cr: 900-1150 N/mm² **1000 kN/m max.**

508 mm	*20.00"*	17.6 kg	
1100 mm	*43.31"*	38.0 kg	F

W=188 | H=250 | R=1.0 mm
W=7.40 | H=9.84 | R=0.039 in

85°>

.HORN 2



BPR.250.P4-RFA

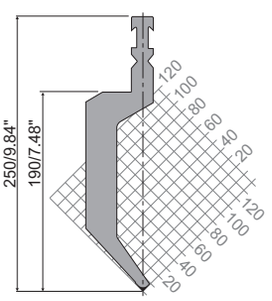
42Cr: 900-1150 N/mm² **900 kN/m max.**

508 mm	*20.00"*	27.4 kg	
1100 mm	*43.31"*	59.0 kg	F

W=190 | H=250 | R=1.5 mm
W=7.48 | H=9.84 | R=0.059 in

85°

.HORN 2



F-BPR: 1100 mm - *43.30"*
mm: ◁ 200-375-300-50-30-20-15-10-100 ▷
in: ◁ 7.87-14.76-11.81-1.97-1.18-0.79-0.59-0.39-3.94 ▷

F-BP: 1100 mm - *43.30"*
mm: ◁ 100-300-200-100-75-60-50-40-30-20-15-10-100 ▷
in: ◁3.94-11.81-7.87-3.94-2.95-2.36-1.97-1.57-1.18-0.79-0.59-0.39-3.94▷

BP.175.30.R1-RFA

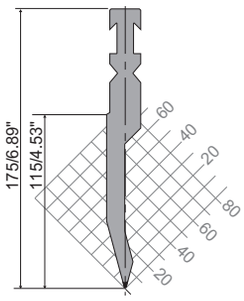
42Cr: 900-1150 N/mm² **900 kN/m max.**

1000 mm	*39.37"*	16.0 kg	
500 mm	*19.68"*	8.0 kg	
1100 mm	*43.31"*	17.6 kg	F

W=115 | H=175 | R=1.0 mm
W=4.53 | H=6.89 | R=0.039 in

30°>

.HORN 1



BPR.250.P6-RFA

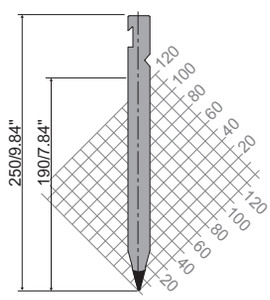
42Cr: 900-1150 N/mm² **1400 kN/m max.**

508 mm	*20.00"*	27.4 kg	
1100 mm	*43.31"*	59.0 kg	F

W=190 | H=250 | R=1.0 mm
W=7.48 | H=9.84 | R=0.039 in

30°

.HORN 2



BPR.250.P7-RFA

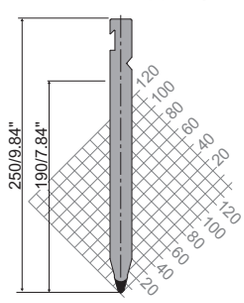
42Cr: 900-1150 N/mm² **1400 kN/m max.**

508 mm	*20.00"*	27.4 kg	
1100 mm	*43.31"*	59.0 kg	F

W=190 | H=250 | R=3.0 mm
W=7.84 | H=9.84 | R=0.11 in

30°

.HORN 2



BPR.250.P5.30.RFA

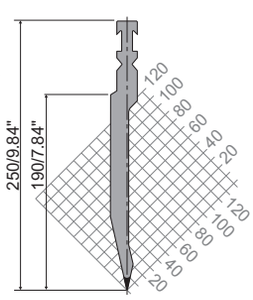
42Cr: 900-1150 N/mm² **750 kN/m max.**

508 mm	*20.00"*	27.4 kg	
1100 mm	*43.31"*	59.0 kg	F

W=190 | H=250 | R=1.0 mm
W=7.48 | H=9.84 | R=0.039 in

30°

.HORN 2



BPR.250.P5-RFA

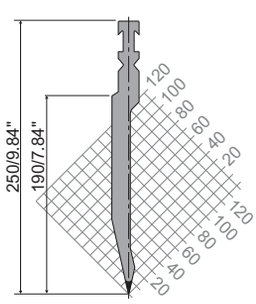
42Cr: 900-1150 N/mm² **1000 kN/m max.**

508 mm	*20.00"*	27.4 kg	
1100 mm	*43.31"*	59.0 kg	F

W=190 | H=250 | R=1.0 mm
W=7.84 | H=9.84 | R=0.039 in

26°>

.HORN 2



F-BPR: 1100 mm - *43.30"*
mm: ◁ 200-375-300-50-30-20-15-10-100 ▷
in: ◁ 7.87-14.76-11.81-1.97-1.18-0.79-0.59-0.39-3.94 ▷

F-BP: 1100 mm - *43.30"*
mm: ◁ 100-300-200-100-75-60-50-40-30-20-15-10-100 ▷
in: ◁3.94-11.81-7.87-3.94-2.95-2.36-1.97-1.57-1.18-0.79-0.59-0.39-3.94▷

BPR.SP-195.28.6

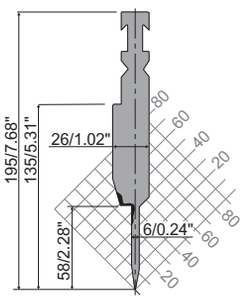
42Cr: 900-1150 N/mm² **800-1000 kN/m max.**

525 mm	*20.67"*	8.7 kg	
495 mm	*19.49"*	8.2 kg	F

W=135 | H=195 | R=0.6 mm
W=5.31 | H=7.68 | R=0.024 in

28°>

TO USE WITH:
BPR.SM.195.28.6
SM55.12.30/C



For all information relating to hemming tools see page 87.

BPR.SP-195.28.8

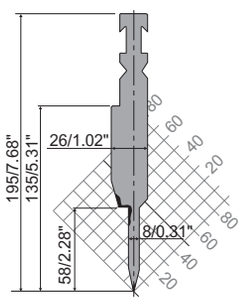
42Cr: 900-1150 N/mm² **800-1000 kN/m max.**

525 mm	*20.67"*	8.7 kg	
495 mm	*19.49"*	8.2 kg	F

W=135 | H=195 | R=0.6 mm
W=5.31 | H=7.68 | R=0.024 in

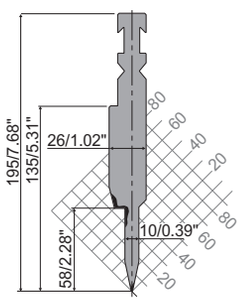
28°

TO USE WITH:
BPR.SM.195.28.8



BPR.SP-195.24.10

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



525 mm	*20.67"*	8.7 kg	
495 mm	*19.49"*	8.2 kg	F

W=135 | H=195 | R=0.6 mm
W=5.31 | H=7.68 | R=0.024 in

24°>

TO USE WITH:
BPR.SM.195.24.10

BPR.SP-195.24.12

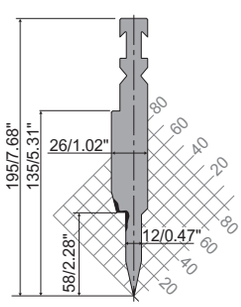
42Cr: 900-1150 N/mm² **800-1000 kN/m max.**

525 mm	*20.67"*	8.7 kg	
495 mm	*19.49"*	8.2 kg	F

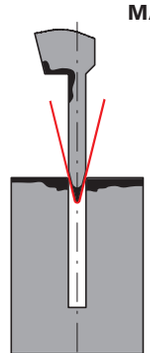
W=135 | H=195 | R=0.6 mm
W=5.31 | H=7.68 | R=0.024 in

24°

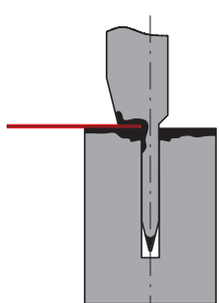
TO USE WITH:
BPR.SM.195.24.12



MAX. CAPACITY



500 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
0.60	*0.02*	3.0	*0.12*	90	150
0.80	*0.03*	3.0	*0.12*	120	200
1.00	*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
0.60	*0.02*	1.2	*0.05*	230	350
0.80	*0.03*	1.6	*0.06*	320	500
1.00	*0.04*	1.0	*0.04*	400	600
1.25	*0.05*	2.5	*0.10*	500	800

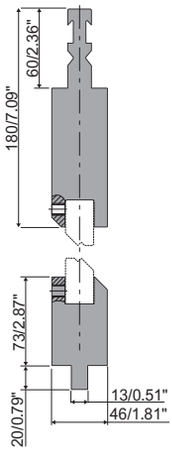
F: 495 mm - *19.48"*
mm: 170-100-50-45-40-35-30-25
in: 7.87-3.94-1.97-1.77-1.57-1.38-1.18-0.98

BPZ-RFA

C45: 560-710 N/mm²

1000 kN/m max.

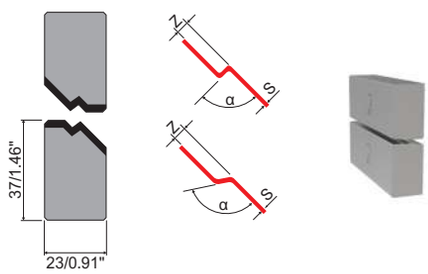
835 mm	*32.87"*	37.5 kg
415 mm	*16.34"*	18.7 kg

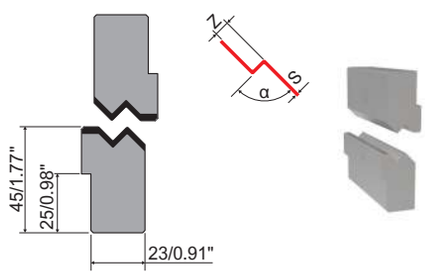


JOGGLE TOOLS INSERTS

C45: 560-710 N/mm² **1000 kN/m max.**

	Z mm	Z in	α	Thickness ! mm	in	835 mm 32.87 in	415 mm 16.34 in	
CEZ 1.0	1	*0.04*	160°	1.2	*0.05*	11 kg	5.5 kg	160°
CEZ 1.5	1.5	*0.06*	160°	1.5	*0.06*	11 kg	5.5 kg	
CEZ 2.0	2	*0.08*	150°	1.4	*0.06*	11 kg	5.5 kg	150°
CEZ 2.5	2.5	*0.10*	140°	1.3	*0.05*	11 kg	5.5 kg	140°
CEZ 1.0/90	1	*0.04*	90°	0.3	*0.01*	11 kg	5.5 kg	
CEZ 1.5/90	1.5	*0.06*	90°	0.3	*0.01*	11 kg	5.5 kg	
CEZ 2.0/90	2	*0.08*	90°	0.4	*0.02*	11 kg	5.5 kg	
CEZ 2.5/90	2.5	*0.10*	90°	0.5	*0.02*	11 kg	5.5 kg	
CEZ 3.0	3	*0.12*	90°	1.0	*0.04*	10.3 kg	5.1 kg	
CEZ 3.5	3.5	*0.14*	90°	1.0	*0.04*	10 kg	5.0 kg	
CEZ 4.0	4	*0.16*	90°	1.2	*0.05*	10 kg	5.0 kg	
CEZ 4.5	4.5	*0.18*	90°	1.2	*0.05*	10 kg	5.0 kg	90°
CEZ 5.0	5	*0.20*	90°	1.3	*0.05*	10 kg	5.0 kg	
CEZ 5.5	5.5	*0.22*	90°	1.4	*0.06*	10 kg	5.0 kg	
CEZ 6.0	6	*0.24*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 6.5	6.5	*0.26*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 7.0	7	*0.28*	90°	1.5	*0.06*	10 kg	5.0 kg	
CEZ 7.5	7.5	*0.30*	90°	1.6	*0.06*	10 kg	5.0 kg	
CEZ 8.0	8	*0.31*	90°	1.6	*0.06*	10 kg	5.0 kg	
CEZ 9.0	9	*0.35*	90°	1.8	*0.07*	13.5 kg	6.5 kg	
CEZ 10.0	10	*0.39*	90°	1.8	*0.07*	13.5 kg	5.0 kg	
CEZ 11.0	11	*0.43*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 12.0	12	*0.47*	90°	2	*0.08*	13.5 kg	5.0 kg	90°
CEZ 13.0	13	*0.51*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 14.0	14	*0.55*	90°	2	*0.08*	13.5 kg	5.0 kg	
CEZ 15.0	15	*0.59*	90°	2.3	*0.09*	13.5 kg	5.0 kg	





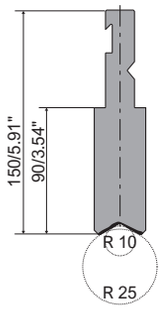
Joggle tools can make two bends at the same time, so the bending process is extremely quick.
Furthermore, it is very flexible and convenient, as by using the same BPZ holder you can produce 15 different joggles by changing inserts only. By using CEZ inserts, the bending result is guaranteed. Z dimensions and angles mentioned in the above table are valid only to bend mild steel with max. tensile strength 420 N/mm2.
If you have to bend other sheet metal types, please contact our technical department at sales@rolleri.it

BPR.150.P10.10-RFA

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

522 mm	*20.55"*	16.5 kg
495 mm	*19.49"*	16.0 kg

W=90 | H=150 | R=1.0 mm
W=3.54 | H=5.91 | R=0.039 in

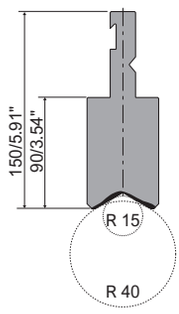


BPR.150.P10.15-RFA

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

522 mm	*20.55"*	23.0 kg
495 mm	*19.49"*	21.7 kg

W=90 | H=150 | R=1.0 mm
W=3.54 | H=5.91 | R=0.039 in

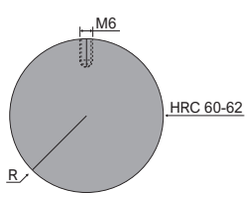


RADIUS TOOLS: R10-R40

C45: 560-710 N/mm² **1000 kN/m max.**

	R mm	*R in*	525 mm *20.67 in*	FA
TOP.C10	10.0	*0.39*	1.3 kg	1.2 kg
TOP.C11	11.0	*0.43*	1.6 kg	1.5 kg
TOP.C12.5	12.5	*0.49*	2.0 kg	1.9 kg
TOP.C14	14.0	*0.55*	2.5 kg	2.4 kg
TOP.C15	15.0	*0.59*	2.9 kg	2.7 kg
TOP.C16	16.0	*0.63*	3.3 kg	3.1 kg
TOP.C17.5	17.5	*0.69*	4.0 kg	3.7 kg
TOP.C19	19.0	*0.75*	4.7 kg	4.4 kg
TOP.C20	20.0	*0.79*	5.2 kg	4.9 kg
TOP.C21	21.0	*0.83*	5.7 kg	5.4 kg
TOP.C22.5	22.5	*0.88*	6.6 kg	6.2 kg
TOP.C24	24.0	*0.94*	7.5 kg	7.0 kg
TOP.C25	25.0	*0.98*	8.1 kg	7.6 kg
TOP.C27.5	27.5	*1.08*	9.8 kg	9.2 kg
TOP.C30	30.0	*1.18*	11.6 kg	11.0 kg
TOP.C32.5	32.5	*1.28*	13.7 kg	12.9 kg
TOP.C35	35.0	*1.14*	15.9 kg	14.9 kg
TOP.C37.5	37.5	*1.47*	18.2 kg	17.2 kg
TOP.C40	40.0	*1.57*	20.7 kg	19.5 kg

The same holder can be equipped with different radius tools and, in case of BPU, also with E30.22 flat hemming insert to flatten thick sheet metal.
Radius profiles bent with radius tools show a more regular shape and therefore they aesthetically look better.
PU holders and C radius tools have been designed to guarantee the maximum flexibility thanks to the wide range of different radius tools which can be used. For specific needs the same concept can be used for special shapes like U shapes, omega etc..
The assembly system has been studied in order to be flexible and to guarantee the easy and quick radius tool change.



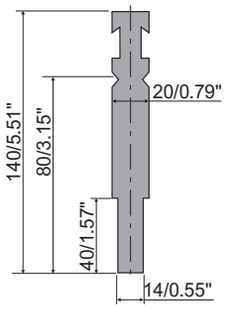
F: 495 mm - *19.48"*
mm: 170-100-50-45-40-35-30-25
in: 7.87-3.94-1.97-1.77-1.57-1.38-1.18-0.98

BPU-RFA

C45: 560-710 N/mm² **800 kN/m max.**

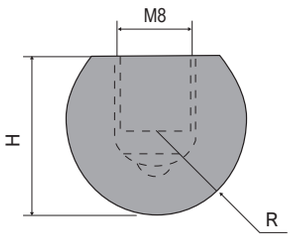
830 mm	*32.68"*	15.3 kg
410 mm	*16.14"*	7.6 kg

W=80 | H=140 mm
W=3.15 | H=5.51 in



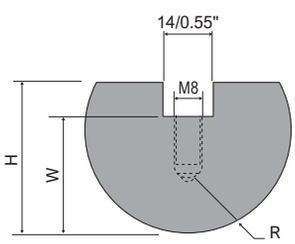
RADIUS TOOLS Ø 16 - 20

	R	*R*	H	*H*	A	*A*	835 mm	415 mm
	mm	*in*	mm	*in*	mm	*in*	*32.87 in*	*16.34 in*
C13.08	8	*0.31*	13	*0.51*	-	-	2.0 kg	1.0 kg
C13.09	9	*0.35*	16	*0.63*	-	-	2.0 kg	1.0 kg
C16.10	10	*0.39*	16	*0.63*	-	-	2.0 kg	1.0 kg



RADIUS TOOLS Ø 25 - 100

	R	*R*	H	*H*	A	*A*	835 mm	415 mm
	mm	*in*	mm	*in*	mm	*in*	*32.87 in*	*16.34 in*
C17.12	12.5	*0.49*	17	*0.67*	22	*0.87*	2.5 kg	1.2 kg
C20.15	15	*0.59*	20	*0.79*	27	*1.06*	3.7 kg	1.8 kg
C22.17	17.5	*0.69*	22	*0.87*	32	*1.26*	5.0 kg	2.4 kg
C24.20	20	*0.79*	24	*0.94*	34	*1.33*	7.0 kg	3.5 kg
C25.22	22.5	*0.89*	25	*0.98*	35	*1.38*	7.5 kg	3.8 kg
C29.25	25	*0.98*	29	*1.14*	39	*1.53*	10.0 kg	4.7 kg
C34.27	27.5	*1.08*	34	*1.33*	44	*1.73*	12.4 kg	6.2 kg
C34.30	30	*1.18*	34	*1.33*	44	*1.73*	13.5 kg	6.7 kg
C37.32	32.5	*1.28*	37	*1.46*	47	*1.85*	15.9 kg	7.9 kg
C45.35	35	*1.38*	45	*1.77*	55	*2.16*	20.3 kg	10.0 kg
C42.37	37.5	*1.48*	42	*1.65*	52	*2.04*	20.5 kg	10.3 kg
C45.40	40	*1.57*	45	*1.77*	55	*2.16*	23.0 kg	11.5 kg
C60.45	45	*1.77*	60	*2.36*	70	*2.75*	34.0 kg	17.0 kg
C70.50	50	*1.97*	70	*2.75*	80	*3.15*	43.5 kg	21.7 kg

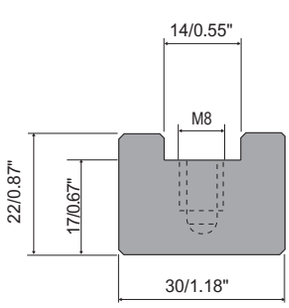


E30.22

C45: 560-710 N/mm² **800 kN/m max.**

835 mm	*32.87"*	3.5 kg
415 mm	*16.34"*	1.7 kg

HEMMING TOOLS

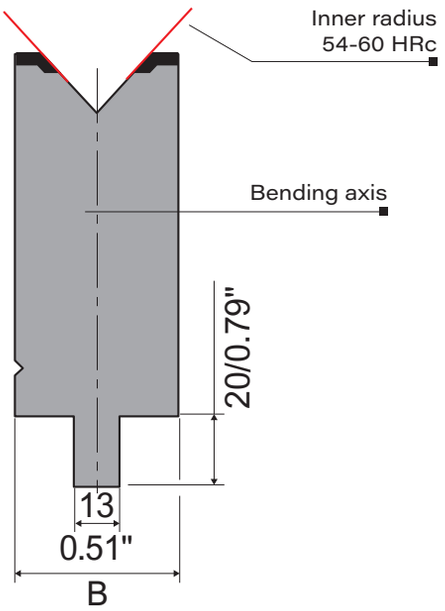


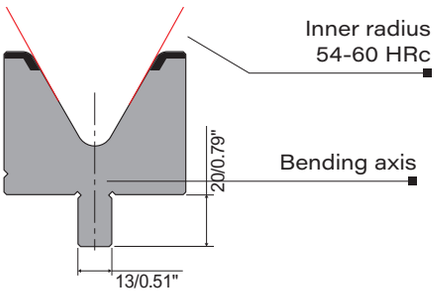
.R2-R3 dies

Compatibles with press brakes: Bystronic Beyeler RFA, Bystronic Beyeler RF, Bystronic Beyeler R, Bystronic Beyeler S, Darley, Safan, SMD, Trumpf and press brake machines with system NSCR.

.standard tang

All Rolleri R2-R3 dies have got 13x20 mm 0.51x0.79 in tang.





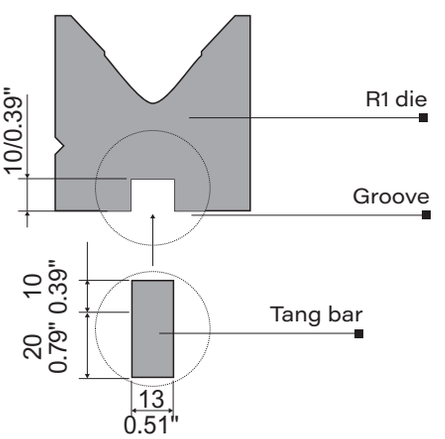
.standard length

500 mm | *19.68"*
515 mm | *20.28"*
525 mm | *20.67"*
1000 mm | *39.36"*

.modification wedge/bar tail

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

A30 - example



.segmentation

Single segments are also available on request.
sales@rolleri.it to know more about price and availability

FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

F: 495 mm - *19.49"*
mm: 170-100-50-45-40-35-30-25
in: 6.69-3.94-1.97-1.77-1.57-1.37-1.18-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

F: 1100 mm - *43.31"*
mm: 400-200-100-100-75-60-50-40-30-20-15-10
in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

Available on request:

FA mm: 1250-2050-2550-3050-4050
FA in: 49.21-80.71-100.39-120.08-159.45

Length		25	30	35	40	45	50	100	100	100
mm	*in*	*0.98*	*1.18*	*1.18*	*1.18*	*1.18*	*1.97*	*3.94*	*3.94*	*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

FB mm: 1250-2050-2550-3050-4050
FB in: 49.21-80.71-100.39-120.08-159.45

Length		25	30	35	40	45	50	100	200	300	500
mm	*in*	*0.98*	*1.18*	*1.18*	*1.18*	*1.18*	*1.97*	*3.94*	*7.87*	*11.81*	*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

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Rolleri BLACKFIRE is a surface treatment against steel oxidation. After such treatment tools become black and laser marking golden.

Rolleri FREEZINC is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation.

BMR55.06.90

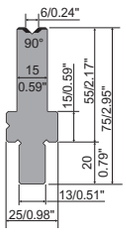
42Cr: 900-1150 N/mm² **1150 kN/m max.**

1000 mm	*39.37"*	8.5 kg	
500 mm	*19.68"*	4.2 kg	
1100 mm	*43.31"*	9.3 kg	F
550 mm	*21.65"*	4.6 kg	FW

W=55 | H=75 | R=0.4 | V=6

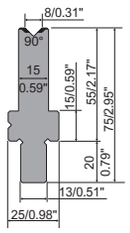
W=2.17 | H=2.36 | R=0.016 | V=0.24

90°>



BMR55.08.90

42Cr: 900-1150 N/mm² **1100 kN/m max.**



1000 mm	*39.37"*	9.0 kg	
500 mm	*19.68"*	4.5 kg	
1100 mm	*43.31"*	9.9 kg	F
550 mm	*21.65"*	4.6 kg	FW

W=55 | H=75 | R=0.5 | V=8

W=2.17 | H=2.36 | R=0.020 | V=0.31

90°

BMR55.10.90

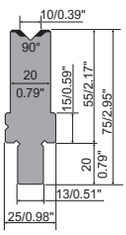
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	10.5 kg	
500 mm	*19.68"*	5.2 kg	
1100 mm	*43.31"*	11.5 kg	F
550 mm	*21.65"*	5.7 kg	FW

W=55 | H=75 | R=1.0 | V=10

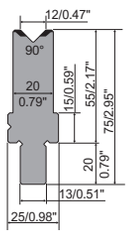
W=2.17 | H=2.36 | R=0.039 | V=0.39

90°



BMR55.12.90

42Cr: 900-1150 N/mm² **1200 kN/m max.**



1000 mm	*39.37"*	10.5 kg	
500 mm	*19.68"*	5.2 kg	
1100 mm	*43.31"*	11.5 kg	F
550 mm	*21.65"*	5.7 kg	FW

W=55 | H=75 | R=1.5 | V=12

W=2.17 | H=2.36 | R=0.059 | V=0.47

90°

BMR55.16.90

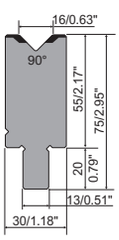
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	14.5 kg	
500 mm	*19.68"*	7.2 kg	
1100 mm	*43.31"*	16.0 kg	F
550 mm	*21.65"*	7.9 kg	FW

W=55 | H=75 | R=2.0 | V=16

W=2.17 | H=2.36 | R=0.079 | V=0.63

90°



BMR55.06.88

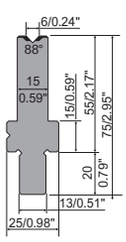
42Cr: 900-1150 N/mm² **1150 kN/m max.**

1000 mm	*39.37"*	8.5 kg	
500 mm	*19.68"*	4.2 kg	
1100 mm	*43.31"*	9.3 kg	F
550 mm	*21.65"*	4.6 kg	FW

W=55 | H=75 | R=0.4 | V=6

W=2.17 | H=2.36 | R=0.016 | V=0.24

88°>



F: 1100 mm - *43.31"*

mm: 400-200-100-100-75-60-50-40-30-20-15-10

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*

mm: 200-100-50-45-40-35-30-25-25

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

BMR55.08.88

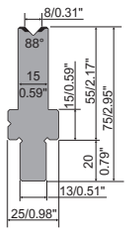
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	8.5 kg	
500 mm	*19.68"*	4.2 kg	
1100 mm	*43.31"*	9.3 kg	F
550 mm	*21.65"*	4.6 kg	FW

W=55 | H=75 | R=0.5 | V=8

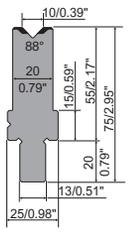
W=2.17 | H=2.36 | R=0.020 | V=0.31

88°



BMR55.10.88

42Cr: 900-1150 N/mm² **1100 kN/m max.**



1000 mm	*39.37"*	11.0 kg	
500 mm	*19.68"*	5.0 kg	
1100 mm	*43.31"*	12 kg	F
550 mm	*21.65"*	5.5 kg	FW

W=55 | H=75 | R=1.0 | V=10

W=2.17 | H=2.36 | R=0.039 | V=0.39

88°

BMR55.12.88

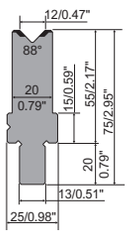
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	10.5 kg	
500 mm	*19.68"*	5.2 kg	
1100 mm	*43.31"*	11.5 kg	F
550 mm	*21.65"*	5.7 kg	FW

W=55 | H=75 | R=1.5 | V=12

W=2.17 | H=2.36 | R=0.059 | V=0.47

88°



BMR55.16.88

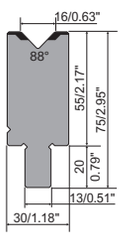
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	14.5 kg	
500 mm	*19.68"*	7.2 kg	
1100 mm	*43.31"*	16.0 kg	F
550 mm	*21.65"*	7.9 kg	FW

W=55 | H=75 | R=2.0 | V=16

W=2.17 | H=2.36 | R=0.079 | V=0.63

88°



BMR55.20.88

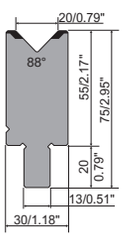
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	14.5 kg	
500 mm	*19.68"*	7.2 kg	
1100 mm	*43.31"*	16.0 kg	F
550 mm	*21.65"*	7.9 kg	FW

W=55 | H=75 | R=2.0 | V=20

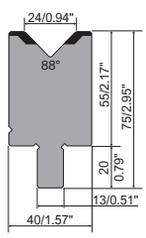
W=2.17 | H=2.36 | R=0.079 | V=0.79

88°



BMR55.24.88

42Cr: 900-1150 N/mm² **1200 kN/m max.**



1000 mm	*39.37"*	18.5 kg	
500 mm	*19.68"*	9.2 kg	
1100 mm	*43.31"*	20.3 kg	F
550 mm	*21.65"*	10.1 kg	FW

W=55 | H=75 | R=3.0 | V=24

W=2.17 | H=2.36 | R=0.118 | V=0.94

88°

F: 1100 mm - *43.31"*

mm: 400-200-100-100-75-60-50-40-30-20-15-10

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*

mm: 200-100-50-45-40-35-30-25-25

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

BMR55.06.85

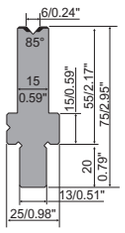
42Cr: 900-1150 N/mm² **1150 kN/m max.**

1000 mm	*39.37"*	8.5 kg	
500 mm	*19.68"*	4.2 kg	
1100 mm	*43.31"*	9.3 kg	F
550 mm	*21.65"*	4.6 kg	FW

W=55 | H=75 | R=0.4 | V=6

W=2.17 | H=2.36 | R=0.016 | V=0.24

85°>



BMR55.08.85

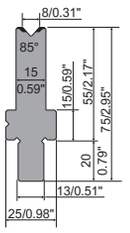
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	9.0 kg	
500 mm	*19.68"*	4.5 kg	
1100 mm	*43.31"*	9.3 kg	F
550 mm	*21.65"*	4.9 kg	FW

W=55 | H=75 | R=0.5 | V=8

W=2.17 | H=2.36 | R=0.020 | V=0.31

85°



BMR55.10.85

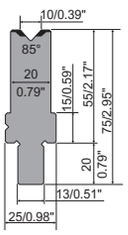
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	11.0 kg	
500 mm	*19.68"*	5.0 kg	
1100 mm	*43.31"*	12.0 kg	F
550 mm	*21.65"*	5.5 kg	FW

W=55 | H=75 | R=1.0 | V=10

W=2.17 | H=2.36 | R=0.039 | V=0.39

85°



BMR55.12.85

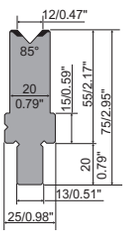
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	10.5 kg	
500 mm	*19.68"*	5.2 kg	
1100 mm	*43.31"*	11.5 kg	F
550 mm	*21.65"*	5.7 kg	FW

W=55 | H=75 | R=1.5 | V=12

W=2.17 | H=2.36 | R=0.059 | V=0.47

85°



BMR55.16.85

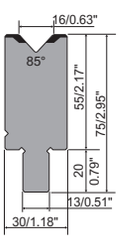
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	14.5 kg	
500 mm	*19.68"*	7.2 kg	
1100 mm	*43.31"*	16.0 kg	F
550 mm	*21.65"*	7.9 kg	FW

W=55 | H=75 | R=2.0 | V=16

W=2.17 | H=2.36 | R=0.079 | V=0.63

85°



BMR55.20.85

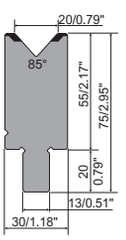
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	14.5 kg	
500 mm	*19.68"*	7.2 kg	
1100 mm	*43.31"*	16.0 kg	F
550 mm	*21.65"*	7.9 kg	FW

W=55 | H=75 | R=2.0 | V=20

W=2.17 | H=2.36 | R=0.079 | V=0.79

85°



BMR55.24.85

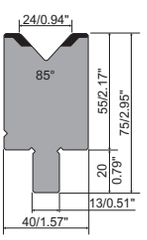
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	18.5 kg	
500 mm	*19.68"*	9.2 kg	
1100 mm	*43.31"*	20.3 kg	F
550 mm	*21.65"*	10.1 kg	FW

W=55 | H=75 | R=3.0 | V=24

W=2.17 | H=2.36 | R=0.118 | V=0.94

85°



BMR55.32.85

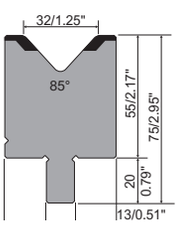
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	21.0 kg	
500 mm	*19.68"*	10.5 kg	
1100 mm	*43.31"*	23.0 kg	F
550 mm	*21.65"*	11.5 kg	FW

W=55 | H=75 | R=4.0 | V=32

W=2.17 | H=2.36 | R=0.157 | V=1.26

85°



F: 1100 mm - *43.31"*

mm: 400-200-100-100-75-60-50-40-30-20-15-10

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*

mm: 200-100-50-45-40-35-30-25-25

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

BMR55.40.85

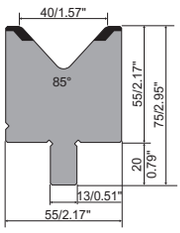
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	21.5 kg	
500 mm	*19.68"*	10.7 kg	
1100 mm	*43.31"*	25.0 kg	F
550 mm	*21.65"*	11.8 kg	FW

W=55 | H=75 | R=4.0 | V=40

W=2.17 | H=2.36 | R=0.157 | V=1.57

85°



BMR55.06.80

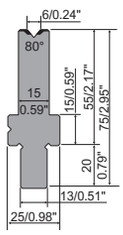
42Cr: 900-1150 N/mm² **1150 kN/m max.**

1000 mm	*39.37"*	8.5 kg	
500 mm	*19.68"*	4.2 kg	
1100 mm	*43.31"*	9.3 kg	F
550 mm	*21.65"*	4.6 kg	FW

W=55 | H=75 | R=0.4 | V=6

W=2.17 | H=2.36 | R=0.016 | V=0.24

80°>



BMR55.08.80

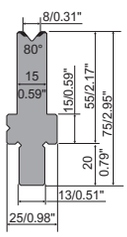
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	9.0 kg	
500 mm	*19.68"*	4.5 kg	
1100 mm	*43.31"*	9.3 kg	F
550 mm	*21.65"*	4.9 kg	FW

W=55 | H=75 | R=0.5 | V=8

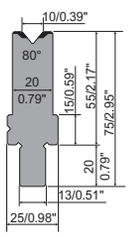
W=2.17 | H=2.36 | R=0.020 | V=0.31

80°



BMR55.10.80

42Cr: 900-1150 N/mm² **1100 kN/m max.**



1000 mm	*39.37"*	11.0 kg	
500 mm	*19.68"*	5.0 kg	
1100 mm	*43.31"*	12.0 kg	F
550 mm	*21.65"*	5.5 kg	FW

W=55 | H=75 | R=1.0 | V=10

W=2.17 | H=2.36 | R=0.039 | V=0.39

80°

BMR55.12.80

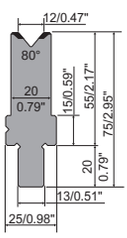
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	10.5 kg	
500 mm	*19.68"*	5.2 kg	
1100 mm	*43.31"*	11.5 kg	F
550 mm	*21.65"*	5.7 kg	FW

W=55 | H=75 | R=1.5 | V=12

W=2.17 | H=2.36 | R=0.059 | V=0.47

80°



F: 1100 mm - *43.31"*

mm: 400-200-100-100-75-60-50-40-30-20-15-10

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*

mm: 200-100-50-45-40-35-30-25-25

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

BMR55.16.80

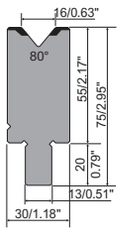
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	14.5 kg	
500 mm	*19.68"*	7.2 kg	
1100 mm	*43.31"*	16.0 kg	F
550 mm	*21.65"*	7.9 kg	FW

W=55 | H=75 | R=2.0 | V=16

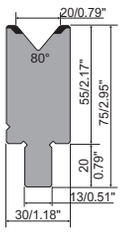
W=2.17 | H=2.36 | R=0.079 | V=0.63

80°



BMR55.20.80

42Cr: 900-1150 N/mm² **1100 kN/m max.**



1000 mm	*39.37"*	14.5 kg	
500 mm	*19.68"*	7.2 kg	
1100 mm	*43.31"*	16.0 kg	F
550 mm	*21.65"*	7.9 kg	FW

W=55 | H=75 | R=2.0 | V=20

W=2.17 | H=2.36 | R=0.079 | V=0.79

80°

BMR55.24.80

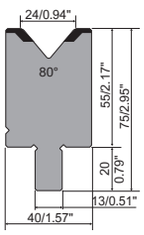
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	18.5 kg	
500 mm	*19.68"*	9.2 kg	
1100 mm	*43.31"*	20.3 kg	F
550 mm	*21.65"*	10.1 kg	FW

W=55 | H=75 | R=3.0 | V=24

W=2.17 | H=2.36 | R=0.118 | V=0.94

80°



BMR55.32.80

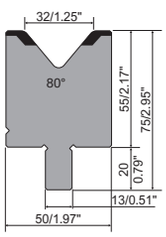
42Cr: 900-1150 N/mm² **1200 kN/m max.**

1000 mm	*39.37"*	21.0 kg	
500 mm	*19.68"*	10.5 kg	
1100 mm	*43.31"*	23.1 kg	F
550 mm	*21.65"*	11.5 kg	FW

W=55 | H=75 | R=4.0 | V=32

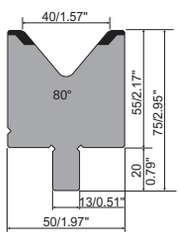
W=2.17 | H=2.36 | R=0.157 | V=1.26

80°



BMR55.40.80

42Cr: 900-1150 N/mm² **1200 kN/m max.**



1000 mm	*39.37"*	21.5 kg	
500 mm	*19.68"*	10.7 kg	
1100 mm	*43.31"*	25.0 kg	F
550 mm	*21.65"*	11.8 kg	FW

W=55 | H=75 | R=4.0 | V=40

W=2.17 | H=2.36 | R=0.157 | V=1.57

80°

BMR65.80.80

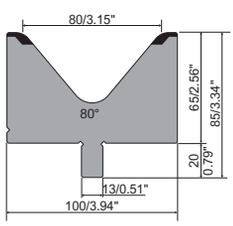
42Cr: 900-1150 N/mm² **1700 kN/m max.**

1000 mm	*39.37"*	39.0 kg	
500 mm	*19.68"*	20.0 kg	
1100 mm	*43.31"*	43.0 kg	F
550 mm	*21.65"*	22.0 kg	FW

W=65 | H=85 | R=10 | V=80

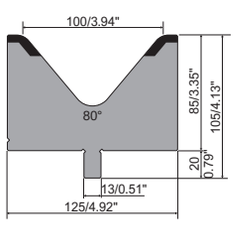
W=3.35 | H=3.35 | R=0.394 | V=3.15

80°



BMR85.100.80

42Cr: 900-1150 N/mm² **2300 kN/m max.**



1000 mm	*39.37"*	62.0 kg	
500 mm	*19.68"*	31.0 kg	
1100 mm	*43.31"*	69.0 kg	F
550 mm	*21.65"*	34.1 kg	FW

W=85 | H=105 | R=12 | V=100

W=3.53 | H=4.13 | R=0.472 | V=3.94

80°

F: 1100 mm - *43.31"*

mm: 400-200-100-100-75-60-50-40-30-20-15-10

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*

mm: 200-100-50-45-40-35-30-25-25

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

BMR55.40.60

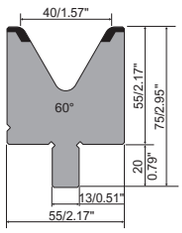
42Cr: 900-1150 N/mm² **1300 kN/m max.**

1000 mm	*39.37"*	20.3 kg	
500 mm	*19.68"*	10.5 kg	
1100 mm	*43.31"*	22.3 kg	F
550 mm	*21.65"*	11.5 kg	FW

W=55 | H=75 | R=5.0 | V=40

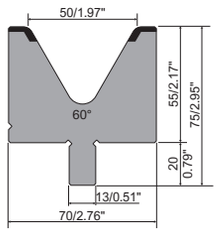
W=2.17 | H=2.36 | R=0.197 | V=1.57

60°>



BMR55.50.60

42Cr: 900-1150 N/mm² **1200 kN/m max.**



1000 mm	*39.37"*	24.0 kg	
500 mm	*19.68"*	12.0 kg	
1100 mm	*43.31"*	26.4 kg	F
550 mm	*21.65"*	13.2 kg	FW

W=55 | H=75 | R=5.0 | V=50

W=2.17 | H=2.36 | R=0.197 | V=1.97

60°

BMR65.60.60

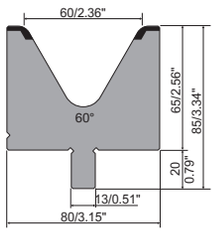
42Cr: 900-1150 N/mm² **1100 kN/m max.**

1000 mm	*39.37"*	31.0kg	
500 mm	*19.68"*	15.5 kg	
1100 mm	*43.31"*	34.1 kg	F
550 mm	*21.65"*	17.0 kg	FW

W=65 | H=85 | R=7.0 | V=60

W=3.35 | H=3.35 | R=0.276 | V=2.36

60°



BMR55.06.30

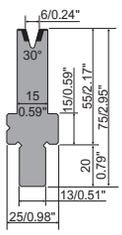
42Cr: 900-1150 N/mm² **350 kN/m max.**

1000 mm	*39.37"*	8.0 kg	
500 mm	*19.68"*	4.0 kg	
1100 mm	*43.31"*	9.0 kg	F
550 mm	*21.65"*	4.4 kg	FW

W=55 | H=75 | R=0.6 | V=6

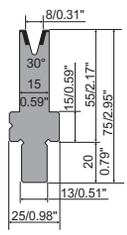
W=2.17 | H=2.36 | R=0.024 | V=0.24

30°>



BMR55.08.30

42Cr: 900-1150 N/mm² **200 kN/m max.**



1000 mm	*39.37"*	9.2 kg	
500 mm	*19.68"*	4.0 kg	
1100 mm	*43.31"*	10.1 kg	F
550 mm	*21.65"*	4.4 kg	FW

W=55 | H=75 | R=0.8 | V=8

W=2.17 | H=2.36 | R=0.031 | V=0.31

30°

BMR55.10.30

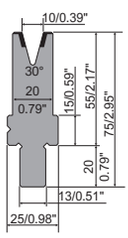
42Cr: 900-1150 N/mm² **350 kN/m max.**

1000 mm	*39.37"*	10.0 kg	
500 mm	*19.68"*	5.0 kg	
1100 mm	*43.31"*	11.0 kg	F
550 mm	*21.65"*	5.5 kg	FW

W=55 | H=75 | R=1.0 | V=10

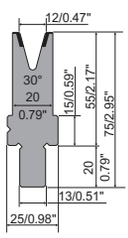
W=2.17 | H=2.36 | R=0.039 | V=0.39

30°



BMR55.12.30

42Cr: 900-1150 N/mm² **300 kN/m max.**



1000 mm	*39.37"*	10.0 kg	
500 mm	*19.68"*	5.0 kg	
1100 mm	*43.31"*	11.0 kg	F
550 mm	*21.65"*	5.5 kg	FW

W=55 | H=75 | R=1.5 | V=12

W=2.17 | H=2.36 | R=0.059 | V=0.47

30°

F: 1100 mm - *43.31"*

mm: 400-200-100-100-75-60-50-40-30-20-15-10

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*

mm: 200-100-50-45-40-35-30-25-25

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

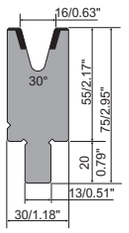
BMR55.16.30

42Cr: 900-1150 N/mm² **450 kN/m max.**

1000 mm	*39.37"*	13.5 kg	
500 mm	*19.68"*	6.7 kg	
1100 mm	*43.31"*	14.9 kg	F
550 mm	*21.65"*	7.4 kg	FW

W=55 | H=75 | R=2.0 | V=16
W=2.17 | H=2.36 | R=0.079 | V=0.63

30°



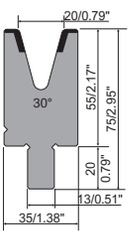
BMR55.20.30

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

1000 mm	*39.37"*	10.5 kg	
500 mm	*19.68"*	5.2 kg	
1100 mm	*43.31"*	11.5 kg	F
550 mm	*21.65"*	5.7 kg	FW

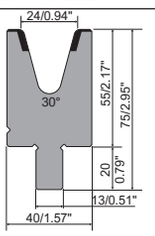
W=55 | H=75 | R=2.5 | V=20
W=2.17 | H=2.36 | R=0.098 | V=0.79

30°



BMR55.24.30

42Cr: 900-1150 N/mm² **550 kN/m max.**



1000 mm	*39.37"*	15.5 kg	
500 mm	*19.68"*	7.8 kg	
1100 mm	*43.31"*	17.0 kg	F
550 mm	*21.65"*	8.6 kg	FW

W=55 | H=75 | R=3.0 | V=24
W=2.17 | H=2.36 | R=0.118 | V=0.94

30°

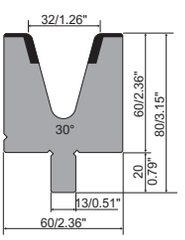
BMR60.32.30

42Cr: 900-1150 N/mm² **650 kN/m max.**

1000 mm	*39.37"*	23.0 kg	
500 mm	*19.68"*	11.5 kg	
1100 mm	*43.31"*	25.3 kg	F
550 mm	*21.65"*	12.7 kg	FW

W=60 | H=80 | R=4.0 | V=32
W=2.36 | H=3.15 | R=0.157 | V=1.26

30°



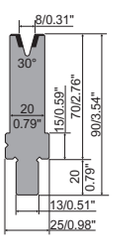
BMR70.08.30

42Cr: 900-1150 N/mm² **200 kN/m max.**

1000 mm	*39.37"*	13.1 kg	
500 mm	*19.68"*	6.5 kg	
1100 mm	*43.31"*	14.0 kg	F
550 mm	*21.65"*	7.1 kg	FW

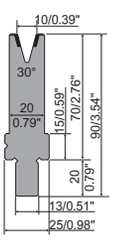
W=70 | H=90 | R=0.75 | V=8
W=2.75 | H=3.54 | R=0.030 | V=0.31

30°



BMR70.10.30

42Cr: 900-1150 N/mm² **350 kN/m max.**



1000 mm	*39.37"*	12.8 kg	
500 mm	*19.68"*	6.4 kg	
1100 mm	*43.31"*	14.0 kg	F
550 mm	*21.65"*	7.0 kg	FW

W=70 | H=90 | R=1.0 | V=10
W=2.75 | H=3.54 | R=0.039 | V=0.39

30°

F: 1100 mm - *43.31"*
mm: 400-200-100-100-75-60-50-40-30-20-15-10
in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

BMR70.12.30

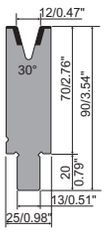
42Cr: 900-1150 N/mm² **300 kN/m max.**

1000 mm	*39.37"*	14.7 kg	
500 mm	*19.68"*	7.3 kg	
1100 mm	*43.31"*	16.1 kg	F
550 mm	*21.65"*	8.0 kg	FW

W=70 | H=90 | R=1.5 | V=12

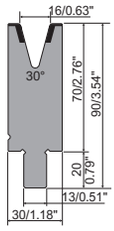
W=2.76 | H=3.54 | R=0.059 | V=0.47

30°



BMR70.16.30

42Cr: 900-1150 N/mm² **450 kN/m max.**



1000 mm	*39.37"*	16.7 kg	
500 mm	*19.68"*	8.3 kg	
1100 mm	*43.31"*	16.2 kg	F
550 mm	*21.65"*	9.1 kg	FW

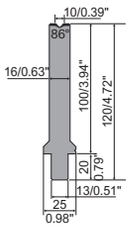
W=70 | H=90 | R=2.0 | V=16

W=2.76 | H=3.54 | R=0.079 | V=0.63

30°

WMR100.06.86

42Cr: 900-1150 N/mm² **400 kN/m max.**



515 mm	*20.28"*	7.9 kg	
550 mm	*21.651"*	7.4 kg	FW

W=100 | H=120 | R=2.0 | V=6

W=3.94 | H=4.72 | R=0.079 | V=0.24

86°

TMR100.04.86

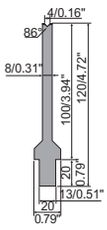
42Cr: 900-1150 N/mm² **250 kN/m max.**

500 mm	*19.68"*	4.8 kg	
250 mm	*9.84"*	2.4 kg	FC
550 mm	*21.65"*	5.2 kg	FW

W=100 | H=120 | R=0.6 | V=4

W=3.94 | H=4.72 | R=0.024 | V=0.16

86°>



TMR100.06.86

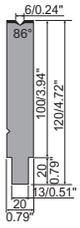
42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	8.9 kg	
250 mm	*9.84"*	4.4 kg	FC
550 mm	*21.65"*	9.8 kg	FW

W=100 | H=120 | R=0.6 | V=6

W=3.94 | H=4.72 | R=0.024 | V=0.24

86°



F: 1100 mm - *43.31"*
mm: 400-200-100-100-75-60-50-40-30-20-15-10
in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

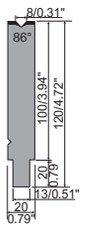
TMR100.08.86

42Cr: 900-1150 N/mm² **1150 kN/m max.**

500 mm	*19.68"*	8.8 kg	
250 mm	*9.84"*	4.4 kg	FC
550 mm	*21.65"*	9.6 kg	FW

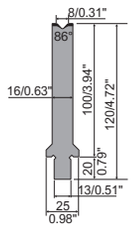
W=100 | H=120 | R=0.8 | V=8
W=3.94 | H=4.72 | R=0.031 | V=0.31

86°



WMR100.08.86

42Cr: 900-1150 N/mm² **400 kN/m max.**



515 mm	*20.28"*	7.7 kg	
550 mm	*21.65"*	8.2 kg	FW

W=100 | H=120 | R=2.5 | V=8
W=3.94 | H=4.72 | R=0.098 | V=0.31

86°

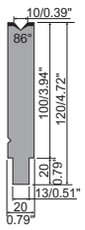
TMR100.10.86

42Cr: 900-1150 N/mm² **1100 kN/m max.**

500 mm	*19.68"*	8.8 kg	
250 mm	*9.84"*	4.4 kg	FC
550 mm	*21.65"*	9.6 kg	FW

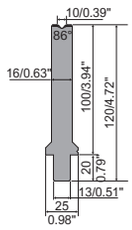
W=100 | H=120 | R=1.0 | V=10
W=3.94 | H=4.72 | R=0.039 | V=0.39

86°



WMR100.10.86

42Cr: 900-1150 N/mm² **1100 kN/m max.**



515 mm	*20.28"*	9.5 kg	
550 mm	*21.651"*	10.1 kg	FW

W=100 | H=120 | R=2.5 | V=10
W=3.94 | H=4.72 | R=0.098 | V=0.39

86°

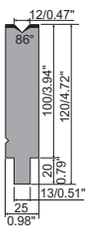
TMR100.12.86

42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	10.7 kg	
250 mm	*9.84"*	5.3 kg	FC
550 mm	*21.65"*	11.7 kg	FW

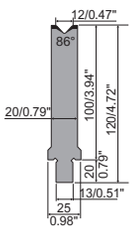
W=100 | H=120 | R=1.0 | V=12
W=3.94 | H=4.72 | R=0.039 | V=0.47

86°



WMR100.12.86

42Cr: 900-1150 N/mm² **1200 kN/m max.**



515 mm	*20.28"*	9.0 kg	
550 mm	*21.65"*	9.6 kg	FW

W=100 | H=120 | R=3.0 | V=12
W=3.94 | H=4.72 | R=0.118 | V=0.47

86°

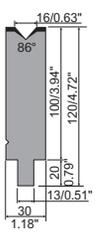
TMR100.16.86

42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	12.5 kg	
250 mm	*9.84"*	6.3 kg	FC
550 mm	*21.65"*	13.8 kg	FW

W=100 | H=120 | R=1.6 | V=16
W=3.94 | H=4.72 | R=0.063 | V=0.63

86°



FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

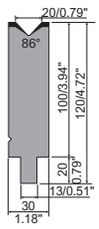
TMR100.20.86

42Cr: 900-1150 N/mm² **1150 kN/m max.**

500 mm	*19.68"*	12.2 kg	
250 mm	*9.84"*	6.2 kg	FC
550 mm	*21.65"*	13.5 kg	FW

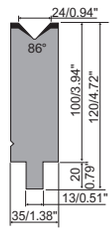
W=100 | H=120 | R=2.0 | V=20
W=3.94 | H=4.72 | R=0.079 | V=0.79

86°



TMR100.24.86

42Cr: 900-1150 N/mm² **1200 kN/m max.**



500 mm	*19.68"*	14.0 kg	
250 mm	*9.84"*	7.0 kg	FC
550 mm	*21.65"*	15.5 kg	FW

W=100 | H=120 | R=2.5 | V=24
W=3.94 | H=4.72 | R=0.098 | V=0.94

86°

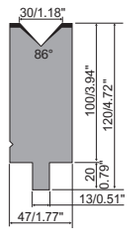
TMR100.30.86

42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	17.6 kg	
250 mm	*9.84"*	8.8 kg	FC
550 mm	*21.65"*	19.4 kg	FW

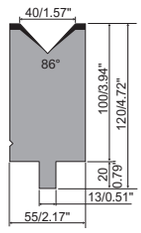
W=100 | H=120 | R=3.0 | V=30
W=3.94 | H=4.72 | R=0.118 | V=1.18

86°



TMR100.40.86

42Cr: 900-1150 N/mm² **1200 kN/m max.**



500 mm	*19.68"*	20.8 kg	
250 mm	*9.84"*	10.4 kg	FC
550 mm	*21.65"*	22.8 kg	FW

W=100 | H=120 | R=3.0 | V=40
W=3.94 | H=4.72 | R=0.118 | V=1.57

86°

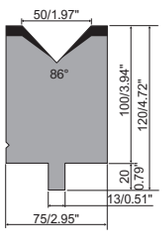
TMR100.50.86

42Cr: 900-1150 N/mm² **1500 kN/m max.**

500 mm	*19.68"*	24.8 kg	
250 mm	*9.84"*	12.4 kg	FC
550 mm	*21.65"*	30.5 kg	FW

W=100 | H=120 | R=3.0 | V=50
W=3.94 | H=4.72 | R=0.118 | V=1.97

86°



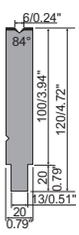
TMR100.06.84

42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	8.8 kg	
250 mm	*9.84"*	4.4 kg	FC
550 mm	*21.65"*	9.7 kg	FW

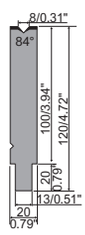
W=100 | H=120 | R=0.6 | V=6
W=3.94 | H=4.72 | R=0.024 | V=0.24

84°>



TMR100.08.84

42Cr: 900-1150 N/mm² **1150 kN/m max.**



500 mm	*19.68"*	8.8 kg	
250 mm	*9.84"*	4.4 kg	FC
550 mm	*21.65"*	9.7 kg	FW

W=100 | H=120 | R=0.8 | V=8
W=3.94 | H=4.72 | R=0.031 | V=0.31

84°

FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

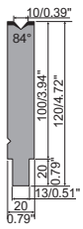
TMR100.10.84

42Cr: 900-1150 N/mm² **1100 kN/m max.**

500 mm	*19.68"*	8.8 kg	
250 mm	*9.84"*	4.4 kg	FC
550 mm	*21.65"*	9.6 kg	FW

W=100 | H=120 | R=1.0 | V=10
W=3.94 | H=4.72 | R=0.039 | V=0.39

84°



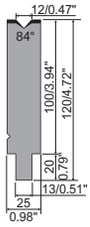
TMR100.12.84

42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	10.7 kg	
250 mm	*9.84"*	5.3 kg	FC
550 mm	*21.65"*	11.7 kg	FW

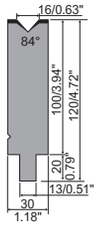
W=100 | H=120 | R=1.0 | V=12
W=3.94 | H=4.72 | R=0.039 | V=0.47

84°



TMR100.16.84

42Cr: 900-1150 N/mm² **1200 kN/m max.**



500 mm	*19.68"*	12.5 kg	
250 mm	*9.84"*	6.3 kg	FC
550 mm	*21.65"*	13.8 kg	FW

W=100 | H=120 | R=1.6 | V=16
W=3.94 | H=4.72 | R=0.063 | V=0.63

84°

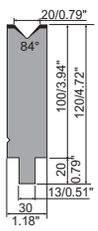
TMR100.20.84

42Cr: 900-1150 N/mm² **1150 kN/m max.**

500 mm	*19.68"*	12.2 kg	
250 mm	*9.84"*	6.1 kg	FC
550 mm	*21.65"*	13.4 kg	FW

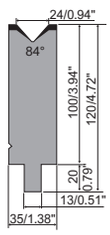
W=100 | H=120 | R=2.0 | V=20
W=3.94 | H=4.72 | R=0.079 | V=0.79

84°



TMR100.24.84

42Cr: 900-1150 N/mm² **1200 kN/m max.**



500 mm	*19.68"*	14.0 kg	
250 mm	*9.84"*	7.0 kg	FC
550 mm	*21.65"*	15.4 kg	FW

W=100 | H=120 | R=2.5 | V=24
W=3.94 | H=4.72 | R=0.098 | V=0.94

84°

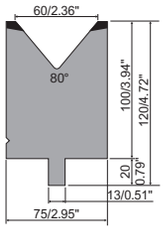
TMR100.60.80

42Cr: 900-1150 N/mm² **1500 kN/m max.**

500 mm	*19.68"*	25.8 kg	
250 mm	*9.84"*	13.0 kg	FC
550 mm	*21.65"*	28.4 kg	FW

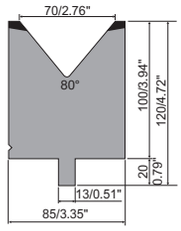
W=100 | H=120 | R=5.0 | V=60
W=3.94 | H=4.72 | R=0.197 | V=2.36

80°>



TMR100.70.80

42Cr: 900-1150 N/mm² **1500 kN/m max.**



500 mm	*19.68"*	28.2 kg	
250 mm	*9.84"*	14.1 kg	FC
550 mm	*21.65"*	31 kg	FW

W=100 | H=120 | R=5.0 | V=70
W=3.94 | H=4.72 | R=0.197 | V=2.76

80°

FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

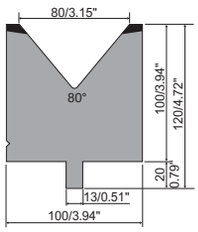
TMR100.80.80

42Cr: 900-1150 N/mm² **1500 kN/m max.**

500 mm	*19.68"*	32.3 kg	
250 mm	*9.84"*	16.1 kg	FC
550 mm	*21.65"*	35.5 kg	FW

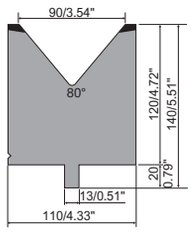
W=100 | H=120 | R=5.0 | V=80
W=3.94 | H=4.72 | R=0.197 | V=3.15

80°



TMR120.90.80

42Cr: 900-1150 N/mm² **1500 kN/m max.**



500 mm	*19.68"*	42.1 kg	
250 mm	*9.84"*	21.0 kg	FC
550 mm	*21.65"*	46.3 kg	FW

W=120 | H=140 | R=8.0 | V=90
W=4.72 | H=5.51 | R=0.315 | V=3.54

80°

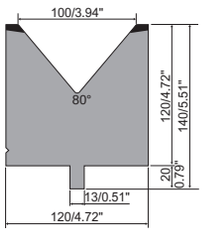
TMR120.100.80

42Cr: 900-1150 N/mm² **1500 kN/m max.**

500 mm	*19.68"*	44.7 kg	
250 mm	*9.84"*	22.4 kg	FC
550 mm	*21.65"*	49.2 kg	FW

W=120 | H=140 | R=8.0 | V=100
W=4.72 | H=5.51 | R=0.315 | V=3.94

80°



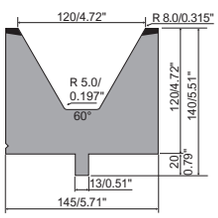
TMR120.120.60

42Cr: 900-1150 N/mm² **1600 kN/m max.**

500 mm	*19.68"*	44.5 kg	
250 mm	*9.84"*	22.8 kg	FC
550 mm	*21.65"*	49.0 kg	FW

W=120 | H=140 | R=8.0 | V=120
W=4.72 | H=5.51 | R=0.315 | V=4,72

60°>



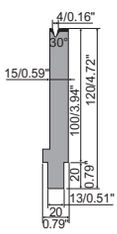
TMR100.04.30

42Cr: 900-1150 N/mm² **150 kN/m max.**

500 mm	*19.68"*	7.0 kg	
250 mm	*9.84"*	3.5 kg	FC
550 mm	*21.65"*	7.7 kg	FW

W=100 | H=120 | R=0.6 | V=4
W=3.94 | H=4.72 | R=0.024 | V=0.16

30°>



FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

TMR100.06.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

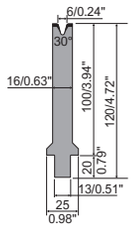
500 mm	*19.68"*	8.8 kg	
250 mm	*9.84"*	4.4 kg	FC
550 mm	*21.65"*	9.6 kg	FW

W=100 | H=120 | R=0.6 | V=6
W=3.94 | H=4.72 | R=0.024 | V=0.24

30°

WMR100.06.30

42Cr: 900-1150 N/mm² **400 kN/m max.**



515 mm	*20.28"*	7.7 kg	
550 mm	*21.65"*	8.2 kg	FW

W=100 | H=120 | R=2.0 | V=6
W=3.94 | H=4.72 | R=0.079 | V=0.24

30°

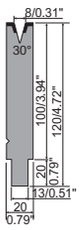
TMR100.08.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	12.2 kg	
250 mm	*9.84"*	6.1 kg	FC
550 mm	*21.65"*	13.4 kg	FW

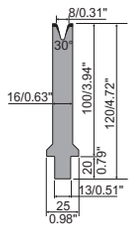
W=100 | H=120 | R=1.0 | V=8
W=3.94 | H=4.72 | R=0.039 | V=0.31

30°



WMR100.08.30

42Cr: 900-1150 N/mm² **400 kN/m max.**



515 mm	*20.28"*	14.0 kg	
550 mm	*21.65"*	15.4 kg	FW

W=100 | H=120 | R=2.5 | V=8
W=3.94 | H=4.72 | R=0.098 | V=0.31

30°

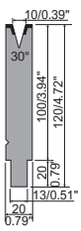
TMR100.10.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	8.5 kg	
250 mm	*9.84"*	4.3 kg	FC
550 mm	*21.65"*	9.4 kg	FW

W=100 | H=120 | R=1.0 | V=10
W=3.94 | H=4.72 | R=0.039 | V=0.39

30°



FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

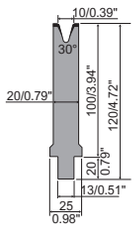
WMR100.10.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

515 mm	*20.28"*	9.0 kg	
550 mm	*43.31"*	9.6 kg	FW

W=100 | H=120 | R=2.5 | V=10
W=3.94 | H=4.72 | R=0.098 | V=0.39

30°



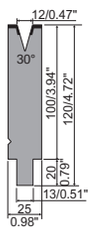
TMR100.12.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	10.3 kg	
250 mm	*9.84"*	5.1 kg	FC
550 mm	*21.65"*	11.3 kg	FW

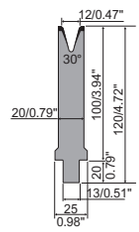
W=100 | H=120 | R=1.0 | V=12
W=3.94 | H=4.72 | R=0.039 | V=0.47

30°



WMR100.12.30

42Cr: 900-1150 N/mm² **400 kN/m max.**



515 mm	*20.28"*	8.9 kg	
550 mm	*43.31"*	9.5 kg	FW

W=100 | H=120 | R=3.0 | V=12
W=3.94 | H=4.72 | R=0.118 | V=0.47

30°

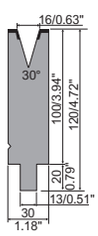
TMR100.16.30

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

500 mm	*19.68"*	11.8 kg	
250 mm	*9.84"*	6.0 kg	FC
550 mm	*21.65"*	13.0 kg	FW

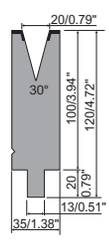
W=100 | H=120 | R=1.6 | V=16
W=3.94 | H=4.72 | R=0.063 | V=0.63

30°



TMR100.20.30

42Cr: 900-1150 N/mm² **600 kN/m max.**



500 mm	*19.68"*	13.2 kg	
250 mm	*9.84"*	6.5 kg	FC
550 mm	*21.65"*	15.0 kg	FW

W=100 | H=120 | R=2.0 | V=20
W=3.94 | H=4.72 | R=0.079 | V=0.79

30°

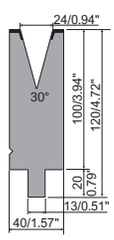
TMR100.24.30

42Cr: 900-1150 N/mm² **650 kN/m max.**

500 mm	*19.68"*	14.8 kg	
250 mm	*9.84"*	7.4 kg	FC
550 mm	*21.65"*	16.2 kg	FW

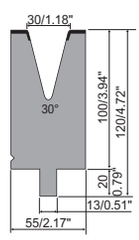
W=100 | H=120 | R=2.5 | V=24
W=3.94 | H=4.72 | R=0.098 | V=0.94

30°



TMR100.30.30

42Cr: 900-1150 N/mm² **900 kN/m max.**



500 mm	*19.68"*	19.0 kg	
250 mm	*9.84"*	9.5 kg	FC
550 mm	*21.65"*	21.0 kg	FW

W=100 | H=120 | R=3.0 | V=30
W=3.94 | H=4.72 | R=0.118 | V=1.18

30°

FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

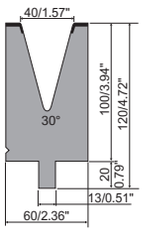
TMR100.40.30

42Cr: 900-1150 N/mm² **900 kN/m max.**

500 mm	*19.68"*	18.3 kg	
250 mm	*9.84"*	9.3 kg	FC
550 mm	*21.65"*	20.1 kg	FW

W=100 | H=120 | R=5.0 | V=40
W=3.94 | H=4.72 | R=0.197 | V=1.57

30°



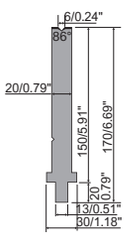
TMR150.06.86

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

500 mm	*19.68"*	13.1 kg	
250 mm	*9.84"*	6.6 kg	FC
550 mm	*21.65"*	14.3 kg	FW

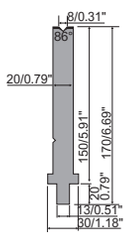
W=150 | H=170 | R=0.6 | V=6
W=5.91 | H=6.69 | R=0.024 | V=0.24

86°>



TMR150.08.86

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



500 mm	*19.68"*	13.1 kg	
250 mm	*9.84"*	6.6 kg	FC
550 mm	*21.65"*	14.4 kg	FW

W=150 | H=170 | R=0.8 | V=8
W=5.91 | H=6.69 | R=0.031 | V=0.31

86°

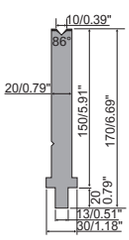
TMR150.10.86

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

500 mm	*19.68"*	13.0 kg	
250 mm	*9.84"*	6.5 kg	FC
550 mm	*21.65"*	14.3 kg	FW

W=150 | H=170 | R=1.0 | V=10
W=5.91 | H=6.69 | R=0.039 | V=0.39

86°



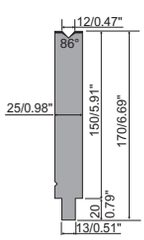
TMR150.12.86

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

500 mm	*19.68"*	15.5 kg	
250 mm	*9.84"*	7.8 kg	FC
550 mm	*21.65"*	17.0 kg	FW

W=150 | H=170 | R=1.0 | V=12
W=5.91 | H=6.69 | R=0.039 | V=0.47

86°



FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

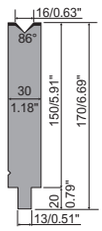
TMR150.16.86

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

500 mm	*19.68"*	18.4 kg	
250 mm	*9.84"*	9.2 kg	FC
550 mm	*21.65"*	20.2 kg	FW

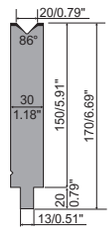
W=150 | H=170 | R=1.6 | V=16
W=5.91 | H=6.69 | R=0.063 | V=0.63

86°



TMR150.20.86

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



500 mm	*19.68"*	18.3 kg	
250 mm	*9.84"*	9.1 kg	FC
550 mm	*21.65"*	20.0 kg	FW

W=150 | H=170 | R=2.0 | V=20
W=5.91 | H=6.69 | R=0.079 | V=0.79

86°

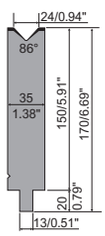
TMR150.24.86

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

500 mm	*19.68"*	20.9 kg	
250 mm	*9.84"*	10.5 kg	FC
550 mm	*21.65"*	23.0 kg	FW

W=150 | H=170 | R=2.5 | V=24
W=5.91 | H=6.69 | R=0.098 | V=0.94

86°



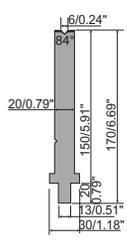
TMR150.06.84

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

500 mm	*19.68"*	13.1 kg	
250 mm	*9.84"*	6.6 kg	FC
550 mm	*21.65"*	14.3 kg	FW

W=150 | H=170 | R=0.6 | V=6
W=5.91 | H=6.69 | R=0.024 | V=0.24

84°>



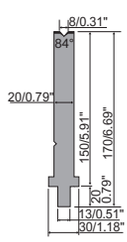
TMR150.08.84

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

500 mm	*19.68"*	13.1 kg	
250 mm	*9.84"*	6.6 kg	FC
550 mm	*21.65"*	14.3 kg	FW

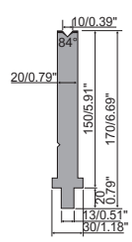
W=150 | H=170 | R=0.8 | V=8
W=5.91 | H=6.69 | R=0.031 | V=0.31

84°



TMR150.10.84

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



500 mm	*19.68"*	13.0 kg	
250 mm	*9.84"*	6.5 kg	FC
550 mm	*21.65"*	14.3 kg	FW

W=150 | H=170 | R=1.0 | V=10
W=5.91 | H=6.69 | R=0.039 | V=0.39

84°

FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

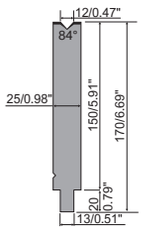
TMR150.12.84

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

500 mm	*19.68"*	15.5 kg	
250 mm	*9.84"*	7.8 kg	FC
550 mm	*21.65"*	17.0 kg	FW

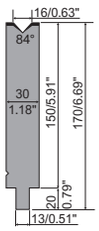
W=150 | H=170 | R=1.0 | V=12
W=5.91 | H=6.69 | R=0.039 | V=0.47

84°



TMR150.16.84

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



500 mm	*19.68"*	18.4 kg	
250 mm	*9.84"*	9.2 kg	FC
550 mm	*21.65"*	20.2 kg	FW

W=150 | H=170 | R=1.6 | V=16
W=5.91 | H=6.69 | R=0.063 | V=0.63

84°

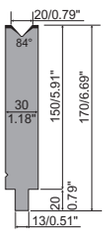
TMR150.20.84

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

500 mm	*19.68"*	18.3 kg	
250 mm	*9.84"*	9.1 kg	FC
550 mm	*21.65"*	20.0 kg	FW

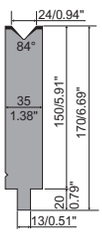
W=150 | H=170 | R=2.0 | V=20
W=5.91 | H=6.69 | R=0.079 | V=0.79

84°



TMR150.24.84

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



500 mm	*19.68"*	20.9 kg	
250 mm	*9.84"*	10.4 kg	FC
550 mm	*21.65"*	22.9 kg	FW

W=150 | H=170 | R=2.5 | V=24
W=5.91 | H=6.69 | R=0.098 | V=0.94

84°

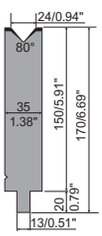
TMR150.24.80

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

500 mm	*19.68"*	20.9 kg	
250 mm	*9.84"*	10.4 kg	FC
550 mm	*21.65"*	22.9 kg	FW

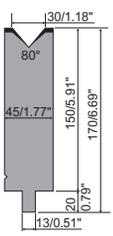
W=150 | H=170 | R=2.5 | V=24
W=5.91 | H=6.69 | R=0.098 | V=0.94

80°>



TMR150.30.80

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



500 mm	*19.68"*	26.3 kg	
250 mm	*9.84"*	13.1 kg	FC
550 mm	*21.65"*	28.9 kg	FW

W=150 | H=170 | R=5.0 | V=30
W=5.91 | H=6.69 | R=0.197 | V=1.18

80°

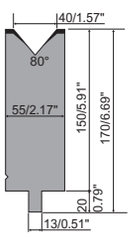
TMR150.40.80

42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	31.3 kg	
250 mm	*9.84"*	15.6 kg	FC
550 mm	*21.65"*	34.4 kg	FW

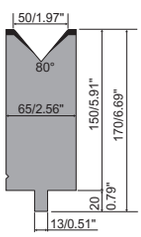
W=150 | H=170 | R=5.0 | V=40
W=5.91 | H=6.69 | R=0.197 | V=1.57

80°



TMR150.50.80

42Cr: 900-1150 N/mm² **1500 kN/m max.**



500 mm	*19.68"*	36.0 kg	
250 mm	*9.84"*	18.0 kg	FC
550 mm	*21.65"*	39.6 kg	FW

W=150 | H=170 | R=5.0 | V=50
W=5.91 | H=6.69 | R=0.197 | V=1.97

80°

FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

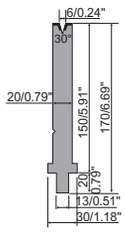
TMR150.06.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	13.0 kg	
250 mm	*9.84"*	6.5 kg	FC
550 mm	*21.65"*	14.3 kg	FW

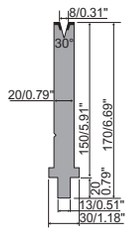
W=150 | H=170 | R=0.6 | V=6
W=5.91 | H=6.69 | R=0.024 | V=0.24

30°>



TMR150.08.30

42Cr: 900-1150 N/mm² **400 kN/m max.**



500 mm	*19.68"*	13.0 kg	
250 mm	*9.84"*	6.7 kg	FC
550 mm	*21.65"*	14.3 kg	FW

W=150 | H=170 | R=1.0 | V=8
W=5.91 | H=6.69 | R=0.039 | V=0.31

30°

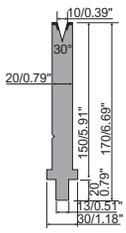
TMR150.10.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	12.8 kg	
250 mm	*9.84"*	6.4 kg	FC
550 mm	*21.65"*	13.9 kg	FW

W=150 | H=170 | R=1.0 | V=10
W=5.91 | H=6.69 | R=0.039 | V=0.39

30°



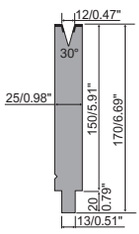
TMR150.12.30

42Cr: 900-1150 N/mm² **400 kN/m max.**

500 mm	*19.68"*	15.2 kg	
250 mm	*9.84"*	7.6 kg	FC
550 mm	*21.65"*	16.7 kg	FW

W=150 | H=170 | R=1.0 | V=12
W=5.91 | H=6.69 | R=0.039 | V=0.47

30°



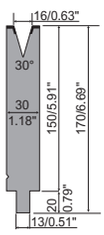
TMR150.16.30

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

500 mm	*19.68"*	17.7 kg	
250 mm	*9.84"*	8.9 kg	FC
550 mm	*21.65"*	19.5 kg	FW

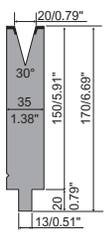
W=150 | H=170 | R=1.6 | V=16
W=5.91 | H=6.69 | R=0.063 | V=0.63

30°



TMR150.20.30

42Cr: 900-1150 N/mm² **600 kN/m max.**



500 mm	*19.68"*	20.1 kg	
250 mm	*9.84"*	10.0 kg	FC
550 mm	*21.65"*	22.0 kg	FW

W=150 | H=170 | R=2.0 | V=20
W=5.91 | H=6.69 | R=0.079 | V=0.79

30°

FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

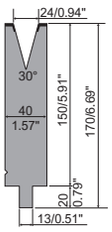
TMR150.24.30

42Cr: 900-1150 N/mm² **650 kN/m max.**

500 mm	*19.68"*	22.3 kg	
250 mm	*9.84"*	11.2 kg	FC
550 mm	*21.65"*	24.5 kg	FW

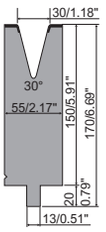
W=150 | H=170 | R=2.5 | V=24
W=5.91 | H=6.69 | R=0.098 | V=0.94

30°



TMR150.30.30

42Cr: 900-1150 N/mm² **900 kN/m max.**



500 mm	*19.68"*	30.0 kg	
250 mm	*9.84"*	15.0 kg	FC
550 mm	*21.65"*	33.0 kg	FW

W=150 | H=170 | R=3.0 | V=30
W=5.91 | H=6.69 | R=0.118 | V=1.18

30°

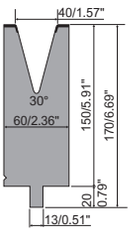
TMR150.40.30

42Cr: 900-1150 N/mm² **900 kN/m max.**

500 mm	*19.68"*	30.1 kg	
250 mm	*9.84"*	15.1 kg	FC
550 mm	*21.65"*	33.1 kg	FW

W=150 | H=170 | R=5.0 | V=40
W=5.91 | H=6.69 | R=0.197 | V=1.57

30°



BENDING HANDBOOK
The Bending handbook target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.
Visit rolleriools.com to find out more about the handbook

Create your account on www.rolleritools.com. You can use our website to ask for offers, keep you up to date on the latest news, check prices and place orders online.

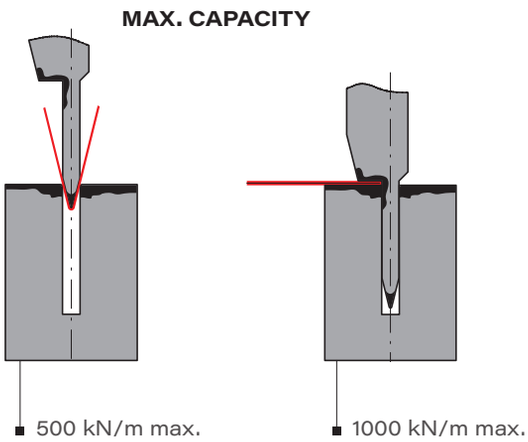
FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

.hemming dies >>

Hemming tools are used to prebend and afterwards flatten a sheet metal edge by using the same tool set.
Thanks to this operation you can strengthen sheet metal edges and avoid burr on their external side. For this reason, this operation is especially used for safety reason, in order to avoid operators' accidental injuries which may occur to those who have to handle sheet metal parts.
The maximum sheet metal thickness usually recommended for this operation is 3mm mild steel and 2mm stainless steel. However, for thicker sheet metal special solutions can be proposed, which consider the necessary bending force involved to flatten.
There are 2 types of flattening: partial flattening and total flattening.
Partial flattening is a kind of flattening which doesn't win against the sheet metal springback. For this reason, if you measure the flattened point, it won't be twice the sheet metal thickness but a bigger measure; for example, if you flatten 1.5mm partially, the flattened point will be about 4mm. This dimension depends on the bending force only. Hence, if you want to flatten 1.5mm mild steel and get 3mm high flattened point, you have to increase the tonnage. In the table below you can check the necessary tonnage according to sheet metal thickness and type.
The choice of hemming tools should be influenced by the sheet metal type to be flattened; 35° punch and dies are recommended to flatten aluminium and mild steel, which have small springback, whereas more resitant sheet metal types like stainless steel require at least 30°, or better 26°, punch and die.
Springback control is fundamental to win against sheet metal resistance during the flattening phase. In fact, if the angle obtained during the pre-bending phase is too wide, sheet metal will slip towards the operator during the flattening phase.
The choice of TOP series hemming tools with dies with U shape opening has to take into consideration the fact that the U opening of the die has to match perfectly with the punch tip width. These tools are 525mm long and the sectioned set is also available.

MAX. CAPACITY



S mm	*S in*	A mm	*A in*	R.420 N/ mm² kN/m	R.700 N/ mm² kN/m
0.60	*0.02*	3.0	*0.12*	90	150
0.80	*0.03*	3.0	*0.12*	120	200
1.00	*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
0.60	*0.02*	1.2	*0.05*	230	350
0.80	*0.03*	1.6	*0.06*	320	500
1.00	*0.04*	1.0	*0.04*	400	600
1.25	*0.05*	2.5	*0.10*	500	800

BPR.SM.195.28.6

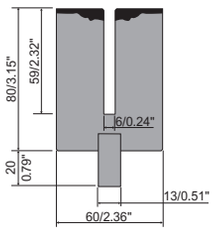
42Cr: 900-1150 N/mm² **500 - 1000 kN/m max.**

525 mm	*20.67"*	12.0 kg	
495 mm	*19.49"*	11.0 kg	F

W=80 | H=100 | R=1.0 | V=6
W=3.15 | H=3.94 | R=0.039 | V=0.24

28°>

TO USE WITH:
BPR.SP-195.28.6



TPR.SM.195.28.8

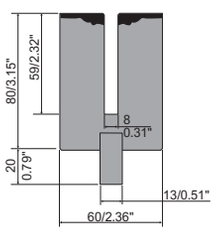
42Cr: 900-1150 N/mm² **500 - 1000 kN/m max.**

525 mm	*20.67"*	12.0 kg	
495 mm	*19.49"*	11.0 kg	F

W=80 | H=100 | R=1.0 | V=8
W=3.15 | H=3.94 | R=0.039 | V=0.31

28°

TO USE WITH:
BPR.SP-195.28.8
TPR.SP.195.24.8



TPR.SM.195.28.8/TPR.SM.195.24.8

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

525 mm	*20.67"*	12.0 kg	
495 mm	*19.49"*	11.0 kg	F

W=80 | H=100 | R=1.0 | V=8
W=3.15 | H=3.94 | R=0.039 | V=0.31

28°

TPR.SM.195.24.10

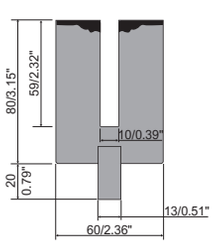
42Cr: 900-1150 N/mm² **500 - 1000 kN/m max.**

525 mm	*20.67"*	12.0 kg	
495 mm	*19.49"*	11.0 kg	F

W=80 | H=100 | R=1.0 | V=10
W=3.15 | H=3.94 | R=0.039 | V=0.39

24°>

TO USE WITH:
BPR.SP-195.24.10
TPR.SP.195.24.10



TPR.SM.195.24.12

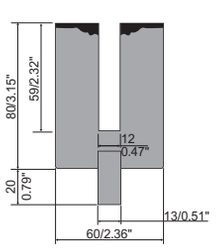
42Cr: 900-1150 N/mm² **500 - 1000 kN/m max.**

525 mm	*20.67"*	12.0 kg	
495 mm	*19.49"*	11.0 kg	F

W=80 | H=100 | R=1.0 | V=12
W=3.15 | H=3.94 | R=0.039 | V=0.47

24°

TO USE WITH:
BPR.SP-195.24.12
TPR.SP.195.24.12

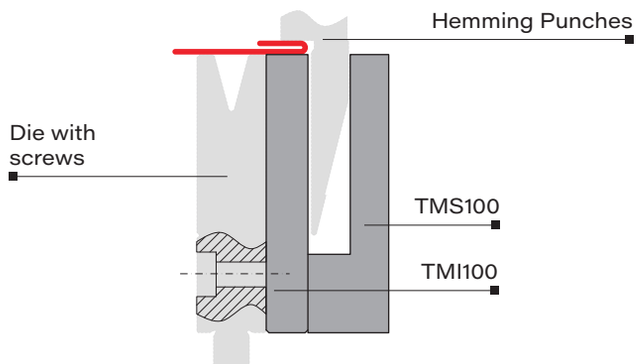


F: 495 mm - *19.49"*
mm: 170-100-50-45-40-35-30-25
in: 6.69-3.94-1.97-1.77-1.57-1.37-1.18-0.98

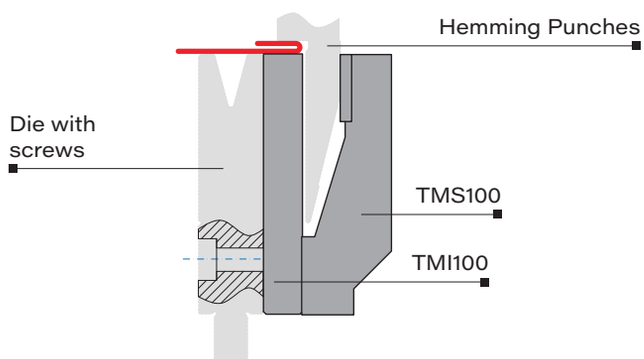
.hemming dies for movable table >>

R2 type dies offers a further solution to get flattened profiles with press brakes with movable table. Such solution is for those press brakes having a table which moves along a dedicated axis in order to centre die for the pre-bending phase and then to centre TMI100 or TML100 insert to carry out flattening.
Both TMI100 or TML100 inserts are induction hardened to 56-58HRc to resist against wear and compression during flattening phase.
On request R2 type dies can be supplied with holes with standard pitch to be screwed to TMI100 or TML100 inserts.
The insert choice depends on sheet metal type and thickness to be flattened.
For thin sheet metal TMI100 is enough but for thicker and more resistant sheet metal, you need TML100 or TMS100 inserts to keep punch tip more stable.
TML100 is a good compromise, as according to its orientation, it can be used as a flattening surface or as a guide for punch.
Punch models used for this applications are TPR176.28.R1 and TPR276.28.R1.
In case you have to flatten 2.5mm or 3mm sheet metal, we recommend you use TMI100 with TMS100. TMS100 is very robust and is equipped with an insert made of a ductile material which can keep punch stable without wearing its own surface excessively.
These inserts are as long as dies, which need to have 30° opening.
Sectioned sets are also available.
You don't need a set of inserts for each die set, as mounting and dismantling operations are very easy as you only have to tighten and untighten some allen screws on the operator side.
A very important parameter to take into consideration is the necessary press force to get a complete flattened or a partially flattened profile.
In this case tools are the same but it's fundamental to set the CNC up for the type of flattening required. An important feature for TMI, TML and TMS inserts is their capacity, ranging from 1200kN/m for TMI and TML and 1300 kN/m for TMS.

TMI100 + TML100
Example of application



TMI100 + TMS100
Example of application

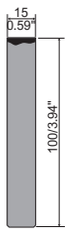


TMI100

42Cr: 900-1150 N/mm² **1200 kN/m max.**

500 mm	*19.68"*	5.0 kg	
250 mm	*9.84"*	2.5 kg	FC
550 mm	*21.65"*	5.5 kg	FW

C45: 560-710 N/mm²
1200 kN/m max.

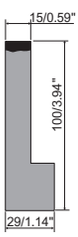


TML100

42Cr: 900-1150 N/mm² **1150 kN/m max.**

500 mm	*19.68"*	5.0 kg	
250 mm	*9.84"*	2.5 kg	FC
550 mm	*21.65"*	5.5 kg	FW

C45: 560-710 N/mm²
1200 kN/m max.

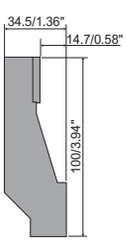


TMS100

42Cr: 900-1150 N/mm² **1100 kN/m max.**

500 mm	*19.68"*	5.0 kg	
250 mm	*9.84"*	2.5 kg	FC
550 mm	*21.65"*	5.5 kg	FW

C45: 560-710 N/mm²
1300 kN/m max.



FC: 250 mm - *9.84"*
mm: 50-45-40-35-30-25-25
in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

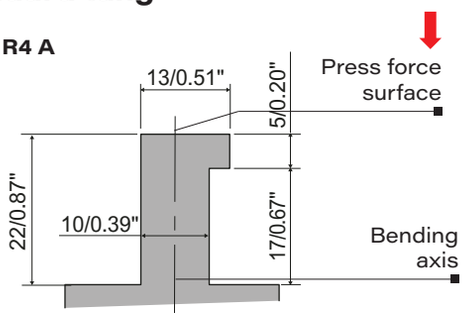
FW: 550 mm - *21.65"*
mm: 200-100-50-45-40-35-30-25-25
in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

.R4 punches

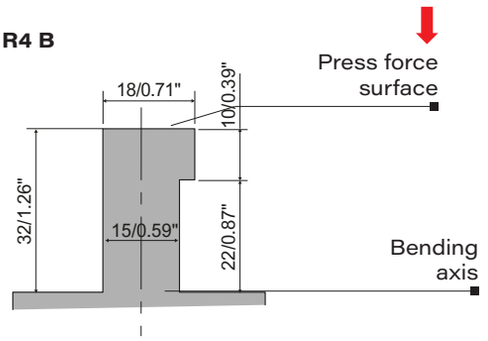
Compatibles with press brakes: LVD

.standard tang

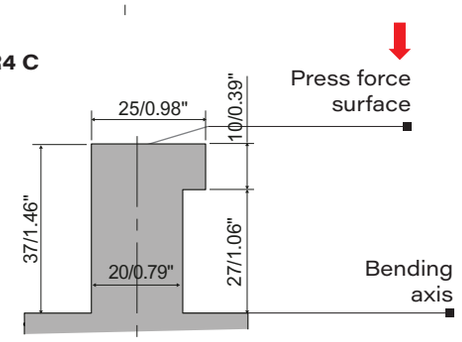
R4 A



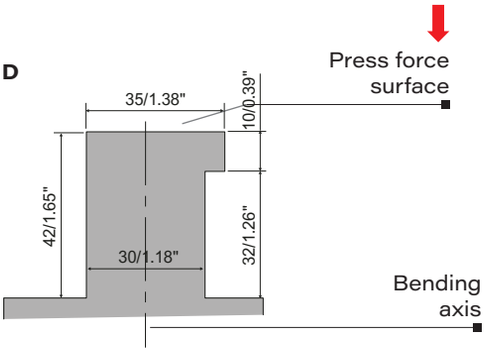
R4 B



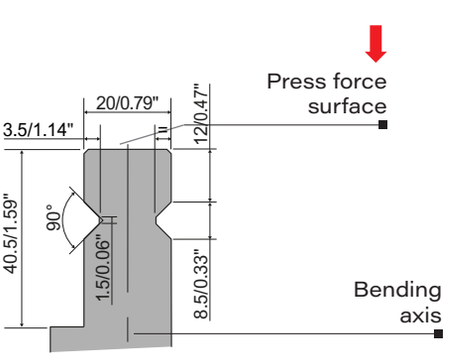
R4 C



R4 D



R4 W



.standard length

	NEW W Series
510 mm | 20.08" QL	●
525 mm | 20.67" QL	○

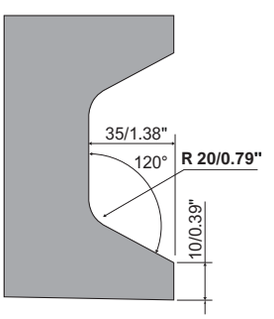
○ Available only for hemming tools

Rolleri BLACKFIRE is a surface treatment against steel oxidation. After such treatment tools become black and laser marking golden.

Rolleri FREEZINC is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation.

.horn types

Check the standard horn in each code. All the other horns are available on request based on the Series of the tool - check the feasibility with sales@rolleri.it



.segmentation

Customised sectioning is also available on request. Check the feasibility with sales@rolleri.it

◁ = left horn ▷ = right horn

F: 550 mm - *21.65"*

mm: ◁ 75-20-20-25-25-30-35-40-40-45-120-75 ▷

in:◁ 2.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95 ▷

.clamping systems

QuickLock - Standard

- Vertical tool change
- Easy handling
- Reduced setup time and costs
- Standard for tooling weight <12.5kg and segmented sets
- According to local regulation about weight limit to be lifted manually, QL can be applied with extra charge. For further information contact: tecnico@rolleri.it

QL

Safety pins - standard

- Horizontal tool change

S

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LPW196.D10-R1

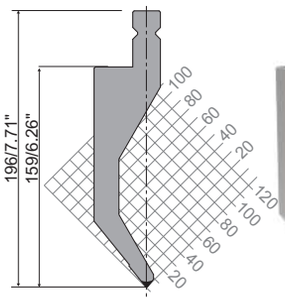
42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	16.3 kg	
250 mm	*9.84"*	8.0 kg	
550 mm	*21.65"*	17.6 kg	F

W=159 | H=196 | R=1.0 mm
W=6.26 | H=7.71 | R=0.039 in

78°>

.HORN 1



LPW196.D10-R2

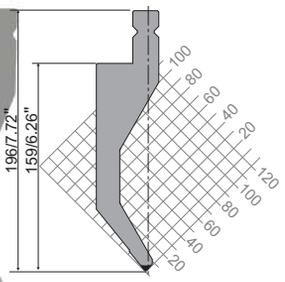
42Cr: 900-1150 N/mm² **750 kN/m max.**

510 mm	*20.07"*	12.5 kg	
250 mm	*9.84"*	6.1 kg	
550 mm	*21.65"*	13.5 kg	F

W=159 | H=196 | R=2.0 mm
W=6.26 | H=7.71 | R=0.039 in

78°

.HORN 1



LPW196.E10-R1

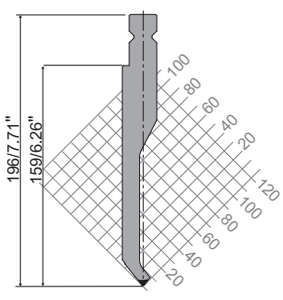
42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	12.9 kg	
250 mm	*9.84"*	6.3 kg	
550 mm	*21.65"*	14.0 kg	F

W=159 | H=196 | R=1.0 mm
W=6.26 | H=7.71 | R=0.039 in

78°

.HORN 1



LPW196.E10-R2

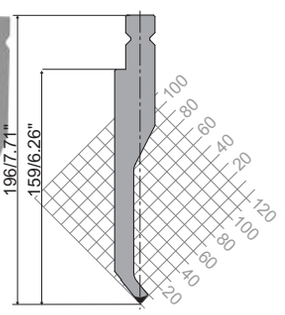
42Cr: 900-1150 N/mm² **680 kN/m max.**

510 mm	*20.07"*	13.7 kg	
250 mm	*9.84"*	6.7 kg	
550 mm	*21.65"*	14.9 kg	F

W=159 | H=196 | R=2.0 mm
W=6.26 | H=7.71 | R=0.078 in

78°

.HORN 1



LPW196.J10-R1

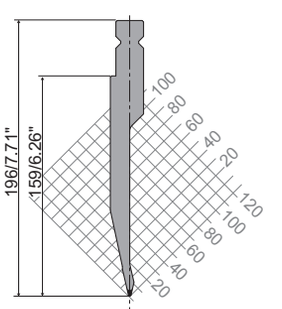
42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	8.8 kg	
250 mm	*9.84"*	4.3 kg	
550 mm	*21.65"*	9.4 kg	F

W=159 | H=196 | R=1.0 mm
W=6.26 | H=7.71 | R=0.039 in

26°>

.HORN 1



LPW196.J10-R2

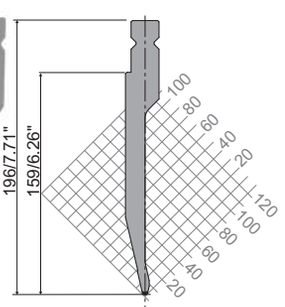
42Cr: 900-1150 N/mm² **600 kN/m max.**

510 mm	*20.07"*	11.4 kg	
250 mm	*9.84"*	5.6 kg	
550 mm	*21.65"*	12.3 kg	F

W=159 | H=196 | R=2.0 mm
W=6.26 | H=7.71 | R=0.078 in

26°

.HORN 1



LPW196.R10-R2

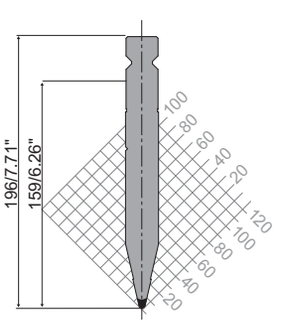
42Cr: 900-1150 N/mm² **800 kN/m max.**

510 mm	*20.07"*	9.0 kg	
250 mm	*9.84"*	4.4 kg	
550 mm	*21.65"*	9.8 kg	F

W=159 | H=196 | R=2.0 mm
W=6.26 | H=7.71 | R=0.078 in

26°

.HORN 1



F: 550 mm - *21.65"*
mm: ◁ 75-20-20-25-25-30-35-40-40-45-120-75 ▷
in: ◁ 2.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95 ▷

LPW231.D15-R1

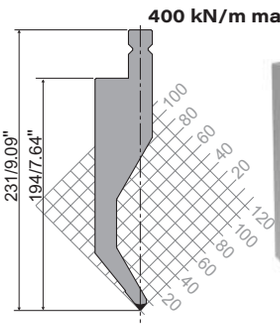
42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	20.1 kg	
250 mm	*9.84"*	9.9 kg	
550 mm	*21.65"*	21.7 kg	F

W=194 | H=231 | R=1.0 mm
W=7.64 | H=9.09 | R=0.039 in

78°>

.HORN 1



LPW231.D15-R2

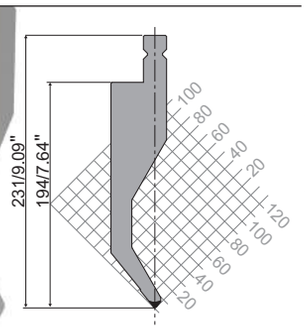
42Cr: 900-1150 N/mm² **750 kN/m max.**

510 mm	*20.07"*	21.9 kg	
250 mm	*9.84"*	10.7 kg	
550 mm	*21.65"*	23.7 kg	F

W=194 | H=231 | R=2.0 mm
W=7.64 | H=9.09 | R=0.078 in

78°

.HORN 1



LPW231.E15-R1

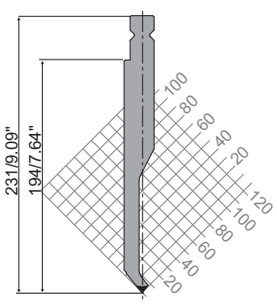
42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	16.5 kg	
250 mm	*9.84"*	8.1 kg	
550 mm	*21.65"*	17.9 kg	F

W=194 | H=231 | R=1.0 mm
W=7.64 | H=9.09 | R=0.039 in

78°

.HORN 1



LPW231.E15-R2

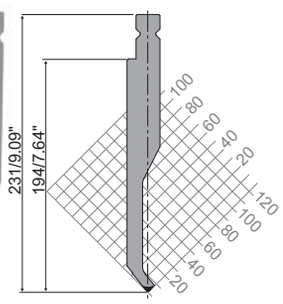
42Cr: 900-1150 N/mm² **680 kN/m max.**

510 mm	*20.07"*	17.6 kg	
250 mm	*9.84"*	8.6 kg	
550 mm	*21.65"*	19.0 kg	F

W=194 | H=231 | R=2.0 mm
W=7.64 | H=9.09 | R=0.078 in

78°

.HORN 1



LPW231.J15-R1

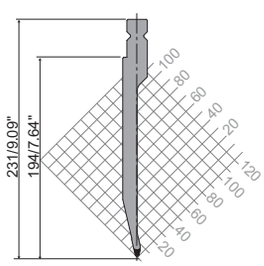
42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	13.3 kg	
250 mm	*9.84"*	6.5 kg	
550 mm	*21.65"*	14.5 kg	F

W=194 | H=231 | R=1.0 mm
W=7.64 | H=9.09 | R=0.039 in

26°>

.HORN 1



LPW231.J15-R2

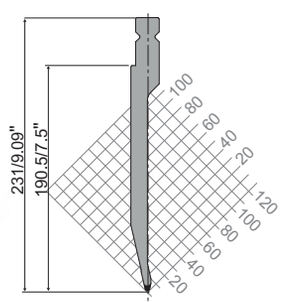
42Cr: 900-1150 N/mm² **600 kN/m max.**

510 mm	*20.07"*	12.1 kg	
250 mm	*9.84"*	5.9 kg	
550 mm	*21.65"*	13.2 kg	F

W=190.5| H=231 | R=2.0 mm
W=7.5 | H=9.09 | R=0.078 in

26°

.HORN 1



LPW231.R15-R3

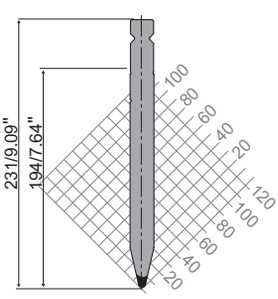
42Cr: 900-1150 N/mm² **1200 kN/m max.**

510 mm	*20.07"*	16.3 kg	
250 mm	*9.84"*	8.0 kg	
550 mm	*21.65"*	17.6 kg	F

W=194 | H=231 | R=3.0 mm
W=7.64 | H=9.09 | R=0.011 in

26°

.HORN 1



F: 550 mm - *21.65"*

mm: ◁ 75-20-20-25-25-30-35-40-40-45-120-75 ▷

in: ◁ 2.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95 ▷

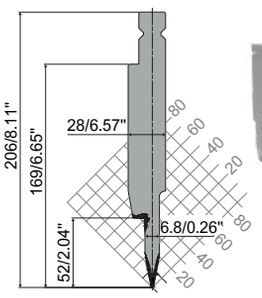
LPW.P10.08

42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	15.4 kg	
250 mm	*9.84"*	7.5 kg	
550 mm	*21.65"*	16.6 kg	F

W=169 | H=206 | R=1.0 mm
W=6.65 | H=8.11 | R=0.039 in

20°>



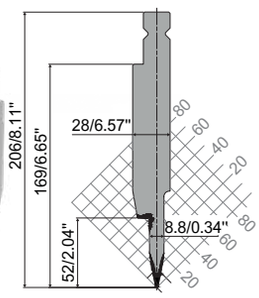
LPW.P10.10

42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	15.9 kg	
250 mm	*9.84"*	7.8 kg	
550 mm	*21.65"*	17.1 kg	F

W=169 | H=206 | R=1.0 mm
W=6.65 | H=8.11 | R=0.039 in

20°



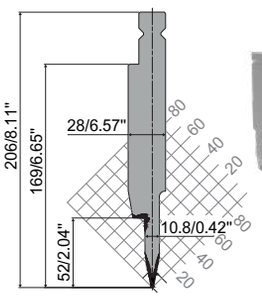
LPW.P10.12

42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	17.0 kg	
250 mm	*9.84"*	8.3 kg	
550 mm	*21.65"*	18.3 kg	F

W=169 | H=206 | R=1.0 mm
W=6.65 | H=8.11 | R=0.039 in

20°



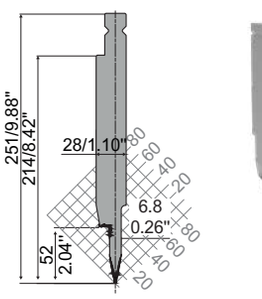
LPW.P15.08

42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	20.1 kg	
250 mm	*9.84"*	9.9 kg	
550 mm	*21.65"*	21.7 kg	F

W=214 | H=251 | R=1.0 mm
W=8.42 | H=9.88 | R=0.039 in

20°



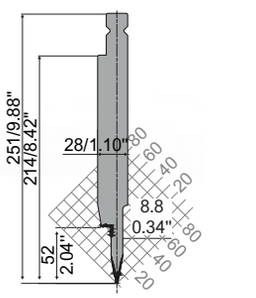
LPW.P15.10

42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	20.5 kg	
250 mm	*9.84"*	10.0 kg	
550 mm	*21.65"*	22.1 kg	F

W=214 | H=251 | R=1.0 mm
W=8.42 | H=9.88 | R=0.039 in

20°



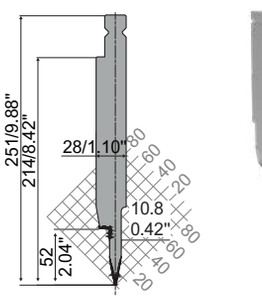
LPW.P15.12

42Cr: 900-1150 N/mm² **400 kN/m max.**

510 mm	*20.07"*	22.0 kg	
250 mm	*9.84"*	10.8 kg	
550 mm	*21.65"*	23.7 kg	F

W=214 | H=251 | R=1.0 mm
W=8.42 | H=9.88 | R=0.039 in

20°



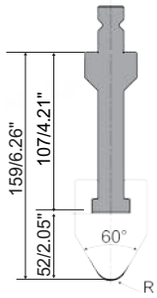
F: 550 mm - *21.65"*
mm: ◁ 75-20-20-25-25-30-35-40-40-45-120-75 ▷
in: ◁ 2.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95 ▷

LPW144-200

42Cr: 900-1150 N/mm²

2000 kN/m max.

510 mm	*20.07"*	13.7 kg	
250 mm	*9.84"*	6.7 kg	
550 mm	*21.65"*	14.8 kg	F

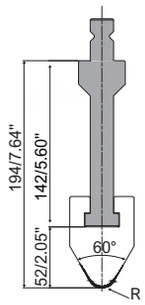


LPW179-200

42Cr: 900-1150 N/mm²

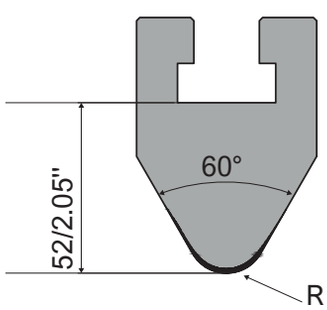
2000 kN/m max.

510 mm	*20.07"*	16.5 kg	
250 mm	*9.84"*	8.0 kg	
550 mm	*21.65"*	17.8 kg	F



RADIUS TOOLS Ø 10 - 100

	R mm	*R in*	kN/m max.	510 mm *20.07 in*	250 mm *9.84 in*	550 mm F *21.65 in*
LPW52.60.R5	5	*0.49*	2000	10.4 kg	5.0 kg	11.2 kg
LPW52.60.R6	6	*0.59*	2400	10.6 kg	5.2 kg	11.4 kg
LPW52.60.R8	8	*0.69*	3000	10.9 kg	5.3 kg	11.7 kg
LPW52.60.R10	10	*0.79*	3000	11.3 kg	5.5 kg	12.2 kg
LPW52.60.R12	12	*0.89*	3000	11.6 kg	5.6 kg	12.5 kg
LPW52.60.R15	15	*0.98*	3000	12 kg	5.8 kg	12.9 kg
LPW52.60.R20	20	*1.08*	3000	12.6 kg	6.1 kg	13.6 kg
LPW52.60.R25	25	*1.18*	3000	13.1 kg	6.4 kg	14.1 kg
LPW52.60.R30	30	*1.28*	3000	13.4 kg	6.6 kg	14.4 kg
LPW52.60.R35	35	*1.38*	3000	19.1 kg	9.4 kg	20.6 kg
LPW52.60.R40	40	*1.48*	3000	19.6 kg	9.6 kg	21.1 kg
LPW52.60.R50	50	*1.97*	3000	22.5 kg	11.0 kg	24.2 kg



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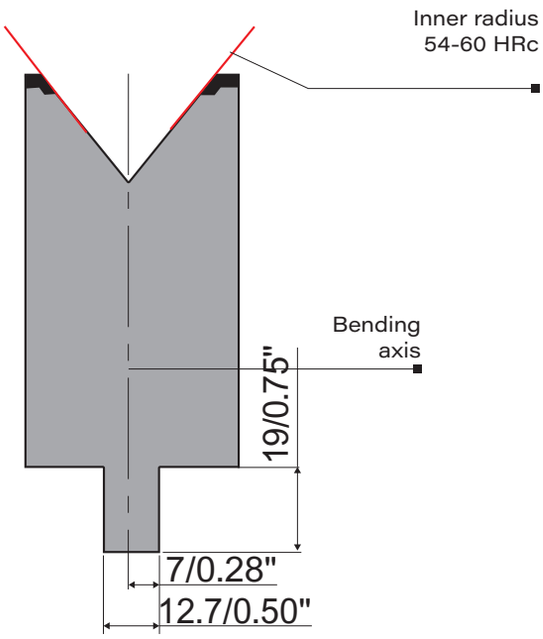
.R4 dies

Compatibles with press brakes: LVD

.dies: content explanation >>

.standard tang

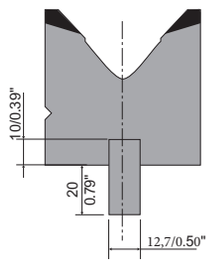


! New BLM dies are grinded on the sides and they are compatible with the laser angle measurement system.

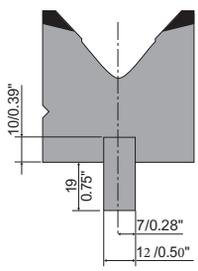
.modifications from safety grooves

To use Rolleri typer R1 dies, a 10 mm 0.39" groove is milled where a ground bar is mounted.

A31



A32



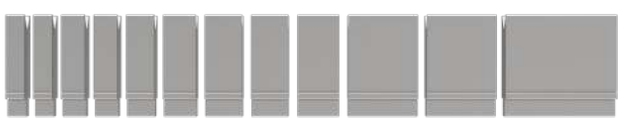
.segmentation

Customised sectioning is also available on request. Check the feasibility with sales@rolleri.it

F: 550 mm - *21.65"*

mm: 20-20-25-25-30-35-40-40-45-75-75-120

in: 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72



.standard length

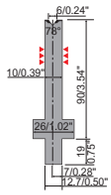
250 mm | *9.84"*
510 mm | *20.08"*

B-LM90.06.78

42Cr: 900-1150 N/mm² **280 kN/m max.**

510 mm	*20.08"*	5.2 kg	
250 mm	*9.84"*	2.5 kg	
550 mm	*21.65"*	5.6 kg	F

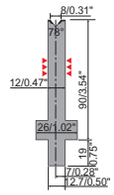
W=90 | R=0.8 | V =6 mm
W=3.54 | R=0.03 | V=0.24 in



78°>

B-LM90.08.78

42Cr: 900-1150 N/mm² **320 kN/m max.**



510 mm	*20.08"*	5.8 kg	
250 mm	*9.84"*	2.8 kg	
550 mm	*21.65"*	6.3 kg	F

W=90 | R=0.8 | V =8 mm
W=3.54 | R=0.03 | V=0.31 in

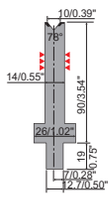
78°

B-LM90.10.78

42Cr: 900-1150 N/mm² **360 kN/m max.**

510 mm	*20.08"*	6.4 kg	
250 mm	*9.84"*	3.1 kg	
550 mm	*21.65"*	6.9 kg	F

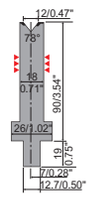
W=90 | R=1.0 | V=10 mm
W=3.54 | R=0.03 | V=0.39 in



78°

B-LM90.12.78

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



510 mm	*20.08"*	7.6 kg	
250 mm	*9.84"*	3.7 kg	
550 mm	*21.65"*	8.2 kg	F

W=90 | R=1.2 | V=12 mm
W=3.54 | R=0.04 | V=0.47 in

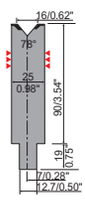
78°

B-LM90.16.78

42Cr: 900-1150 N/mm² **700 kN/m max.**

510 mm	*20.08"*	9.6 kg	
250 mm	*9.84"*	4.7 kg	
550 mm	*21.65"*	10.4 kg	F

W=90 | R=2.5 | V=16 mm
W=3.54 | R=0.09 | V=0.63 in



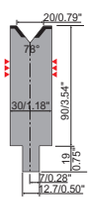
78°

B-LM90.20.78

42Cr: 900-1150 N/mm² **750 kN/m max.**

510 mm	*20.08"*	11.3 kg	
250 mm	*9.84"*	5.5 kg	
550 mm	*21.65"*	12.2 kg	F

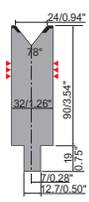
W=90 | R=1.6 | V=20 mm
W=3.54 | R=0.06 | V=0.79 in



78°

B-LM90.24.78

42Cr: 900-1150 N/mm² **910 kN/m max.**



510 mm	*20.08"*	11.4 kg	
250 mm	*9.84"*	5.6 kg	
550 mm	*21.65"*	12.3 kg	F

W=90 | R=2.4 | V=24 mm
W=3.54 | R=0.09 | V=0.94 in

78°

F: 550 mm - *21.65"*
mm: 20-20-25-25-30-35-40-40-45-75-75-120
in: ◁ 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72 ▷

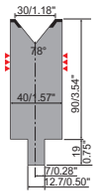
B-LM90.30.78

42Cr: 900-1150 N/mm² **1150 kN/m max.**

510 mm	*20.08"*	14.2 kg	
250 mm	*9.84"*	7.0 kg	
550 mm	*21.65"*	15.3 kg	F

W=90 | R=3.0 | V=30 mm
W=3.54 | R=0.11 | V=1.18 in

78°



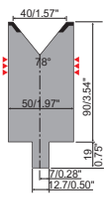
B-LM90.40.78

42Cr: 900-1150 N/mm² **1350 kN/m max.**

510 mm	*20.08"*	17.0 kg	
250 mm	*9.84"*	8.3 kg	
550 mm	*21.65"*	18.3 kg	F

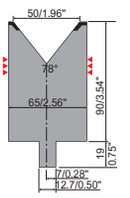
W=90 | R=4.0 | V=40 mm
W=3.54 | R=0.15 | V=1.57 in

78°



B-LM90.50.78

42Cr: 900-1150 N/mm² **1800 kN/m max.**



510 mm	*20.08"*	21.3 kg	
250 mm	*9.84"*	10.4 kg	
550 mm	*21.65"*	23.0 kg	F

W=90 | R=4.0 | V=50 mm
W=3.54 | R=0.15 | V=1.97 in

78°

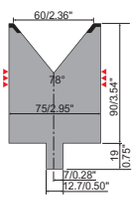
B-LM90.60.78

42Cr: 900-1150 N/mm² **2000 kN/m max.**

510 mm	*20.08"*	23.6 kg	
250 mm	*9.84"*	11.6 kg	
550 mm	*21.65"*	25.5 kg	F

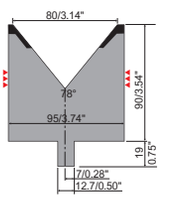
W=90 | R=5.0 | V=60 mm
W=3.54 | R=0.19 | V=2.36 in

78°



B-LM90.80.78

42Cr: 900-1150 N/mm² **2300 kN/m max.**



510 mm	*20.08"*	25.6 kg	
250 mm	*9.84"*	12.5 kg	
550 mm	*21.65"*	27.6 kg	F

W=90 | R=6.0 | V=80 mm
W=3.54 | R=0.23 | V=3.15 in

78°

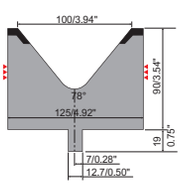
B-LM90.100.78

42Cr: 900-1150 N/mm² **2500 kN/m max.**

510 mm	*20.08"*	34.8 kg	
250 mm	*9.84"*	17.0 kg	
550 mm	*21.65"*	37.5 kg	F

W=90 | R=6.0 | V=100 mm
W=3.54 | R=0.23 | V=3.94 in

78°



F: 550 mm - *21.65"*
mm: 20-20-25-25-30-35-40-40-45-75-75-120
in: ◁ 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72 ▷

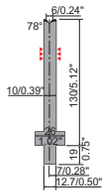
B-LM130.06.78

42Cr: 900-1150 N/mm² **280 kN/m max.**

510 mm	*20.08"*	6.8 kg	
250 mm	*9.84"*	3.3 kg	
550 mm	*21.65"*	7.3 kg	F

W=130 | R=0.8 | V=6 mm
W=5.12 | R=0.03 | V=0.23 in

78°



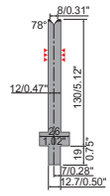
B-LM130.08.78

42Cr: 900-1150 N/mm² **320 kN/m max.**

510 mm	*20.08"*	7.7 kg	
250 mm	*9.84"*	3.8 kg	
550 mm	*21.65"*	8.3 kg	F

W=130 | R=0.8 | V=8 mm
W=5.12 | R=0.03 | V=0.31 in

78°



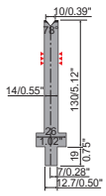
B-LM130.10.78

42Cr: 900-1150 N/mm² **360 kN/m max.**

510 mm	*20.08"*	8.6 kg	
250 mm	*9.84"*	4.2 kg	
550 mm	*21.65"*	9.3 kg	F

W=130 | R=1.0 | V=10 mm
W=5.12 | R=0.03 | V=0.39 in

78°



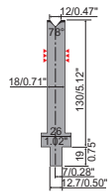
B-LM130.12.78

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

510 mm	*20.08"*	10.4 kg	
250 mm	*9.84"*	5.1 kg	
550 mm	*21.65"*	11.2 kg	F

W=130 | R=1.0 | V=12 mm
W=5.12 | R=0.03 | V=0.47 in

78°



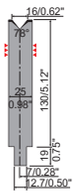
B-LM130.16.78

42Cr: 900-1150 N/mm² **700 kN/m max.**

510 mm	*20.08"*	13.6 kg	
250 mm	*9.84"*	6.7 kg	
550 mm	*21.65"*	14.7 kg	F

W=130 | R=1.6 | V=16 mm
W=5.12 | R=0.06 | V=0.63 in

78°



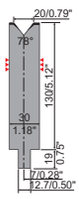
B-LM130.20.78

42Cr: 900-1150 N/mm² **750 kN/m max.**

510 mm	*20.08"*	16.0 kg	
250 mm	*9.84"*	7.8 kg	
550 mm	*21.65"*	17.3 kg	F

W=130 | R=2.0 | V=20 mm
W=5.12 | R=0.08 | V=0.79 in

78°



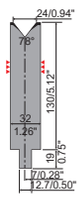
B-LM130.24.78

42Cr: 900-1150 N/mm² **910 kN/m max.**

510 mm	*20.08"*	16.9 kg	
250 mm	*9.84"*	8.3 kg	
550 mm	*21.65"*	18.2 kg	F

W=130 | R=2.4 | V=24 mm
W=5.12 | R=0.09 | V=0.94 in

78°



F: 550 mm - *21.65"*
mm: 20-20-25-25-30-35-40-40-45-75-75-120
in: ◁ 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72 ▷

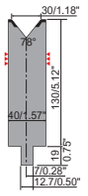
B-LM130.30.78

42Cr: 900-1150 N/mm² **1150 kN/m max.**

510 mm	*20.08"*	20.6 kg	
250 mm	*9.84"*	10.2 kg	
550 mm	*21.65"*	22.2 kg	F

W=130 | R=3.0 | V=30 mm
W=5.12 | R=0.11 | V=1.18 in

78°



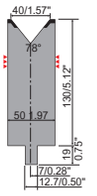
B-LM130.40.78

42Cr: 900-1150 N/mm² **1350 kN/m max.**

510 mm	*20.08"*	24.9 kg	
250 mm	*9.84"*	12.2 kg	
550 mm	*21.65"*	26.9 kg	F

W=130 | R=4.0 | V=40 mm
W=5.12 | R=0.15 | V=1.57 in

78°



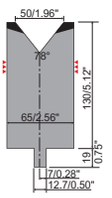
B-LM130.50.78

42Cr: 900-1150 N/mm² **1800 kN/m max.**

510 mm	*20.08"*	31.6 kg	
250 mm	*9.84"*	15.5 kg	
550 mm	*21.65"*	34.0 kg	F

W=130 | R=4.0 | V=50 mm
W=5.12 | R=0.15 | V=1.97 in

78°



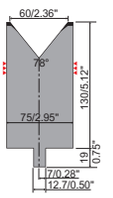
B-LM130.60.78

42Cr: 900-1150 N/mm² **2000 kN/m max.**

510 mm	*20.08"*	35.5 kg	
250 mm	*9.84"*	17.4 kg	
550 mm	*21.65"*	38.3 kg	F

W=130 | R=5.0 | V=60 mm
W=5.12 | R=0.19 | V=2.36 in

78°



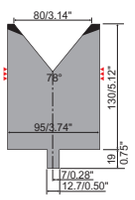
B-LM130.80.78

42Cr: 900-1150 N/mm² **2300 kN/m max.**

510 mm	*20.08"*	42.5 kg	
250 mm	*9.84"*	20.8 kg	
550 mm	*21.65"*	45.8 kg	F

W=130 | R=6.0 | V=80 mm
W=5.12 | R=0.24 | V=3.15 in

78°



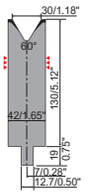
B-LM130.30.60

42Cr: 900-1150 N/mm² **1050 kN/m max.**

510 mm	*20.08"*	21.2 kg	
250 mm	*9.84"*	10.4 kg	
550 mm	*21.65"*	22.9 kg	F

W=130 | R=3.0 | V=30 mm
W=5.12 | R=0.11 | V=1.18 in

60°>



F: 550 mm - *21.65"*
mm: 20-20-25-25-30-35-40-40-45-75-75-120
in: ◁0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72▷

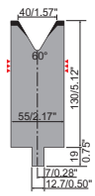
B-LM130.40.60

42Cr: 900-1150 N/mm² **1300 kN/m max.**

510 mm	*20.08"*	26.9 kg	
250 mm	*9.84"*	13.2 kg	
550 mm	*21.65"*	29.0 kg	F

W=130 | R=4.0 | V=40 mm
W=5.12 | R=0.16 | V=1.57 in

60°



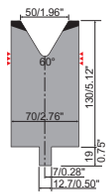
B-LM130.50.60

42Cr: 900-1150 N/mm² **1780 kN/m max.**

510 mm	*20.08"*	33.1 kg	
250 mm	*9.84"*	16.2 kg	
550 mm	*21.65"*	35.7 kg	F

W=130 | R=4.0 | V=50 mm
W=5.12 | R=0.16 | V=1.97 in

60°



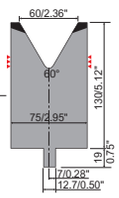
B-LM130.60.60

42Cr: 900-1150 N/mm² **1700 kN/m max.**

510 mm	*20.08"*	33.9 kg	
250 mm	*9.84"*	16.6 kg	
550 mm	*21.65"*	36.6 kg	F

W=130 | R=5.0 | V=60 mm
W=5.12 | R=0.19 | V=2.36 in

60°



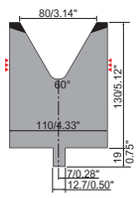
B-LM130.80.60

42Cr: 900-1150 N/mm² **2500 kN/m max.**

510 mm	*20.08"*	47.4 kg	
250 mm	*9.84"*	23.2 kg	
550 mm	*21.65"*	51.1 kg	F

W=130 | R=6.0 | V=80 mm
W=5.12 | R=0.24 | V=3.15 in

60°



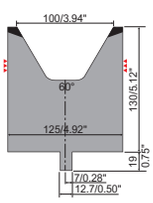
B-LM130.100.60

42Cr: 900-1150 N/mm² **2700 kN/m max.**

510 mm	*20.08"*	49.4 kg	
250 mm	*9.84"*	24.2 kg	
550 mm	*21.65"*	53.3 kg	F

W=130 | R=6.0 | V=100 mm
W=5.12 | R=0.24 | V=3.94 in

30°>



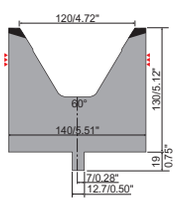
B-LM130.120.60

42Cr: 900-1150 N/mm² **2200 kN/m max.**

510 mm	*20.08"*	50.6 kg	
250 mm	*9.84"*	24.8 kg	
550 mm	*21.65"*	54.6 kg	F

W=130 | R=8.0 | V=120 mm
W=5.12 | R=0.31 | V=4.72 in

30°



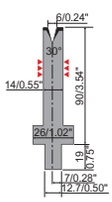
B-LM90.06.30

42Cr: 900-1150 N/mm² **250 kN/m max.**

510 mm	*20.08"*	5.2 kg	
250 mm	*9.84"*	2.5 kg	
550 mm	*21.65"*	5.6 kg	F

W=90 | R=0.8 | V=6 mm
W=3.54 | R=0.03 | V=0.24 in

30°



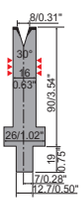
B-LM90.08.30

42Cr: 900-1150 N/mm² **260 kN/m max.**

510 mm	*20.08"*	6.9 kg	
250 mm	*9.84"*	3.4 kg	
550 mm	*21.65"*	7.4 kg	F

W=90 | R=0.8 | V=8 mm
W=3.54 | R=0.03 | V=0.31 in

30°



F: 550 mm - *21.65"*
mm: 20-20-25-25-30-35-40-40-45-75-75-120
in: ◁ 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72 ▷

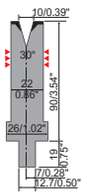
B-LM90.10.30

42Cr: 900-1150 N/mm² **360 kN/m max.**

510 mm	*20.08"*	9.9 kg	
250 mm	*9.84"*	4.9 kg	
550 mm	*21.65"*	10.7 kg	B

W=90 | R=1.0 | V=10 mm
W=3.54 | R=0.03 | V=0.39 in

30°



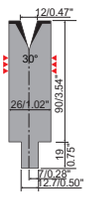
B-LM90.12.30

42Cr: 900-1150 N/mm² **460 kN/m max.**

510 mm	*20.08"*	9.8 kg	
250 mm	*9.84"*	4.8 kg	
550 mm	*21.65"*	10.6 kg	F

W=90 | R=1.2 | V=12 mm
W=3.54 | R=0.04 | V=0.47 in

30°



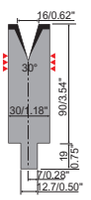
B-LM90.16.30

42Cr: 900-1150 N/mm² **510 kN/m max.**

510 mm	*20.08"*	10.8 kg	
250 mm	*9.84"*	5.3 kg	
550 mm	*21.65"*	11.6 kg	F

W=90 | R=1.6 | V=16 mm
W=3.54 | R=0.06 | V=0.63 in

30°



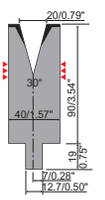
B-LM90.20.30

42Cr: 900-1150 N/mm² **680 kN/m max.**

510 mm	*20.08"*	13.9 kg	
250 mm	*9.84"*	6.8 kg	
550 mm	*21.65"*	14.9 kg	F

W=90 | R=2.0 | V=20 mm
W=3.54 | R=0.07 | V=0.79 in

30°



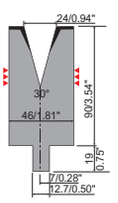
B-LM90.24.30

42Cr: 900-1150 N/mm² **930 kN/m max.**

510 mm	*20.08"*	15.5 kg	
250 mm	*9.84"*	7.6 kg	
550 mm	*21.65"*	16.7 kg	F

W=90 | R=2.4 | V=24 mm
W=3.54 | R=0.09 | V=0.94 in

30°



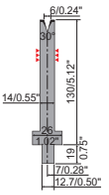
B-LM130.06.30

42Cr: 900-1150 N/mm² **250 kN/m max.**

510 mm	*20.08"*	8.6 kg	
250 mm	*9.84"*	4.2 kg	
550 mm	*21.65"*	9.3 kg	F

W=130 | R=0.8 | V=6 mm
W=5.12 | R=0.03 | V=0.24 in

30°



F: 550 mm - *21.65"*
mm: 20-20-25-25-30-35-40-40-45-75-75-120
in: ◁ 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72 ▷

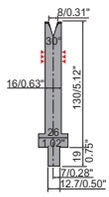
B-LM130.08.30

42Cr: 900-1150 N/mm² **260 kN/m max.**

510 mm	*20.08"*	9.4 kg	
250 mm	*9.84"*	4.6 kg	
550 mm	*21.65"*	10.1 kg	F

W=130 | R=0.8 | V=8 mm
W=5.12 | R=0.03 | V=0.31 in

30°



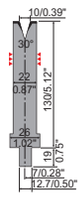
B-LM130.10.30

42Cr: 900-1150 N/mm² **360 kN/m max.**

510 mm	*20.08"*	14.1 kg	
250 mm	*9.84"*	6.9 kg	
550 mm	*21.65"*	15.2 kg	F

W=130 | R=1.0 | V=10 mm
W=5.12 | R=0.03 | V=0.39 in

30°



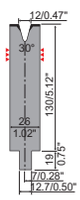
B-LM130.12.30

42Cr: 900-1150 N/mm² **460 kN/m max.**

510 mm	*20.08"*	13.9 kg	
250 mm	*9.84"*	6.8 kg	
550 mm	*21.65"*	15.0 kg	F

W=130 | R=1.2 | V=12 mm
W=5.12 | R=0.04 | V=0.47 in

30°



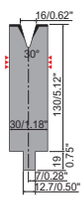
B-LM130.16.30

42Cr: 900-1150 N/mm² **510 kN/m max.**

510 mm	*20.08"*	15.6 kg	
250 mm	*9.84"*	7.6 kg	
550 mm	*21.65"*	16.8 kg	F

W=130 | R=1.6 | V=16 mm
W=5.12 | R=0.06 | V=0.63 in

30°



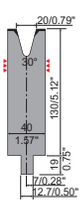
B-LM130.20.30

42Cr: 900-1150 N/mm² **680 kN/m max.**

510 mm	*20.08"*	20.2 kg	
250 mm	*9.84"*	10.0 kg	
550 mm	*21.65"*	21.7 kg	F

W=130 | R=2.0 | V=20 mm
W=5.12 | R=0.07 | V=0.79 in

30°



Create your account on www.rolleritools.com. You can use our website to ask for offers, keep you up to date on the latest news, check prices and place orders online.

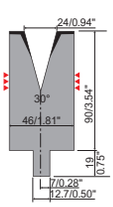
B-LM130.24.30

42Cr: 900-1150 N/mm² **930 kN/m max.**

510 mm	*20.08"*	22.8 kg	
250 mm	*9.84"*	11.2 kg	
550 mm	*21.65"*	24.6 kg	F

W=130 | R=2.4 | V=24 mm
W=5.12 | R=0.09 | V=0.94 in

30°



F: 550 mm - *21.65"*
mm: 20-20-25-25-30-35-40-40-45-75-75-120
in: ◁ 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72 ▷

B-LM90.T08.20

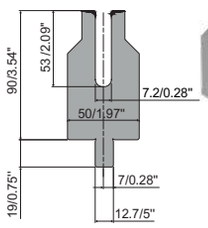
42Cr: 900-1150 N/mm² **360 kN/m max.**

510 mm	*19.68"*	15.5 kg	
250 mm	*9.84"*	7.8 kg	
550 mm	*21.65"*	17.0 kg	F

W=90 | R=0.8 | V=8

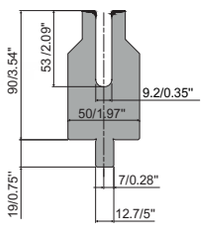
W=3.54 | R=0.03 | V=0.31

20°>



B-LM90.T10.20

42Cr: 900-1150 N/mm² **300 kN/m max.**



510 mm	*19.68"*	15.0 kg	
250 mm	*9.84"*	7.4 kg	
550 mm	*21.65"*	16.2 kg	FW

W=90 | R=1 | V=10

W=3.54 | R=0.039 | V=0.39

20°

B-LM90.T12.20

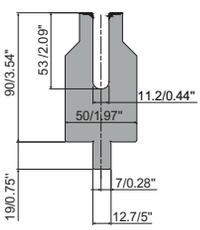
42Cr: 900-1150 N/mm² **210 kN/m max.**

510 mm	*19.68"*	14.6 kg	
250 mm	*9.84"*	7.2 kg	
550 mm	*21.65"*	15.7 kg	FW

W=90 | R=1.2 | V=12

W=3.54 | R=0.047 | V=0.472

20°



B-LM130.T08.20

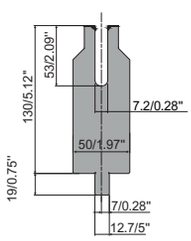
42Cr: 900-1150 N/mm² **360 kN/m max.**

510 mm	*19.68"*	23.3 kg	
250 mm	*9.84"*	11.4 kg	
550 mm	*21.65"*	25.1 kg	FW

W=130 | R=0.8 | V=8

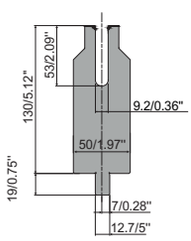
W=5.12 | R=0.03 | V=0.31

20°



B-LM130.T10.20

42Cr: 900-1150 N/mm² **300 kN/m max.**



510 mm	*19.68"*	22.9 kg	
250 mm	*9.84"*	11.2 kg	
550 mm	*21.65"*	24.7 kg	FW

W=130 | R=1 | V=10

W=5.12 | R=0.039 | V=0.39

20°

B-LM130.T12.20

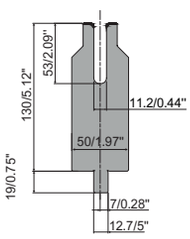
42Cr: 900-1150 N/mm² **210 kN/m max.**

510 mm	*19.68"*	23.3 kg	
250 mm	*9.84"*	11.4 kg	
550 mm	*21.65"*	25.1 kg	FW

W=130 | R=1.2 | V=12

W=5.12 | R=0.047 | V=0.472

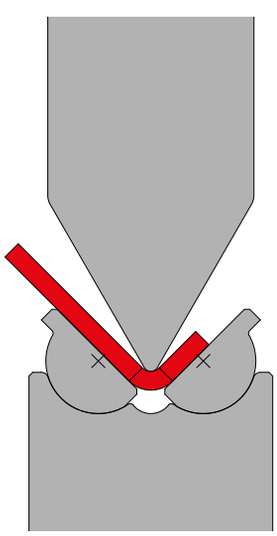
20°



.Rolla-V

Rolla-V dies differ from traditional dies thanks to two rotors where sheet metal lays before being bent. During bending these rotors accompany sheet metal and reduce consistently its friction resistance and the minimum flange. This die type applies the principles of swivel bending and for this reason sheet metal reaction is different. In case there are holes near the bending line, they are not deformed or flared-out.

Discover all the advantages and use Rolla-V formulas on our website.



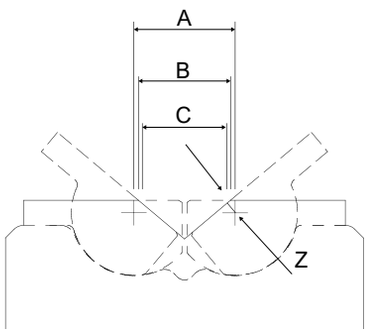
Sheet metal is always supported during bending

Minimum sheet metal movement onto inserts and therefore minimum marks

Internal bending radius equal to punch tip radius

.rolla-v: content explanation >>

- Ideal for inclined sides of metal sheet and to reduce bending marks on it.
- Aluminium and galvanised steel residues on sheet metal are absent.
- No friction, longer life and higher precision.
- Quicker tool change.



Model	A		B		C		Z	
	mm	*in*	mm	*in*	mm	*in*	mm	*in*
XT1	5.7	*0.22*	5.04	*0.2*	4.57	*0.18*	0.8	*0.03*
XT2	10	*0.39*	9.21	*0.36*	8.66	*0.34*	0.95	*0.04*
Model 1	8	*0.31*	7.17	*0.28*	6.59	*0.26*	1	*0.04*
Model 2	15	*0.59*	13.92	*0.55*	13.16	*0.52*	1.3	*0.05*
Model 2.5	28	*1.1*	26.34	*1.04*	25.17	*0.99*	2	*0.08*
Model 3	38	*1.5*	33.44	*1.32*	30.22	*1.19*	5.5	*0.22*
Model 3.5	60	*2.36*	57.1	*2.25*	55.05	*2.17*	3.5	*0.14*
Model 4	85	*3.35*	80.03	*3.15*	76.51	*3.01*	6	*0.24*

	with V		**Max. tool load (kN/m)**	**Material thickness**		**Min. bending angle**	**Needed press force mild steel with max. 450 N/mm2 (kN)**	**Needed press force stainless steel with max. 700 N/mm2 (kN)**	**Min. outside flange**		**Max. outside radius**	
	mm	*in*		mm	*in*				mm	*in*	mm	*in*
Model XT1 Max. recommended thickness= 1.2 mm *0.05*	5.7	*0.22*	500	0.5	*0.02*	60°	50	75	2.7	*0.11*	1.7	*0.07*
				1.0	*0.04*	60°	180	260	4.0	*0.16*	1.3	*0.05*
Model XT2 Max. recommended thickness= 2.3 mm *0.09*	10	*0.39*	500	1.2	*0.05*	60°	120	170	4.9	*0.19*	3.3	*0.13*
				2.0	*0.79*	60°	320	450	6.0	*0.24*	2.4	*0.09*
Model 1 Max. recommended thickness= 1.5 mm *0.06*	8	*0.31*	1000	0.7	*0.03*	40°	50	70	3	*0.12*	3	*0.12*
				1.1	*0.04*	35°	130	200	3.9	*0.15*	2.6	*0.1*
				1.5	*0.06*	35°	270	410	4.2	*0.17*	2.2	*0.09*
Model 2 Max. recommended thickness= 3.2 mm *0.12*	15	*0.59*	1500	2	*0.08*	59°	210	320	8.5	*0.33*	6	*0.24*
				3	*0.12*	47°	550	850	9.3	*0.37*	5	*0.2*
				3.2	*0.13*	47°	650	1000	9.3	*0.37*	4.8	*0.19*
Model 2.5 Max. recommended thickness= 6.3 mm *0.25*	28	*1.1*	2500	2	*0.08*	46°	100	150	18.6	*0.73*	13.2	*0.52*
				4	*0.16*	46°	470	730	18.6	*0.73*	12	*0.47*
				6	*0.24*	55°	1270	1960	18.6	*0.73*	9.8	*0.39*
Model 3 Max. recommended thickness= 6.3 mm *0.25*	38	*1.5*	2500	2	*0.08*	68°	70	110	22.5	*0.89*	13.9	*0.55*
				4	*0.16*	47°	340	500	22.5	*0.89*	11.9	*0.47*
				6	*0.24*	50°	900	1300	22.5	*0.89*	9.9	*0.39*
Model 3.5 Max. recommended thickness= 8 mm *0.31*	60	*2.36*	2500	6	*0.24*	75°	440	610	39	*1.53*	20	*0.79*
				8	*0.31*	75°	850	1190	39	*1.53*	20	*0.79*
Model 4 Max. recommended thickness= 16 mm *0.63*	85	*3.35*	3000	6	*0.24*	78°	260	440	56.6	*2.23*	36.4	*1.43*
				8	*0.31*	76°	500	840	56.6	*2.23*	36.4	*1.43*
				12	*0.47*	73°	1290	2150	56.6	*2.23*	36.4	*1.43*

.compatibility

serie \ tools	R1	R2	R3	R4	R5
RVP	●	-	-	-	-
RVS	○	-	-	-	-
RVT55-60	-	●	●	-	○
RVT100	-	●	●	-	○
RVT90	-	-	-	●	-
RVM	○	○	○	○	○
RVHD-RVPV	○	○	○	○	○
XT	●	○	○	-	-

○ available for some models only or on request with modifications

.materiale degli inserti

model \ material	LR 606 through hardened and triple tempered to give hardness of 54-56 HRC	D2 through hardened in a Vacuum to 61 HRC (Rockwell)
1	●	
2	●	
2.5		●
3		●
3.5		●
4		●
XT	●	

All measurements using HRc hardness are accurate to within 2 points.

.segmentation

single segments are also available on request - contact sales@rolleri.it to know more about price and availability

Model 1 and XT series: 440 mm - *17.32"*
mm: 200-100-50-30-25-20-15
in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59

Model 2: 450 mm - *17.72"*
mm: 200-100-40-35-30-25-20
in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79

Model 2.5: 470 mm - *18.50"*
mm: 200-100-50-45-40-35
in: 7.87-3.94-1.97-1.77-1.57 -1.38

Model 3: 455 mm - *17.91"*
mm: 200-100-60-50-45
in: 7.87-3.94-2.36-1.97-1.77

.standard length

length \ serie	RVP	RVS	RVT55-60	RVT100	RVT90	RVM	RVHD RVPV	XT
50 mm | *1.97"*	-	-	-	-	-	-	-	●
100 mm | *3.94"*	-	-	-	-	-	-	-	●
200 mm | *7.87"*	-	-	-	-	-	-	-	●
250 mm | *9.84"*	-	-	-	-	-	-	●	-
500 mm | *19.68"*	●	●	●	●	●	●	●	●

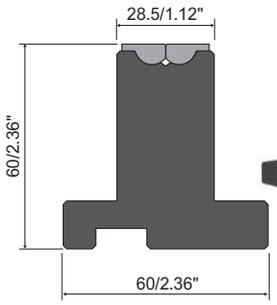
.RVP series >>

RVP60-1

42Cr: 900-1150 N/mm² **1500 kN/m max.**

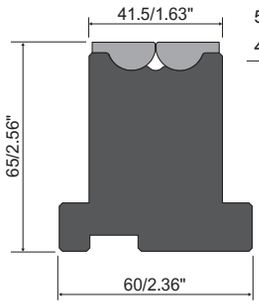
500 mm	*16.68"*	6.9 kg	
440 mm	*17.32"*	6.1 kg	F

MODEL 1



RVP65-2

42Cr: 900-1150 N/mm² **1500 kN/m max.**



500 mm	*16.68"*	7.9 kg	
450 mm	*17.72"*	7.4 kg	F

MODEL 2

Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

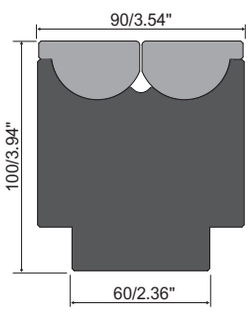
RVP100-3

42Cr: 900-1150 N/mm² **2500 kN/m max.**

500 mm	*16.68"*	28.8 kg	
455 mm	*17.91"*	26.2 kg	F

W=130 | R=2.0 | V=12 mm
W=5.12 | R=0.07 | V=0.47 in

MODEL 3



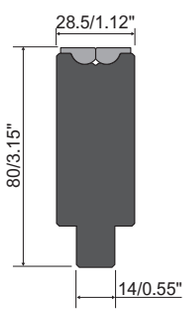
.RVS series >>

RVS80-1

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

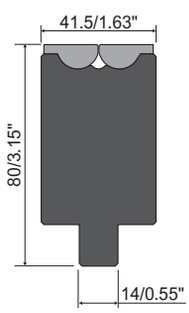
500 mm	*19.68"*	6.3 kg	
440 mm	*17.32"*	5.8 kg	F

MODEL 1



RVS80-2

42Cr: 900-1150 N/mm² **1500 kN/m max.**



500 mm	*19.68"*	8.3 kg	
450 mm	*17.72"*	7.8 kg	F

MODEL 2

Model 1: 440 mm - *17.32"*
mm: 200-100-50-30-25-20-15
in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59

Model 2: 450 mm - *17.72"*
mm: 200-100-40-35-30-25-20
in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79

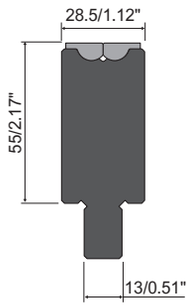
.RVT55-60 series >>

RVT55-1

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

500 mm	*19.68"*	5.5 kg	
440 mm	*17.32"*	5.0 kg	F

MODEL 1

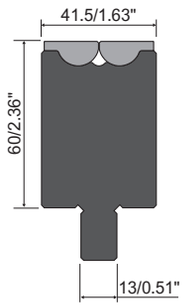


RVT60-2

42Cr: 900-1150 N/mm² **1500 kN/m max.**

500 mm	*19.68"*	7.9 kg	
450 mm	*17.72"*	7.4 kg	F

MODEL 2



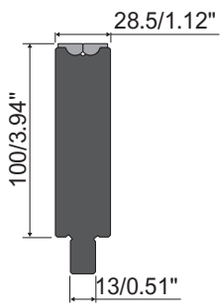
.RVT100 series >>

RVT100-1

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

500 mm	*19.68"*	9.4 kg	
440 mm	*17.32"*	8.6 kg	F

MODEL 1

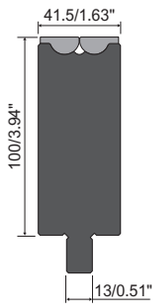


RVT100-2

42Cr: 900-1150 N/mm² **1500 kN/m max.**

500 mm	*19.68"*	12.4 kg	
450 mm	*17.72"*	11.7 kg	F

MODEL 2

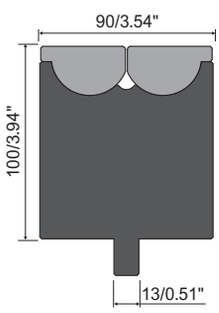


RVT100-3

42Cr: 900-1150 N/mm² **2500 kN/m max.**

500 mm	*19.68"*	30.9 kg	
455 mm	*17.91"*	28.5 kg	F

MODEL 3



Model 1: 440 mm - *17.32"*
mm: 200-100-50-30-25-20-15
in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59

Model 2: 450 mm - *17.72"*
mm: 200-100-40-35-30-25-20
in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79

Model 3: 455 mm - *17.91"*
mm: 200-100-60-50-45
in: 7.87-3.94-2.36-1.97-1.77

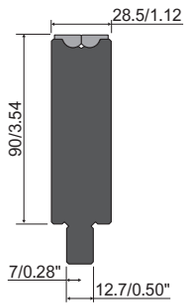
.RVT90 series >>

RVT90-1

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

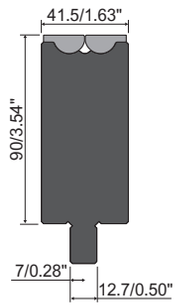
500 mm	*19.68"*	9.4 kg	
440 mm	*17.32"*	7.8 kg	F

MODEL 1



RVT90-2

42Cr: 900-1150 N/mm² **1500 kN/m max.**



500 mm	*19.68"*	11.3 kg	
450 mm	*17.72"*	10.6 kg	F

MODEL 2

.RVM series >>

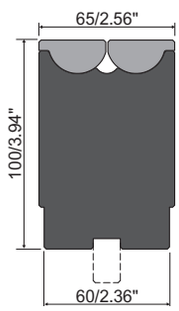
RVM2.5

42Cr: 900-1150 N/mm² **2500 kN/m max.**

with base 60 *2.36"*

500 mm	*19.68"*	22.0 kg	
470 mm	*18.50"*	21.0 kg	F

MODEL 2.5



RVM2.5-13 / RVM2.5-12.7

42Cr: 900-1150 N/mm² **2500 kN/m max.**

with tang 13 mm *0.51"*

500 mm	*19.68"*	23.5 kg	
470 mm	*18.50"*	22.4 kg	F

with tang 12.7 *0.5"*

500 mm	*19.68"*	23.5 kg	
470 mm	*18.50"*	22.4 kg	F

MODEL 2.5

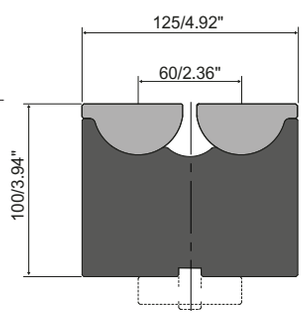
RVM3.5

42Cr: 900-1150 N/mm² **2000 kN/m max.**

with base 60 *2.36"*

250 mm	*9.84"*	22.0 kg
500 mm	*19.68"*	44.0 kg

MODEL 3.5



RVM3.5-13 / RVM3.5-12.7

42Cr: 900-1150 N/mm² **2500 kN/m max.**

with tang 13 mm *0.51"*

250 mm	*9.84"*	22.0 kg
500 mm	*19.68"*	44.0 kg

with tang 12.7 *0.5"*

500 mm	*9.84"*	22.0 kg
470 mm	*19.68"*	44.0 kg

MODEL 3.5

Model 1: 440 mm - *17.32"*
mm: 200-100-50-30-25-20-15
in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59

Model 2: 450 mm - *17.72"*
mm: 200-100-40-35-30-25-20
in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79

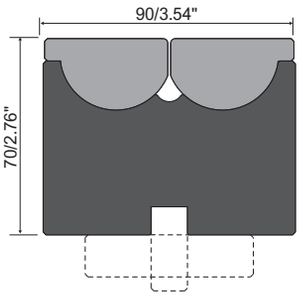
Model 2.5: 470 mm - *18.50"*
mm: 200-100-50-45-40-35
in: 7.87-3.94-1.97-1.77-1.57 -1.38

RVM70-3 / RVM70-3-60

42Cr: 900-1150 N/mm² **2500 kN/m max.**

Without tang			
500 mm	*19.68"*	20.6 kg	
455 mm	*17.91"*	18.7 kg	F
With base 60 mm *2.36"*			
500 mm	*19.68"*	23.5 kg	
455 mm	*17.91"*	23.0 kg	F

MODEL 3



RVM70-3-13 / RVM70-3-12.7

42Cr: 900-1150 N/mm² **2500 kN/m max.**

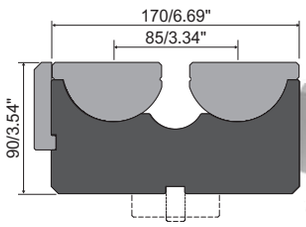
With tang 13 mm *0.51"*			
500 mm	*19.68"*	22.1 kg	
455 mm	*17.91"*	20.1 kg	F
With offset tang 12.7 *0.5"*			
500 mm	*19.68"*	22.1 kg	
455 mm	*17.91"*	20.1 kg	F

RVM90-4 / RVM90-4-60

42Cr: 900-1150 N/mm² **3000 kN/m max.**

Without tang		
500 mm	*19.68"*	56.6 kg
250 mm	*9.84"*	22.7 kg
With base 60 mm *2.36"*		
500 mm	*19.68"*	61.3 kg
250 mm	*9.84"*	24.6 kg

MODEL 4



RVM90-4-13 / RVM90-4-12.7

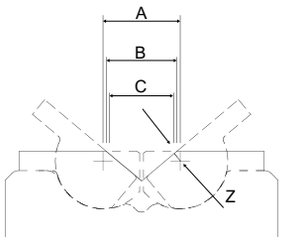
42Cr: 900-1150 N/mm² **3000 kN/m max.**

With tang 13 mm *0.51"*		
500 mm	*19.68"*	58.1 kg
250 mm	*9.84"*	23.3 kg
With offset tang 12.7 *0.5"*		
500 mm	*19.68"*	58.1 kg
250 mm	*9.84"*	23.3 kg

Model 3: 455 mm - *17.91"*
mm: 200-100-60-50-45
in: 7.87-3.94-2.36-1.97-1.77

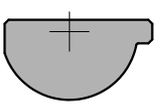
.adjustable dies series >>

All advantages described for Rolla-V dies are extended to the adjustable models.
Obviously the adjustable is as it says and the 'vee size' is adjustable.
Each of the HD models, 2, 2.5, 3 & 4 has its own parameters. Top formers can be supplied individually to form these radii, unfortunately there is not an adjustable top former.
There are 3 types of insert for all of these adjustable models, flat style for normal bending, concave style for producing complete radiused 'U' channels in one hit, and finally 'Pacman' style inserts to produce flat type channels.
One standard bottom tool to do all these.

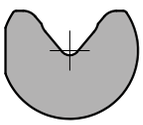


Model	A		B		C		Z	
	mm	*in*	mm	*in*	mm	*in*	mm	*in*
RVHD2	30	*1.18*	29	*1.14*	28.2	*1.11*	1.3	*0.05*
RVHD2.5	69	*2.72*	67.3	*2.65*	66.2	*2.61*	2.0	*0.08*
RVHD3	118	*4.65*	113.4	*4.46*	110.2	*4.34*	5.5	*0.22*
RVHD4	220	*8.66*	215	*8.46*	211.5	*8.33*	6.0	*0.24*

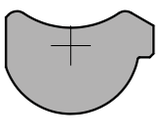
Model	A		B		C		Z	
	mm	*in*	mm	*in*	mm	*in*	mm	*in*
RVHD2	16	*0.63*	15	*0.59*	14.2	*0.56*	1.3	*0.05*
RVHD2.5	28	*1.1*	26.3	*1.04*	25.2	*0.99*	2.0	*0.08*
RVHD3	38	*1.5*	33.4	*1.31*	30.2	*1.19*	5.5	*0.22*
RVHD4	68.5	*2.7*	63.5	*2.5*	60	*2.36*	6.0	*0.24*



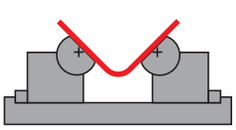
FLAT INSERT



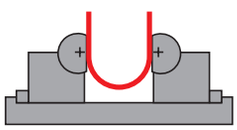
V INSERT



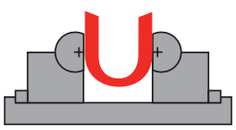
CONCAVE INSERT



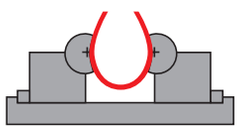
V-Bending
Flat inserts



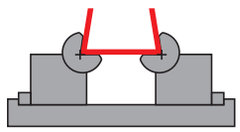
Radius-Bending
Flat inserts



Conical Bending
Flat inserts



Radius-Overbending
Concave inserts



U-Bending
V-inserts

	Max. load kN/m	Min. equivalent Vee - Flat Insert		Max. equivalent Vee - Flat insert		Max. Material Thickness - Flat Insert		Min. Outside Radius - Concave Insert		Max. Outside Radius - Concave Insert		Max. Material Thickness - Concave Insert		V Insert equivalent vee		Minimum Channel Width - V Insert		Maximum Channel Width - V Insert		Min/Max External Corner Radius - V insert		Max. Material Thickness - V Insert	
		mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*
RVHD2	2000	14	*0.55*	28	*1.10*	5	*0.19*	8	*0.31*	12	*0.47*	2	*0.07*	10	*0.39*	18.5	*0.72*	31.75	*1.25*	2.5-4	*0.09-0.15*	1.5	0.06
RVHD2.5	2500	25	*0.98*	65	*2.56*	10	*0.39*	15	*0.59*	27	*1.06*	4	*0.15*	18	*0.71*	35	*1.38*	72	*2.83*	4-9	*0.15-0.35*	2	*0.07*
RVHD3	3500	30	*1.18*	110	*4.33*	16	*0.63*	20	*0.78*	40	*1.57*	8	*0.31*	25	*0.98*	45	*1.77*	120	*4.72*	5-12	*0.19-0.47*	3	*0.11*
RVHD4	3500	60	*2.36*	210	*8.27*	26	*1.02*	40	*1.57*	65	2.56	12	0.47	40	1.57	72.5	2.85	220	8.66	5-20	*0.19-0.78*	5	0.19

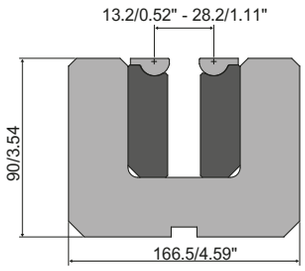
The present table is a guideline only and specific tests are recommended.
For further information contact tecnico@rolleri.it and get the correct parameters.

RVHD2

42Cr: 900-1150 N/mm² **2000 kN/m max.**

500 mm	*19.68"*	67.5 kg
250 mm	*9.84"*	27.0 kg

V RANGE
MM: 13.2 - 28.2
IN: 0.52 - 1.11

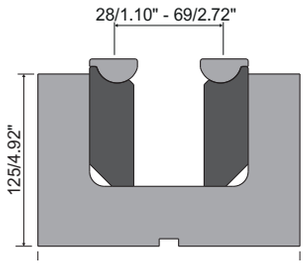


RVHD2.5

42Cr: 900-1150 N/mm² **2500 kN/m max.**

500 mm	*19.68"*	67.5 kg
250 mm	*9.84"*	27.0 kg

V RANGE
MM: 28 - 69
IN: 1.10 - 2.72

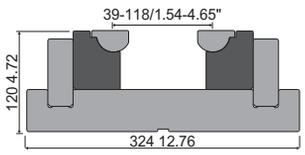


RVHD3

42Cr: 900-1150 N/mm² **3500 kN/m max.**

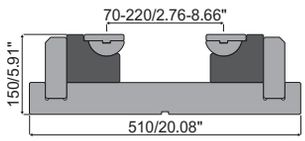
500 mm	*19.68"*	98.0 kg
250 mm	*9.84"*	38.1 kg

V RANGE
MM: 39 - 118
IN: 1.53 - 4.65



RVHD4

42Cr: 900-1150 N/mm² **4000 kN/m max.**



500 mm	*19.68"*	200.0 kg
250 mm	*9.84"*	80.0 kg

V RANGE
MM: 70 - 220
IN: 2.76 - 8.66

HANDLES INCLUDED

In order to move easily dies model RVPV3 and RVHD series, dies are equipped with two handles which can be screwed to threaded holes already drilled in the die. Such handles can be used for manual handling (when weight limit enables it) and for mechanical handling.
Thanks to this solution, die positioning and removal is easy and safe.

RVX1 grease is a litium-based lubricant with specific properties.
Thanks to its additives it can bear high work load generated by compression; it protects components undergoing friction, therefore it is suitable to protect rotors seat and avoid abrasion.

.XT series >>

Rolla-V XT dies are suitable to:
- Make tight counterbends thanks to their thin stem;
- Bend profiles with deformations near the bending line;
- Bend shorter flanges than with conventional dies;
- Bend feathered sides without flaring;
- Bend profiles with holes or slots near the bending line without deformation.

REFERENCE VALUE FOR MINIMUM FLANGE: MILD STEEL

	RVXT-1				RVXT-2			
	mm	*in*	mm	*in*	mm	*in*	mm	*in*
Radius of the punch/top-tool	**R0.5**	***R0.019***	**R1.0**	***R0.039***	**R0.5**	***R0.019***	**R1.0**	***R0.039***
Material thickness 0.5 mm - *0.019"*	2.7	*0.10*	2.9	*0.11*				
Material thickness 0.8 mm - *0.031"*	3.2	*0.12*	3.1	*0.12*	4.9	*1.19*	4.7	*0.18*
Material thickness 1.0 mm - *0.039"*	3.5	*0.14*	3.6	*0.14*	5.5	*0.22*	5.4	*0.21*
Material thickness 1.5 mm *0.059"*					6.0	*0.24*	6.1	*0.24*
Material thickness 2.0 mm *0.078"*					5.8	*0.23*	6.6	*0.26*

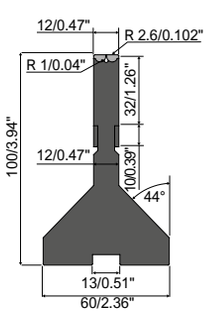
TABLE OF FORCE: TENSILE STRENGTH RM = 450 N/mm², BENDING ANGLE 90°

	RVXT-1				RVXT-2					
	mm	*in*	mm	*in*	mm	*in*	mm	*in*	mm	*in*
Radius of the punch/top-tool	**R0.2**	***R0.007***	**R1.0**	***R0.039***	**R0.2**	***R0.007***	**R1.0**	**R0.039**	**R3.0**	**R0.11**
Material thickness 0.3 mm - *0.01"*	40	*1.57*	50	*1.96*	40	*1.57*	50	*1.96*	50	*1.96*
Material thickness 0.5 mm - *0.019"*	50	*1.96*	60	*2.36*	50	*1.96*	50	*1.96*	50	*1.96*
Material thickness 0.8 mm - *0.031"*	100	*3.93*	130	*5.11*	70	*2.75*	80	*3.15*	90	*3.54*
Material thickness 1.0 mm - *0.039"*	150	*5.90*	190	*7.48*	80	*3.15*	100	*3.93*	130	*5.11*
Material thickness 1.2 mm - *0.04"*	240	*9.45*	300	*11.81*	110	*4.33*	140	*5.51*	180	*7.08*
Material thickness 1.6 mm - *0.06"*					200	*7.87*	220	*8.66*	250	*9.84*
Material thickness 2.0 mm - *0.078"*					300	*11.81*	330	*12.99*		
Material thickness 2.3 mm - *0.09"*					400	*15.74*	420	*16.53*		

RVXT-1

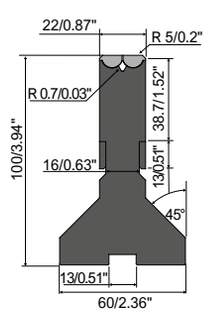
42Cr: 900-1150 N/mm² **500 kN/m max.**

50 mm	*1.97"*	0.2 kg	
100 mm	*3.94"*	0.4 kg	
200 mm	*7.87"*	0.9 kg	
500 mm	*19.68"*	2.1 kg	
440 mm	*17.32"*	1.9 kg	F



RVXT-2

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



50 mm	*1.97"*	1.0 kg	
100 mm	*3.94"*	2.0 kg	
200 mm	*7.87"*	4.0 kg	
500 mm	*19.68"*	10.0 kg	
440 mm	*17.32"*	8.8 kg	F

For mark free applications apply RVX-TAPE onto Rolla-V dies.
This adhesive tape is made of a composite material able to resist compression and at the same time to avoid friction between sheet metal and die.

Model 1: 440 mm - *17.32"*
mm: 200-100-50-30-25-20-15
in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59

RVX1

GREASE

RVX1 grease is a litium-based lubricant with specific properties. Thanks to its additives it can bear high work load generated by compression; it protects components undergoing friction, therefore it is suitable to protect rotors seat and avoid abrasion. A single pack contains 500g grease.

RVX-TAPE

PROTECTION

For mark free applications apply RVX-TAPE with width 12mm 0.47" or 20mm 0.79" onto Rolla-V dies. This adhesive tape is made of a composite material able to resist compression and at the same time to avoid friction between sheet metal and die.

RV-TO

MOUNTING TOOL

This tool has been designed to remove easily a spring from its dowel. Thanks to its shape, RV-TO can carry out this operation safely and replace worn parts very quickly.

Compatibility	Springs	Inserts	Lower spines	U clip
RVP60-1	RVP60-1/SP	RVP60-1/IN	RVP60-1/DO	RVP60-1/U
RVP65-2	RVP65-2/SP	RVP65-2/IN	RVP65-2/DO	RVP65-2/U
RVP100-3	RVP100-3/SP	RVP100-3/IN	RVP100-3/DO	RVP100-3/U
RVS80-1	RVS80-1/SP	RVS80-1/IN	RVS80-1/DO	RVS80-1/U
RVS80-2	RVS80-2/SP	RVS80-2/IN	RVS80-2/DO	RVS80-2/U
RVT55-1	RVT55-1/SP	RVT55-1/IN	RVT55-1/DO	RVT55-1/U
RVT60-2	RVT60-2/SP	RVT60-2/IN	RVT60-2/DO	RVT60-2/U
RVT100-1	RVT100-1/SP	RVT100-1/IN	RVT100-1/DO	RVT100-1/U
RVT100-2	RVT100-2/SP	RVT100-2/IN	RVT100-2/DO	RVT100-2/U
RVT100-3	RVT100-3/SP	RVT100-3/IN	RVT100-3/DO	RVT100-3/U
RVT90-1	RVT90-1/SP	RVT90-1/IN	RVT90-1/DO	RVT90-1/U
RVT90-2	RVT90-2/SP	RVT90-2/IN	RVT90-2/DO	RVT90-2/U
RVM2.5	RVM2.5/SP	RVM2.5/IN	RVM2.5/DO	RVM2.5/U
RVM3.5	RVM3.5/SP	RVM3.5/IN	RVM3.5/DO	RVM3.5/U
RVM70-3	RVM70-3/SP	RVM70-3/IN	RVM70-3/DO	RVM70-3/U
RVM90-4	RVM90-4/SP	RVM90-4/IN	RVM90-4/DO	RVM90-4/U
RVHD2	RVHD2/SP	RVHD2/IN	RVHD2/DO	RVHD2/U
RVHD2.5	RVHD2.5/SP	RVHD2.5/IN	RVHD2.5/DO	RVHD2.5/U
RVHD3	RVHD3/SP	RVHD3/IN	RVHD3/DO	RVHD3/U
RVHD4	RVHD4/SP	RVHD4/IN	RVHD4/DO	RVHD4/U
RVPV3	RVPV3/SP	RVPV3/IN	RVPV3/DO	RVPV3/U
RVXT-1	RVXT-1/SP	RVXT-1/IN	RVXT-1/DO	RVXT-1/U
RVXT-2	RVXT-2/SP	RVXT-2/IN	RVXT-2/DO	RVXT-2/U

.adjustable dies and dies with rollers

Adjustable dies, dies with rollers and the exclusive and patent-pending Rolleri Vario.
Rolleri Vario is a patent-pending adjustable die. Thanks to this solution you can mount one single tool onto a press brake table and change die V opening manually or with CNC.

.rolleri VARIO >>

Rolleri Vario is a patent-pending adjustable die.
Thanks to this solution you can mount one single tool onto a press brake table and change die V opening manually or with CNC.
The main features of Rolleri Vario are easy use, max. load 2500 KN/m, 60° die angle to control better sheet metal springback and its modularisation.
Rolleri Vario is manufactured in modules of 1000mm length each, which can be connected to each other and work like a unique die.
Minimum length is therefore 1000mm and maximum length depends on press brake length. Rolleri Vario already installed in the market are 4m, 6m, 7m, 8m and 12m long.
A specific feature of Rolleri Vario consists in the possibility to disconnect single modules from each other and use them as single dies with different V openings at the same time. This is very useful for stage bending.
Thanks to its modularization you can get different angles and different internal radii. The operating principle is very easy and handy: a pneumatic system releases the die from its toothered rack positioned on the bottom, so that the V opening needed can be set quickly. Once V opening is adjusted by rotating a round nonium, close compressed air (6bar) so that die sits in the toothered rack and it's ready to bend.
To adjust the die from the smallest to the biggest V opening you need about 5 seconds in the manual version. The system is supplied with an acustic device which signals the correct position of every V opening.
Vario is equipped with hardened R11 fixed elements, an effective compromise for bending a wide variety of materials and sheet thicknesses.
The die is made of heavy duty steel and its base and toothered rack are induction hardened.
The die is also supplied with a protective cloth to be quickly positioned in the V opening in order to protect the internal structure from dust and sheet metal residues.
Rolleri offers dies ranging from V40 up to V 400mm. There are 4 models with max. opening V=200 mm (7.87"), 260 mm (10.23"), 300 mm (11.81") and 400 mm (15.75") and V opening can be adjusted in steps of 20 mm (0.75") or 25 mm (0.98").
Every die can be adjusted manually, with an independent motoreducer and PLC or with a motoreducer connected to press brake CNC.
Rolleri Vario can also be supplied with an adapter positioned in the V opening, which can mount all standard dies in our catalogue.
Rolleri Vario is the synthesis of technology, practicality, safety and time-saving: setup time is reduced by 85%, operators don't have to handle big and heavy tools and the investment is lower than the total amount of single dies.

VARIO 50 - 200

mm	*in*
50	*1.97*
75	*2.95*
100	*3.94*
125	*4.92*
150	*5.90*
175	*6.89*
200	*7.87*

VARIO 40 - 260

mm	*in*
40	*1.57*
60	*2.36*
80	*3.15*
100	*3.94*
120	*4.72*
140	*5.51*
160	*6.23*
180	*7.09*
200	*7.87*
220	*8.66*
240	*9.45*
260	*10.23*

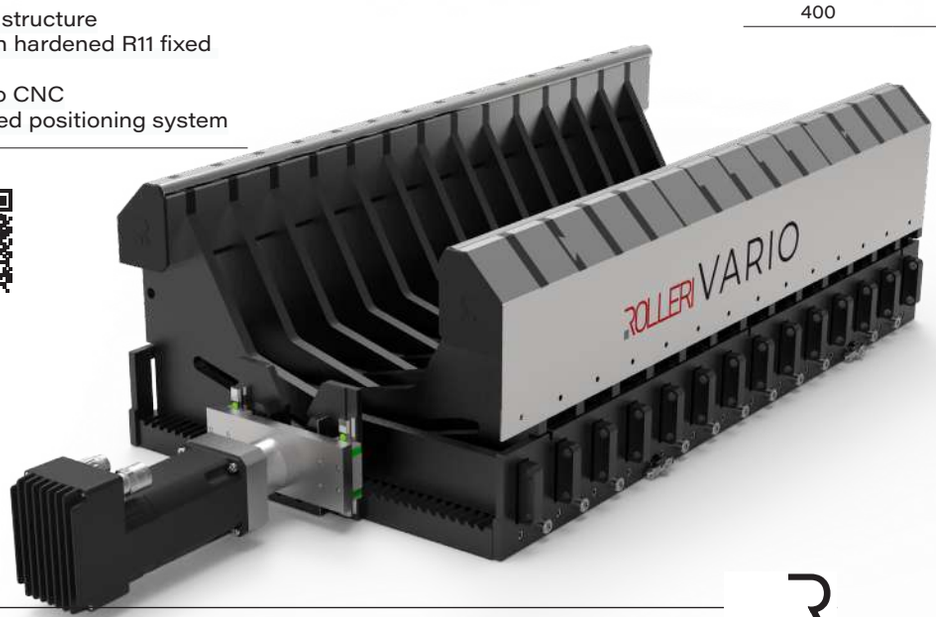
VARIO 50 - 300

mm	*in*
50	*1.97*
75	*2.95*
100	*3.94*
125	*4.92*
150	*5.90*
175	*6.89*
200	*7.87*
225	*8.86*
250	*9.84*
275	*10.83*
300	*11.81*

VARIO 50 - 400

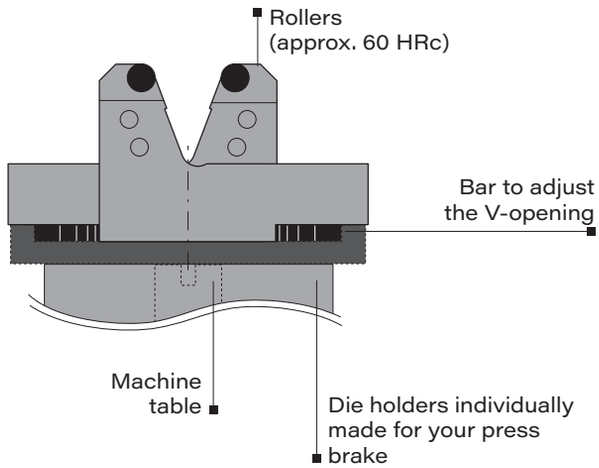
mm	*in*
50	*1.97*
75	*2.95*
100	*3.94*
125	*4.92*
150	*5.90*
175	*6.89*
200	*7.87*
225	*8.86*
250	*9.84*
275	*10.83*
300	*11.81*
325	*12.80*
350	*13.78*
375	*14.76*
400	*15.75*

- High resistance steel structure
- Vario is equipped with hardened R11 fixed elements
- Gearmotor plugged to CNC
- Pneumatically operated positioning system



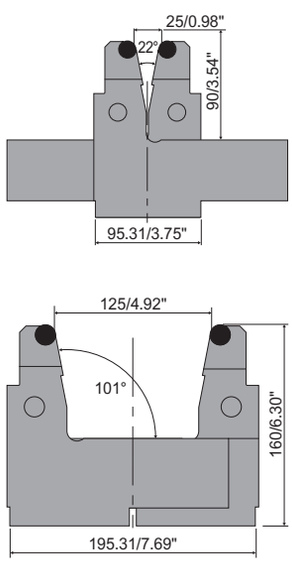
.adjustable dies >>

AD dies can bend different sheet metal thickness types with one single die. V opening can be adjusted very easily and quickly and set by using spacer bars.
There are 4 models with different V opening range in order to bend different sheet metal thickness. V opening can be adjusted in 3 ways: manually, semiautomatically by using a starter or automatically with a motorized system.
The die structure is composed of 3 parts: the main frame which represents a die, a holder and spacer bars. The holder can be supplied with different tangs.
Spacer bars are inserted into the die sides to stop the V opening in a certain position. All AD dies have hardened rollers and can bend up to 30° in order to control better sheet metal springback.
To preserve die structure from dust and sheet metal residues, a die is supplied with a protection foil to be positioned into the V opening.
Such operation is quick and simple.
A remarkable feature is their max. workload, which for some models reaches 6000 Kn/m. In order to set press brake CNC we can supply dxf drawings.

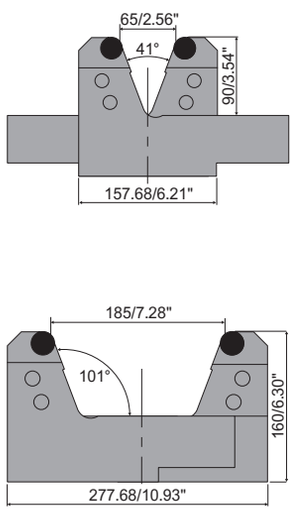


Protection foil available in different width to be placed into the V opening to protect it from dust and sheet metal residues.
Easy to be placed and it doesn't interfere during bending.

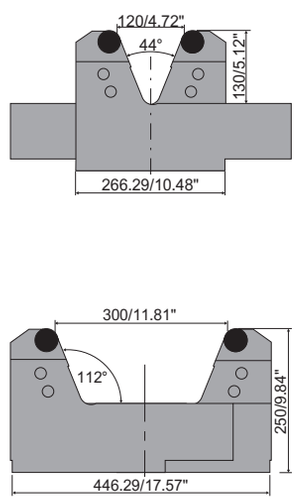
AD25.125



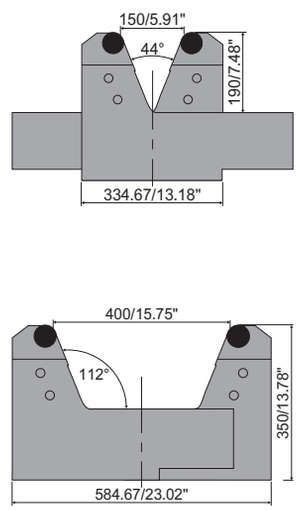
AD65.185



AD120.300



AD150.400



		AD25.125	AD65.125	AD120.300	AD150.400
		42Cr: 900-1150 N/mm²	42Cr: 900-1150 N/mm²	42Cr: 900-1150 N/mm²	42Cr: 900-1150 N/mm²
		1250 kN/m max. (90°)	2000 kN/m max. (90°)	4000 kN/m max. (90°)	6000 kN/m max. (90°)
		V 25-125 mm *0.98-4.92 in*	**V** 65-185 mm *2.56-7.28 in*	**V** 120-300 mm *4.72-11.81 in*	**V** 150-400 mm *5.91-15.75 in*
		° 30°-180°	**°** 60°-180°	**°** 60°-180°	**°** 60°-180°
		R 8 mm *0.31 in*	**R** 12.5 mm *0.49 in*	**R** 20 mm *0.79 in*	**R** 25 mm *0.98 in*
mm	*in*				
250	*9.84*	34.0 kg	44.0 kg		
500	*19.69*	64.0 kg	86.0 kg		
550	*21.65*	72.0 kg	96.0 kg		
1000	*39.37*	125.0 kg	170.0 kg		
1050	41.34	133.0 kg	180.0 kg		
600	23.62			360.0 kg	560.0 kg

BAR AD25.185

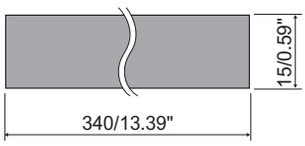
BAR

42Cr: 900-1150 N/mm²

500 mm	*19.69"*	21.0 kg
1000 mm	*39.37"*	42.0 kg
2000 mm	*78.74"*	84.0 kg

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

TO USE WITH:
AD25.125



BAR AD120.300

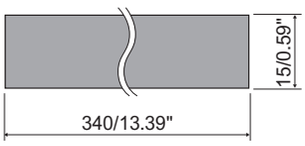
BAR

42Cr: 900-1150 N/mm²

600 mm	*23.62"*	45.0 kg
1200 mm	*47.24"*	90.0 kg
1800 mm	*70.78"*	135.0 kg

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

TO USE WITH:
AD120.300



BAR AD150.400

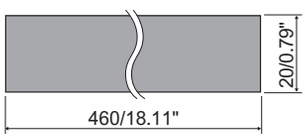
BARRA

42Cr: 900-1150 N/mm²

600 mm	*23.62"*	55.0 kg
1200 mm	*47.24"*	110.0 kg
1800 mm	*70.78"*	165.0 kg

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

TO USE WITH:
AD150.400



HAD25.125-A

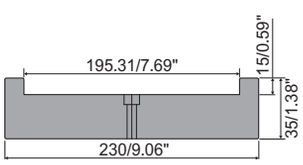
HOLDER

42Cr: 900-1150 N/mm²

500 mm	*19.69"*	20.0 kg
1000 mm	*39.37"*	40.0 kg
2000 mm	*78.74"*	80.0 kg
3000 mm	*118.11"*	120.0 kg

Holders available with
flat bottom and with tang

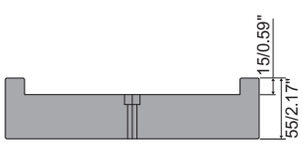
TO USE WITH:
AD25.125



HAD25.125-B

HOLDER

42Cr: 900-1150 N/mm²



500 mm	*19.69"*	38.0 kg
1000 mm	*39.37"*	76.0 kg
2000 mm	*78.74"*	152.0 kg
3000 mm	*118.11"*	228.0 kg

Holders available with
flat bottom and with tang

TO USE WITH:
AD25.125

HAD65.185-A

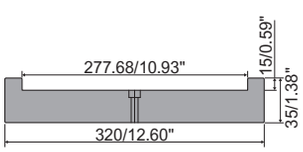
HOLDER

42Cr: 900-1150 N/mm²

500 mm	*19.69"*	28.0 kg
1000 mm	*39.37"*	56.0 kg
2000 mm	*78.74"*	112.0 kg
3000 mm	*118.11"*	168.0 kg

Holders available with
flat bottom and with tang

TO USE WITH:
AD65.185



HAD65.185-B

HOLDER

42Cr: 900-1150 N/mm²

500 mm	*19.69"*	53.0 kg
1000 mm	*39.37"*	106.0 kg
2000 mm	*78.74"*	212.0 kg
3000 mm	*118.11"*	424.0 kg

Holders available with
flat bottom and with tang

TO USE WITH:
AD65.185

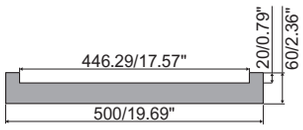
HAD120.300

HOLDER

42Cr: 900-1150 N/mm²

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

Holder available with flat bottom

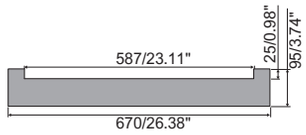


TO USE WITH:
AD120.300

HAD150.400

HOLDER

42Cr: 900-1150 N/mm²



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

Holder available with flat bottom:

TO USE WITH:
AD150.400

BENDING HANDBOOK
The Bending handbook target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.
Visit rolleriools.com to find out more about the handbook

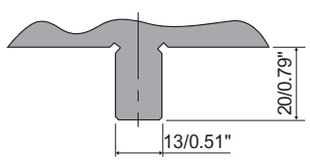
Create your account on www.rolleritools.com. You can use our website to ask for offers, keep you up to date on the latest news, check prices and place orders online.

.dies with rollers >>

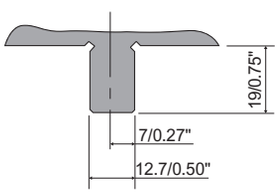
Dies with rollers are an effective solution to reduce sheet metal marks, thanks to their hardened and ground rollers which slide sheet metal into the V opening.
Roller rotation reduces friction and subsequently necessary tonnage by about 10-15-%.
Roller seat is machined to avoid accidental fall of rollers.
All dies are made of 42CrMo4 steel and they can be manufactured with any tang to be clamped in press brake table. In order to better control springback, all die V openings have 78°.

Available tangs:

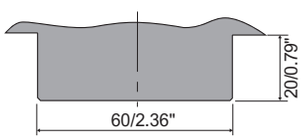
A11



A13



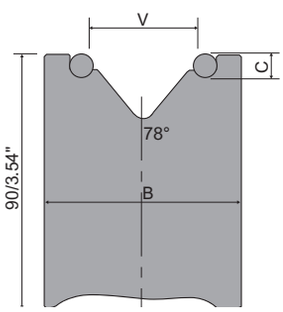
A10



MR90

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

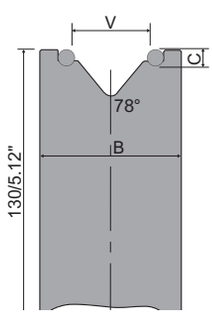
42Cr: 900-1150 N/mm²
Roller: C53:610-760 N/mm²



MR130

	V		B		C		Length		
	mm	*in*	mm	*in*	mm	*in*	mm	*in*	
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	*0.31*	835	*32.87*	28.0 kg
MR130.40.78	40	*1.57*	70	*2.76*	8	*0.31*	835	*32.87*	34.0 kg
MR130.50.78	50	*1.97*	84	*3.31*	10	*0.39*	835	*32.87*	40.0 kg
MR130.60.78	60	*2.36*	94	*3.70*	10	*0.39*	835	*32.87*	45.0 kg
MR130.75.78	75	*2.95*	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

42Cr: 900-1150 N/mm²
Roller: C53:610-760 N/mm²

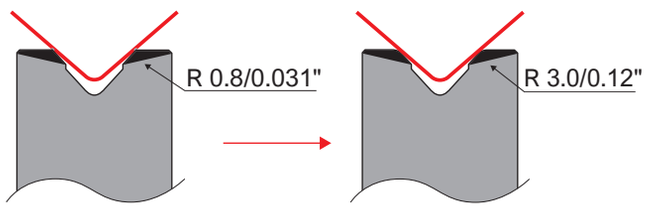


.mark free bending

Avoiding sheet metal marks like scratches and abrasions during bending is very difficult. Such a problem arises when bending stainless steel, aluminium and prepainted sheet metal.
Rolleri offers different solutions to avoid such marks in the friction areas between sheet metal and die.

.rolfilm >>

One of the most common ways to avoid sheet metal marks during bending is the use of ROLFILM. Rolfilm is a foil available in different thicknesses, which is positioned between sheet metal and die.
The choice of one rolfilm thickness or the other depends on the sheet metal thickness to be bent. To find out more about it, we recommend you write to tecnico@rolleri.it.
Minimum thickness is 0.4mm (0.02") whereas maximum thickness is 2.0mm (0.08").
Rolfilm is also available in different widths: 100mm, 150mm and 200mm (3.94", 5.90" and 7.87").
By shifting Rolfilm along X axis, you can use its whole surface; if for example you use a V20 die, you have at least 15-20 bending positions in the same film portion before moving the foil forward. Rolfilm rolls are available in four different lengths: 3m, 10m, 20m and 30m. A very useful accessory to use the whole Rolfilm width is CT, a pair of tensioners. Each tensioner is mounted at one end of dies with a clamp tightened to die stem. In the upper part of CT you can insert Rolfilm.
Both tensioners mounted opposite to each other are fundamental to set the proper foil tension for correct use.
ROLFILM has very good elastic and compression properties. For this reason CNC setup correction needed are limited.
In order to improve foil operational life by bending on the same foil portion, you can use Rolfilm with dies with bigger radius (for example T dies CLASSIC - TR dies).



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

ROLFILM

Model	Thickness		Width		Lenght	
	mm	*in*	mm	*in*	m	*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	*393.7*
ROLFILM 20-0.4-100	0.4	*0.016*	100	*3.94*	20	*787.4*
ROLFILM 30-0.4-100	0.4	*0.016*	100	*3.94*	30	*1181.1*
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	*393.7*
ROLFILM 20-0.4-150	0.4	*0.016*	150	*5.91*	20	*393.7*
ROLFILM 30-0.4-150	0.4	*0.016*	150	*5.91*	30	*787.4*
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	*393.7*
ROLFILM 20-0.6-150	0.6	*0.024*	150	*5.91*	20	*787.4*
ROLFILM 30-0.6-150	0.6	*0.024*	150	*5.91*	30	*1181.1*
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	*393.7*
ROLFILM 20-0.6-200	0.6	*0.024*	200	*7.87*	20	*787.4*
ROLFILM 30-0.6-200	0.6	*0.024*	200	*7.87*	30	*1181.1*
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	*393.7*
ROLFILM 20-2-150	2.0	*0.079*	150	*5.91*	20	*787.4*
ROLFILM 30-2-150	2.0	*0.079*	150	*5.91*	30	*1181.1*

CT

TENSIONER

per piece	6 kg

Scan the QRCode or click on it to watch the video and find out more about ROLFILM.

.polyurethane inserts and holders >>

Polyurethane inserts and their holders have been designed to give a good quality solution when bending large-radii. Such solution provides two important advantages: mark-free profile and precise radius.
A polyurethane insert can be compressed in the middle during bending and can wrap sheet metal around a radius tool.
Actually it works like a die deforming according to punch radius.
Please notice that the maximum sheet metal thickness to be used for this application is 2mm.
Rolleri offers different polyurethane inserts with different dimensions according to the needed radius.
As far as profile angle is concerned, we can offer full inserts (for wider profile angle) or inserts with a hole, which can undergo bigger compression and can bend narrower angles.
Holders have to limit polyurethane insert deformations, so that its deformation happens only according to punch radius.
Each insert has its own holder, so that deformations are guided.
The last element to take into consideration is PSTCON: a pair of plates to close inserts at both ends to avoid uncontrolled deformations in this areas.

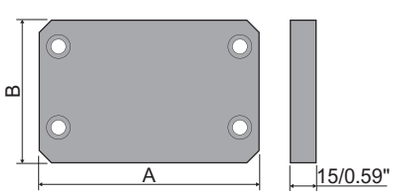
Such insert deformation at the ends may cause profile and angle deformations, as angle may be more open in the last 100mm (3.94").
This solution is usually used with radius tool holders in chapters R1, R2, R3 and R4 with their respective radius tools.

PSTCON

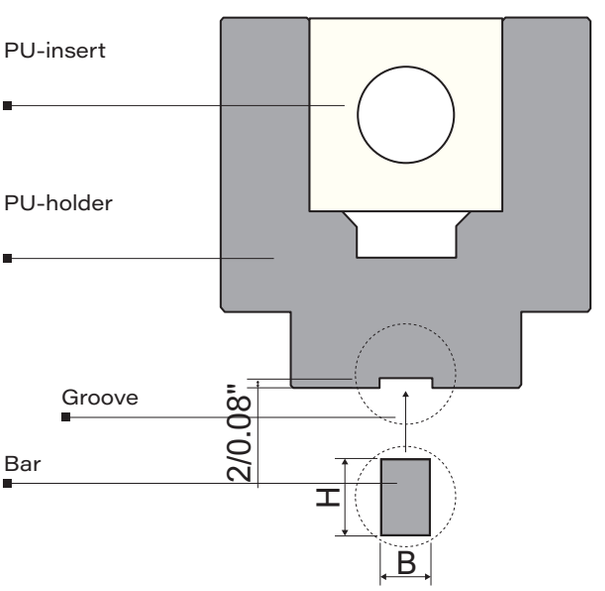
COVER PLATE

C45: 560-710 N/mm2

	A mm	*A in*	B mm	*B in*	
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

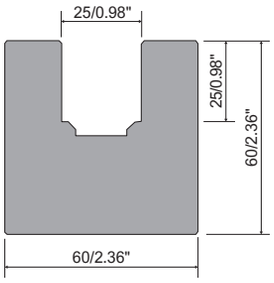


.mark free bending

MPG25

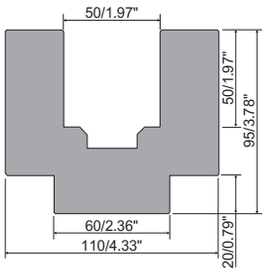
C45: 560-710 N/mm2

835 mm	*32.87″*	18.5 kg
415 mm	*16.34″*	9.2 kg



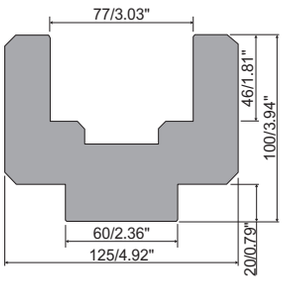
MPG50

C45: 560-710 N/mm2



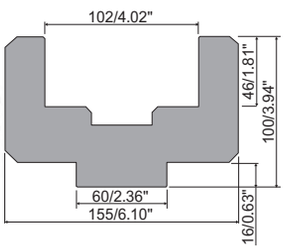
MPG75

C45: 560-710 N/mm2

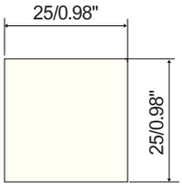


MPG100

C45: 560-710 N/mm2

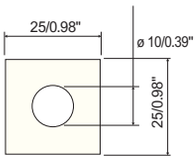


GM 25X25



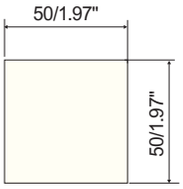
835 mm	*32.87″*	0.6 kg
415 mm	*16.34″*	0.3 kg

GMF 25X25X10



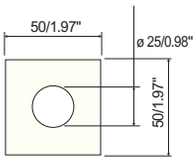
835 mm	*32.87″*	0.6 kg
415 mm	*16.34″*	0.3 kg

GM 50X50



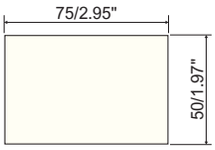
835 mm	*32.87″*	2.5 kg
415 mm	*16.34″*	1.2 kg

GMF 50X50X25



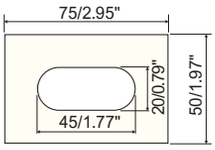
835 mm	*32.87″*	2.5 kg
415 mm	*16.34″*	1.2 kg

GM 75X50



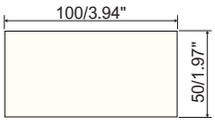
835 mm	*32.87″*	3.5 kg
415 mm	*16.34″*	1.7 kg

GMF 75X50X20



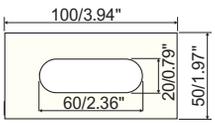
835 mm	*32.87″*	3.5 kg
415 mm	*16.34″*	1.7 kg

GM 100X50



835 mm	*32.87″*	2.5 kg
415 mm	*16.34″*	1.2 kg

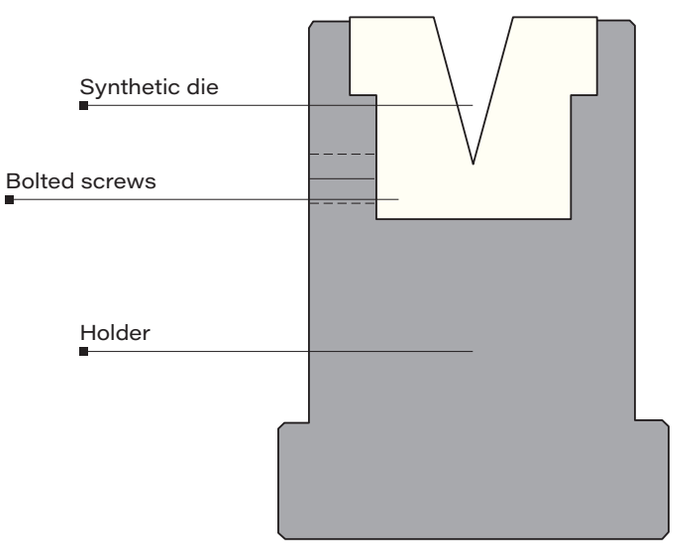
GMF 100X50X20



835 mm	*32.87″*	3.0 kg
415 mm	*16.34″*	2.2 kg

.synthetinc dies >>

A solution to avoid sheet metal marks is the use of nylon inserts and their holders.
These nylon inserts have a V opening in the middle similar to standard dies V opening. The main difference is the material, which in this case is nylon in order to reduce sheet metal friction while sliding into the V opening. In this case the surface contact is soft and therefore it doesn't scratch sheet metal.
Each insert is available with V opening ranging from 6mm to 16mm (0.24" to 0.63") and according to the bending angle you can choose angle 88°, 60°, 45° and 30°. Inserts are always positioned in precise holders, so that they have no space to move freely.
On holder operator's side there are fixing screws to clamp inserts properly.
Insert outside dimensions are 14mm, 20mm, 30mm (0.55", 0.79", 1.18") and they have been studied in order to bear the necessary tonnage according to the sheet metal to be bent.
Such a solution is recommended to bend profiles with bends and counterbends, as you can use die stem for the negative bend.
DXF drawings are supplied to set up press brake CNC.
Press brake operator should control bending angle frequently and set corrections caused by slight wear of insert radius, especially when insert is new.

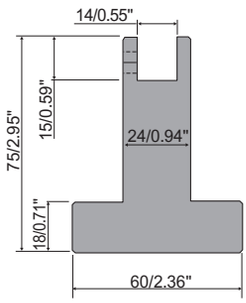


TN80.14

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	15.0 kg
415 mm	*16.34"*	7.5 kg

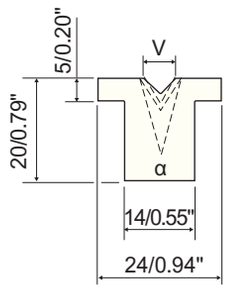
.R1 TYPE



INS14...

INSERT **200 kN/m max.**

835 mm	*32.87"*	0.30 kg
415 mm	*16.34"*	0.15 kg



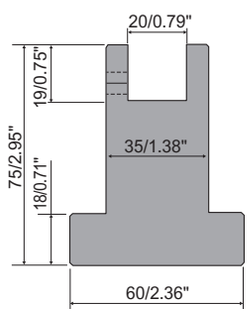
		V mm	*V in*
INS14.06.88	88°	6	*0.24*
INS14.08.88	88°	8	*0.31*
INS14.10.88	88°	10	*0.39*
INS14.06.60	60°	6	*0.24*
INS14.08.60	60°	8	*0.31*
INS14.10.60	60°	10	*0.39*
INS14.06.45	45°	6	*0.24*
INS14.08.45	45°	8	*0.31*
INS14.10.45	45°	10	*0.39*
INS14.06.30	30°	6	*0.24*
INS14.08.30	30°	8	*0.31*

TN80.20

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	19.0 kg
415 mm	*16.34"*	9.5 kg

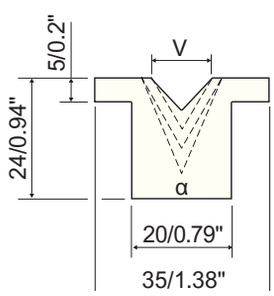
.R1 TYPE



INS20...

INSERT **200 kN/m max.**

835 mm	*32.87"*	0.4 kg
415 mm	*16.34"*	0.2 kg



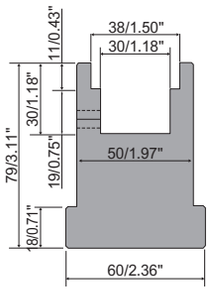
		V mm	*V in*
INS20.06.88	88°	6	*0.24*
INS20.08.88	88°	8	*0.31*
INS20.10.88	88°	10	*0.39*
INS20.12.88	88°	12	*0.47*
INS20.16.88	88°	16	*0.63*
INS20.06.60	60°	6	*0.24*
INS20.08.60	60°	8	*0.31*
INS20.10.60	60°	10	*0.39*
INS20.12.60	60°	12	*0.47*
INS20.16.60	60°	16	*0.63*
INS20.06.45	45°	6	*0.24*
INS20.08.45	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*

TN80.30

C45: 560-710 N/mm² **1000 kN/m max.**

835 mm	*32.87"*	25.0 kg
415 mm	*16.34"*	12.5 kg

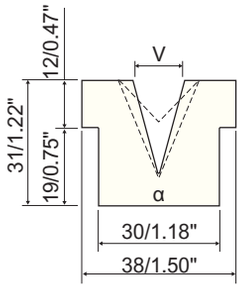
.R1 TYPE



INS30...

INSERT **200 kN/m max.**

835 mm	*32.87"*	0.5 kg
415 mm	*16.34"*	0.3 kg



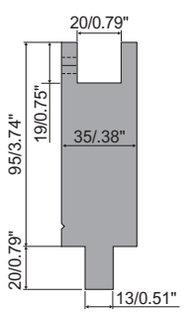
		V mm	*V in*
INS30.06.88	88°	6	*0.24*
INS30.08.88	88°	8	*0.31*
INS30.10.88	88°	10	*0.39*
INS30.12.88	88°	12	*0.47*
INS30.16.88	88°	16	*0.63*
INS30.20.88	88°	20	*0.79*
INS30.25.88	88°	25	*0.98*
INS30.06.60	60°	6	*0.24*
INS30.08.60	60°	8	*0.31*
INS30.10.60	60°	10	*0.39*
INS30.12.60	60°	12	*0.47*
INS30.16.60	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*

TMN95.20

C45: 560-710 N/mm² **1000 kN/m max.**

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

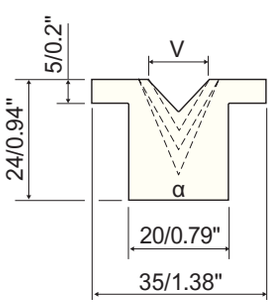
.R2/R3 TYPE



INS20...

INSERT **200 kN/m max.**

835 mm	32.87"	0.4 kg
415 mm	16.34"	0.2 kg



		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*

.accessories

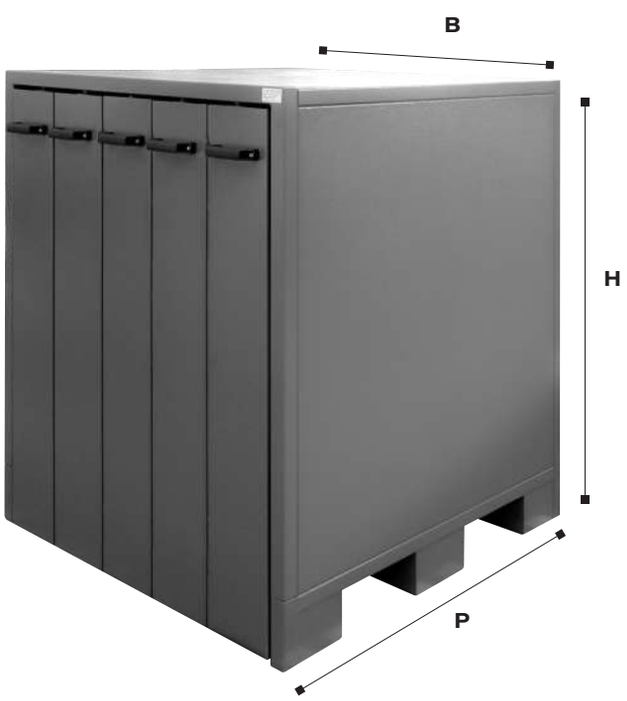
A wide range of Rolleri accessories, to be used while bending, for storage and for press brake setup.

.tooling cabinets: explanation >>

- 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 colors available on request

	STANDARD series	TOP series
Structure thickness	1.5 mm	3.0 mm
Max.drawer load	250-280 kg	900 kg
Compatibility	Check model	Universal
Drawer closing	With handle	With independent lock
Structure holes	Check model	Hole pitch 25 mm

B = width
H = height
P = depth



ARM 835-4

B	H	P	Drawers	
850 mm	1240 mm	1050 mm		
33.46"	*48.82"*	*41.34"*	4 (CS-1)	271 kg

250 kg max./drawer
Max. tool length = 835 mm *32.87"*
Approx. 20 m of tools
Tools tang 13 mm *0.51 in*

UC-13-1	**16**
UL-13-3	**4**

ARM 835-5

B	H	P	Drawers	
1040 mm	1240 mm	1050 mm		
33.46"	*48.82"*	*41.34"*	5 (CS-1)	350 kg

250 kg max./drawer
Max. tool length = 835 mm *32.87"*
Approx. 25 m of tools
Tools tang 13 mm *0.51 in*

UC-13-1	**20**
UL-13-3	**5**

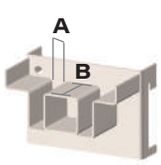
ARM 1060-4.13

B	H	P	Drawers	
850 mm	1240 mm	1360 mm		
33.46"	*48.82"*	*53.54"*	4 (CS-2)	340 kg

250 kg max./drawer
Max. tool length = 835 mm *32.87"*
Approx. 26/39 m of tools
Tools tang 13 mm *0.51"*

UL-13-4	**20**

	L mm	*L in*	A mm	*A in*	B mm	*B in*	
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



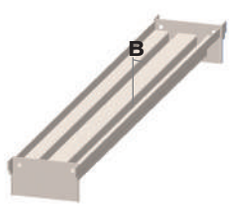
ARM 1060-5.13

B	H	P	Drawers	
1040 mm	1240 mm	1360 mm		
33.46"	*48.82"*	*53.54"*	5 (CS-1)	400 kg

250 kg max./drawer
Max. tool length = 835 mm *32.87"*
Approx. 32.5/52 m of tools
Tools tang 13 mm *0.51"*

UL-13-4	**25**

	L mm	*L in*	B mm	*B in*	
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



ARM 1060-4

B	H	P	Drawers	
850 mm	1240 mm	1360 mm		
33.46"	*48.82"*	*53.54"*	4 (CS-2)	340 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 26/39 m of tools
Tools tang 20 mm *0.79"*

UC-20-2	**16**
UL-20-4	**4**

ARM 1060-4-CV

B	H	P	Drawers	
850 mm	1240 mm	1360 mm		
33.46"	*48.82"*	*53.54"*	4 (CS-2)	351 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 26/39 m of tools
Tools tang 20 mm *0.79"*

UC-20-1	**20**
UL-20-4	**10**

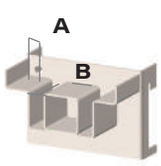
ARM 1060-5

B	H	P	Drawers	
1040 mm	1240 mm	1360 mm		
40.94"	*48.82"*	*53.54"*	5 (CS-2)	400 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 32.5/52 m of tools
Tools tang 20 mm *0.79"*

UC-20-2	**20**
UL-20-4	**5**

	L mm	*L in*	A mm	*A in*	B mm	*B in*	
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



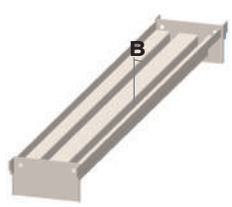
ARM 1060-5-CV

B	H	P	Drawers	
1040 mm	1240 mm	1360 mm		
40.94"	*48.82"*	*53.54"*	5 (CS-2)	490 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 32.5/52 m of tools
Tools tang 20 mm *0.79"*

UC-20-1	**30**
UL-20-4	**10**

	L mm	*L in*	B mm	*B in*	
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



ARM 1060-4-T

B	H	P	Drawers	
850 mm	1240 mm	1360 mm		
33.46"	*48.82"*	*53.54"*	4 (CS-2)	340 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 20.8/31.2 m of tools
Tools tang 13 mm *0.51"*-20 mm *0.79"*

UL-13-4	**8**
UT-4	**8**

ARM 1060-4-T-CV

B	H	P	Drawers	
850 mm	1240 mm	1360 mm		
33.46"	*48.82"*	*53.54"*	4 (CS-2)	395 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 20.8/31.2 m of tools
Tools tang 13 mm *0.51"*-20 mm *0.79"*

UC-13-1	**16**
UT-4	**8**

ARM 1060-5-T

B	H	P	Drawers	
1040 mm	1240 mm	1360 mm		
40.94"	*48.82"*	*53.54"*	5 (CS-2)	400 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 26/41.6 m of tools
Tools tang 13 mm *0.51"*-20 mm *0.79"*

UL-13-4	**10**
UT-4	**10**

ARM 1060-5-T-CV

B	H	P	Drawers	
1040 mm	1240 mm	1360 mm		
40.94"	*48.82"*	*53.54"*	5 (CS-2)	400 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 26/41.6 m of tools
Tools tang 13 mm *0.51"*-20 mm *0.79"*

UC-13-1	**24**
UT-4	**8**

	L mm	*L in*	
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

ADATTO PER PUNZONI CON SPINE DI SAFETY

	L mm	*L in*	
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

WKS013 SET A

B	H	P	Drawers	
660 mm	1240 mm	1050 mm		
33.46"	*48.82"*	*40.33"*	3	300 kg

900 kg max./drawer
Max. tool length = 850 mm *33.46"*
Approx. 16 m of tools
For all tang

WKH102	**9**
WEB360	**3**
TRB360	**12**

WKS033 SET A

B	H	P	Drawers	
660 mm	1240 mm	1300 mm		
33.46"	*48.82"*	*51.18"*	3	312 kg

900 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 19 m of tools
For all tang

WKH103	**9**
WEB366	**3**
TRB360	**15**

WKS001 SET A

B	H	P	Drawers	
1040 mm	1240 mm	1050 mm		
40.94"	*48.82"*	*40.33"*	5	330 kg

900 kg max./drawer
Max. tool length = 850 mm *33.46"*
Approx. 16 m of tools
For all tang

WKH102	**15**
WEB360	**5**
TRB360	**25**

WKS003 SET A

B	H	P	Drawers	
850 mm	1240 mm	1300 mm		
40.94"	*48.82"*	*51.18"*	5	510 kg

900 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 33 m of tools
For all tang

WKH103	**15**
WEB366	**5**
TRB360	**25**

	L mm	*L in*	P mm	*P in*
WKH102	180	*7.08"*	1050	*41.33"*
WKH103	180	*7.08"*	1300	*51.18"*

BENDING TOOLS RETAINER

	L mm	*L in*	P mm	*P in*
WKH502	180	*7.08"*	1050	*41.33"*
WKH504	180	*7.08"*	1300	*51.18"*

UNIVERSAL TRAYS

WKS035 SET A

B	H	P	Drawers	
1040 mm	1620 mm	1050 mm		
40.94"	*63.77"*	*40.33"*	5	590 kg

900 kg max./drawer
Max. tool length = 850 mm *33.46"*
Approx. 44 m of tools
For all tang

WKH103	**20**
WEB366	**5**
TRB360	**25**

WKS335 SET A

B	H	P	Drawers	
660 mm	1620 mm	1300 mm		
25.98"	*63.77"*	*51.18"*	3	312 kg

900 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 19 m of tools
For all tang

WKH103	**12**
WEB366	**3**
TRB366	**5**

WKS006 SET A

B	H	P	Drawers	
1040 mm	2140 mm	1300 mm		
40.94"	*84.25"*	*51.18"*	5	720 kg

900 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 44 m of tools
For all tang

WKH103	**20**
Universaltabletts	**10**
Behälter	**60**
WKH830	**1**

	L mm	*L in*	P mm	*P in*
WKH102	180	*7.08"*	1050	*41.33"*
WKH103	180	*7.08"*	1300	*51.18"*

RETAINER FOR MEASUREMENTS TOOLS AND SMALL PARTS
WEB360 INCLUDED N° 4 TRB360
WEB366 INCLUDED N° 5 TRB360

PARTITION PLATE

.tooling trolley >>

A-TR

B	H	W	Drawers	
1060 mm	1520 mm	1160 mm		
41.73"	*59.84"*	*45.66"*	30	108 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 26/39 m of tools

FOR R1 TOOLS

T-TR

B	H	W	Drawers	
1060 mm	1520 mm	1160 mm		
41.73"	*59.84"*	*45.66"*	21	175 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 26/39 m of tools

FOR R2 TOOLS

B-TR

B	H	W	Drawers	
1060 mm	1520 mm	1160 mm		
41.73"	*59.84"*	*45.66"*	21	135 kg

250 kg max./drawer
Max. tool length = 1060 mm *41.73"*
Approx. 26/39 m of tools

FOR R3 TOOLS

WSW582

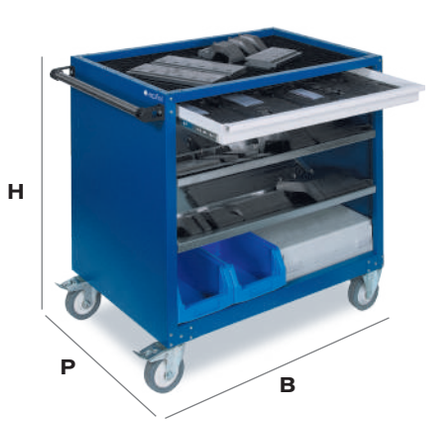
B	H	W	Drawers
582 mm	922 mm	922 mm	
22.91"	*36.29"*	*36.29"*	1

Sloped shelves	**2**
Non-slip mat	**1**
Fixed castors	**2**
Guided rollers with brake	**2**

WSW583 PLUS

B	H	W	Drawers
582 mm	922 mm	922 mm	
22.91"	*36.29"*	*36.29"*	1

Sloped shelves	**2**
Tools retainer	**3**
Fixed castors	**2**
Guided rollers with brake	**2**



MSA

MSA.D	Right	per piece	1.4 kg
MSA.S	Left	per piece	1.4 kg

MSA is a very useful tool for the correct sheet metal positioning.
When do you need it?
When according to the profile to be bent, sheet metal should refer to only one backgauge. In this way the bending line can have the correct angle in relation to the outside edge because sheet metal can lay against 2 fix points for a repetitive bending result.
MSA is adjustable in order to position sheet metal at different angles.
Thanks to this and to backgauges, we can guarantee precise profiles even when they have small dimensions.
MSA is very easy to be used and it is clamped directly to die stem by means of very strong magnets. We offer MSA.D to have a reference lever on the right handside of sheet metal and MSA.S to have it on the left handside of sheet metal.

AS

3.5 kg

AS is a very useful tool for the correct sheet metal positioning.
When do you need it?
When according to the profile to be bent, sheet metal should refer to only one backgauge. In this way the bending line can have the correct angle in relation to the outside edge because sheet metal can lay against 2 fix points for a repetitive bending result.
AS is adjustable and this means that thanks to the goniometer and the rear gauge, we can also manage small sheet metal sheets with absolute precision. It is a very simple system to use and it is mounted directly on the stem of the die.

AS FIX

3.0 kg

AS FIX is a very useful tool for the correct sheet metal positioning.
When do you need it?
When according to the profile to be bent, sheet metal should refer to only one backgauge. In this way the bending line will be perfectly at 90° in relation to the outside edge.
AS FIX is a fix reference point and it can guarantee precise profiles even when they have small dimensions.
AS FIX is very easy to be used and it is clamped directly to die stem.

RIF

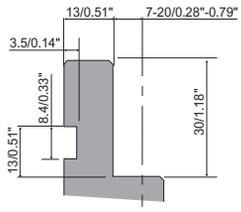
	L mm	*L in*	
RIF500	500	*19.68*	7.0 kg
RIF1000	1000	*39.37*	12.0 kg
RIF1500	1500	*59.05*	17.0 kg

RIF is a front reference tool for sheet metal even of big dimensions.
It is a support mounted directly to the front part of a press brake table and thanks to slotted holes drilled to the fixing plates, it can be adjusted in height to make sure it is always at the same height of the dies mounted.
A millimeter ruler goes all along RIF support to position front stops properly. On the same RIF you may have more stops for different bending sequences. Such stops have been designed not to interfere with the bending process when they are not in use.
Furthermore, to position sheet metal more precisely, you can use micrometric stop, which has centesimal adjustment precision.
RIF supports are available in different lengths and can be mounted single or in pair.

.press brake Easy Press >>

EASY PRESS manual press brake doesn't need any specific tooling nor connection to any power supply and therefore it is very versatile.

COMPATIBILITY

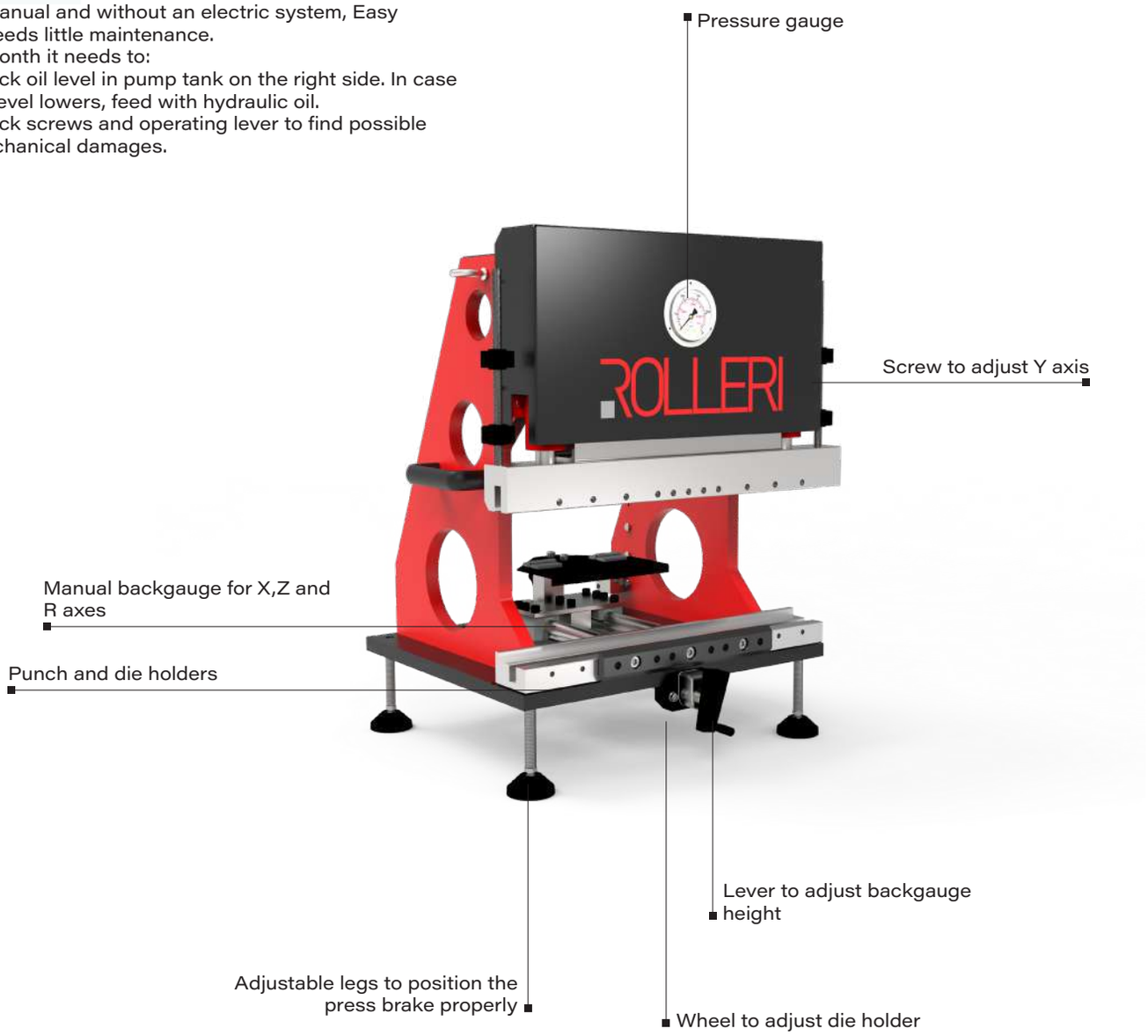


TECHNICAL INFORMATION

	Standard	Super six
Weight without tooling	111 Kg	120 Kg
Bending force	Max 6.5 Ton	Max 6.5 Ton
Bending length	Max 415 mm	Max 415 mm
Throat depth	100 mm	165 mm
Max.stroke	Max 110 mm	Max 110 mm
Distance between upper beam and table	Max 180 mm	Max 250 mm
Backgauge X-axis stroke	Max 200 mm	Max 200 mm
Standard R1 type tools	●	●
Promecam base	60 mm	60 mm
Use with manual lever	●	●
Use with footpedal	○	○
Oil used	DTE 24 type	DTE 24 type
Pedal pneumatic pressure	6 bar	6 bar
Pedal-press brake connection cable	2.5-3 m with female connection ¼ gas	2.5-3 m with female connection ¼ gas

● = standard ○ = on request

MAINTENANCE
Being manual and without an electric system, Easy Press needs little maintenance.
Every month it needs to:
- check oil level in pump tank on the right side. In case oil level lowers, feed with hydraulic oil.
- check screws and operating lever to find possible mechanical damages.



.bending box >>

BOX

1.6 kg

It contains all the useful tools for press brake operators
- PRECISION DIGITAL CALIBER
- SET SQUARE
- ANGLE MEASURING DEVICE

.intermediates, clamps and adapters

Intermediates can be fix or with crowning wedge. For fix intermediates, working height with +/-0.01mm tolerance is fundamental, as it eases any lower crowning system. The second type of intermediates is represented by adjustable intermediates thanks to a crowning wedge. In this way you can adjust any press brake following a fix scheme according to the press brake length. Each intermediate has to be numbered and positioned always in the same place to get perfect crowning and subsequently precise angles.

Adapters are designed to equip a press brake with a wider range of tooling regardless of the original tool clamping system of a press brake. There are upper adapters to mount punches properly and lower adapters to clamp dies.

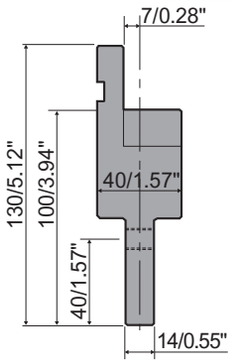
INT100F

C45 hardened and ground **1000 kN/m max.**

150 mm *5.90"*

W=100 | H=130 m
W=3.94 | H=5.12

WITHOUT CROWNING WEDGE



INT100

C45 hardened and ground **1000 kN/m max.**

5.90" 3.5 kg

V=100 | H=130 mm
W=3.94 | H=5.12 in

WITH CROWNING WEDGE

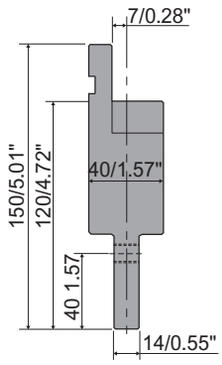
INT120F

C45 hardened and ground **1000 kN/m max.**

150 mm *5.90"*

W=120 | H=150
W=4.72 | H=5.

WITHOUT CROWNING WEDGE



INT120

C45 hardened and ground **1000 kN/m max.**

5.90" 3.5 kg

:120 | H=150 mm
=4.72 | H=5.91 in

WITH CROWNING WEDGE

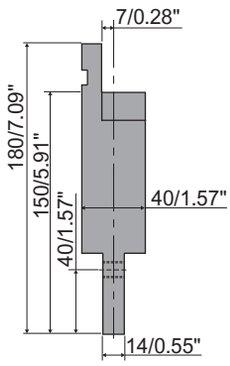
INT150

C45 hardened and ground **1000 kN/m max.**

150 mm *5.90"* 5.9 kg

W=150 | H=180 mm
W=5.91 | H=7.09 in

WITH CROWNING WEDGE



INT120-40

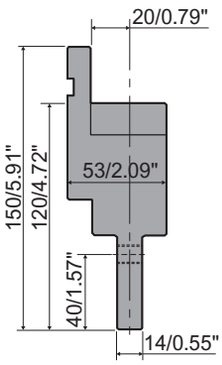
C45 hardened and ground **1000 kN/m max.**

150 mm *5.90"* 5.2 kg

C45: 560-710 N/mm²
1000 kN/m max.

W=120 | H=150 mm
W=4.72 | H=5.91 in

WITH CROWNING WEDGE



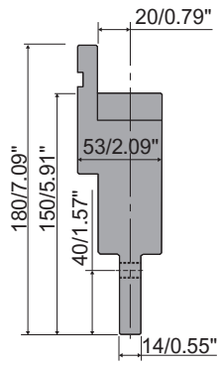
INT150-40

C45: 560-710 N/mm2

150 mm *5.90"* 8 kg

W=150 | H=180 mm
W=5.91 | H=7.09 in

1000 kN/m max.



INT120HD

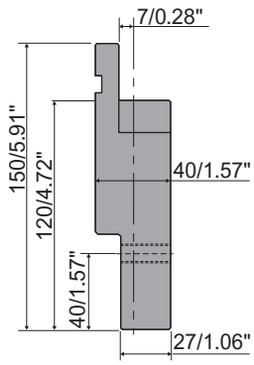
42CrMo4

150 mm *5.90"* 4 kg

W=120 | H=150 mm
W=4.72 | H=5.91 in

HEAVY DUTY

1600 kN/m max.



INT150HD

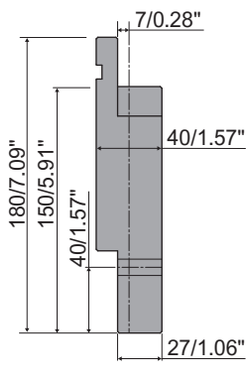
42CrMo4

150 mm *5.90"* 5.9 kg

W=150 | H=180 mm
W=5.91 | H=7.09 in

HEAVY DUTY

1600 kN/m max.



As integration of standard solutions, Rolleri has created Heavy Duty intermediates. Their main feature is their capacity.
In case you need more than 1000 kN/m, you have to choose these intermediates, which are made of different material and with different dimensions to reach 1600 kN/m.

INT120-40HD

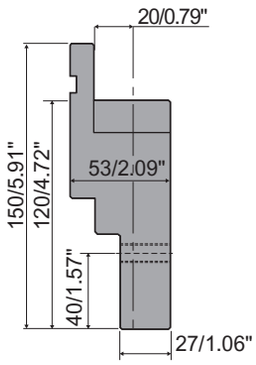
42CrMo4

1600 kN/m max.

150 mm *5.90"* 4 kg

W=100 | H=130 mm
W=3.94 | H=5.12 in

HEAVY DUTY



INT150-40HD

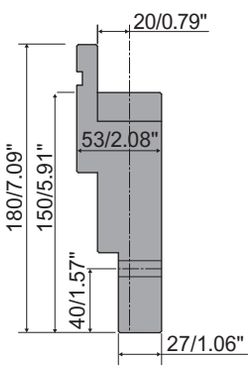
42CrMo4

1600 kN/m max.

150 mm *5.90"* 8 kg

W=120 | H=150 mm
W=4.72 | H=5.91 in

HEAVY DUTY



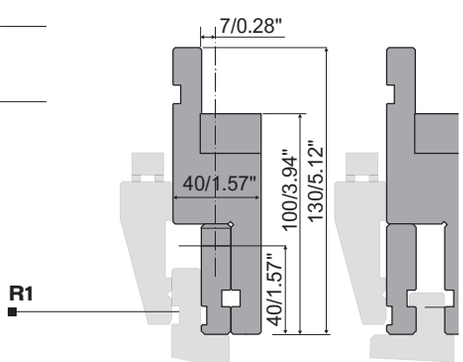
INT100-A

C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 3.5 kg

W=150 | H=180 mm
W=5.91 | H=7.09 in



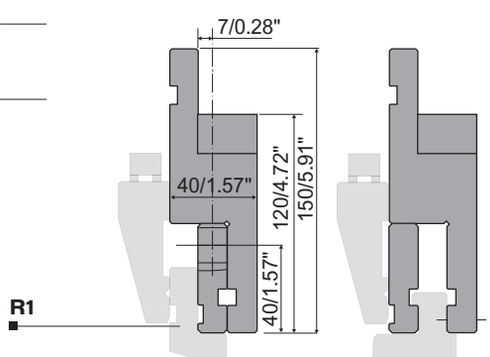
INT120-A

C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 5.2 kg

W=120 | H=150 mm
W=4.72 | H=5.91 in



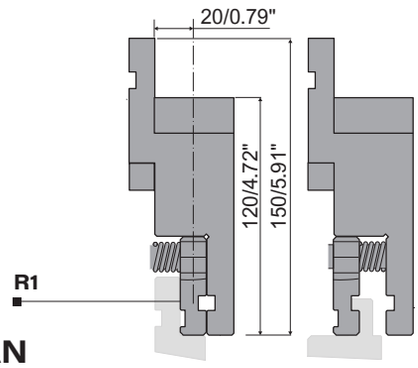
INT120-40-A

C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 6.0 kg

W=120 | H=150 mm
W=4.72 | H=5.91 in



INT100-A AMERICAN

C45: 560-710 N/mm2

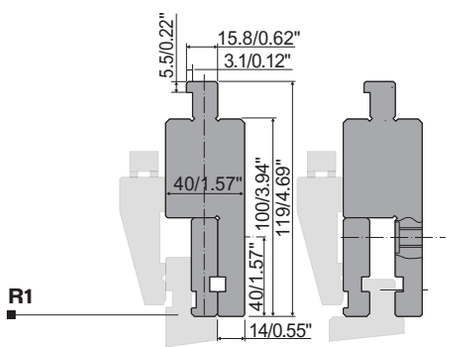
1000 kN/m max.

150 mm *5.90"* 3.5 kg

W=100 | H=119 mm
W=3.94 | H=4.69 in

- **INT100-AAM1** Tang AM1
- **INT100-AAM2** Tang AM2
- **INT100-AAM3** Tang AM3

X → R1



AD4

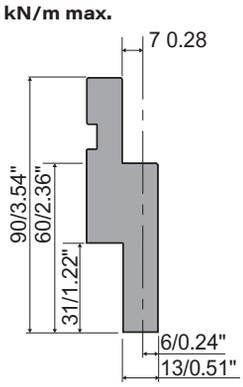
C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 1.8 kg

W=60 | H=90 mm
W=2.36 | H=3.54 in

WITHOUT CROWNING WEDGE

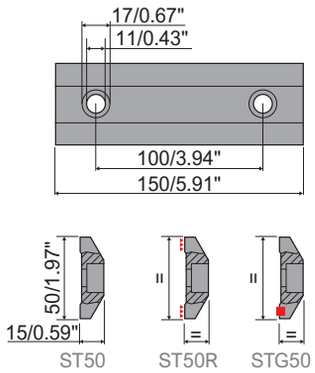


Every intermediate needs a clamp, which can be manual like ST50 or ST60 or with a lever like STL60 or with a retractable lever like STX60.

ST50 / ST50R / STG50

Fe37: 370-470 N/mm²

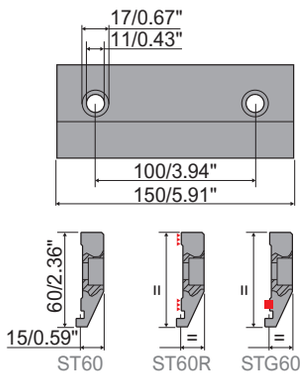
ST50	150 mm	*5.90"*	0.7 kg
ST50R	150 mm	*5.90"*	0.5 kg
STG50	150 mm	*5.90"*	0.7 kg



ST60 / ST60R / STG60

Fe37: 370-470 N/mm²

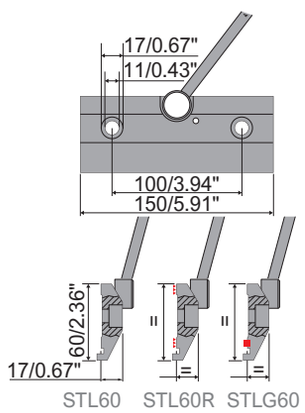
ST60	150 mm	*5.90"*	0.8 kg
ST60R	150 mm	*5.90"*	0.8 kg
STG60	150 mm	*5.90"*	0.8 kg



STL60 / STL60R / STLG60

Fe37: 370-470 N/mm²

STL60	150 mm	*5.90"*	1.0 kg
STL60R	150 mm	*5.90"*	0.8 kg
STLG60	150 mm	*5.90"*	1.0 kg

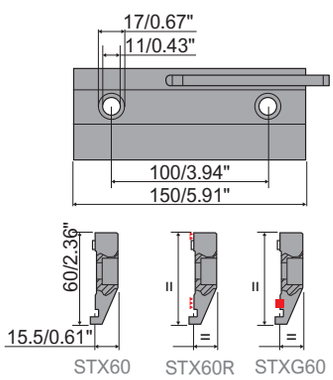


STX60 / STX60R / STXG60

Fe37: 370-470 N/mm²

STX60	150 mm	*5.90"*	0.85 kg
STX60R	150 mm	*5.90"*	0.5 kg
STXG60	150 mm	*5.90"*	1.0 kg

All clamps with number 60 in their code have an antifall nose. When clamp screws are released, punch hangs and only when the operator slides it sideways, it can be removed safely. A further evolution of these clamping systems is represented by a polyurethane insert in clamps with lever to clamp segmented tools better.

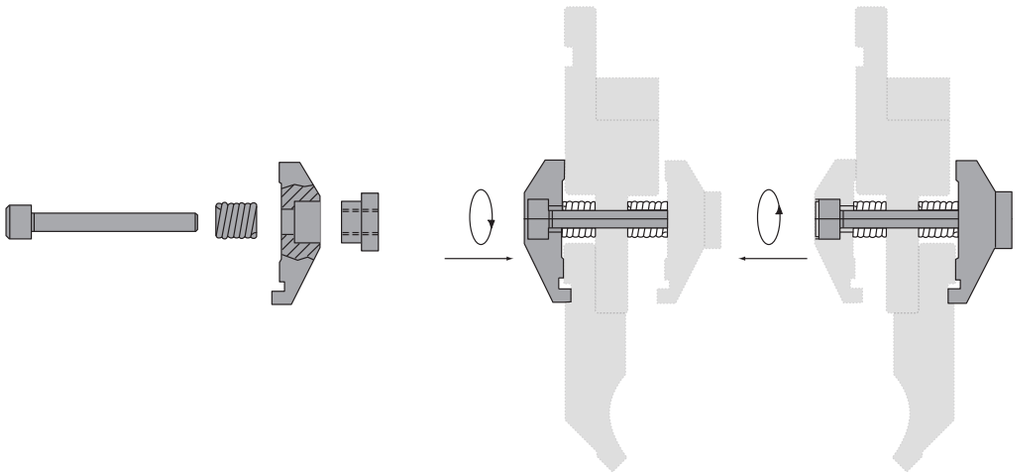


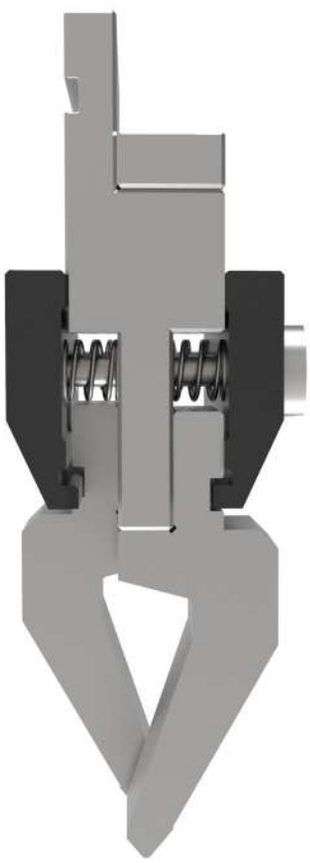
KDS

Fe37: 370-470 N/mm²

150 mm *5.90"* 0.5 kg

REAR CLAMP





The acronym KDS means in Italian "kit for double clamping" and this is a very useful solution for whom needs to mount punches on the opposite side as normal. The system is designed so that the two front screws can clamp front punch by tightening them, but by releasing them, back punch is tightened.
Thanks to this design, the operator doesn't have to go to the press brake backside to clamp back clamps.

.upper adapters >>

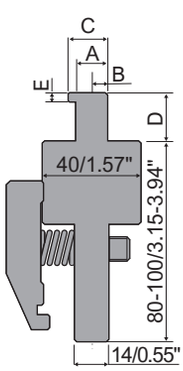
There are two categories: upper adapters for punches and lower adapters for dies. Upper adapters have very precise dimensions and limited height. They are studied to be mounted directly to press brake upper beam and when mounted, they can host punches with a different tang than the original one. Such solution is very interesting when you have to retrofit a press brake: in a press brake with a special tang you can mount all standard tools in the catalogue.
Thanks to this operation, time and costs are reduced.
Adapter precision needs to have max +/-0.01mm tolerance, so that bending axis is precise and guaranteed. In this way you can get precise profiles, as distance between backgauges and die V center is also precise.
As far as dimensions are concerned, we have limited height not to lose too much daylight. Length is mostly 150mm and they need a clamp like ST60, STL60 and STX60 (do not forget the possibility to mount a more efficient system like FAST CLAMP3).
In addition to the adapters explained, we can also offer AW adapters.
This is another solution to mount standard R1 type tools in a press brake with a different tang. They consist in small adapters as big as press brake tang and as long as the punch they have to be mounted with. They can be supplied in segmented version as well. Some holes are drilled and countersinked in punch tang, whereas some threaded holes are made in AW adapter so that they can be screwed together and become a single body.
In press brake CNC the total height of punch and adapter has to be set either manually or imported automatically from our DXF drawing.
This system offers the possibility to use a wide range of standard R1 type punches and avoid using special tooling.

Adapters are designed to equip a press brake with a wider range of tooling regardless of the original tool clamping system of a press brake.
There are upper adapters to mount punches properly and lower adapters to clamp dies.

INT80-100

C45: 560-710 N/mm2 **1000 kN/m max.**

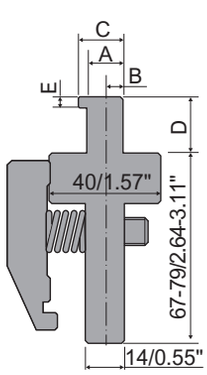
835 mm	*32.87"*	25 kg
415 mm	*16.34"*	12.5 kg



INT67-79

C45: 560-710 N/mm2 **1000 kN/m max.**

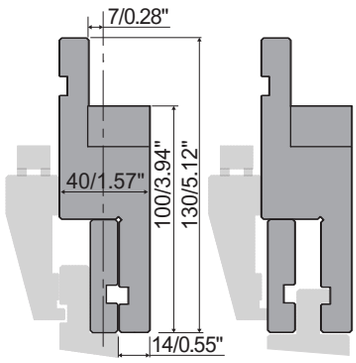
835 mm	*32.87"*	20.5 kg
415 mm	*16.34"*	10.0 kg



INT100-N NEWTON

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm	*5.90"*	5.2 kg

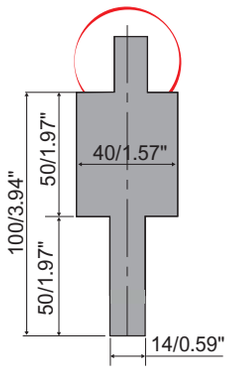


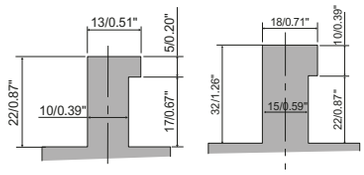
AD1

C45: 560-710 N/mm2 **1000 kN/m max.**

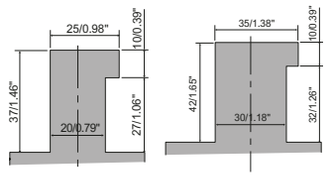
AD1-A	150 mm	*5.90"*	3.1 kg
AD1-B	150 mm	*5.90"*	3.1 kg
AD1-C	150 mm	*5.90"*	3.1 kg
AD1-D	150 mm	*5.90"*	3.1 kg

R4 A, B, C, D → R1





B



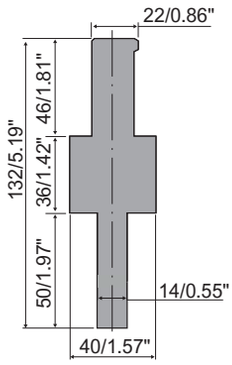
D

AD3

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm	*5.90"*	3.3 kg

R3 S → R1

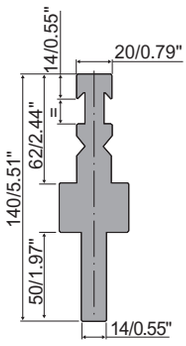


AD10

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm	*5.90"*	3.4 kg

R3 RFA → R1



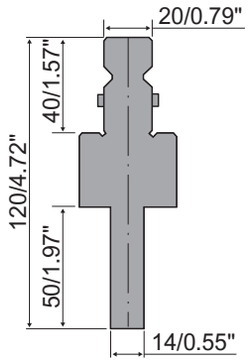
AD11

C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 3 kg

R2 → R1



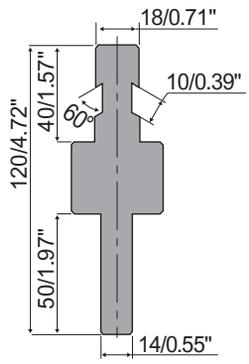
AD12

C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 3 kg

R8 → R1



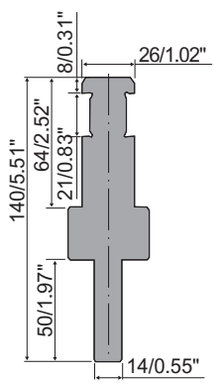
AD13

C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 3 kg

RX TYPE EHT → R1



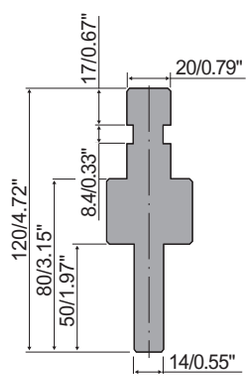
AD14

C45: 560-710 N/mm2

1000 kN/m max.

150 mm *5.90"* 3.2 kg

R9 → R1



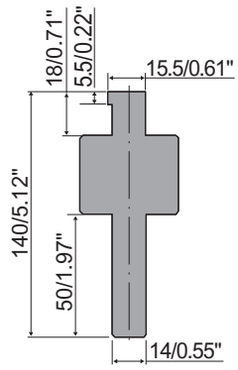
AD15

C45: 560-710 N/mm2

150 mm *5.90"* 3 kg

R10 → R1

1000 kN/m max.



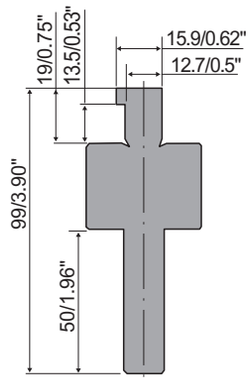
AD16

C45: 560-710 N/mm2

150 mm *5.90"* 4 kg

R5 → R1

1000 kN/m max.



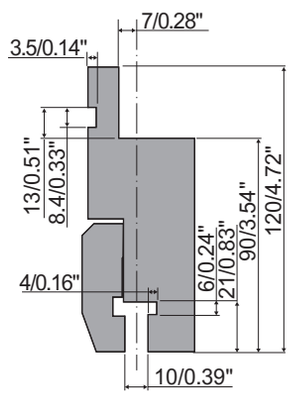
AD19-A

C45: 560-710 N/mm2

150 mm *5.90"* 6 kg

R1 → R4

1000 kN/m max.



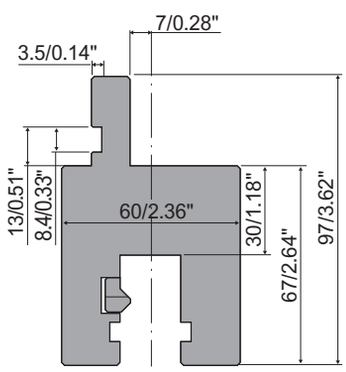
AD20

C45: 560-710 N/mm2

150 mm *5.90"* 4 kg

R1 → R2

1000 kN/m max.

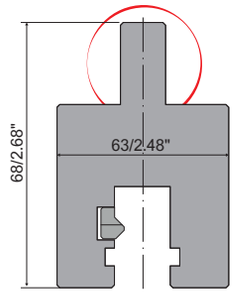


AD20 LVD

C45: 560-710 N/mm2 **1000 kN/m max.**

AD20 LVD-A	150 mm	*5.90"*	3.6 kg
AD20 LVD-B	150 mm	*5.90"*	3.6 kg
AD20 LVD-C	150 mm	*5.90"*	3.6 kg
AD20 LVD-D	150 mm	*5.90"*	3.6 kg

R4 A,B,C,D → R1

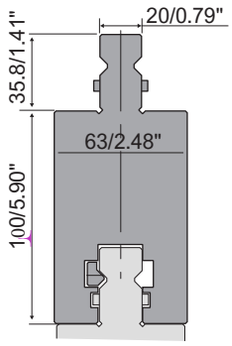


AD21

42CrMo4 **1600 kN/m max.**

100 mm *5.90"* 7 kg

R2 → R2

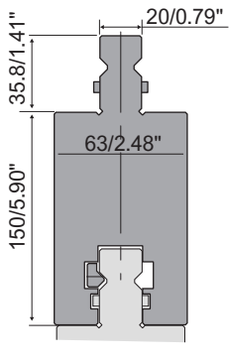


AD21/150

42CrMo4 **1600 kN/m max.**

150 mm *5.90"* 7 kg

R2 → R2

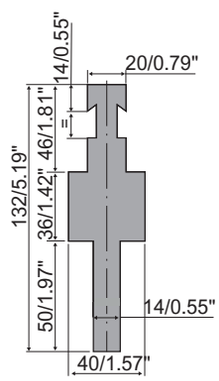


AD22

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm *5.90"* 3.4 kg

R3 R → R1

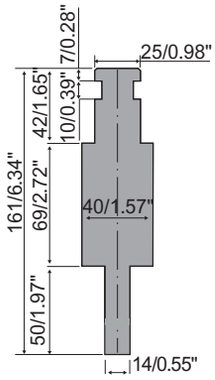


AD23

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm *5.90"* 5.0 kg

RX WEINBRENNER → R1

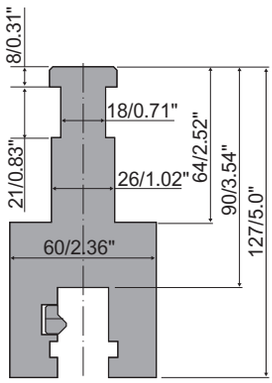


AD28

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm *5.90"* 5 kg

RX EHT → R2

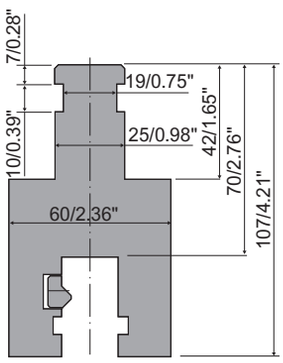


AD29

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm *5.90"* 4.5 kg

RX WEINBRENNER → R2

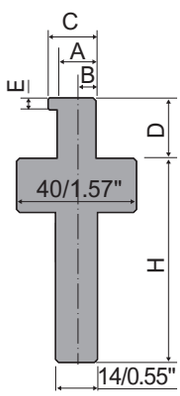


ADX

C45: 560-710 N/mm2 **1000 kN/m max.**

150 mm *5.90"* 3.5 kg

x → R1



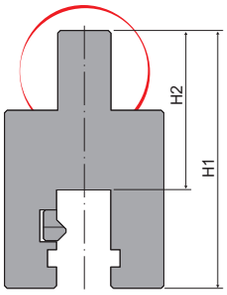
ADX2

C45: 560-710 N/mm2

1000 kN/m max.

150 mm	*5.90"*	2.4 kg

x → R2

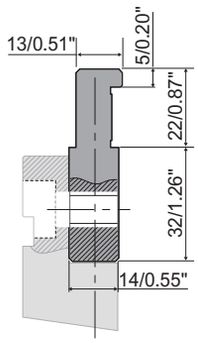


AW1-A

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	3 kg	
415 mm	*16.34"*	1.5 kg	
805 mm	*31.69"*	6.7 kg	F

R4 A → R1

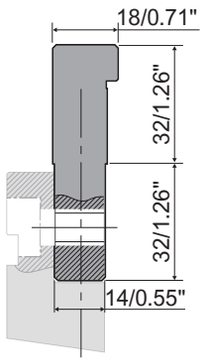


AW1-B

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	3 kg	
415 mm	*16.34"*	1.5 kg	
805 mm	*31.69"*	3 kg	F

R4 B → R1

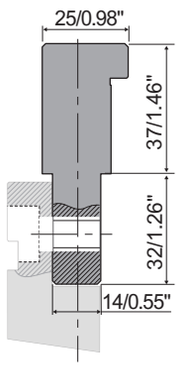


AW1-C

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	9.7 kg	
415 mm	*16.34"*	4.8 kg	
805 mm	*31.69"*	9.4 kg	F

R4 C → R1

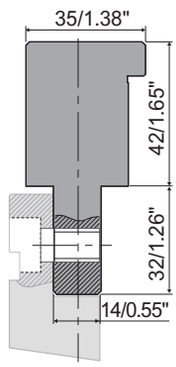


AW1-D

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	11.5 kg	
415 mm	*16.34"*	5.7 kg	
805 mm	*31.69"*	11.1 kg	F

R4 D → R1



F: 805 mm - *31.69"*

mm: ◁ 100-370-10-15-20-40-50-100-100 ▷

in: ◁ 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94 ▷

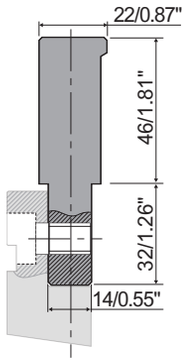
AW3

C45: 560-710 N/mm2

1000 kN/m max.

835 mm	*32.87"*	3 kg	
415 mm	*16.34"*	1.5 kg	
805 mm	*31.69"*	3 kg	F

R3 S → R1



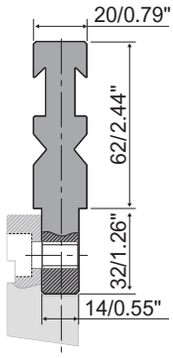
AW10

C45: 560-710 N/mm2

1000 kN/m max.

835 mm	*32.87"*	3 kg	
415 mm	*16.34"*	1.5 kg	
805 mm	*31.69"*	3 kg	F

R3 RFA → R1



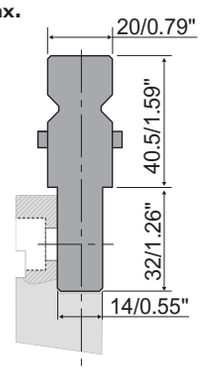
AW11

C45: 560-710 N/mm2

1000 kN/m max.

835 mm	*32.87"*	8.4 kg	
415 mm	*16.34"*	4.2 kg	
805 mm	*31.69"*	8.4 kg	F

R2 → R1



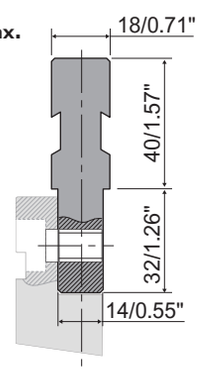
AW12

C45: 560-710 N/mm2

1000 kN/m max.

835 mm	*32.87"*	7 kg	
415 mm	*16.34"*	3.5 kg	
805 mm	*31.69"*	6.7 kg	F

R8 → R1



F: 805 mm - *31.69"*

mm: ◁ 100-370-10-15-20-40-50-100-100 ▷

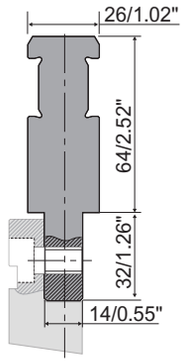
in: ◁ 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94 ▷

AW13

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	12.6 kg	
415 mm	*16.34"*	6.3 kg	
805 mm	*31.69"*	12.1 kg	F

RX EHT → R1

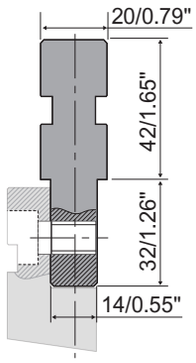


AW14

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	8 kg	
415 mm	*16.34"*	4 kg	
805 mm	*31.69"*	7.7 kg	F

R9 → R1

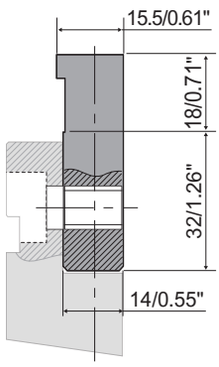


AW15

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	3 kg	
415 mm	*16.34"*	1.5 kg	
805 mm	*31.69"*	3 kg	F

R10 → R1

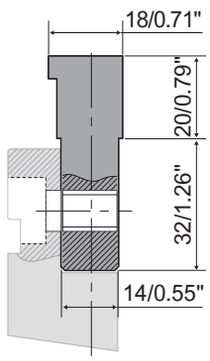


AWC16

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	5 kg	
415 mm	*16.34"*	2.5 kg	
805 mm	*31.69"*	4.8 kg	F

R7 → R1



.69"

mm: ◁ 100-370-10-15-20-40-50-100-100 ▷

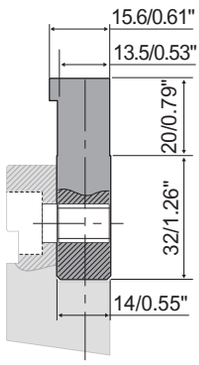
in: ◁ 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94 ▷

AWC13.5

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	4.8 kg	
415 mm	*16.34"*	2.4 kg	
805 mm	*31.69"*	4.6 kg	F

R7 → R1

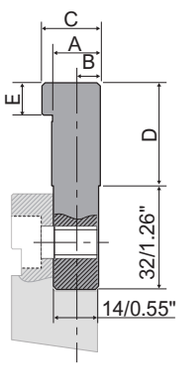


AWX

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	3 kg	
415 mm	*16.34"*	1.5 kg	
805 mm	*31.69"*	3 kg	F

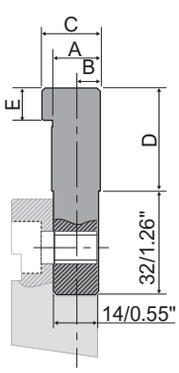
X → R1



INT35

C45: 560-710 N/mm2 **1000 kN/m max.**

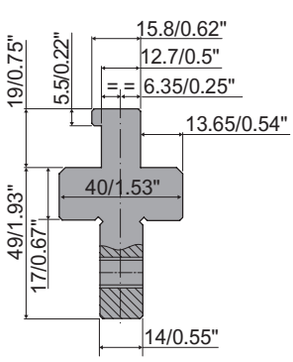
835 mm	*32.87"*	4 kg	
415 mm	*16.34"*	2.5 kg	
805 mm	*31.69"*	3.9 kg	F



INT35-A

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	*32.87"*	5 kg	
415 mm	*16.34"*	2.5 kg	
805 mm	*31.69"*	4.8 kg	F



AW4

C45: 560-710 N/mm2 **1000 kN/m max.**

835 mm	32.87"	5 kg	
415 mm	16.34"	2.5 kg	
805 mm	31.69"	4.8 kg	F

GROUND

F: 805 mm - *31.69"*

mm: ◁ 100-370-10-15-20-40-50-100-100 ▷

in: ◁ 3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94 ▷

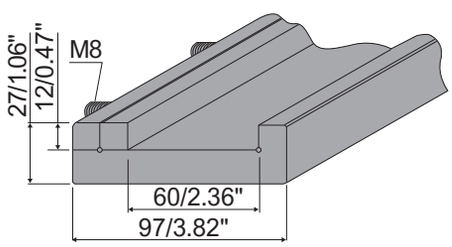
.lower adapters and die holders >>

A lower adapter changes the original die slot of a press brake table into a different one.
In the first images you can see die holders. Die holders standardize R1 dies clamping as they can clamp dies with 60mm 2.36" or 90mm 3.53" base. Die holders are positioned directly onto the press brake table, centered and fixed by threaded bars and they are ready to work. In this way every die placed into a die holder will perfectly match with punch.
Standard die holders are max. 4100mm 161.42" long but we can manufacture special die holders up to 6000mm in one single length.
For longer die holders you can use standard die holders C1050-R, C1050-RS and C1050-90, which are 1050mm 41.34" long. These die holders can be connected to each other by means of feather keyes and they are fixed to the table by threaded bars.
Dies are clamped in a die holder by locking pins on the operator's side.
With the same construction we can offer TC 2000/S up to TC 4000/S (from 2100mm to 4100mm long) to clamp R2 and R3 dies.
For different applications we can offer adapters to clamp standard dies in our catalogue in press brake tables with a different tang.
They are 1000mm 39.37" and 835mm 32.87" long and their short /C versions are respectively 500mm 19.68" and 415mm 16.34" long.
One of the most common example is AD5 and AD6 which enable R2 dies to be mounted in a press brake with R1 slot. Thanks to this solution you can bend medium thick sheet metal with tight bends and counterbends like a joggle in 2 hits and a downward side up to 150mm 5.90" long. Dies are clamped in a die holder by locking pins on the operator's side.
Some operators may need the opposite solution. In this case we can offer AD7 to be mounted on a press brake with R2 type die slot and can mount R1 type dies using ST50 clamps.
For the last two examples you can always have to set the press brake CNC considering the total height consisting in die height + adapter height.
Rolleri can always supply a DXF drawing of adapter and die holder mounted together with very precise overall dimensions.
Lower adapters too are manufactured with +/-0.01mm tolerance. This is a fundamental requisite to guarantee maximum precision so that the theoretical machine bending axis is confirmed. This means that all parameters regarding X axis in all press brake programs don't need to be modified.

C2000/S-C4000/S

C45: 560-710 N/mm2 **1000 kN/m max.**

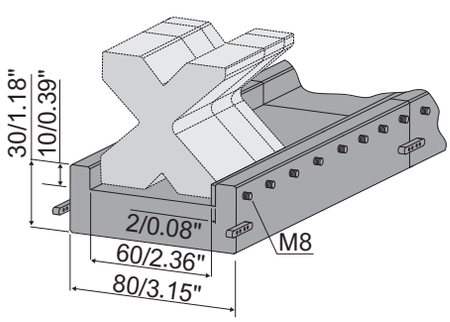
C2000/S	2100 mm	*82.68"*	27.0 kg
C2500/S	2600 mm	*102.36"*	34.0 kg
C3000/S	3100 mm	*122.05"*	40.0 kg
C4000/S	4100 mm	*161.42"*	53.0 kg

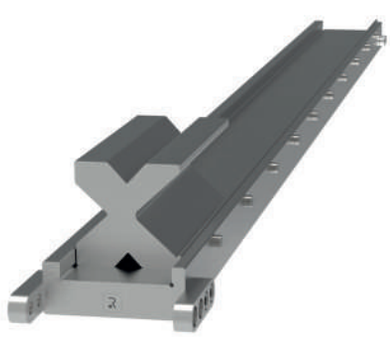


C1050/RS

C45: 560-710 N/mm2 **1000 kN/m max.**

C1050/RS	1050 mm	*41.34"*	15.0 kg
C1050/RS/C	520 mm	*20.47"*	7.5 kg



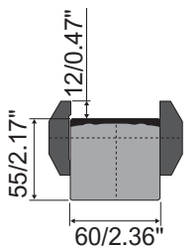


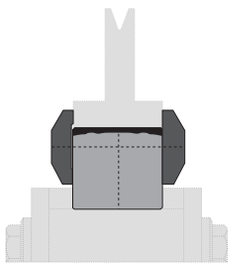
CTS60

C45: 560-710 N/mm2

1000 kN/m max.

835 mm	*32.87"*	29.0 kg
415 mm	*16.34"*	14.5 kg



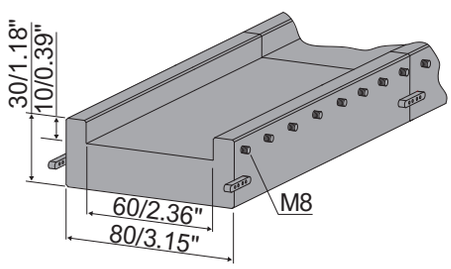


C1050/R

C45: 560-710 N/mm2

1000 kN/m max.

C1050/RS	1050 mm	*41.34"*	15.0 kg
C1050/RS/C	520 mm	*20.47"*	7.5 kg

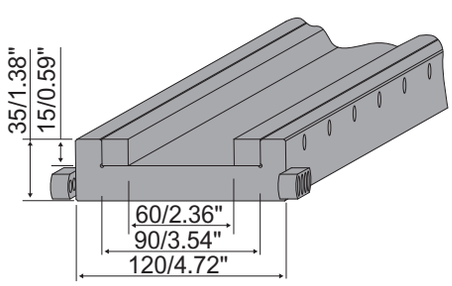


C1050-90

C45: 560-710 N/mm2

1000 kN/m max.

C1050-90	1050 mm	*41.34"*	27.2 kg
C1050-90/C	520 mm	*20.47"*	13.5 kg

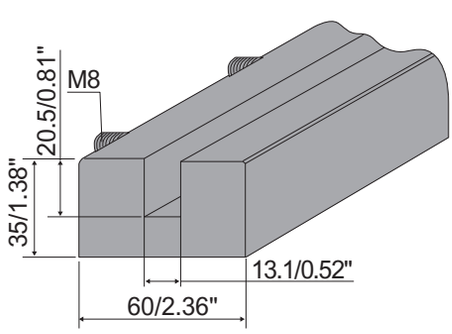


TC2000/S - TC4000/S

C45: 560-710 N/mm2

1000 kN/m max.

TC2000/S	2100 mm	*82.68"*	30.0 kg
TC2500/S	2600 mm	*102.36"*	37.0 kg
TC3000/S	3100 mm	*122.05"*	44.0 kg
TC4000/S	4100 mm	*161.42"*	59.0 kg



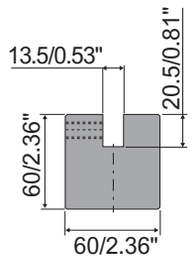
AD5

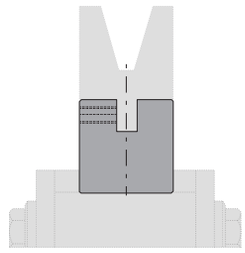
C45: 560-710 N/mm2

1000 mm	*39.87"*	26.1 kg
500 mm	*16.68"*	13 kg

R1 → R2 R3

1000 kN/m max.





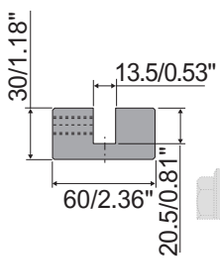
AD6

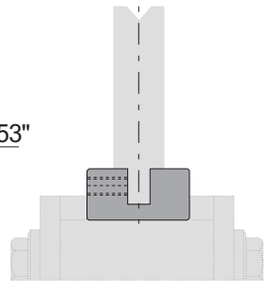
C45: 560-710 N/mm2

1000 mm	*39.87"*	12 kg
500 mm	*16.68"*	6 kg

R1 → R2 R3

1000 kN/m max.





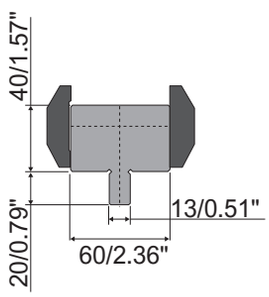
AD7

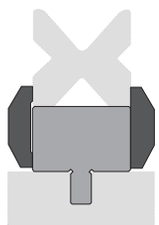
C45: 560-710 N/mm2

835 mm	*32.87"*	25 kg
415 mm	*16.34"*	8.5 kg

R2 R3 → R1

1000 kN/m max.





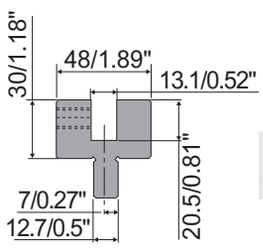
AD8-12.7

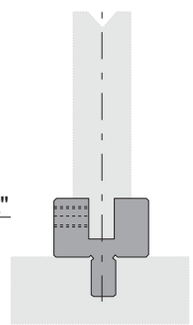
C45: 560-710 N/mm2

1000 mm	*39.87"*	12 kg
500 mm	*16.68"*	6 kg

R4 → R2 R3

1000 kN/m max.





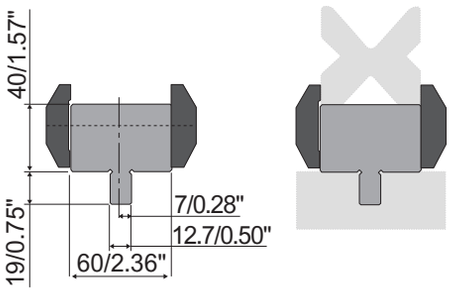
AD9-12.7

C45: 560-710 N/mm2

835 mm	*32.87"*	17 kg
415 mm	*16.34"*	8.5 kg

R4 → R1

1000 kN/m max.



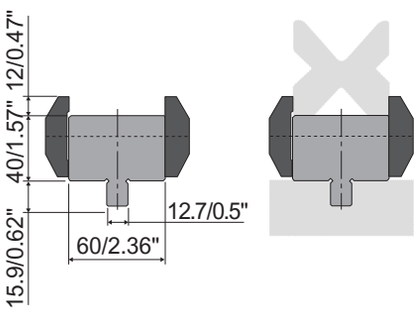
AD17

C45: 560-710 N/mm2

835 mm	*32.87"*	18 kg
415 mm	*16.34"*	18 kg

R5 → R1

1000 kN/m max.



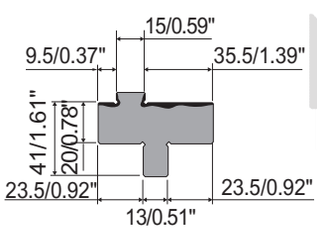
AD18

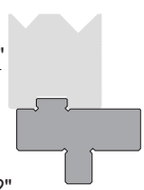
C45: 560-710 N/mm2

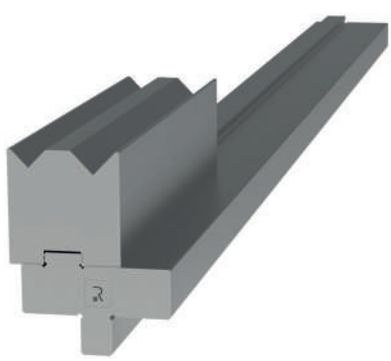
835 mm	*32.87"*	18 kg
415 mm	*16.34"*	9 kg

R2 R3 → RX EHT

1000 kN/m max.







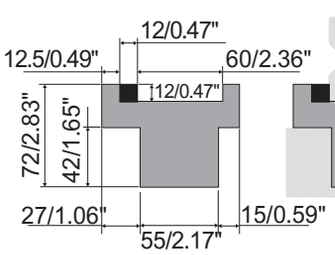
AD24

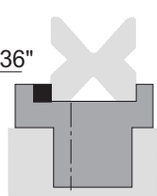
C45: 560-710 N/mm2

835 mm	*32.87"*	30 kg
415 mm	*16.34"*	14.2 kg

RX EHT → R1

1000 kN/m max.





AD25

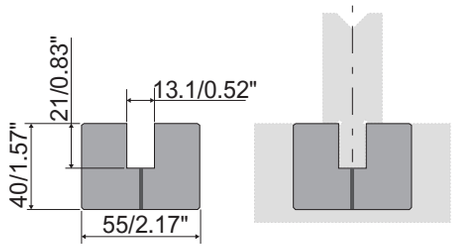
C45: 560-710 N/mm2

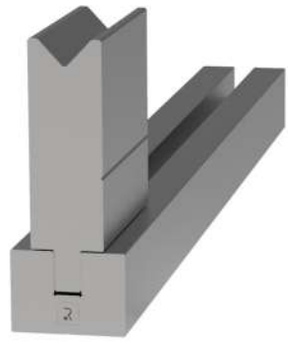
1000 kN/m max.

500 mm *19.68"* 7.5 kg

H=40 mm | *1.57 in*

RX WEINBRENNER → R2 R3





AD26

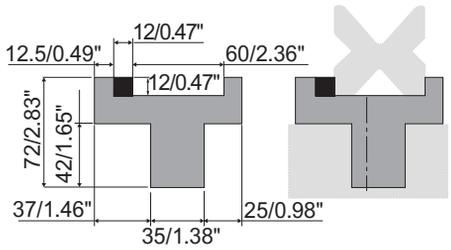
C45: 560-710 N/mm2

1000 kN/m max.

835 mm *32.87"* 23 kg
415 mm *16.34"* 11.4 kg

H=72 mm | *2.83 in*

RX WEINBRENNER → R1



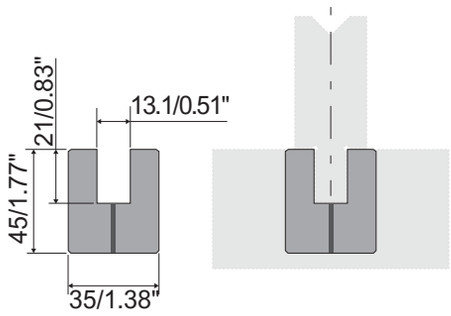
AD27

C45: 560-710 N/mm2

1000 kN/m max.

500 mm *16.68"* 4.5 kg

RX EHT → R2 R3



.fast clamping systems

TIME SAVING
Rolleri fast clamping systems are designed to improve operator's work during machine setup.

SAFETY
Rolleri fast clamping systems comply with the European Regulations currently in force, i.e. MACHINE DIRECTIVE 2006/42/CE.

.ROL GRIP STAR

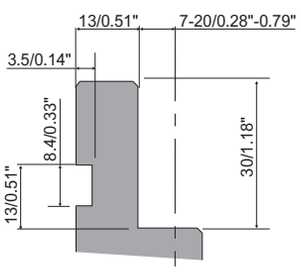
With ROLGRIP, intermediates blocking tools are free from compressed air connections. A special system inside the clamp allows air to pass only when the clamp "recognises" an idoneous automatic module.
If the clamp has to block any other element (special tool, manual intermediate, etc.) there is no air emission, and clamp can be used as a standard manual clamp.

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools.



.TECHNICAL INFORMATION

UPPER CLAMPING
Pneumatic automatic clamping for upper tools.

TECHNICAL INFORMATION
Clamping height=100mm.
Bending axis at 7mm.
Also available with 20mm axis and with different intermediate heights (H=120mm, H=150mm).

VERTICAL TOOL CHANGE
Vertical tool change of standard tool European type and automatic alignment.

SUPPLY
Patented STAR SYSTEM electrical connection. No need of pipes in working area, and free and easy removal of modules everywhere on clamping system.

FLEXIBILITY
Upper clamp 13401-A-ST "STAR SYSTEM" (patented by Teda) electrical connection essential for ROL GRIP STAR SYSTEM, allows the removal of modules everywhere on clamping system, granting complete flexibility of machine tooling.

DOUBLE ORIENTATION
Possibility of mounting the tool reverse (manual clamping from operator side) with manual clamp 11008 (optional).

.ROL GRIP TELESCOPIC

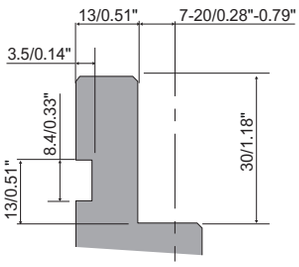
With ROLGRIP TELESCOPIC positioning and alignment are automatic while mounting punches on clamping system. The system has a telescopic pipe which allows a considerable horizonal movement of modules.

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools.



.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Clamping height=100mm.
Bending axis at 7mm.
Also available with 20mm axis and with different intermediate heights (H=120mm, H=150mm).

VERTICAL TOOL CHANGE
Vertical tool change of standard tool European type and automatic alignment.

SUPPLY
Air connection with stainless steel telescopic pipe (patented).

DOUBLE ORIENTATION
Possibility of mounting the tool reverse (manual clamping from operator side) with manual clamp 11008 (optional).

.ROLGRIP FLEX

With ROLGRIP FLEX positioning and alignment are vertical.
To be used with Promecam tang punches.
Flexible pipe in a safe position to allow modules to be moved horizontally and removed easily (with longer pipe).

.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Clamping height=100mm.
Bending axis at 7mm.
Also available with H=150mm intermediate.

VERTICAL TOOL CHANGE
Vertical tool change of standard tool European type and automatic alignment.

SUPPLY
Air connection with nylon flexible pipes.

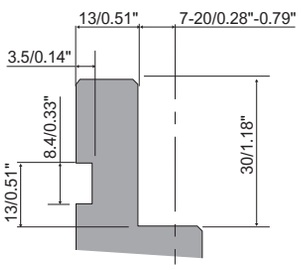
DOUBLE ORIENTATION
Possibility of mounting the tool reverse (manual clamping from operator side) with manual clamp 11008 (optional).

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools.



.fast clamping systems

.ROL GRIP MANUAL

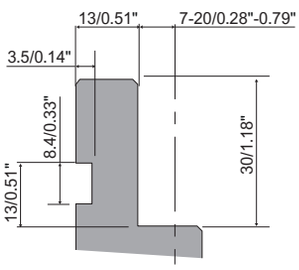
Manual clamping for upper tools with ergonomic lever. Vertical tool change for standard European type punches and automatic alignment. Possibility of mounting the tool reverse (manual clamping from operator side) with manual clamp 11008 (optional) complete with screws and springs.

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools.



.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Clamping height=100mm.
Bending axis at 7mm.
Also available with H=150mm intermediate (13131-150-M), H=120mm bending axis 20mm (13135-M) and H=150mm bending axis 20mm.

VERTICAL TOOL CHANGE
Manual clamping for punches with ergonomic lever. Vertical tool change for standard European type punches and automatic alignment.

SUPPLY
Energy connection via the patented "STAR SYSTEM". NO PRESENCE OF PIPES in the work area and free removal of the modules immediately in any position.

DOUBLE ORIENTATION
Manual clamping for punches with ergonomic lever. Vertical tool change for standard European type punches and automatic alignment.

.ROLGRIP Manual KDS

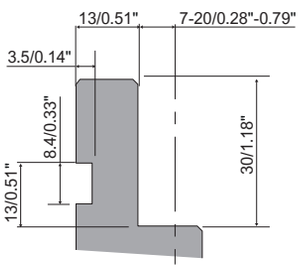
Manual clamping for upper tools with ergonomic lever. Vertical tool change for standard European type punches and automatic alignment. There is no limit of length, shape nor quantity of tools. Possibility of mounting the tool reverse (manual clamping from operator side) with manual clamp 11008 (optional) complete with screws and springs.

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools.



.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Clamping height=100mm.
Bending axis at 7mm.
Also available with intermediates with different heights (H=120mm, H=150mm) and with 20mm bending axis.

VERTICAL TOOL CHANGE
Manual clamping for punches with ergonomic lever. Vertical tool change for standard European type punches for both front and rear clamp with open system. Automatic alignment. There is no limit of length, shape nor quantity of tools.

FLEXIBILITY
Clamping with one lever for each module which works for all tools – on the front and on the rear – with automatic alignment. Lever has no encumbrances. Tool removal is quick, safe and easy.

DOUBLE ORIENTATION
Possibility of mounting the tool reverse from operator side (180° rotation), according specific needs.

COMPARAISON OF MACHINE TOOLING TIME ON 3000MM PRESS BRAKE

OPERATION	MANUAL TRADITIONAL MODEL WITH SCREWS	ROLGRIP MANUAL MODEL (13131-M)
Clamping	30 screws = 5″ each total = 150″	15 modules with lever =2″ each total = 30″
Tool removal	horizontal = 25″ each total = 100″	Vertical = 8″ each total = 32″
Tool mounting	horizontal = 25″ cad. total = 100″	Horizontal = 6″ each total = 24"
Pre-screwing 30 screws	4″ total = 120″	-
Tool settlement	10" total = 10"	-
Screwing of 30 screws	3" total = 90"	-
Clamping 15 modules with ergonomic lever	-	4" total=30"
TOTAL	**570″ = 9′,30″**	**116″ = 1′,56″**

.ROL TOUCH >>

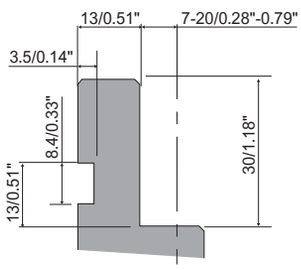
Thanks to ROL TOUCH clamp you can keep the intermediates on your press brake, and replace only front clamp: a fast-clamping system with a small investment. Vertical tool change for standard European type punches and automatic alignment.

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools.



.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Clamping height=100mm.
Bending axis at 7mm.
Also available with bending axis 20mm.

VERTICAL TOOL CHANGE
Manual clamping for punches with ergonomic lever. Vertical tool change for standard European type punches and automatic alignment.

FLEXIBILITY
Allows the use of intermediates already mounted on the press brake, by replacing front clamp only: a fast-clamping system with a small investment.

DOUBLE ORIENTATION
Possibility of mounting the tool reverse from operator side, with manual clamp 11009.

COMPARAISON OF MACHINE TOOLING TIME ON 3000MM PRESS BRAKE

OPERATION	MANUAL TRADITIONAL MODEL WITH SCREWS	ROLGRIP MANUAL MODEL (13131-M)
Clamping	30 screws = 5″ each total = 150″	15 modules with lever =2″ each total = 30″
Tool removal	horizontal = 25″ each total = 100″	vertical = 8″ each total = 32″
Tool mounting	horizontal = 25″ cad. total = 100″	horizontal = 6″ each total = 24"
Pre-screwing 30 screws	4″ total = 120″	-
Tool settlement	10" total = 10"	-
Screwing of 30 screws	3" total = 90"	-
Clamping 15 modules with ergonomic lever	-	4" total= 30"
TOTAL	**570″ = 9′,30″**	**116″ = 1′,56″**

.ROL 200 >>

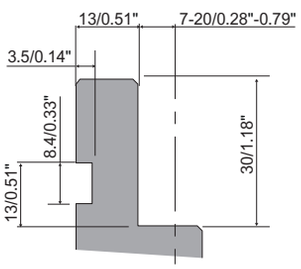
ROL200 is Rolleri patented system for vertical and safe insertion and removal of all punches with R1 type tang. Extreme model can be used with all standard intermediates (H100, H120, H150) and with 7mm (Z1) and 20mm (Z2) axis, whereas Power model is compatible with standard H100 intermediates only, and is specifically meant to provide a pneumatic fast clamping system with a better clamping force than Extreme model. ROL200 Power intermediate is heat-treated to better keep all mechanical properties, such as aesthetic anti-oxidation.
ROL200 Power represents an easy, safe and convenient solution to meet any need, as it is suitable to equip new press brakes as well as to retrofit already operating press brakes.

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools. No punch modification is required.



.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Length = 150 mm | *5.90"*
Max. press force = 1000 kN/m

DOUBLE ORIENTATION
The new ROL200KDS combines convenience, reliability and safety of ROL200 with versatility given by a back clamp and it guarantees the maximum use flexibility.

TOOL CHANGE
A front clamp enables fast vertical tool insertion. Back clamp enables horizontal tool insertion.

ALIGNMENT
These fast clamping systems seat and clamp punches automatically.

SAFETY
Antifall system "full safety" for all R1 punches without any tooling modification.

SUPPLY
The system is available in pneumatic, hydraulic and manual version. ROL200 Power is pneumatic (clamping force higher than ROL200 Extreme. Extreme=12 bar, Power=16 bar).

INSTALLATION
Installation is easy and quick as the system is supplied with Rolleri standard intermediates. No modifications of the press brake are required.

Scan the QRCode or click on it and watch the video to find out more about this system.

TOOL INSERTION AND REMOVAL
Punches are inserted and removed with a special movement, which avoids any accidental fall and improves punch insertion.

INTERMEDIA-TES	PNEUMATIC BAR 12			HYDRAULIC BAR 80			MANUAL		
	Extreme	Extreme + KDS	Power	Extreme	Extreme + KDS	Power	Extreme	Extreme + KDS	Power
INT100F	●	●	-	●	-	-	-	●	-
INT120F	●	●	-	●	●	-	-	●	-
INT100	●	●	● (16 bar)	●	-	-	-	●	-
INT120	●	●	-	●	●	-	-	●	-
INT150	●	●	-	●	●	-	-	●	-
INT120-40	●	●	-	●	●	-	-	●	-
INT150-40	●	●	-	●	●	-	-	●	-
INT120HD	●	-	-	●	-	-	●	-	-
INT150HD	●	-	-	●	-	-	●	-	-
INT120-40HD	●	-	-	●	-	-	●	-	-
INT150-40HD	●	-	-	●	-	-	●	-	-

.driving unit

PNEUMATIC

PPU/12 (Extreme) see page .power units >> - Pag. 241.
PPU/16 (Power) see page .power units >> - Pag. 241.

HYDRAULIC

HPU-E see page .power units >> - Pag. 241.

ROL200 EXTREME

ROL200 POWER

.ROL 4 >>

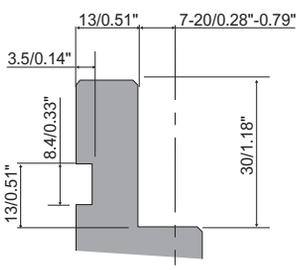
ROL4 is a fast clamping system which allows a really effective clamping, and is specifically suited for automatic alignment without weight restrictions. ROL4 is available in manual and hydraulic version. it's always supplied with a back clamp to insert punches on the back of an intermediate.
The front cover makes the system good-looking and protects the pipes between intermediates. Such protection avoids any accidental collision and preserves all components. The main features of ROL4 are: reliability, robustness and safety.

.press brake compatibility

With all press brakes with Amada-Promecam type tang.

.tools compatibility

R1 tools. No punch modification is required.



.driving unit

HYDRAULIC

HPU-E see page .power units >> - Pag. 241

.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Length = 150 mm | *5.90".*
Max. press force = 1000 kN/m.

DOUBLE ORIENTATION
The double clamping system guarantees the maximum use flexibility.

TOOL CHANGE
Front and back clamps enable horizontal tool change.

ALIGNMENT
These fast clamping systems seat and clamps punches automatically (only front clamp).

SAFETY
Antifall system "full safety" for all R1 punches without any tooling modification.

SUPPLY
This system is available in hydraulic and manual version.

INSTALLATION
Installation is easy and quick as the system is supplied with Rolleri standard intermediates. No press brake modifications are required.

Thanks to a crowning wedge, ROL4 can compensate structure deflection of a press brake. In the central oblong hole you can loose the screw to release the wedge and move it left and right to adjust intermediate height.

	HYDRAULIC BAR 160	MANUAL
INTERMEDIATES		
INT100F	●	●
INT120F	●	●
INT100	●	●
INT120	●	●
INT150	●	●
INT120-40	-	●
INT150-40	●	●
INT120HD	●	●
INT150HD	●	●
INT120-40HD	-	●
INT150-40HD	●	●

.FAST CLAMP1 >>

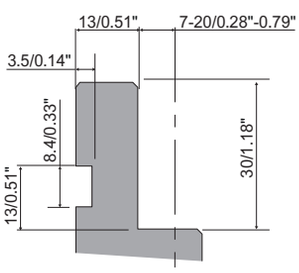
FAST CLAMP1 is a combination of traditional clamps with screws and with a lever. Clamps are made of a more resistant material and undergo several treatments to increase their resistance and to avoid corrosion. Clamps are opened and closed by means of a lever rotating around a central pin.
One of the main features of FAST CLAMP1 is the adjustability of the pin. Thanks to this feature, we can always control the clamping force of punches, even in case punch tang is worn out.
FAST CLAMP1 can be mounted on all standard intermediates and thanks to a hardened back plate, the pin doesn't damage the intermediate as it happens in traditional clamps. A removable lever extender can be used in order to open and close clamps easier. Such lever extender can be used to open clamps with LC shorter lever mounted on the right edge of the upper beam to avoid collision during box bending. With FAST CLAMP1 R1 punches with ROL1 ball bearings can be inserted vertically, lifted and seated automatically.
With KDS (double clamping kit) system you can open and close front and back clamp at the same time by using the central lever.

.press brake compatibility

With all press brakes with Amada-Promecam tang.

.tools compatibility

To be used with ROL1 system, punches are modified and equipped with ball bearings.



INTERMEDIA-TES	FAST CLAMP1	DOUBLE FAST CLAMP1
INT100F	●	●
INT120F	●	●
INT100	●	●
INT120	●	●
INT150	●	●
INT120-40	●	●
INT150-40	●	●
INT120HD	●	-
INT150HD	●	-
INT120-40HD	●	-
INT150-40HD	●	-

.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Length = 150 mm | *5.90"*
Max. press force = 1000 kN/m

DOUBLE CLAMPING
FAST CLAMP1 is available with front clamp only and with double clamps (front and back) - DOUBLE FAST CLAMP1.

TOOL CHANGE
Both front and back clamps enable vertical tool change.

ALIGNMENT
FAST CLAMP1 lifts and seats punches automatically and guarantees their perfect alignment.

SAFETY
Vertical tool change is enabled by ball bearings which also work as antifall system.

SUPPLY
The system is available in manual version. It's a complete, manual, fast and convenient clamping system.

INSTALLATION
FAST CLAMP1 is designed for a press brake with 50mm distance between intermediates. In case such distance is bigger, please make sure that the minimum quantity of ball bearings is taken by the clamp. Such quantity depends on the tool type and length.

.FAST CLAMP3 >>

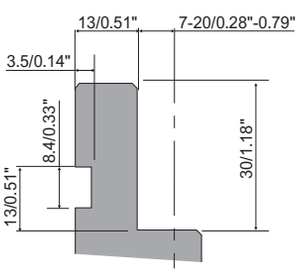
FAST CLAMP3 is a combination of traditional clamps with screws and with a lever. Clamps are made of a more resistant material and undergo several treatments to increase their resistance and to avoid corrosion. Clamps are opened and closed by means of a lever rotating around a central pin. One of the main features of FAST CLAMP3 is the adjustability of the pin. Thanks to this feature, we can always control the clamping force of punches, even in case punch tang is worn out.
FAST CLAMP3 can be mounted on all standard intermediates and thanks to a hardened back plate, the pin doesn't damage the intermediate as it happens in traditional clamps. A removable lever extender can be used in order to open and close clamps easier. Such lever extender can be used to open clamps with LC shorter lever mounted on the right edge of the upper beam to avoid collision during box bending.
With KDS (double clamping kit) system you can open and close front and back clamp at the same time by using the central lever.

.press brake compatibility

With all press brakes with Amada-Promecam tang.

.tools compatibility

R1 tools.
No tooling modification is required.



INTERMEDIA-TES	FAST CLAMP3	DOUBLE FAST CLAMP3
INT100F	●	●
INT120F	●	●
INT100	●	●
INT120	●	●
INT150	●	●
INT120-40	●	●
INT150-40	●	●
INT120HD	●	-
INT150HD	●	-
INT120-40HD	●	-
INT150-40HD	●	-

.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Length = 150 mm | *5.90"*
Max. press force = 1000 kN/m

DOUBLE CLAMPING
FAST CLAMP3 is available with front clamp only and with double clamps (front and back) - DOUBLE FAST CLAMP3.

TOOL CHANGE
Clamp is equipped with an ergonomic and adjustable lever to open and close clamp easily.
Thanks to the adjustable pin, the clamping force is always under control.

TOOL ALIGNMENT
Thanks to its curved form and its elasticity, FAST CLAMP3 guarantees punch perfect clamping and alignment, including short segments.

SAFETY
Punches are safely clamped thanks to the clamp antifall nose.

SUPPLY
The system is available in manual version.
It's a complete, manual, fast and convenient clamping system.

INSTALLATION
FAST CLAMP3 is designed for a press brake with 50 mm 1.96" distance between intermediates.

.EASY CLAMP >>

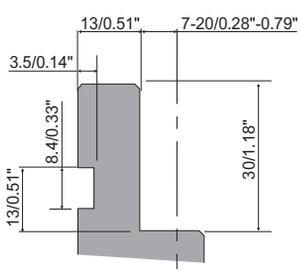
EASY CLAMP is the simplest system and it's considered standard all over the world. Intermediates vary a lot ranging from 100mm (3.94") to 150mm (5.90"). They may also have 2 different bending axis: Z1 at 7mm (0.28") and Z2 at 20mm (0.79") from the tang.
Each intermediate can be used with manual clamps (with screws) and fast clamps (with lever).
Every clamp type is also available with ground clamping surface or with polyurethane insert to clamp better segmented punches.
EASY CLAMP can have fix height with +/- 0.01mm tolerance or it can be equipped with a crowning wedge. By releasing the central screw and moving it to the left or to the right, crowning wedge is moved and intermediate height adjusted.

.press brake compatibility

With all press brakes with Amada-Promecam tang.

.tools compatibility

R1 tools.
No tooling modification is required.



INTERMEDIA-TES	EASY CLAMP	DOUBLE EASY CLAMP
INT100F	●	●
INT120F	●	●
INT100	●	●
INT120	●	●
INT150	●	●
INT120-40	●	●
INT150-40	●	●
INT120HD	●	-
INT150HD	●	-
INT120-40HD	●	-
INT150-40HD	●	-

.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Length = 150 mm | *5.90"*
Max. press force = 1000 kN/m

DOUBLE CLAMPING
EASY CLAMP is available with front clamp only and with double clamps (front and back) - DOUBLE EASY CLAMP. The system offers different front clamps (ST60/ST60R/STG60 - STL60/STL60R/STLG60 - STX60/STX60R/STXG60)

TOOL CHANGE
ST60 clamps are opened and closed with screws and enable horizontal tool change. Back clamp too enables horizontal tool change.

TOOL ALIGNMENT
Punches are aligned manually or by simulating a bending process without sheet metal so that punch presses in the die V opening. Afterwards you can tighten clamp screws.

SAFETY
Screw driven clamps guarantee safe tool clamping even in manual mode. A special optional polyurethane insert clamps better sectioned tools.

SUPPLY
The system is available in manual version. It's a complete, manual, fast and convenient clamping system.

INSTALLATION
EASY CLAMP is designed for a press brake with 50mm 1.97" distance between intermediates. Installation is easy and intuitive. In order to install intermediates with wedges properly, check the press brake user manual to adjust the height to compensate the upper beam deformation.

.ROL2 >>

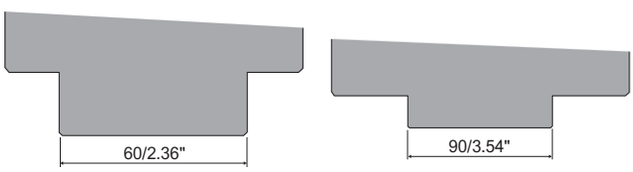
ROL2 is the best system to clamp R1 type dies with 60mm 2.36" and 90mm 3.54" base.
Thanks to its construction, when the clamp is closed, clamping pressure is evenly distributed along the die and guarantees its perfect alignment. The main advantage of such system consists in die V opening being automatically centered. In addition to this, tooling clamping is faster than ever. Both in case an operator uses a pneumatic, hydraulic or manual version, he can start bending after a few seconds under the safest conditions.
ROL2 has been designed to complete clamping system range for R1 type tools.
This system can be mounted in brand new press brakes as well as in already operating press brakes. ROL2 means speed, quality and flexibility.

.press brake compatibility

With all press brakes with Amada-Promecam tang.

.tools compatibility

R1 tools.



Scan the QRCode or click on it and watch the video to find out more about this system

.TECHNICAL INFORMATION

LOWER SYSTEM

TECHNICAL INFORMATION
Manual clamp: 500mm | 19.68"
Pneumatic clamp: 150mm | 5.90"
Hydraulic clamp: 500mm | 19.68"

DOUBLE CLAMPING
DOUBLE CLAMPING ensures maximum flexibility of usage.

SUPPLY
This system is available in manual, pneumatic and hydraulic versions. The manual system is composed of a clamp L=500 mm which is activated by a lever which you have to insert in the middle of the clamp.
The pneumatic system is composed of pneumatic clamps L=150 mm which are activated by a pneumatic driving unit or by press brake CNC. Hydraulic system is composed of L=500 clamps with dedicated hydraulic driving unit.

INSTALLATION ON TABLES 60MM AND 90MM WIDE
Clamps can be installed directly to press brake table using the holes for standard clamps (hole pitch 100mm).
In alternative you need to modify the hole pitch.
In order to clamp Rolleri R1 dies with 60mm 2.36" base in tables 90mm 3.54" wide, we supply 2 shims 15mm 0.59" wide (with clamping pins).
The system is compatible with press brakes with automatic crowning systems.

INSTALLATION
ROL2 system is easy, innovative and, above all, flexible.
To be mounted in a new press brake, it only needs a specific hole pitch and you can mount clamps directly to the table.
To be mounted in an already operating press brakes, the system is supplied with a die holder.

The new design enables clamping of the smallest die segments

Available with CTS holder to increase system height

.ST50S >>

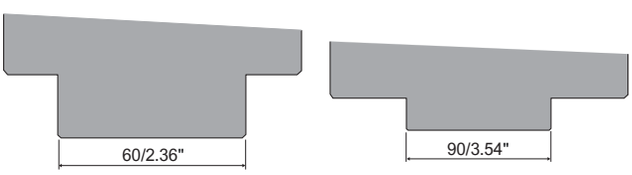
ST50-S is a simple but innovative solution to ease die change onto the press brake table.
ST50-S is considered a retractable clamp, as it can be pushed downwards when screws are released and reaches the same height of the press brake table. With ST50-S you don't have to slide dies sideways and push them until they reach their working position. You can place a die directly onto the press brake table in its working position with 3 advantages: operator's safety, less exertion, no table or die base damages, which guarantees better precision.

.press brake compatibility

With all press brakes with Amada-Promecam tang.

.tools compatibility

R1 tools.
No tooling modification is required



.TECHNICAL INFORMATION

LOWER SYSTEM

TECHNICAL INFORMATION
Material = Fe37: 370-470 N/mm²
Length = 170 mm | *6.69"*
Height = 50 mm | 1.97"

FRONT CLAMP
ST50-S is mounted on the front side of a press brake.

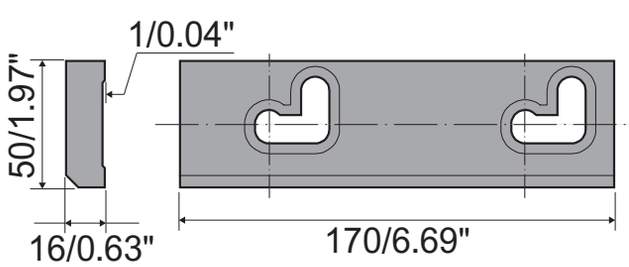
TOOL CHANGE
Dies can be easily changed, as they can be slided frontally without having to lift them.

TOOL ALIGNMENT
ST50-S can line up and clamp dies perfectly thanks to 2 front screws.

SAFETY
Dies can be safely changed thanks to this retractable die, as operator doesn't have to lift them over clamps.
This means operator's safety and better care for tools and press brake table.

SUPPLY
The system is available in manual version.
It's a complete, manual, fast and convenient clamping system.

INSTALLATION
ST50-S is designed for a press brake with 100mm hole pitch. Put the two M10 allen screws of the table into the die slots and slide the clamp following the slot shape without removing the screws.



Find out more about this clamping system by scanning the QRCode or clicking on it.
Create your account on www.rolleritools.com

Scan the QRCode or click on it and watch the video to find out more about this system

.W ROL >>

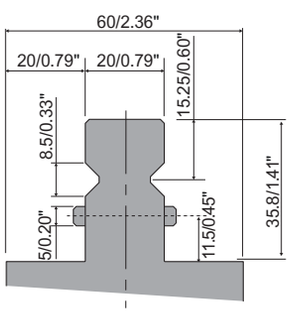
WROL clamping systems represent an evolution of R2 New Standard. They look like long beams in one solid piece (obtained from standard modules L=510mm assembling) with a new structural and aesthetic design.
Every WROL undergoes heating treatment to give proper hardness to the contact surfaces of the system with tooling.
According to the necessary capacity you can choose among Power, Supreme and Extreme line. Several lengths are available from 1020 mm ***(3.346 ft)*** to 6120 mm ***(20.087 ft)*** for any press brake.
You can also retrofit a press brake with R1 type tang to R2 New Standard and gain some daylight thanks to the limited working height of WROL being only 80mm 3.15".
In this version you can choose between AWP version (fix) and AWPC with crowning wedges.
The appearance has been improved by reducing the overall dimensions with ergonomic advantages too and by mounting LED bars for the tool positioning.

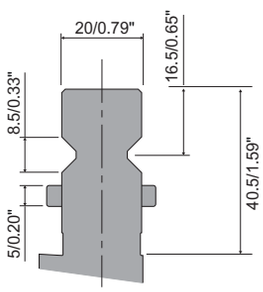
.press brake compatibility

With all press brakes with New Standard - R2 tang.

.tools compatibility

R2 New Standard tools.





.TECHNICAL INFORMATION

UPPER CLAMPING
WROL clamping systems are for R2 New Standard tools. They can also be used to retrofit a R1 type press brake to clamp R2 New Standard tooling.

TECHNICAL INFORMATION
Useful clamping length = from 1020 mm | 3.346 ft to 6120 mm | 20.087 ft

TOOL
WROL clamping system guarantees the maximum flexibility, as punches can be mounted backward.

TOOL CHANGE
Punches with ROL1 or with Quick Lock system can be inserted vertically, whereas punches with safety pins can be slided horizontally.

ALIGNMENT
All WROL systems seat automatically both head thrust and shoulder thrust punches.

SAFETY
Equipped with the antifall system "full safety" for all R2 and R4 (W series) tooling with Quick Lock or with safety pins.

LED BAR
The system can be equipped with a led bar for the correct tool positioning (WROL Exteme).

SUPPLY
The system is available in pneumatic and hydraulic versions.

INSTALLATION
WROL systems can be mounted to the upper beam thanks to holes with standard pitch. TX enables any correction along the X axis. AWP and AWPC models can be easily mounted without any modification of the upper beam. Instructions to connect the system with press brake CNC are given in the user manual.

WROL AWP AND AWPC (WITH CROWNING WEDGES)
Available for R1 type tang press brakes.

PNEUMATIC ○ = optional ● = standard

	POWER	SUPREME	EXTREME
Air supply	12 bar/175 psi	12 bar/175 psi	12 bar/175 psi
Material	Hardened C45 steel	Hardened 42CrMo4 steel	Hardened 42CrMo4 steel
Max. press force on the head	1800 kN/m | *60 t/ft*	2000 kN/m | *80 t/ft*	2000 kN/m | *80 t/ft*
Max. press force on the shoulders	2500 kN/m | *85 t/ft*	3000 kN/m | *90 t/ft*	3000 kN/m | *90 t/ft*
LED for tool positioning	○	○	●

HYDRAULIC ○ = optional ● = standard

	POWER	SUPREME	EXTREME
Air supply	30 bar/435 psi	30 bar/435 psi	30 bar/435 psi
Material	Hardened C45 steel	Hardened 42CrMo4 steel	Hardened 42CrMo4 steel
Max. press force on the head	1800 kN/m | *60 t/ft*	2000 kN/m | *80 t/ft*	2000 kN/m | *80 t/ft*
Max. press force on the shoulders	2500 kN/m | *85 t/ft*	3000 kN/m | *90 t/ft*	3000 kN/m | *90 t/ft*
LED for tool positioning	○	○	●

.driving unit
PNEUMATIC
PPU/12 see page .Power units >> - Pag. 241

LED BAR
- W ROL POWER without positioning LED
- W ROL SUPREME without positioning LED

Find out more about this clamping system by scanning the QRCode or clicking on it.
Create your account on www.rolleritools.com

.driving unit
HYDRAULIC
HPU-MXL see page .Power units >> - Pag. 241

TX
Rolleri adjustment system during installation is very useful to adjust the overall beam length.
The subsequent advantage is the correct position of the bending axis in relation to the backgauges.
Thanks to this, precision and repeatability are guaranteed for any profile.

.AXIAL MANUAL >>

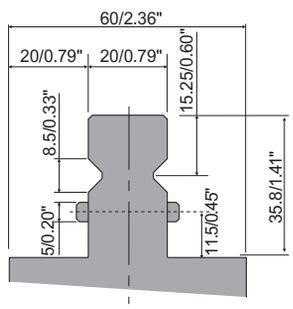
Fast system to turn European R1 tang of press brake into R2 new standard. Vertical tool change and manual alignment.

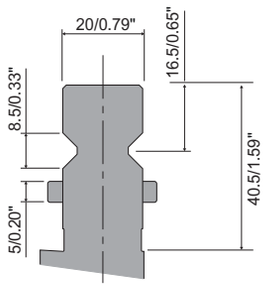
.press brake compatibility

It can be configured for all kinds of press brakes.

.tools compatibility

R2 New Standard tools.





.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Clamping height=100mm.
Bending axis at 7mm.
Also available without crowning wedges (14111X-WM).

TOOL CHANGING
Manual clamping for upper tools with economic lever.
HORIZONTAL tool change with New Standard tools with pins.
VERTICAL tool change with New Standard tools with "safety click".
Automatic alignment.

.W ROL2 >>

WROL2 clamping systems represent an evolution of New Standard systems for R2, R3 dies and R4 dies with 12.7mm 0.5" tang. They are made in one solid piece with a new structural and aesthetic design. Every WROL undergoes heating treatment to give the proper hardness to the contact surfaces with tooling.
According to the necessary capacity you can choose among Power, Supreme and Extreme line. Several lengths are available from 1100mm (3.608 ft) to 6100mm (20.131 ft) for any press brake. WROL2 installation along the axis is guaranteed by TX adjustment.
A press brake can be retrofitted from R1 to R2 New Standard without losing too much daylight thanks to the limited height of WROL2.
The appearance has been improved by reducing the overall dimensions with ergonomic advantages too.

.TECHNICAL INFORMATION

LOWER SYSTEM

TECHNICAL INFORMATION
Useful clamping length = from 1020 mm | 3.346 ft to 6120 mm | 20.087 ft
Material = Hardened C45 steel
Height = 70 mm | *2.76"*
Max. press force = 2000 kN/m
Pneumatic version = 12 bar/175 psi
Hydraulic version = 30 bar

SUPPLY
The system is available in pneumatic and hydraulic versions.

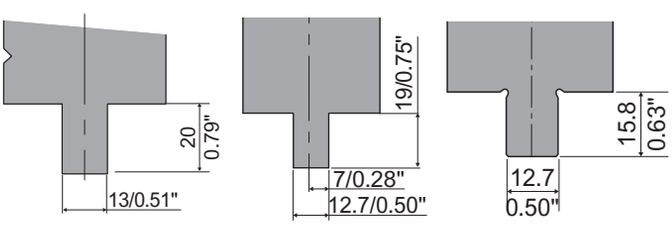
INSTALLATION
WROL2 systems can be mounted onto a lower beam thanks to holes with standard pitch. TX enables any correction along the X axis.
Instructions to connect the system to press brake CNC are given in the user manual.

.press brake compatibility

With all press brakes with New Standard - R2 tang.

.tools compatibility

WROL2 clamping systems are for R2 New Standard, R3 dies and R4 dies with 12.7mm 0.5" tang.

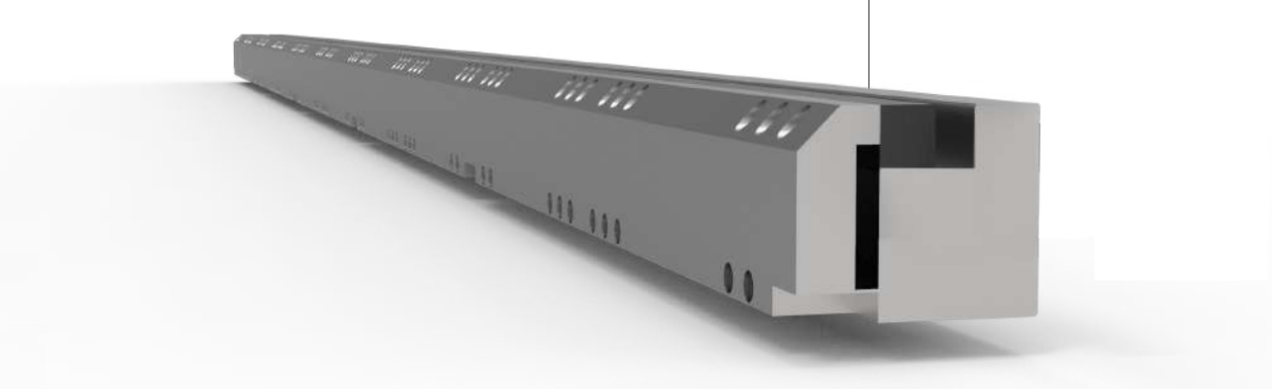


.driving unit

HYDRAULIC
HPU/MXL see page .Power units >> - Pag. 241
PNEUMATIC
PPU/12 see page .Power units >> - Pag. 241

TX
Rolleri adjustment system during installation is very useful to adjust the overall table length.
The subsequent advantage is correct position of the bending axis in relation to backgauges. Thanks to this, precision and repeatability are guaranteed for any profile.

NEW CONCEPT W ROL2 PN



.A ROL >>

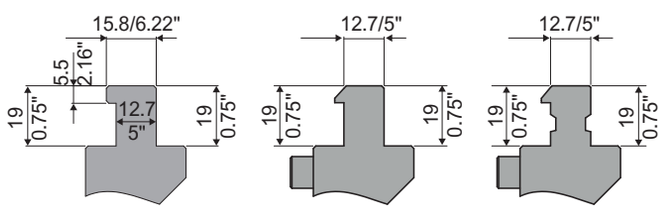
AROL systems represent an evolution of American clamping systems. They are solid one-piece beams, obtained from assembled standard modules L=611mm, with a new aesthetic and mechanical concept. Every AROL undergoes heating treatment to give proper hardness to the contact surfaces of the system with tooling. According to the necessary capacity you can choose among Power, Supreme and Extreme line. Several
lengths are available from 1100mm (3.608 ft) to 6100mm (20.131 ft) for any press brake.
You can also retrofit a press brake with R1 type tang to clamp American type tools and gain some daylight thanks to the limited working height of AROL being only 80mm 3.15". In this version you can choose between AWP version (fix) and AWPC with crowning wedges.
The appearance has been improved by reducing the overall dimensions with ergonomic advantages too and by mounting LED bars for the tool positioning or for on/off signal.

.press brake compatibility

With all press brakes with American tang.

.tools compatibility

AROL clamping systems are for American style tooling.



.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Press brake length = from *3.608 ft* | 1100 mm to *20.131 ft* | 6100 mm

TOOL
AROL clamping system guarantees the maximum flexibility, as punches can be mounted backward.

TOOL CHANGE
Punches with Quick Lock system can be inserted vertically, whereas punches with safety groove can be slided in horizontally.

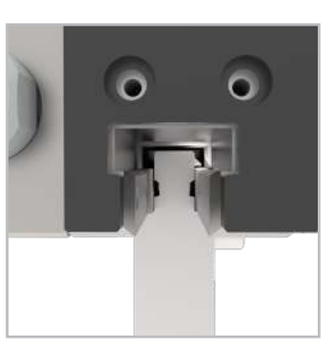
ALIGNMENT
AROL systems guarantee perfect alignment along X axis. Punches with Quick Lock are lifted and seated automatically on the shoulders.

SAFETY
AROL guarantees maximum safety for all punches with Quick Lock and with antifall groove. To clamp punches with straight tang (without Quick Lock or safety groove), we recommend to slide them horizontally using dies as support.

LED BARS
The system can be equipped with a led bar for the correct tool positioning (AROL Exteme).

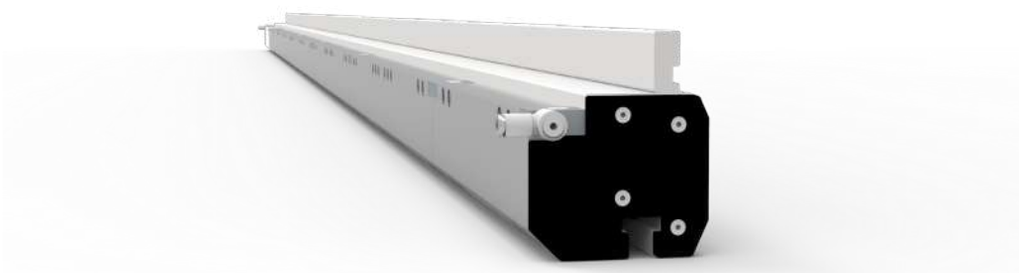
SUPPLY
The system is available in pneumatic and hydraulic versions.

INSTALLATION
AROL systems can be mounted to an upper beam thanks to holes with standard pitch. TX enables any correction along the X axis.
Instructions to connect the system to press brake CNC are given in the user manual.



PNEUMATIC ○ = optional ● = standard

	POWER	SUPREME	EXTREME
Air supply	12 bar/175 psi	12 bar/175 psi	12 bar/175 psi
Material	Hardened C45 steel	Hardened 42CrMo4 steel	Hardened 42CrMo4 steel
Max. press force on the head	1500 kN/m	85 t/ft | 2500 kN/m	85 t/ft | 2500 kN/m
Max. press force on the shoulders	○	●	○
LED for tool positioning	○	○	●
Made up of modules	L=116 mm	L=116 mm	L=116 mm



HYDRAULIC ○ = optional ● = standard

	POWER	SUPREME	EXTREME
Air supply	30 bar/435 psi	30 bar/435 psi	30 bar/435 psi
Material	Hardened C45 steel	Hardened 42CrMo4 steel	Hardened 42CrMo4 steel
Max. press force on the head	1500 kN/m	*85 t/ft* | 2500 kN/m	*85 t/ft* | 2500 kN/m
Max. press force on the shoulders	○	●	○
LED for tool positioning	○	○	●

.driving unit
PNEUMATIC
PPU see page .Power units >> - Pag. 241

LED BAR
- A ROL POWER without positioning LED
- A ROL SUPREME without positioning LED

R5 punches are required for AROL system.
Click on the QRCode or scan it to check the standard tools available.

.driving unit
HYDRAULIC
HPU-MXL see page .Power units >> - Pag. 241

TX
Rolleri adjustment system during installation is very useful to adjust the overall beam length.
The subsequent advantage is the correct position of bending axis in relation to backgauges. Thanks to this, precision and repeatability are guaranteed for any profile.

.UNIVERSAL FAST CLAMP >>

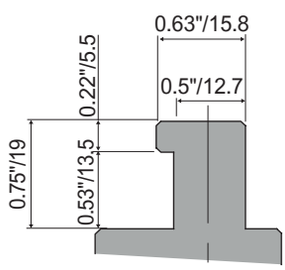
UNIVERSAL FAST CLAMP is a combination of traditional clamps with screws and with a lever. Clamps are made of a more resistant material and undergo several treatments to increase their resistance and to avoid corrosion.
UNIVERSAL FAST CLAMP has been designed to clamp R1 and Americal style tooling. A special insert with several grooves can be moved to the front or to the back to clamp R1 or American style punches.
Clamps are opened and closed by means of a lever rotating around a central pin. One of the main features of UNIVERSAL FAST CLAMP is the adjustability of the pin. Thanks to this feature, we can always control the clamping force of punches, even in case punch tang is worn out.
UNIVERSAL FAST CLAMP can be mounted on all standard intermediates and thanks to a hardened back plate, the pin doesn't damage the intermediate as it happens in traditional clamps.
A removable lever extender can be used in order to open and close clamps easier. Such lever extender can be used to open clamps with LC shorter lever mounted on the right edge of the upper beam to avoid collision during box bending.

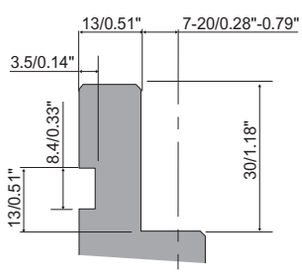
.press brake compatibility

With all press brakes with American and Amada-Promecam tang.

.tools compatibility

R1 and R5 (American) tools.
No tooling modification is required.





INTERMEDIATES	UNIVERSAL FAST CLAMP
INT100-A	●
INT100-A American	●
INT120-40-A	●
INT150-A	●
INT120-A	●

.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Length = 150 mm | *5.90"*
Max. press force = 1000 kN/m

CLAMP
UNIVERSAL FAST CLAMP is available with front clamp only.

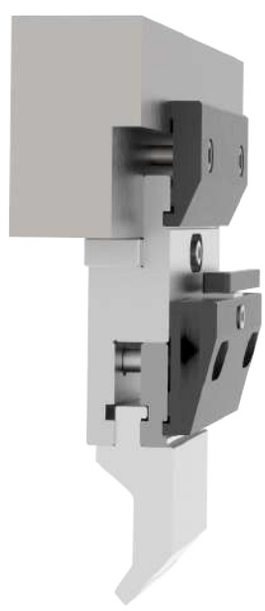
TOOL CHANGE
Clamp is equipped with an ergonomic and adjustable lever to open and close clamp easily.
Thanks to the adjustable pin, the clamping force is always under control.

TOOL ALIGNMENT
Thanks to its curved form and its elasticity, UNIVERSAL FAST CLAMP guarantees the perfect clamping and alignment of punches, including short segments.

SAFETY
Punches are safely clamped thanks to the clamp antifall nose.

SUPPLY
The system is available in manual version.
It's a complete, manual, fast and convenient clamping system.

INSTALLATION
UNIVERSAL FAST CLAMP is designed for a press brake with 1.96" 50 mm distance between intermediates.



.ROL3 >>

ROL3 clamping systems represent the widest range for any type of press brake.
They are complete systems with clamps and beam and they can be pneumatic or hydraulic. Dimensions and length are taylor made according to the press brake upper beam.
ROL3 is suitable for heavy duty jobs and for high tonnage, like 5000kN/m up to 10000 kN/m.
ROL3 system undergoes heating treatment to give proper hardness to the contact surfaces with tooling.
Suitable for press brakes from 1100mm to 6100mm.
Attrezzazzo per presse piegatrici da 1100mm a 6100mm.
The material used for main frame and all components are FEM calculated to guarantee safety.
This solution is quick, handy and convenient.

.TECHNICAL INFORMATION

UPPER CLAMPING

TECHNICAL INFORMATION
Material = C45 - 42CrMo4
Pneumatic version = 12 bar
Hydraulic version = 140-150 bar

TOOL CHANGE
Punches type R3 RFA, RF and R can be inserted vertically, whereas punches type R3 S, R4 and R5 can be slided in horizontally.

ALIGNMENT
Most R3 clamping systems can lift and seat punches automatically.

SUPPLY
The system is available in hydraulic version (clamps □ 500 mm).

INSTALLATION
During design phase, Rolleri draws both system composed of beam and clamps, and clamps mounted on press upper beam.

.press brake compatibility

ROL3 Clamping can be used on press brakes with LVD, Bystronic Beyeler-RFA/RF/R/S, Colly, Colgar, Ajial-Axial, EHT and Ursviken tangs.

.tools compatibility

R3 (RFA/RF/R/S) tools > vertical tooling
R4, R5 tools > horizontal tooling

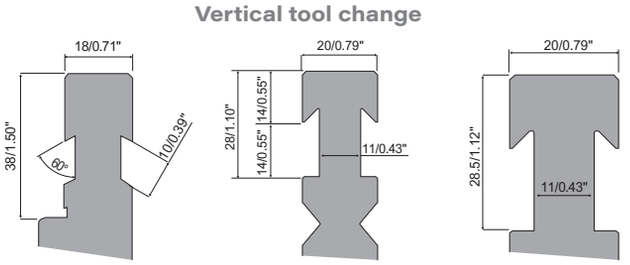
.driving unit

PNEUMATIC
PPU/12 see page .Power units >> - Pag. 241

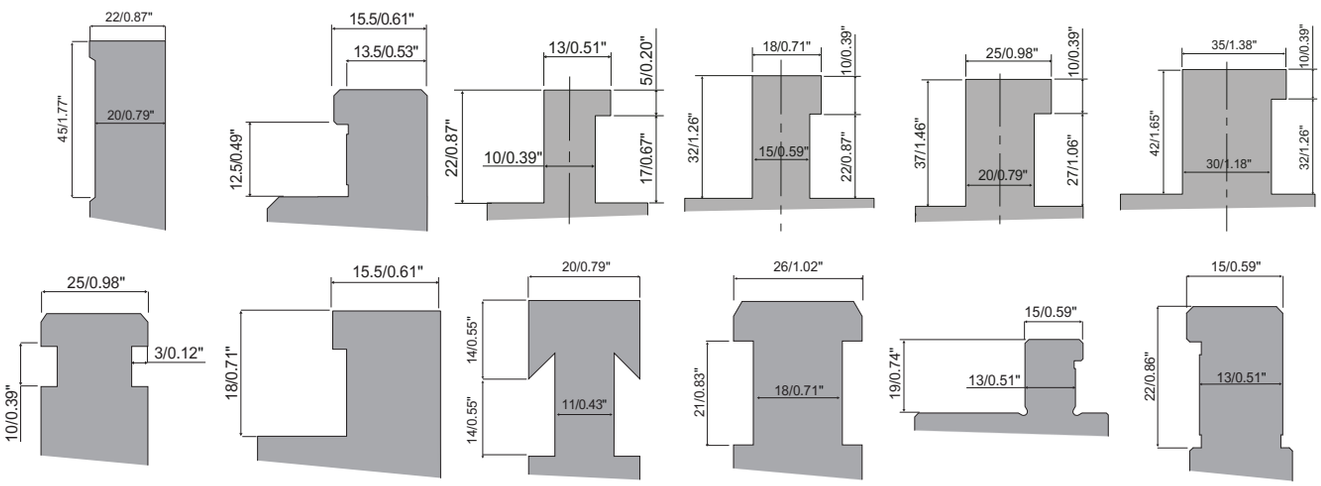
.driving unit

HYDRAULIC
HPU-EXL/1/160 see page .Power units >> - Pag. 241

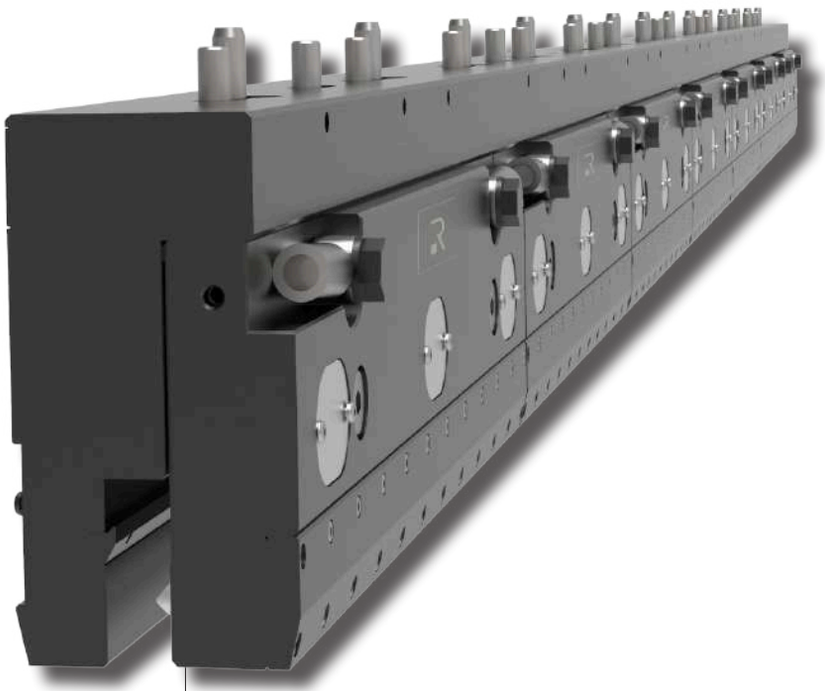
Vertical tool change



Horizontal tool change



.fast clamping systems



For some applications single clamps have to be mounted directly to a press brake upper beam. Rolleri can produce a fast clamping system consisting of clamps only to avoid any upper beam modification.
Modification of upper beam of the press brake will be necessary only if single clamps are ordered separately.

.ROL3/2 >>

ROL3/2 lower clamping systems are an evolution of clamping systems for Colly, EHT, Weinbrenner and other standard dies.
They are made in one solid piece with a new structural and aesthetic design. Every ROL3/2 undergoes heating treatment to give proper hardness to the contact surfaces with tooling.
Several lengths are available from 1100mm (3.608 ft) to 6100mm (20.131 ft) for any press brake. ROL3/2 installation along the axis is guaranteed by TX adjustment.
The appearance has been improved by reducing the overall dimensions with ergonomic advantages too.

.TECHNICAL INFORMATION

LOWER SYSTEM

TECHNICAL INFORMATION
Materiale = C45 - 42CrMo4
Length = from 1100 mm | 3.608 ft to 6100 mm | 20.131 ft
Height = da 80 mm | *3.15"*
Max. press force = 300 kN/m
Pneumatic version = 12 bar/175 psi
Hydraulic version = 140-150 bar

SUPPLY
The system is available in pneumatic and hydraulic versions.

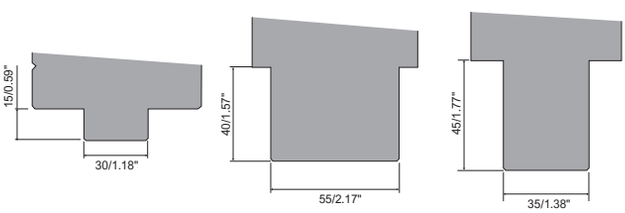
INSTALLATION
ROL3/2 are installed by realising holes directly on press brake table. During design phase, Rolleri draws both system composed of table and clamps, and clamps mounted on press brake table.

.press brake compatibility

ROL3/2 systems are suitable for all press brake models.

.tools compatibility

Colly, EHT and Weinbrenner tools.



.driving unit

PNEUMATICO
PPU/12 see page .Power units >> - Pag. 241

.driving unit

IDRAULICO
HPU-EXL/1/160 see page .Power units >> - Pag. 241

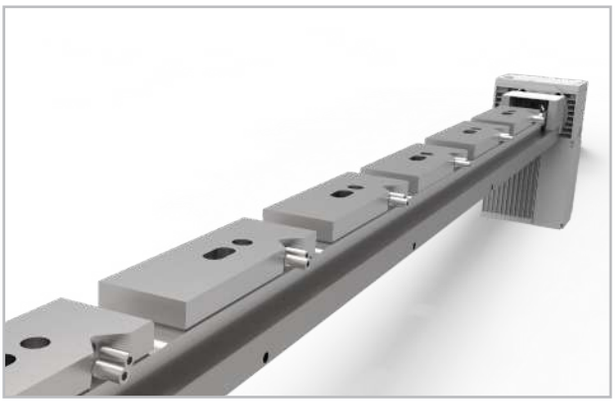
.crowning tables >>

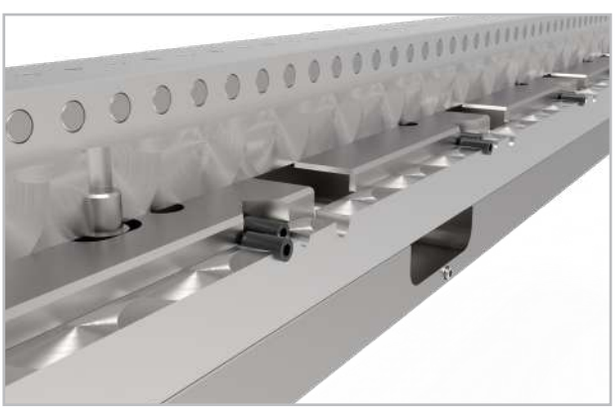
Crowning tables enable mechanical compensation of any press brake deflection. Such deflection is directly proportional to bending length and to the ratio between sheetmetal thickness and die V opening.
Rolleri crowning table is composed of a bar made of special steel opposite to a wedge row.
Each wedge can be individually setto better compensate small working areas.
The bar can be activated manually or automatically thanks to a motoreducer connected to press brake CNC.
Crowning table setup is very simple and fast.
Every table is manufactured according to press brake features in order to improve its activity and integration with a press brake.
Rolleri offers several table versions according to the tang of dies to be clamped. Our tables are supplied with all necessary accessories to be mounted and lined up perfectly with a press brake upper beam.

Die clamping system can be manual, pneumatic or hydraulic.

- Possibility to compensate the whole press brake length or only some areas of it thanks to independent wedges
- Always precise bending angles
- Possibility to clamp R1 dies with 60mm and 90mm base, R2 dies with 13mm tang, R4 and R5 dies.
- Automatic crowning thanks to the connection with press brake CNC or manual crowning with a lever
- Possibility to be installed in new press brakes or in already operating press brakes
- Precise positioning and alignment on press brake table
- Easy and fast use

TX
Rolleri adjustment system during installation is very useful to adjust the overall table length.
The subsequent advantage is correct position of the bending axis in relation to backgauges. Thanks to this, precision and repeatability are guaranteed for any profile.





The images on the left show the way a single wedge can be adjusted for local compensation. This system aids the overall crowning given by the central bar.

On the front side of a table there is a screw with a scale to adjust a specific point along the table. The use is simple and efficient and shows in every moment the type of crowning used to bend any sheet metal.

In this way you can also compensate different thickness you can detect in the same sheet.

In addition, the images show how the crowning table is secured.

Two main features are highlighted: easy installation and simple adjustment of the overall length thanks to reference pins. Rolleri crowning table is very compact to limit overall dimensions and guarantee high capacity.

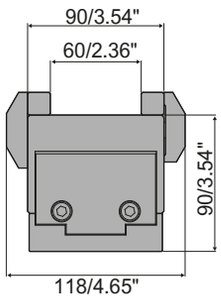
OPTION

- Possibility to have the same hole pitch present on the press brake table
- Possibility to clamp dies with different tang type
- Motor is positioned as standard on the right of operator's side; on request it can be positioned on the left.

ROL TM/R1/MN

C45 hardened and ground **2500 kN/m max.**

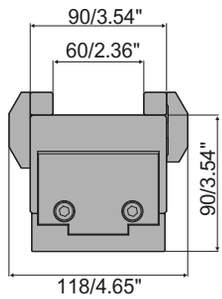
For dies	R1
Crowning type	manual
Clamping	manual

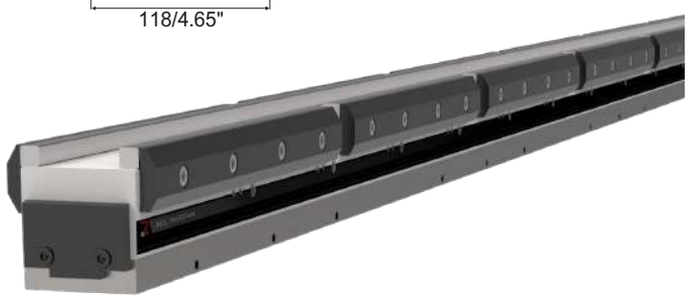


ROL TA/R1/MN

C45 hardened and ground **2500 kN/m max.**

For dies	R1
Crowning type	motorized
Clamping	manual

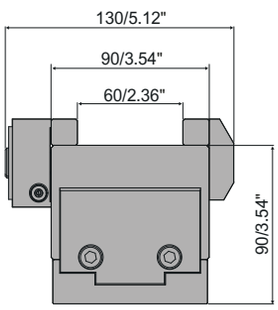




ROL TM/R1/HYD-PN

C45 hardened and ground **2500 kN/m max.**

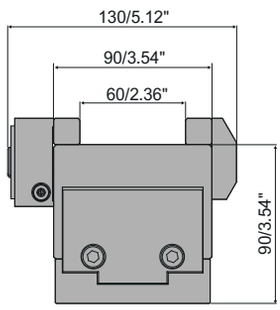
For dies	R1
Crowning type	manual
Clamping	pneumatic or hydraulic



ROL TA/R1/HYD-PN

C45 hardened and ground **2500 kN/m max.**

For dies	R1
Crowning type	motorized
Clamping	pneumatic or hydraulic

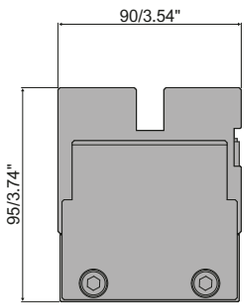


- Table can be supplied with the same hole pitch of press brake
- Table can have different die clamping slots
- Possibility to change motor position

ROL TM/R2/MN

C45 hardened and ground **2500 kN/m max.**

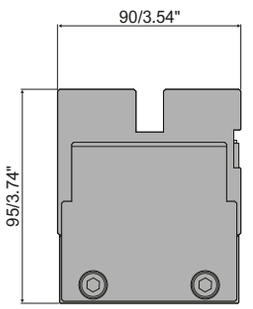
For dies	R2-R3-R4-R5
Crowning type	manual
Clamping	manual

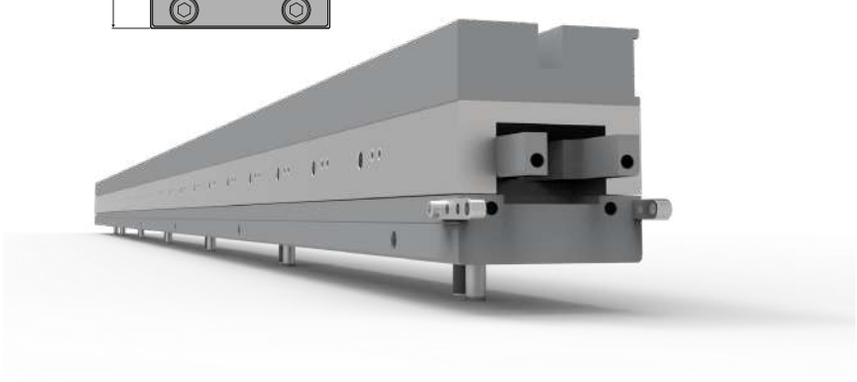


ROL TA/R2/MN

C45 hardened and ground **2500 kN/m max.**

For dies	R2-R3-R4-R5
Crowning type	motorized
Clamping	manual

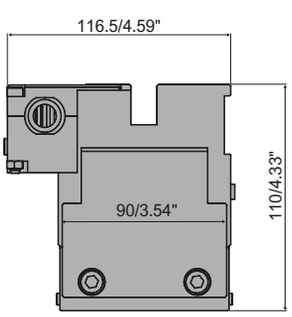




ROL TM/R2/HYD-PN

C45 hardened and ground **2500 kN/m max.**

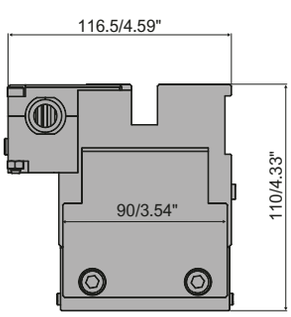
For dies	R2-R3-R4-R5
Crowning type	manual
Clamping	pneumatic or hydraulic

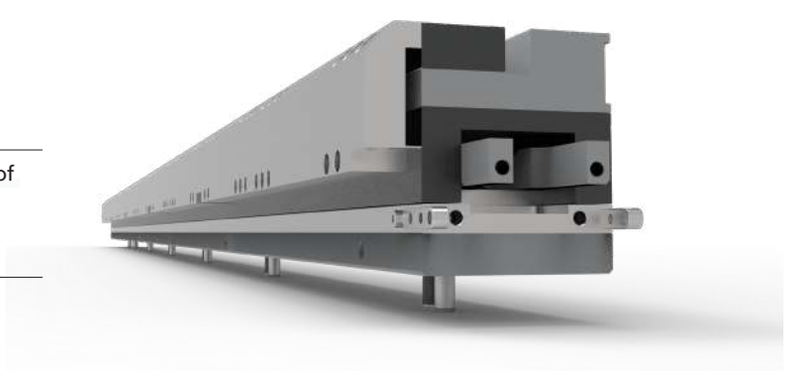


ROL TA/R2/HYD-PN

C45 hardened and ground **2500 kN/m max.**

For dies	R2-R3-R4-R5
Crowning type	motorized
Clamping	pneumatic or hydraulic



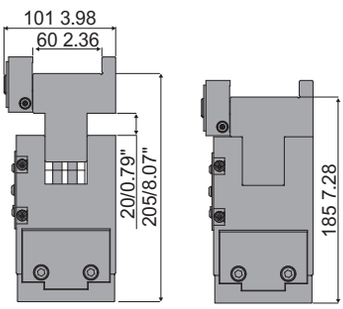


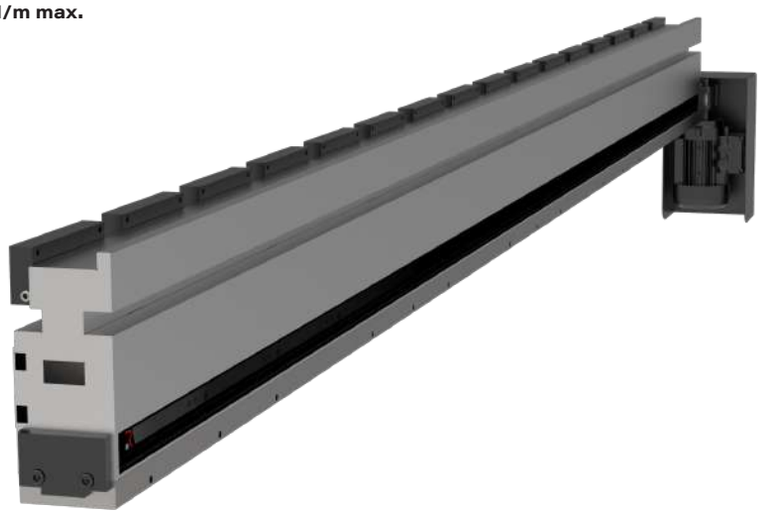
- Table can be supplied with the same hole pitch of press brake
- Table can have different die clamping slots
- Possibility to change motor position

ROL TA/R1/HYD-PN-SPE9

C45 hardened and ground **1500 kN/m max.**

For dies	R1
Crowning type	motorized
Clamping	pneumatic or hydraulic
Maximum stroke	20 mm | *0.79"*
Crowning type	manual available ROL TM/R1/HYD-PN-SPE9

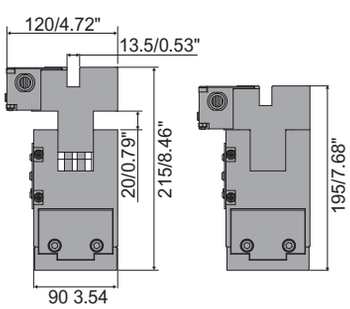




ROL TA/R2/HYD-PN-SPE9

C45 hardened and ground **1500 kN/m max.**

For dies	R2-R3-R4-R5
Crowning type	motorized
Clamping	pneumatic or hydraulic
Maximum stroke	20 mm | *0.79"*
Crowning type	manual available ROL TM/R2/HYD-PN-SPE9

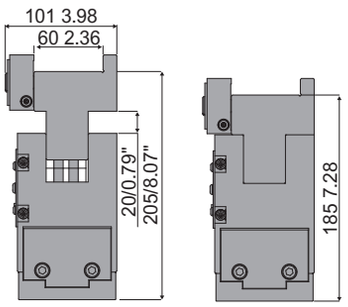


- Table can be supplied with the same hole pitch of press brake
- Table can have different die clamping slots
- Possibility to change motor position

ROL TA/R1/MN-SPE9

C45 hardened and ground **2000 kN/m max.**

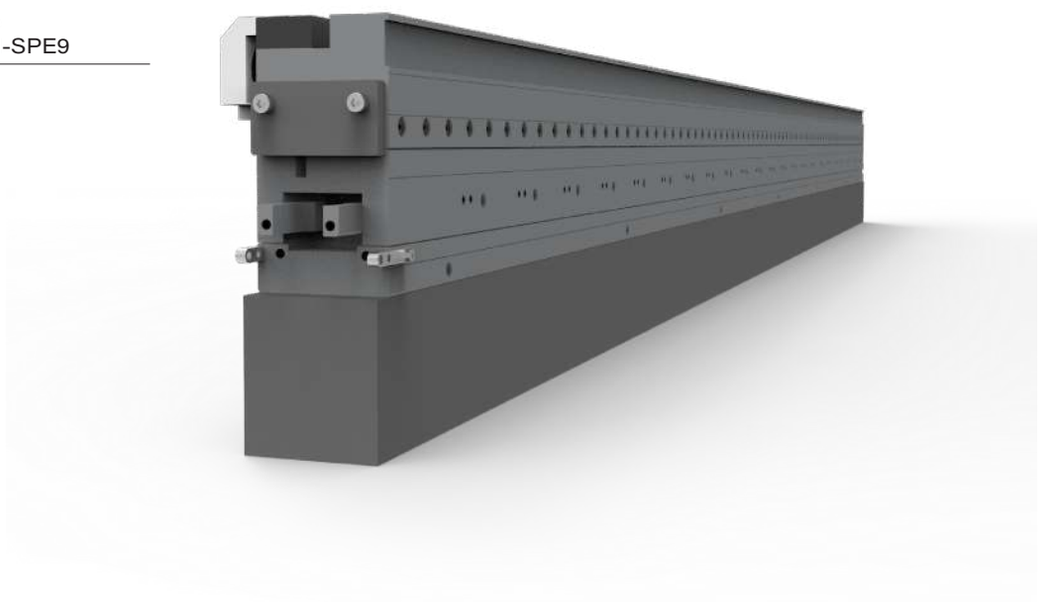
For dies	R1
Crowning type	motorized
Clamping	manual
Maximum stroke	20 mm | *0.79"*
Crowning type	manual available ROL TM/R1/MN-SPE9



ROL TA/R2/MN-SPE9

C45 hardened and ground **2000 kN/m max.**

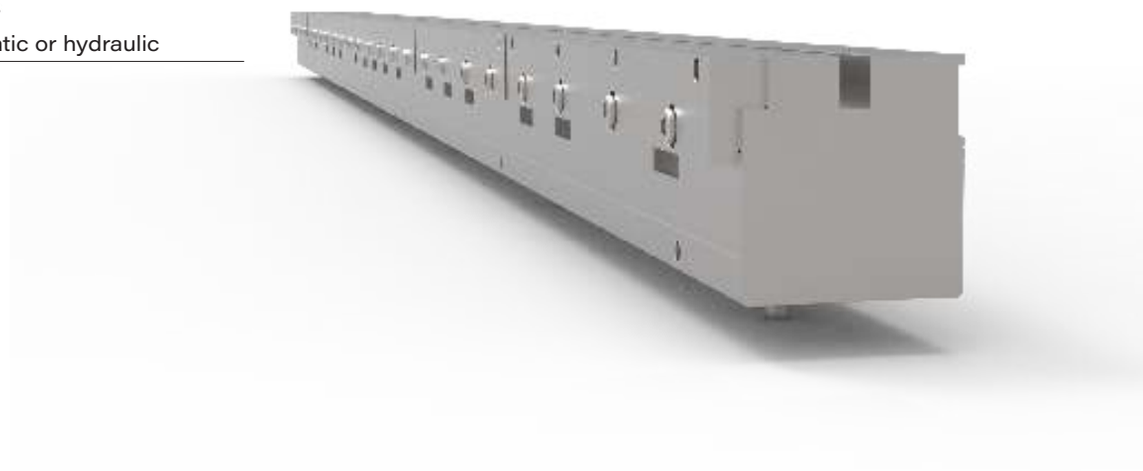
For dies	R2-R3-R4-R5
Crowning type	motorized
Clamping	manual
Maximum stroke	20 mm | *0.79"*
Crowning type	manual available ROL TM/R2/MN-SPE9



W ROL2 CW HYD-PN

C45 hardened and ground **2500 kN/m max.**

For dies	R2-R3-R4-R5
Crowning type	manual with independent wedges
Clamping	pneumatic or hydraulic



W ROL2 CW MN

C45 hardened and ground **2500 kN/m max.**

For dies	R2-R3-R4-R5
Crowning type	manual with independent wedges
Clamping	manual

Table can be supplied with the same hole pitch of press brake

PN

PPU (PNEUMATIC POWER UNIT)
- Checks air pressure at system inlet and outlet
- Amplifies compressed air for better clamping
- Gives an electric signal to CNC in case of low pressure and activates alarm stop
- Supplied with pressure multiplier
- Disponibile su piastra o con cabinet

Types of PPU:

1. **PPU/12/1** (12 bar, in a cabinet, for a single pneumatic system)
2. **PU/12/1/L** (12 bar, mounted on a plate, for a single pneumatic system)
3. **PPU/12/2** (12 bar, in a cabinet, suitable for N.2 combined pneumatic systems)
4. **PPU/12/2/L** (12 bar, mounted on a plate, suitable for N.2 combined pneumatic systems)
5. **PPU/16/1** (16 bar, in a cabinet, for a single pneumatic system)
6. **PPU/16/1/L** (16 bar, mounted on a plate, for a single pneumatic system)
7. **PPU/16/2** (16 bar, in a cabinet, suitable for N.2 combined pneumatic systems)
8. **PPU/16/2/L** (16 bar, mounted on a plate, suitable for N.2 combined pneumatic systems)

HYD

HPU-EXL/1
- To be connected to press brake CNC for opening and closing
- Gives an electric signal to CNC in case of low pressure and activates alarm stop
- It works with 220-380V
- Delivered pressure 30/80/160 bar
- Pump capacity 3,7cc – engine power 1,5 KW
- Complete with cabinet and electric panel

HPU-EXL/2
- To be connected to press brake CNC for opening and closing
- Gives an electric signal to CNC in case of low pressure and activates alarm stop
- It works with 220-380V
- Delivered pressure 30/80/160 bar
- Suitable for N. 2 hydraulic systems
- Pump capacity 3,7cc – engine power 1,5 KW
- Complete with cabinet and electric panel

HPU-MXL/1
- To be connected to press brake CNC for opening and closing
- Gives an electric signal to CNC in case of low pressure and activates alarm stop
- It works with 220-380V
- Maximum delivered pressure: 50 bar. Maximum delivered pressure for combined systems: 30 bar
- Increased pump and engine (pump capacity 7,9cc – engine capacity 2,2 KW)
- Complete with cabinet and electric panel

HPU-MXL/2
- To be connected to press brake CNC for opening and closing
- Gives an electric signal to CNC in case of low pressure and activates alarm stop
- Suitable for N. 2 combined hydraulic systems
- It works with 220-380V
- Maximum delivered pressure: 50 bar. Maximum delivered pressure for combined systems: 30 bar
- Increased pump and engine (pump capacity 7,9cc – engine capacity 2,2 KW)
- Complete with cabinet and electric panel

HPU-E/1

HPU-E/2

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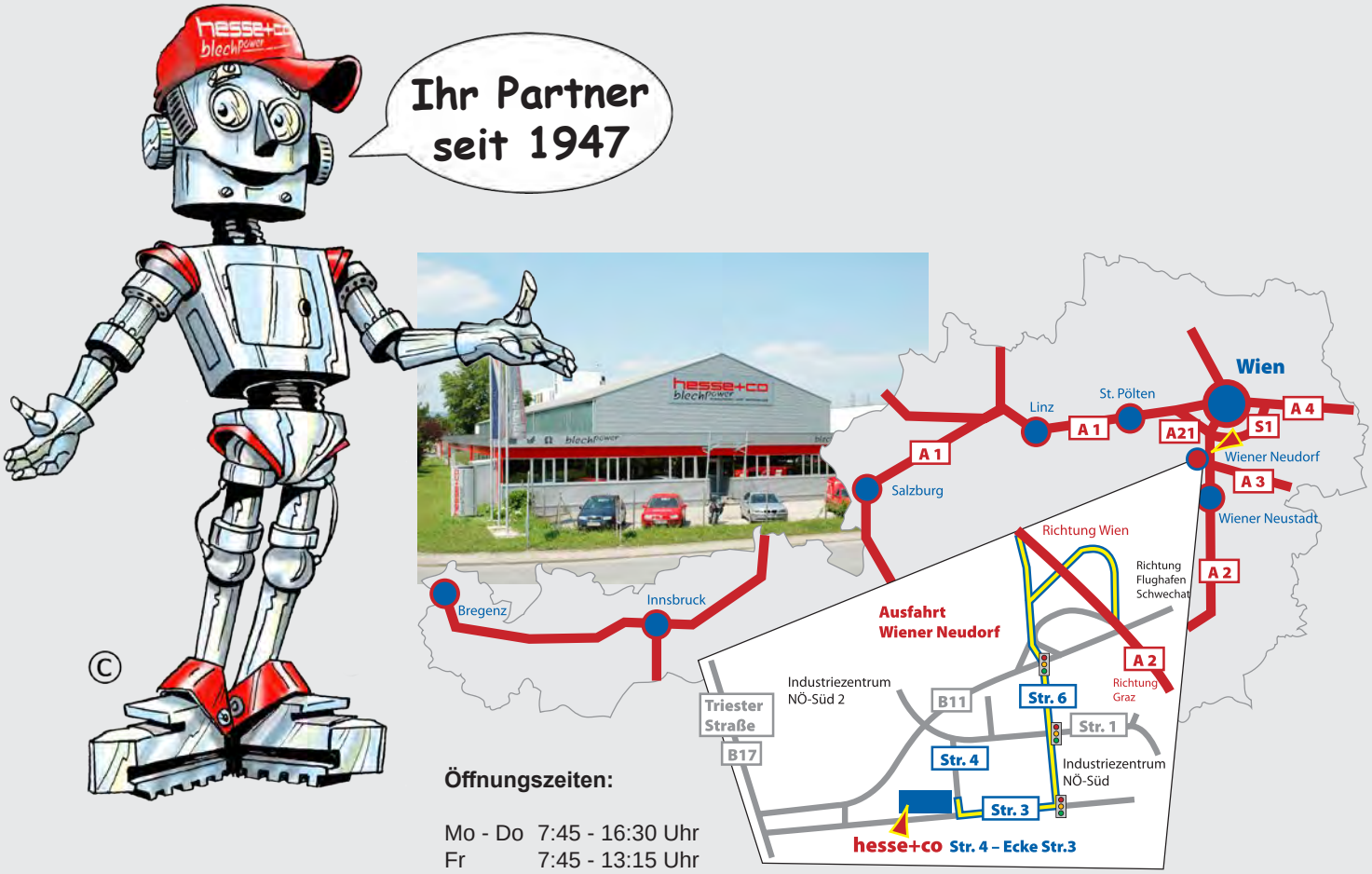

Öffnungszeiten:

Mo - Do 7:45 - 16:30 Uhr
Fr 7:45 - 13:15 Uhr

Hesse + Co Maschinenfabrik GmbH
Industriezentrum NÖ-Süd
Straße 4 - Objekt 8
A-2351 Wiener Neudorf
AUSTRIA

hesse+co blechpower maschinen und werkzeuge

Tel.: +43/2236/638 70-0
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