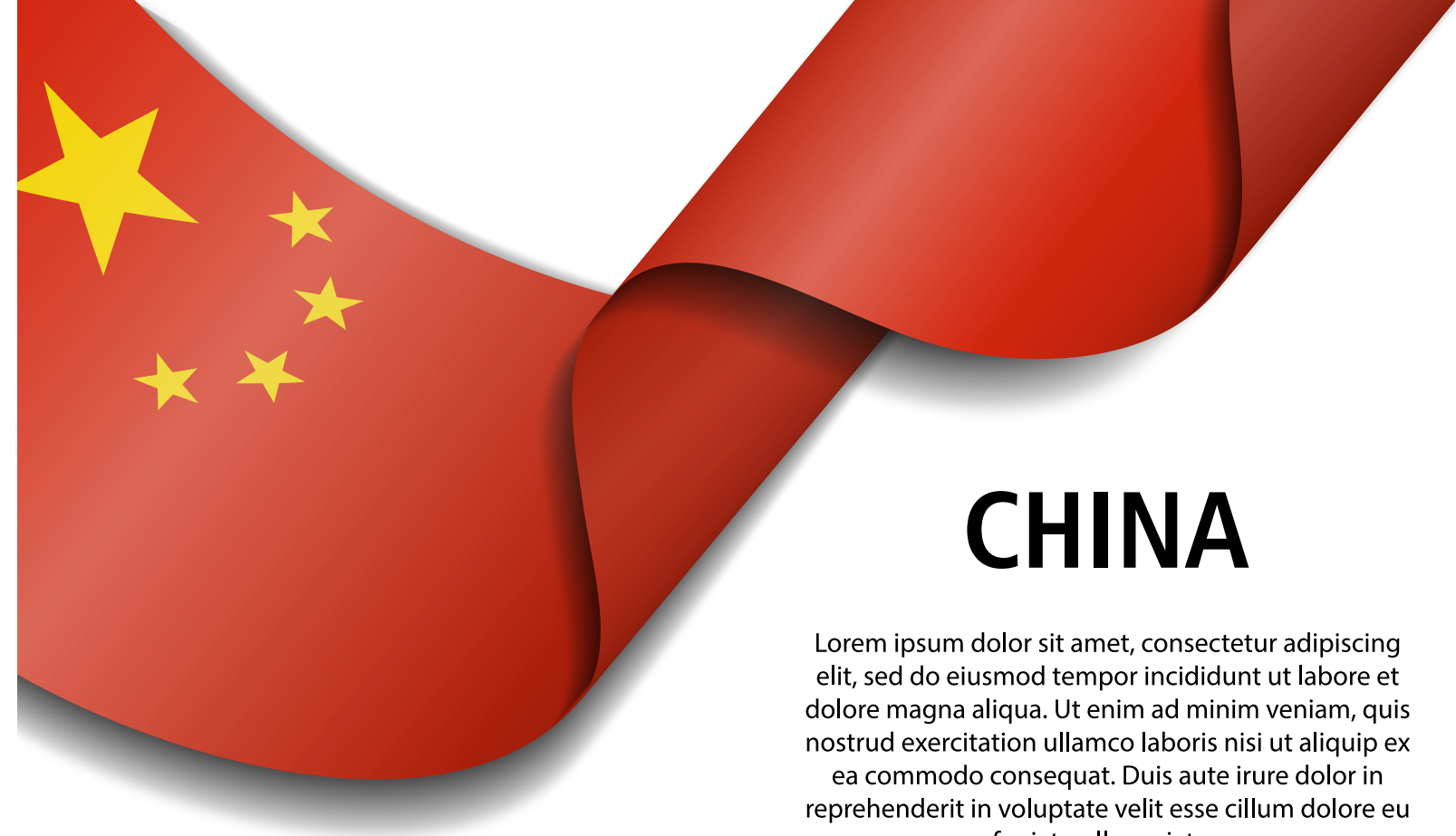




CHINA

Lorem ipsum dolor sit amet, consectetur adipiscing elit, sed do eiusmod tempor incididunt ut labore et dolore magna aliqua. Ut enim ad minim veniam, quis nostrud exercitation ullamco laboris nisi ut aliquip ex ea commodo consequat. Duis aute irure dolor in reprehenderit in voluptate velit esse cillum dolore eu fugiat nulla pariatur.

OUR CUSTOM



FABMAX
ONE STEP AHEAD



www.fabmax.cn

PRODUCTS

Punch

Die

Special tools

Shear Blades

Crowing table

Rolla-V tools

Clamping system

Adjustable table

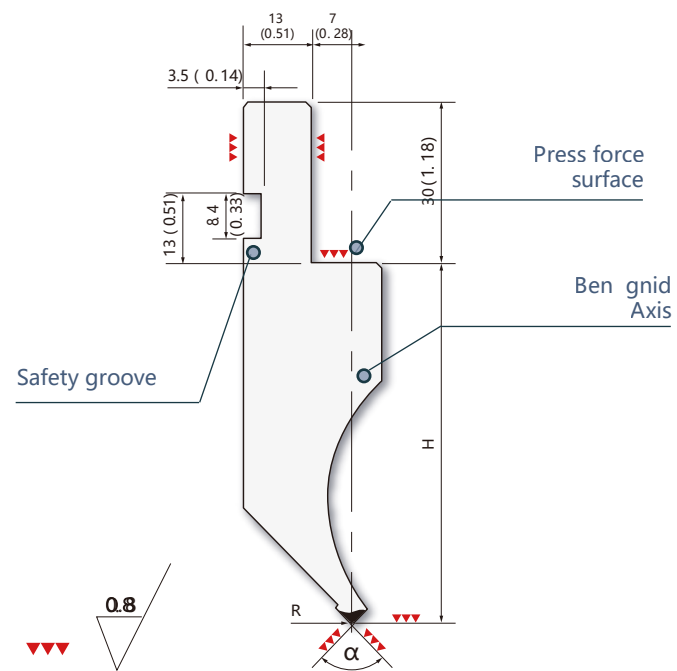
Folding tools

Content Explanation - R1



STANDARD TANG

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



ONE STEP AHEAD



More informations:
www.fabmax.cn

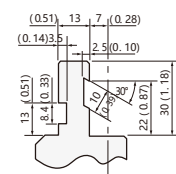


MODIFICATIONS FROM SAFETY GROOVES

A1

Groove in addition to 8.4 x 3.5 mm
Groove for:

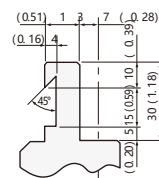
Pneumatic clamping



A8

Groove for:

Hydraulic clamping
Gasparini

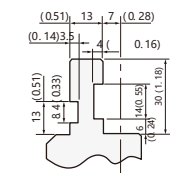


A6

Groove in addition to 8.4 x 3.5 mm
groove for:

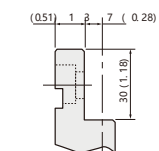


Bystronic-Beyeler Euro
Safan



A9

Modified groove for:

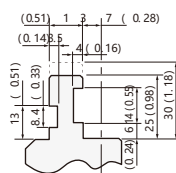


A7

Groove in addition to 8.4 x 3.5 mm
and shortened tang for:

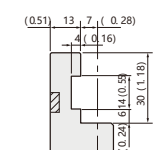


Bystronic-Beyeler Euro
Safan



A41

Modified groove for:

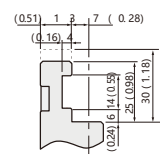


A42

Modified groove for:



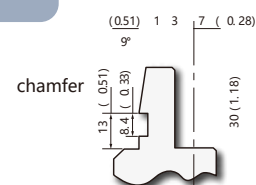
Bystronic-Beyeler Euro
Safan



OT

Modification for:

For Amada fast
clamping
system



STANDARD LENGTH



● TOP

525 mm (20.67 in)

● CLASSIC · A · AFH

835 mm (32.87 in)

415 mm (16.34 in)

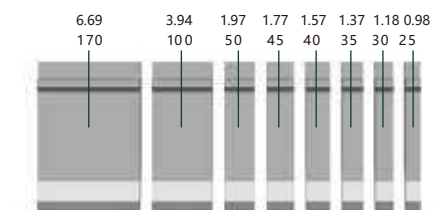
900 mm (35.43 in)

SEGMENTATION

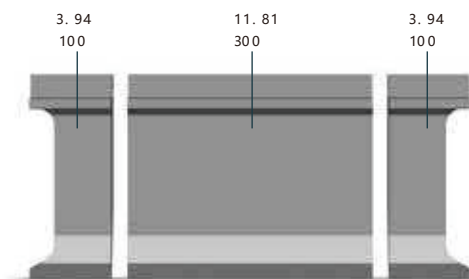


● TOP

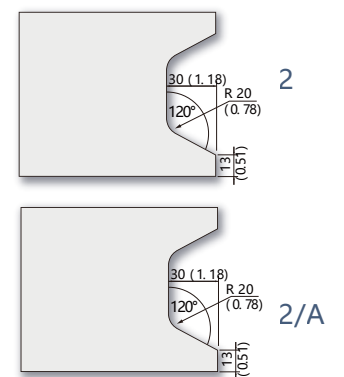
● FA: 495 mm (19.49 in) - 8 segments



● FB: 500 mm (19.68 in) - 3 segments

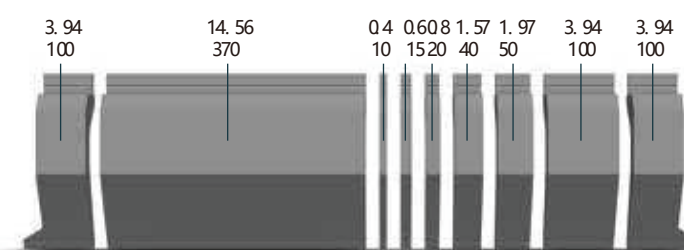


TOP - Horn types

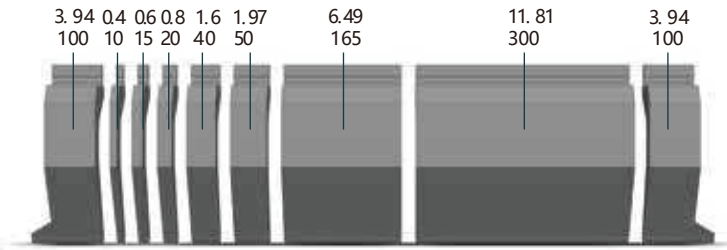


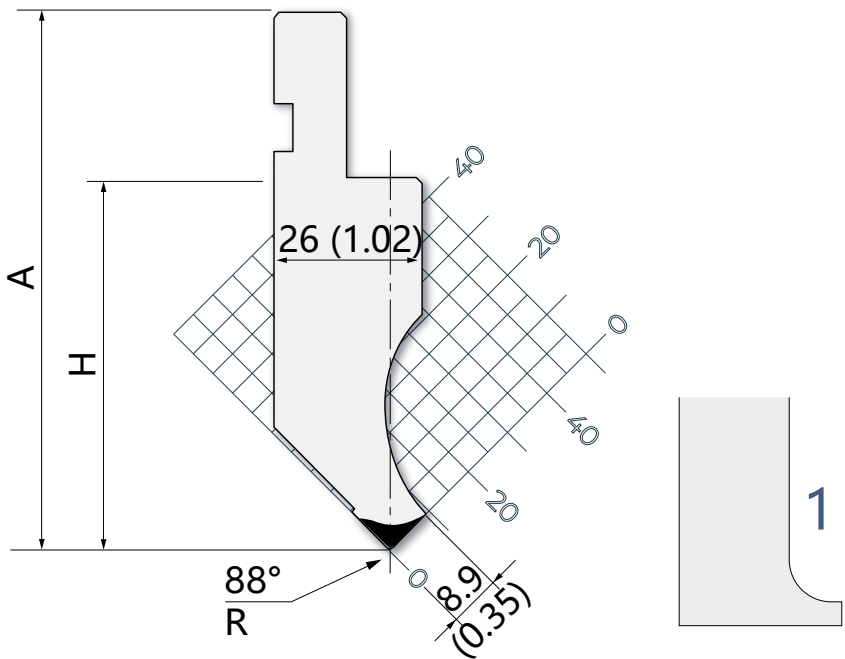
● CLASSIC · A · AFH CLASSIC · A · AFH

● F: 805 mm (31.69 in) - 9 segments

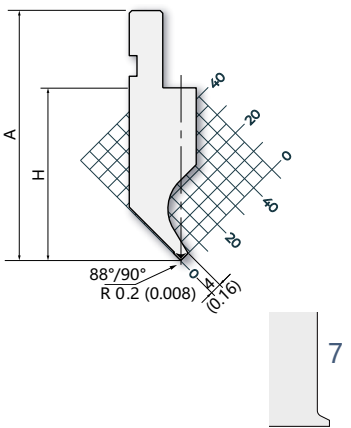


● FC: 800 mm (31.50 in) - 9 segments



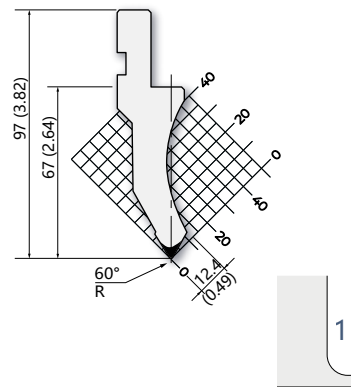


C45: 560-710 N/mm ² 1000 kN/m max.			C45: 560-710 N/mm ² 1000 kN/m max.		
P.97.88.R08			PK.97.88.R025		
H=66.65 / A=96.65 / R=0.8 [mm] (H=262 / A=3.81 / R=0.031) [in]			H=66.60 / A=96.60 / R=0.25 [mm] (H=262 / A=3.80 / R=0.010) [in]		
835 mm	32.87 in	11.1 kg	835 mm	32.87 in	11.1 kg
415 mm	16.34in	5.5 kg	415 mm	16.34in	5.5 kg
795 mm	31.29in	10.6 kg	795 mm	31.29in	10.0 kg
805 mm	3169 in	10.6 kg	805 mm	3169 in	10.0 kg
900 mm	35.43 in	11.0 kg	900 mm	35.43 in	11.8 kg



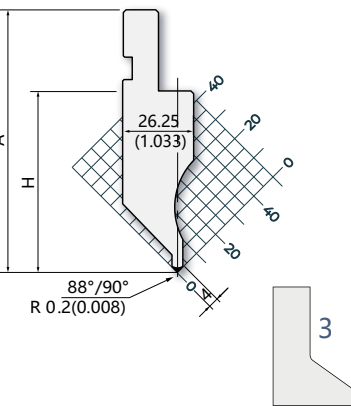
42Cr: 900-1150 N/mm ² 200 kN/m max.		
11700		
H=66.91 / A=96.91 / 88° [mm] (H=263 / A=3.81) [in]		
835 mm	32.87 in	10.7 kg
415 mm	16.34in	5.3 kg
795 mm	31.29in	10.3 kg
800 mm	31.50in	102 kg

42Cr: 900-1150 N/mm ² 200 kN/m max.		
11600		
H=66.90 / A=96.90 / 90° [mm] (H=263 / A=3.81) [in]		
835 mm	32.87 in	11.0 kg
415 mm	16.34in	5.5 kg
795 mm	31.29in	10.1 kg
800 mm	31.50in	110 kg



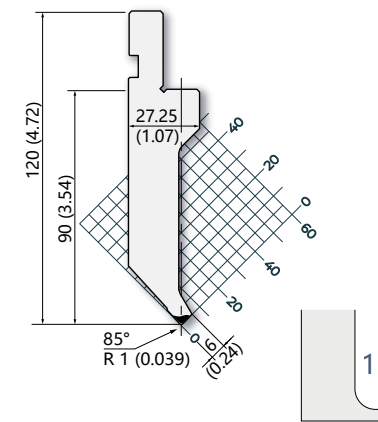
C45: 560-710 N/mm ² 600 kN/m max.		
P.97.60.R08		
R=0.8 (0.031)		
835 mm	32.87 in	9.0 kg
415 mm	16.34in	4.5 kg
795 mm	31.29in	9.0 kg
805 mm	3169 in	9.0 kg

C45: 560-710 N/mm ² 600 kN/m max.		
P.97.60.R2		
R=2.0 (0.079)		
835 mm	32.87 in	9.0 kg
415 mm	16.34in	5.0 kg
795 mm	31.29in	9.0 kg
805 mm	3169 in	9.0 kg

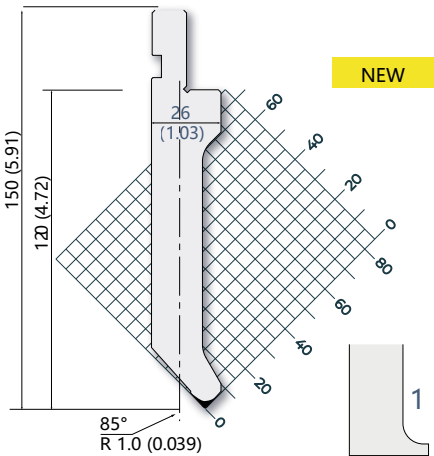


C45: 560-710 N/mm ² 1000 kN/m max.		
00480		
H=66.91 / A=96.91 / R=0.2 88° [mm] (H=263 / A=3.82 / R=0.008) [in]		
835 mm	32.87 in	11.0 kg
415 mm	16.34in	5.5 kg
795 mm	31.29in	10.5 kg
800 mm	31.50in	105 kg

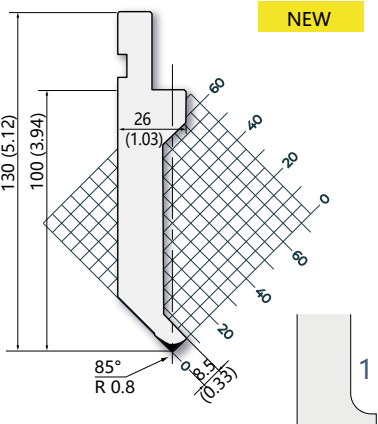
C45: 560-710 N/mm ² 400 kN/m max.		
01680		
H=66.91 / A=96.91 / 90° [mm] (H=263 / A=3.82 / R=0.008) [in]		
835 mm	32.87 in	10.7 kg
415 mm	16.34in	5.5 kg
795 mm	31.29in	10.2 kg
800 mm	31.50in	103 kg



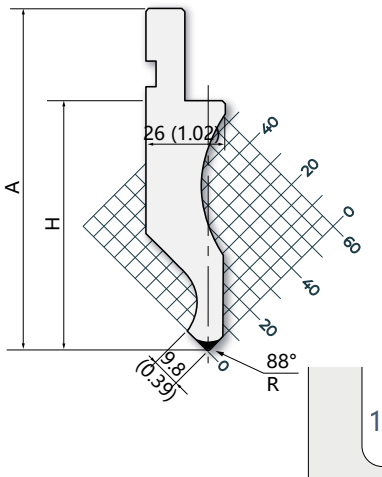
42Cr: 900-1150 N/mm ²		800 kN/m max.
P.120.85.R1		
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.7 kg
795 mm	31.29 in	12.9 kg FX
805 mm	31.69 in	13.0 kg F



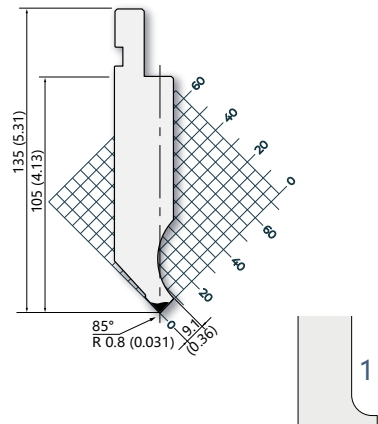
C45: 560-710 N/mm ²		700 kN/m max.
P.150.85.R1		
835 mm	32.87 in	17.5 kg
415 mm	16.34 in	8.7 kg
795 mm	31.29 in	16.6 kg FX
805 mm	31.69 in	16.9 kg F



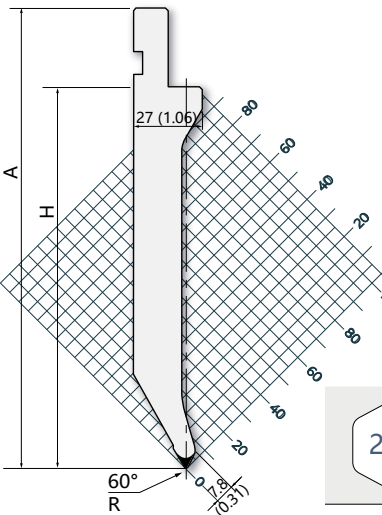
C45: 560-710 N/mm ²		700 kN/m max.
P.130.85.R08		
835 mm	32.87 in	13.7 kg
415 mm	16.34 in	6.8 kg
795 mm	31.29 in	13.0 kg FX
805 mm	31.69 in	13.2 kg F



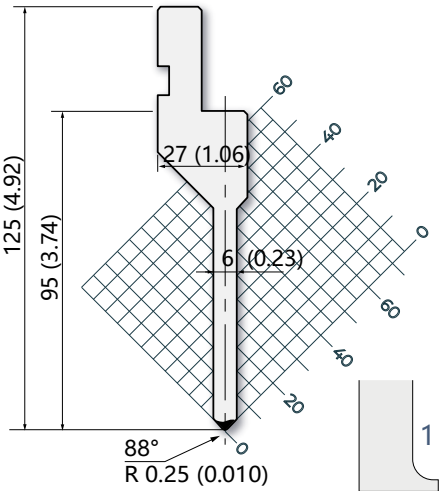
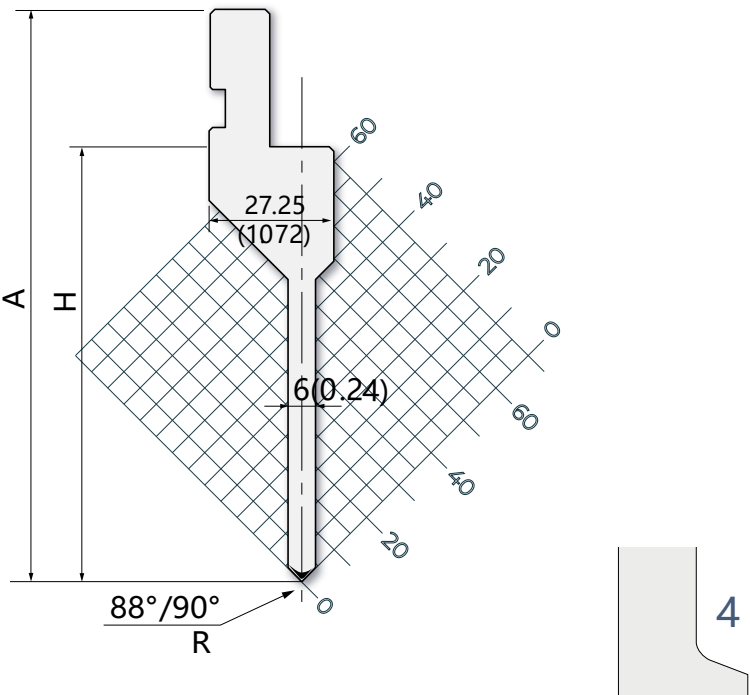
C45: 560-710 N/mm ²		500 kN/m max.	C45: 560-710 N/mm ²		500 kN/m max.
D.116.88.R08			D.116.88.R3		
H=86.00 / A=116.00 / R=0.8 [mm] (H=3.39 / A=4.57 / R=0.031) [in]			H=85.00 / A=115.00 / R=3.0 [mm] (H=3.35 / A=4.53 / R=0.118) [in]		
835 mm	32.87 in	11.9 kg	835 mm	32.87 in	11.9 kg
415 mm	16.34 in	5.8 kg	415 mm	16.34 in	5.9 kg
795 mm	31.29 in	11.9 kg FX	795 mm	31.29 in	11.5 kg FX
805 mm	31.69 in	11.9 kg F	805 mm	31.69 in	11.5 kg F



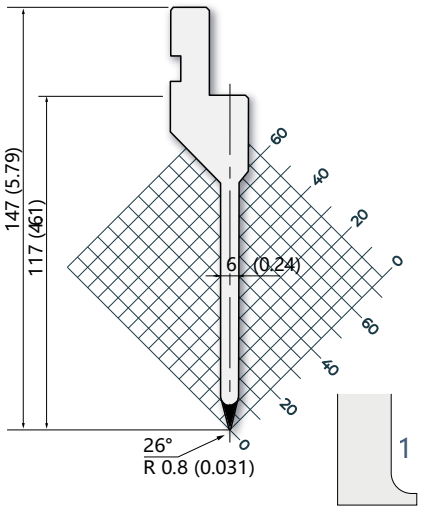
C45: 560-710 N/mm ²		1000 kN/m max.
PS.135.85.R08		
835 mm	32.87 in	17.7 kg
415 mm	16.34 in	8.5 kg
795 mm	31.29 in	16.0 kg FX
805 mm	31.69 in	16.0 kg F



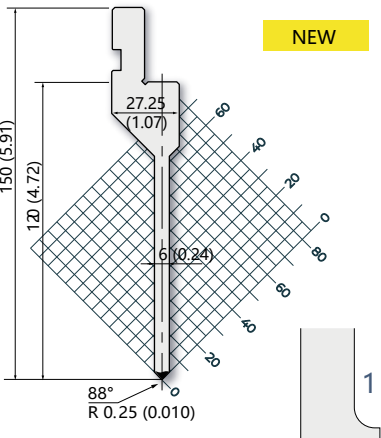
42Cr: 900-1150 N/mm ²		800 kN/m max.	42Cr: 900-1150 N/mm ²		800 kN/m max.
TOP.175.60.R08			TOP.175.60.R2		
H=145.00 / A=175.00 / R=0.8 [mm] (H=5.71 / A=6.89 / R=0.031) [in]			H=143.80 / A=173.80 / R=2.0 [mm] (H=5.66 / A=6.84 / R=0.079) [in]		
525 mm	20.67 in	12.0 kg	525 mm	20.67 in	12.0 kg
495 mm	19.49 in	11.3 kg FA	495 mm	19.49 in	12.0 kg FA
500 mm	19.68 in	11.4 kg FB	500 mm	19.68 in	11.0 kg FB



42Cr: 900-1150 N/mm ²			500 kN/m max.
P.125.88.R025			
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm	31.29 in	9.0 kg	FX
805 mm	3169 in	9.0 kg	F



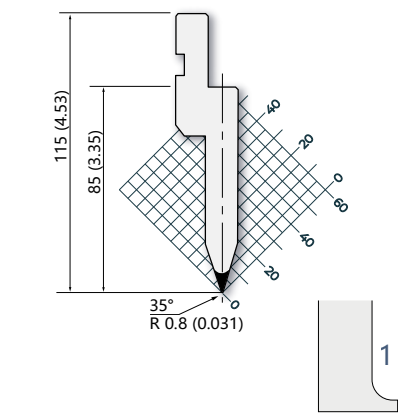
42Cr: 900-1150 N/mm ²			500 kN/m max.
P.147.26.R08			
835 mm	32.87 in	9.8 kg	
415 mm	16.34 in	4.9 kg	
795 mm	31.29 in	9.8 kg	FX
805 mm	3169 in	9.8 kg	F



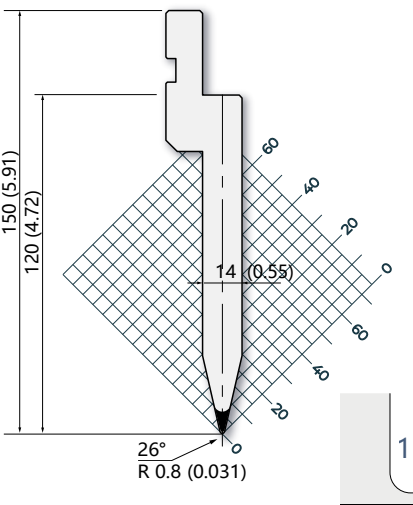
42Cr: 900-1150 N/mm ²			500 kN/m max.
AFH.150.88.R025			
900 mm	35.43 in	10.6 kg	
415 mm	16.34 in	5.3 kg	
795 mm	31.29 in	10.1 kg	FX
805 mm	3169 in	10.2 kg	F

Also available H=85

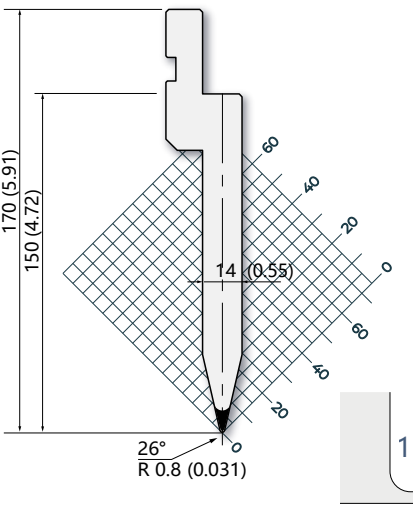
42Cr: 900-1150 N/mm ² 500 kN/m max.			42Cr: 900-1150 N/mm ² 500 kN/m max.			42Cr: 900-1150 N/mm ² 500 kN/m max.		
10900			10906			10800		
H=94.91 / A=124.91 / R=0.2 88° [mm] (H=374 / A=4.92 / R=0.008) [in]			H=94.74 / A=124.74 / R=0.6 / 88° [mm] (H=373 / A=4.91 / R=0.024) [in]			H=94.91 / A=124.91 / R=0.2 / 90° [mm] (H=374 / A=4.92 / R=0.008) [in]		
835 mm	32.87 in	9.0 kg	835 mm	32.87 in	9.0 kg	835 mm	32.87 in	11.0 kg
415 mm	16.34 in	4.5 kg	415 mm	16.34 in	4.5 kg	415 mm	16.34 in	5.5 kg
795 mm	31.29 in	8.5 kg	795 mm	31.29 in	8.5 kg	795 mm	31.29 in	8.5 kg
800 mm	31.50 in	8.6 kg	800 mm	31.50 in	8.6 kg	800 mm	31.50 in	8.6 kg



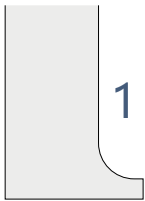
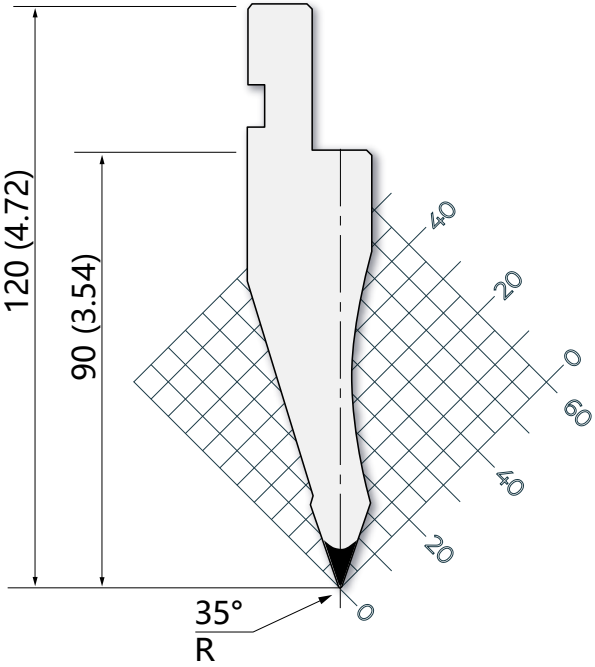
C45: 560-710 N/mm ²			1000 kN/m max.
PU.85.35.R08			
835 mm	32.87 in	11.0 kg	
415 mm	16.34 in	5.5 kg	
795 mm	31.29 in	10.5 kg	FX
805 mm	3169 in	10.5 kg	F



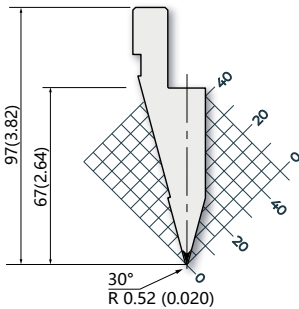
C45: 560-710 N/mm ²			1000 kN/m max.
PU.150.26.R08.L			
900 mm	35.43 in	15.0 kg	
415 mm	16.34 in	6.2 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	3169 in	12.0 kg	F



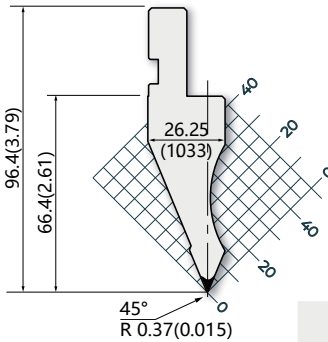
C45: 560-710 N/mm ²			1000 kN/m max.
PU.150.26.R08.L			
900 mm	35.43 in	15.0 kg	
415 mm	16.34 in	6.2 kg	
795 mm	31.29 in	12.0 kg	FX
805 mm	3169 in	12.0 kg	F



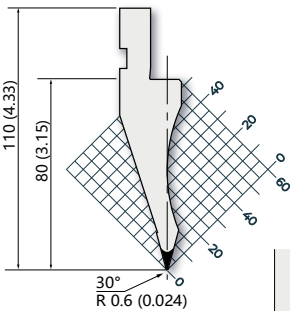
C45: 560-710 N/mm ² 700 kN/m max.			C45: 560-710 N/mm ² 700 kN/m max.			C45: 560-710 N/mm ² 700 kN/m max.		
P.120.35.R08			P.120.35.R15			P.120.35.R3		
R=0.8 (0.031)			R=1.5 (0.059)			R=3.0 (0.118)		
835 mm	32.87 in	12.3 kg	835 mm	32.87 in	12.5 kg	835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.1 kg	415 mm	16.34 in	6.0 kg	415 mm	16.34 in	6.4 kg
795 mm	31.29 in	11.5 kg FX	795 mm	31.29 in	12.0 kg FX	795 mm	31.29 in	12.0 kg FX
805 mm	31.69 in	11.5 kg F	805 mm	31.69 in	12.0 kg F	805 mm	31.69 in	12.0 kg F



42Cr: 900-1150 N/mm ² 1000 kN/m max.		
10300		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm	31.29 in	10.4 kg FX
800 mm	31.50 in	105 kg FC



C45: 560-710 N/mm ² 600 kN/m max.		
00800		
835 mm	32.87 in	9.3 kg
415 mm	16.34 in	4.6 kg
795 mm	31.29 in	9.3 kg FX
800 mm	31.50 in	9.3 kg FC



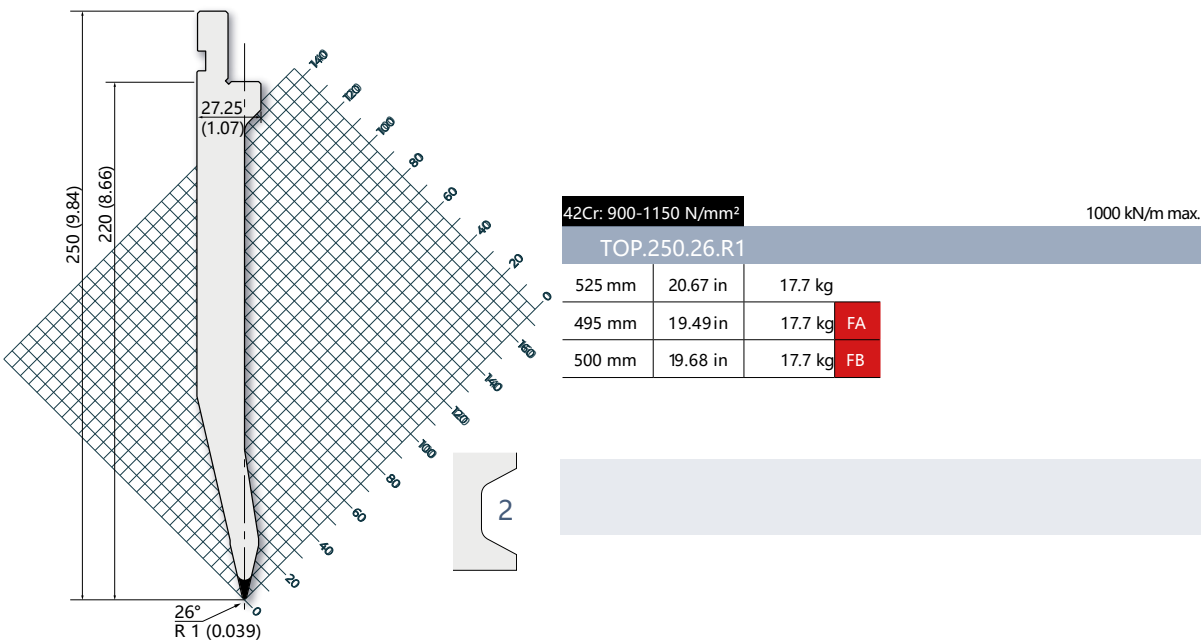
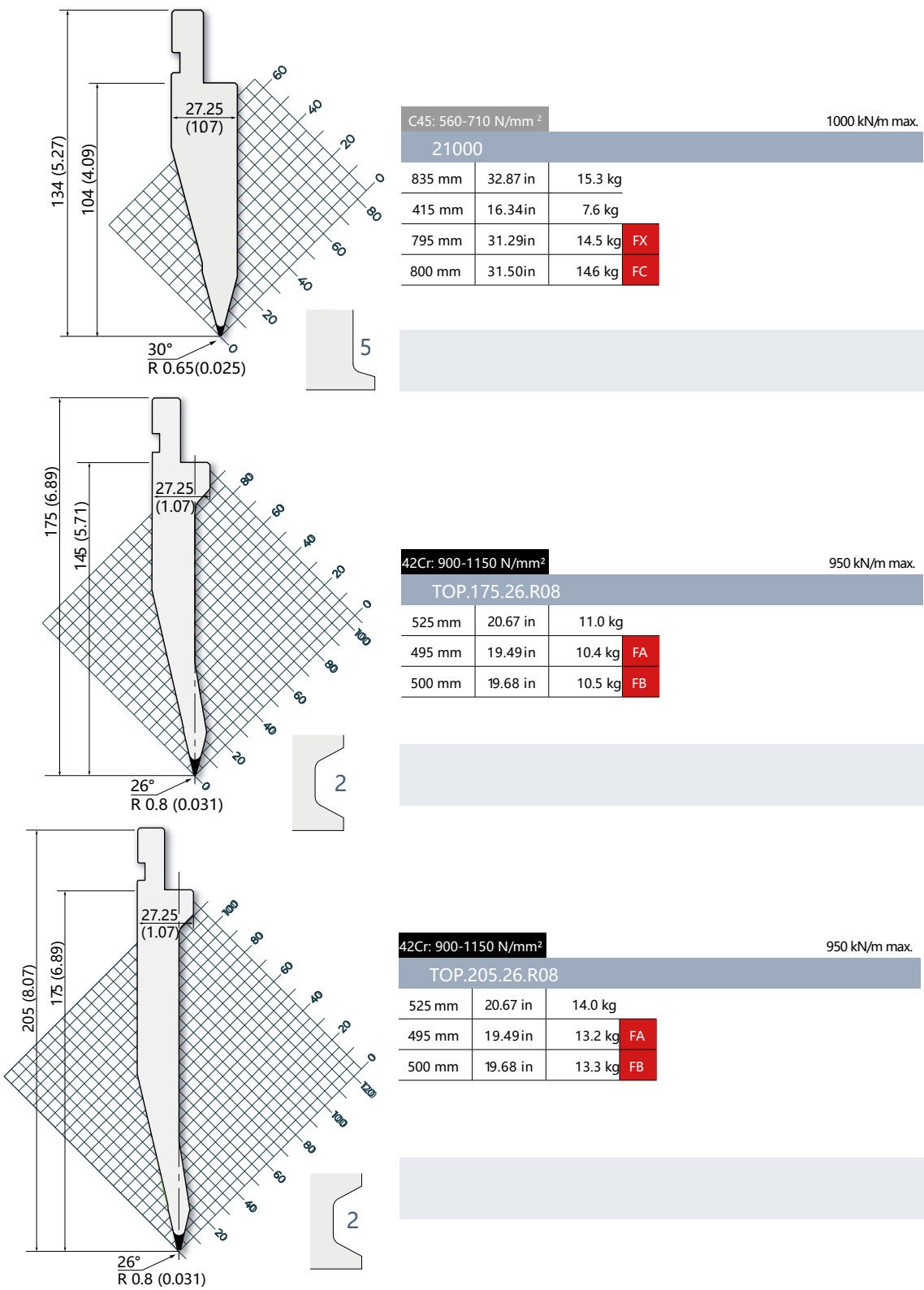
C45: 560-710 N/mm ² 500 kN/m max.		
P.110.30.R06		
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm	31.29 in	10.0 kg FX
805 mm	31.69 in	10.0 kg F

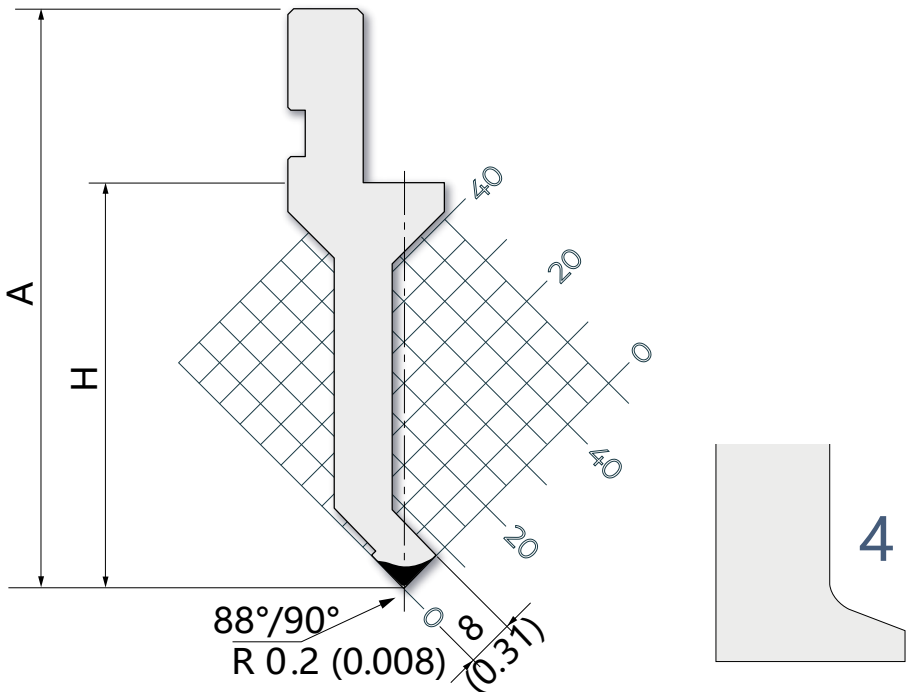


SEGMENTATION

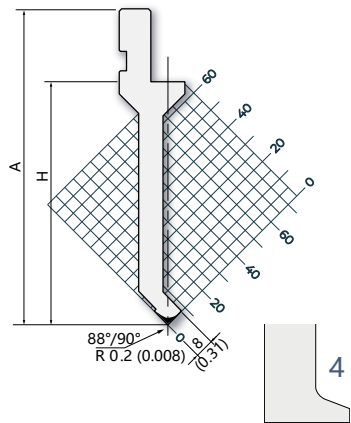


SEGMENTATION

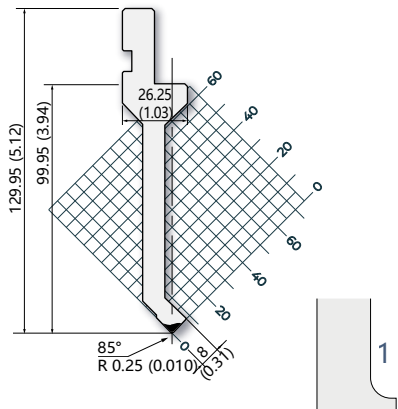




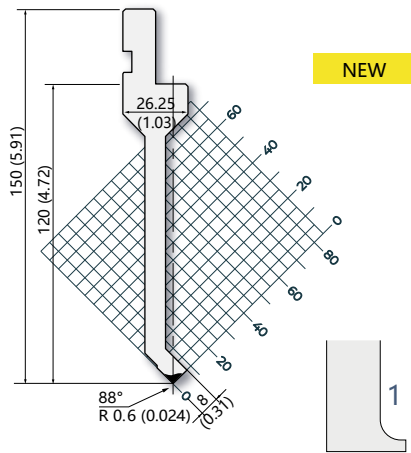
42Cr: 900-1150 N/mm ² 300 kN/m max.			42Cr: 900-1150 N/mm ² 300 kN/m max.		
20000			20100		
H=69.91 / A=99.91 / 88° [mm] (H=2.75 / A=3.93) [in]			H=69.91 / A=99.91 / 90° [mm] (H=2.75 / A=3.93) [in]		
835 mm	32.87 in	7.9 kg	835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg	415 mm	16.34 in	3.9 kg
795 mm	31.29 in	7.5 kg	795 mm	31.29 in	7.6 kg
800 mm	31.50 in	7.5 kg	800 mm	31.50 in	7.7 kg



42Cr: 900-1150 N/mm ² 300 kN/m max.			42Cr: 900-1150 N/mm ² 300 kN/m max.		
20200			20300		
H=99.91 / A=129.91 / 88° [mm] (H=3.93 / A=5.11) [in]			H=99.91 / A=129.91 / 90° [mm] (H=3.93 / A=5.11) [in]		
835 mm	32.87 in	10.0 kg	835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg	415 mm	16.34 in	5.0 kg
795 mm	31.29 in	9.5 kg	795 mm	31.29 in	9.5 kg
800 mm	31.50 in	9.6 kg	800 mm	31.50 in	9.6 kg

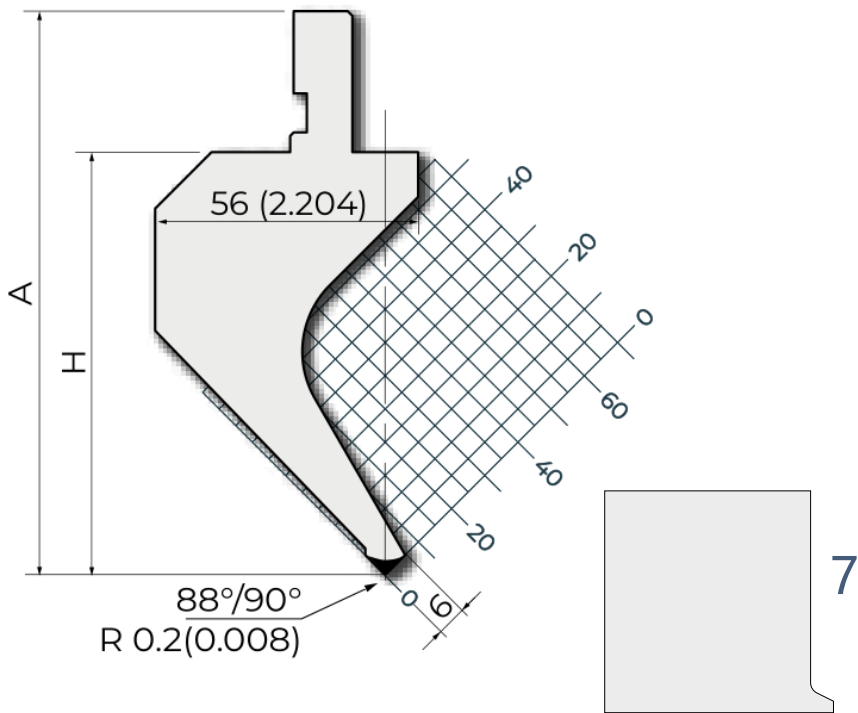


42Cr: 900-1150 N/mm ² 350 kN/m max.		
P.130.85.R025		
835 mm	32.87 in	11.5 kg
415 mm	16.34 in	5.7 kg
795 mm	31.29 in	10.9 kg
805 mm	31.69 in	11.1 kg



42Cr: 900-1150 N/mm ² 350 kN/m max.		
NEW AFH.150.88.R06		
900 mm	35.43 in	12.9 kg
415 mm	16.34 in	5.9 kg
795 mm	31.29 in	12.2 kg
805 mm	31.69 in	12.4 kg

Also available H=85



42Cr: 900-1150 N/mm² 500 kN/m max.

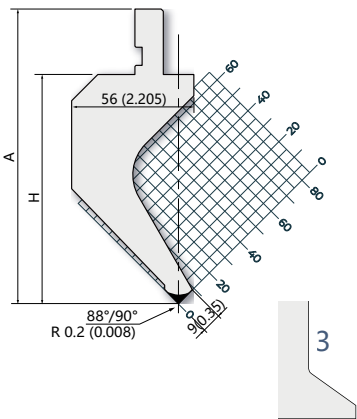
45302		
H=89.91 / A=119.91 / 88° [mm] (H=3.54 / A=472) [in]		

835 mm	32.87 in	18.6 kg
415 mm	16.34 in	9.3 kg
795 mm	31.29 in	17.7 kg FX
800 mm	31.50 in	179 kg FC

42Cr: 900-1150 N/mm² 500 kN/m max.

46300		
H=89.91 / A=119.91 / 88° [mm] (H=3.54 / A=472) [in]		

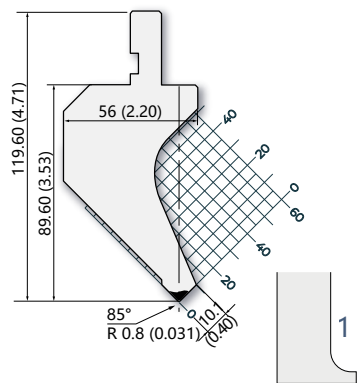
835 mm	32.87 in	18.6 kg
415 mm	16.34 in	9.3 kg
795 mm	31.29 in	17.7 kg FX
800 mm	31.50 in	179 kg FC



42Cr: 900-1150 N/mm² 500 kN/m max.

04502		
H=104.91 / A=134.91 / 88° [mm] (H=4.13 / A=5.31) [in]		

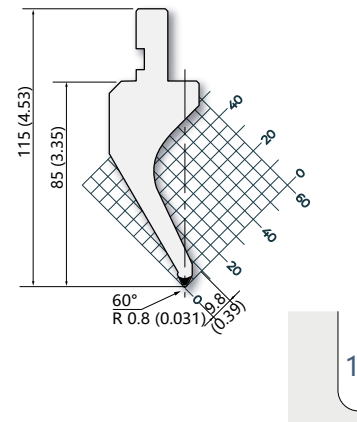
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.9 kg
795 mm	31.29 in	22.0 kg FX
800 mm	31.50 in	22.0 kg FC



C45: 560-710 N/mm² 600 kN/m max.

PK.120.85.R08		
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835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.5 kg
795 mm	31.29 in	21.0 kg FX
805 mm	31.69 in	21.0 kg F



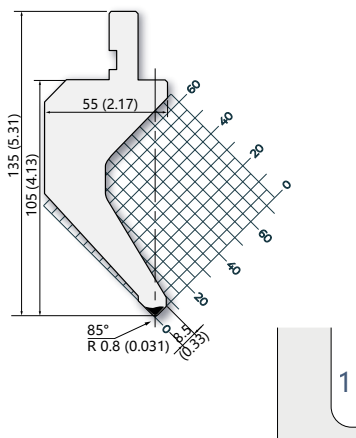
42Cr: 900-1150 N/mm² 400 kN/m max.

P.115.60.R08		
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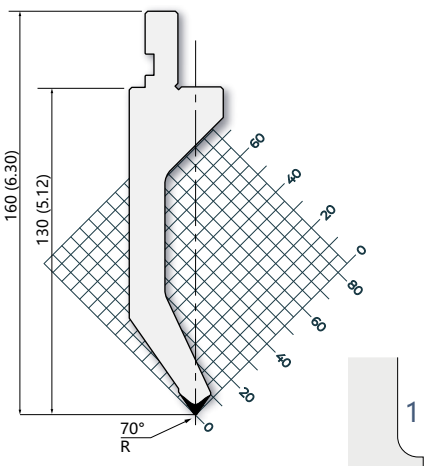
835 mm	32.87 in	11.9 kg
415 mm	16.34 in	5.9 kg
795 mm	31.29 in	10.7 kg FX
805 mm	31.69 in	10.7 kg F



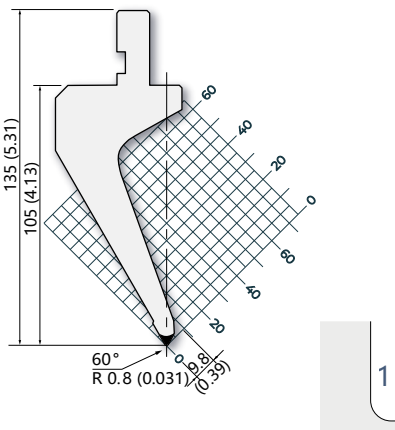
SEGMENTATION



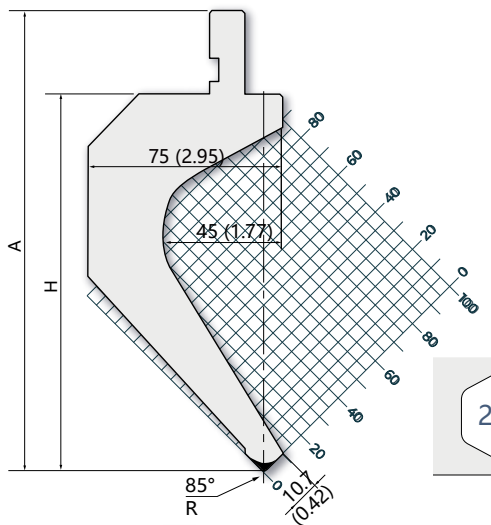
42Cr: 900-1150 N/mm ²			800 kN/m max.
P.135.85.R08			
835 mm	32.87 in	20.9 kg	
415 mm	16.34 in	10.4 kg	
795 mm	31.29 in	19.2 kg	FX
805 mm	31.69 in	19.2 kg	F



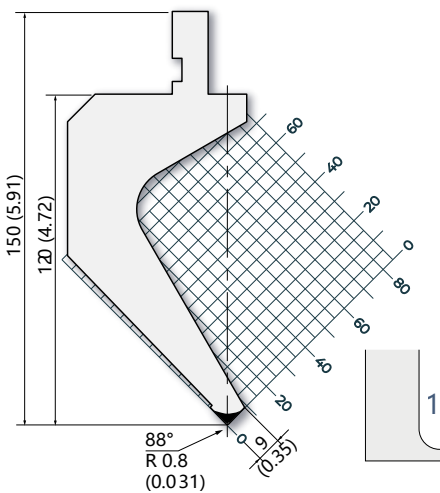
42Cr: 900-1150 N/mm ²			450 kN/m max.	42Cr: 900-1150 N/mm ²			450 kN/m max.
P.160.70.R08				P.160.70.R3			
R=0.8 (0.031)				R=3.0 (0.118)			
835 mm	32.87 in	18.0 kg		835 mm	32.87 in	18.0 kg	
415 mm	16.34 in	8.9 kg		415 mm	16.34 in	8.9 kg	
795 mm	31.29 in	17.3 kg	FX	795 mm	31.29 in	17.3 kg	FX
805 mm	31.69 in	17.3 kg	F	805 mm	31.69 in	17.3 kg	F



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



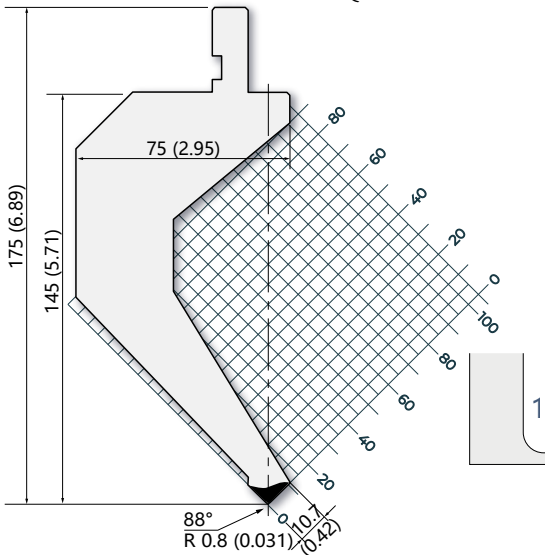
42Cr: 900-1150 N/mm ²			900 kN/m max.	42Cr: 900-1150 N/mm ²			900 kN/m max.
TOP.175.85.R08				TOP.175.85.R2			
H=145.00 / A=175.00 / R=0.8 [mm] (H=571 / A=6.89 / R=0.031) [in]				H=144.30 / A=174.30 / R=2.0 [mm] (H=571 / A=6.89 / R=0.031) [in]			
525 mm	20.67 in	20.9 kg		525 mm	20.67 in	20.9 kg	
495 mm	19.49 in	19.7 kg	FA	495 mm	19.49 in	19.7 kg	FA
500 mm	19.68 in	19.9 kg	FB	500 mm	19.68 in	19.9 kg	FB



42Cr: 900-1150 N/mm ²			500 kN/m max.
AFH.150.88.R08			
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm	31.29 in	20.5 kg	FX
800 mm	31.50 in	20.5 kg	FC

NEW

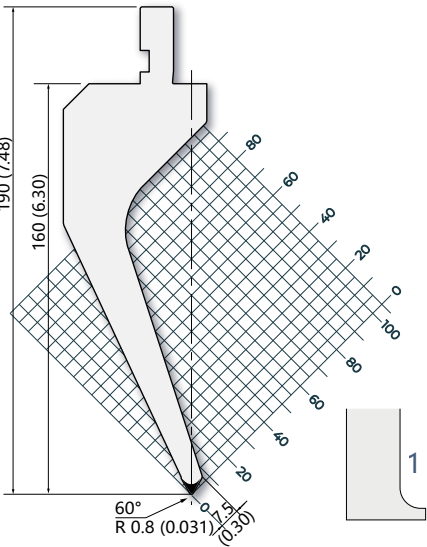
Also available H=85



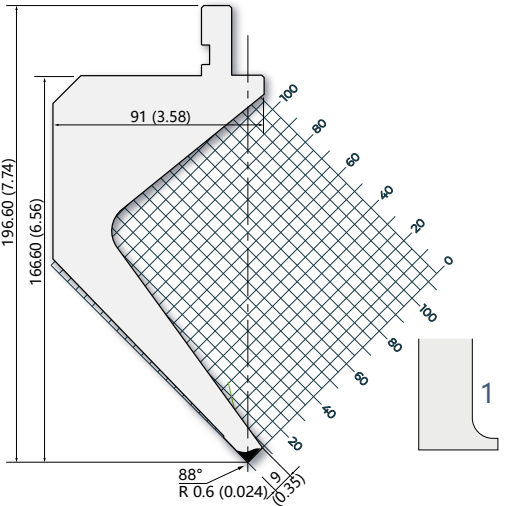
C45: 560-710 N/mm ²			500 kN/m max.
P.175.88.R08			
835 mm	32.87 in	35.0 kg	
415 mm	16.34 in	17.5 kg	
795 mm	31.29 in	39.0 kg	FX
805 mm	31.69 in	39.0 kg	F



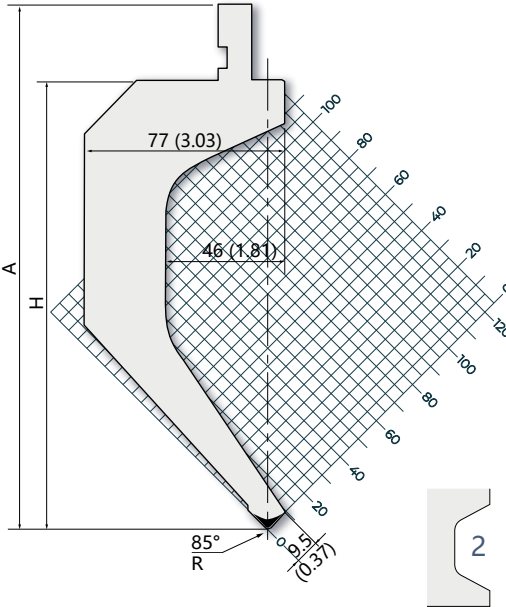
SEGMENTATION



C45: 560-710 N/mm ²			400 kN/m max.
P.190.60.R08			
835 mm	32.87 in	27.0 kg	
415 mm	16.34 in	13.5 kg	
795 mm	31.29 in	26.0 kg	FX
805 mm	31.69 in	26.1 kg	F

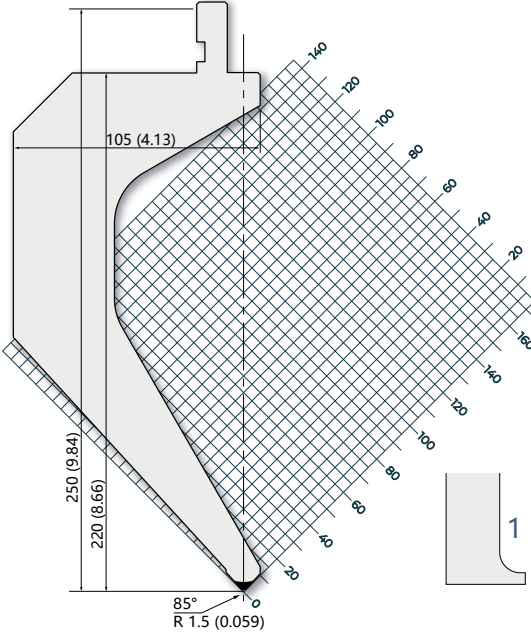


C45: 560-710 N/mm ²			300 kN/m max.
P.196.88.R06			
835 mm	32.87 in	41.8 kg	
415 mm	16.34 in	20.8 kg	
795 mm	31.29 in	40.2 kg	FX
805 mm	31.69 in	40.2 kg	F
900 mm	35.43 in	45.0 kg	



42Cr: 900-1150 N/mm ²			700 kN/m max.	42Cr: 900-1150 N/mm ²			700 kN/m max.
TOP.205.85.R08				TOP.205.85.R2			
H=175.00 / A=205.00 / R=0.8 [mm] (H=6.89 / A=8.07 / R=0.031) [in]				H=174.30 / A=204.30 / R=2.0 [mm] (H=6.86 / A=8.04 / R=0.079) [in]			
525 mm	20.67 in	24.0 kg		525 mm	20.67 in	24.0 kg	
495 mm	19.49 in	22.6 kg	FA	495 mm	19.49 in	22.6 kg	FA
500 mm	19.68 in	22.9 kg	FB	500 mm	19.68 in	22.9 kg	FB

SEGMENTATION

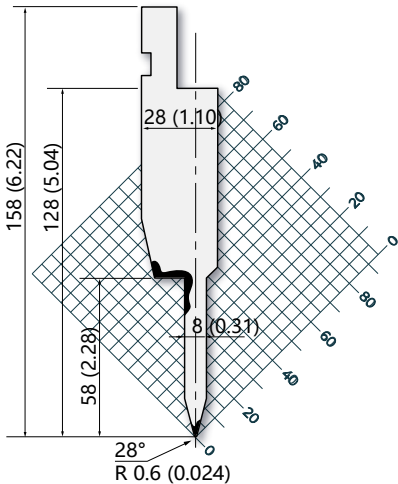


42Cr: 900-1150 N/mm ²			850 kN/m max.
P.250.85.R15			
415 mm	16.34 in	33.1 kg	
795 mm	31.29 in	63.3 kg	FX

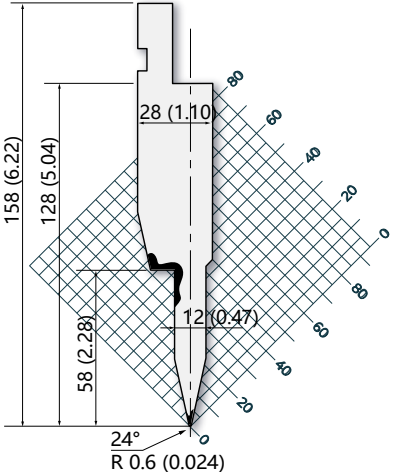


SEGMENTATION

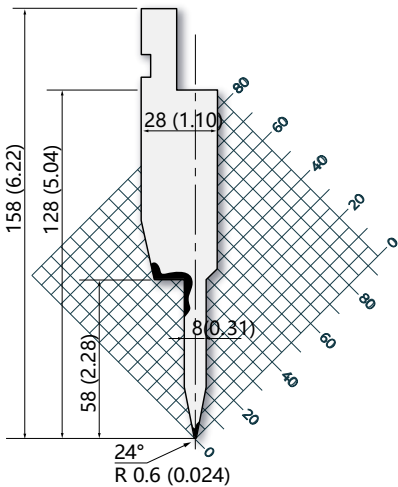
Hemming Punch:



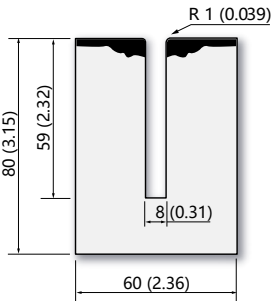
42Cr: 900-1150 N/mm ²			800 kN/m max. - 1000 kN/m max.	
TOP.SP.134.28.8				
525 mm	20.67 in	11.0 kg	To use with: TOP.SM-134.28.8 (Page 81)	
495 mm	19.49 in	10.3 kg		



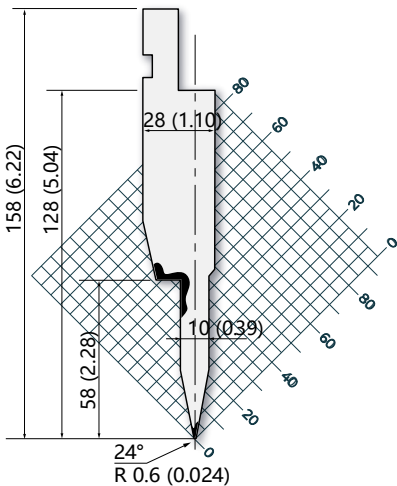
42Cr: 900-1150 N/mm ²			800 kN/m max. - 1000 kN/m max.	
TOP.SP.134.24.12				
525 mm	20.67 in	11.6 kg	To use with: TOP.SM-B4.24.12 (Page 81)	
495 mm	19.49 in	11.0 kg		



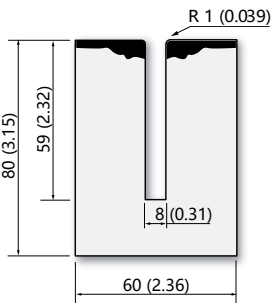
42Cr: 900-1150 N/mm ²			800 kN/m max. - 1000 kN/m max.	
TOP.SP.134.24.8				
525 mm	20.67 in	11.0 kg	To use with: TOP.SM-B4.24.8 (Page 81)	
495 mm	19.49 in	10.3 kg		



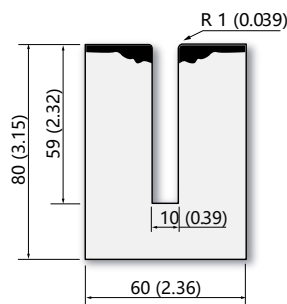
42Cr: 900-1150 N/mm²			500 kN/m max. - 1000 kN/m max.	
TOP.SM-134.28.8				
525 mm	20.67 in	17.5 kg	To use with: TOP.SP-134.28.8 (pag. 15)	
495 mm	19.49 in	16.5 kg		



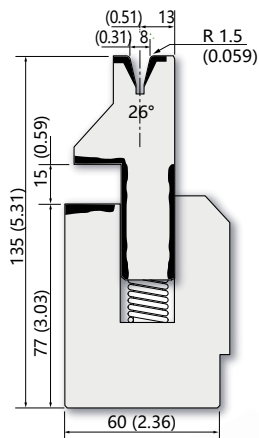
42Cr: 900-1150 N/mm²			800 kN/m max. - 1000 kN/m max.	
TOP.SP.134.24.10				
525 mm	20.67 in	11.0 kg	To use with: TOP.SM-B4.24.10 (Page 81)	
495 mm	19.49 in	10.3 kg		



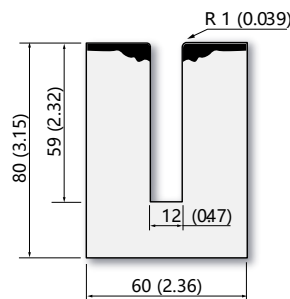
42Cr: 900-1150 N/mm ²			500 kN/m max. - 1000 kN/m max.	
TOP.SM-134.24.8				
525 mm	20.67 in	16.5 kg	To use with: TOP.SP-134.24.8 (page 15)	
495 mm	19.49 in	16.5 kg		



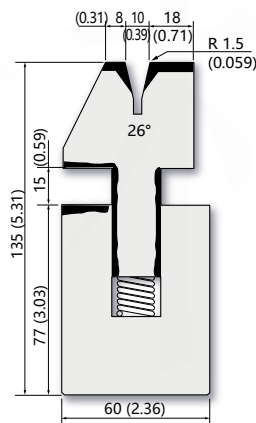
42Cr: 900-1150 N/mm ²			500 kN/m max. - 1000 kN/m max.		
TOP.SM-134.24.10					
525 mm	20.67 in	18.0 kg	To use with: TOP.SP-134.24.10 (page 15)		
495 mm	19.49 in	16.9 kg			



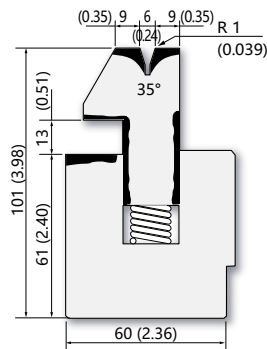
42Cr: 900-1150 N/mm²			400 kN/m max.		
S135.26.08					
835 mm	32.87 in	39.8 kg			
415 mm	16.34 in	21.0 kg			



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



C45: 560-710 N/mm ²			1000 kN/m max
S135.26.10			
835 mm	32.87 in	41.5 kg	
415mm	16.34 in	20.7 kg	



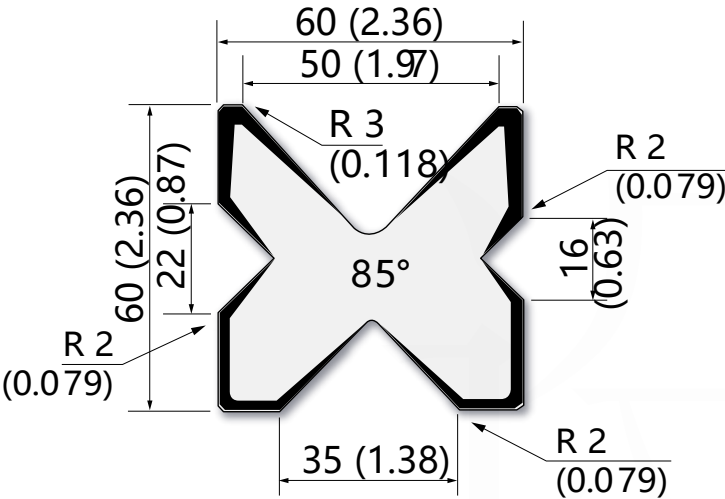
C45: 560-710 N/mm ²			600 kN/m max.		
S101.35.06					
835 mm	32.87 in	30.0 kg			
415 mm	16.34 in	15.4 kg			



SEGMENTATION



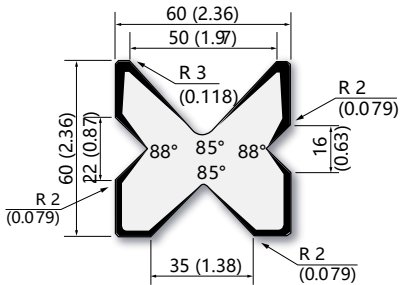
SEGMENTATION



C45: 560-710 N/mm² 800 kN/m max.

M.460.R

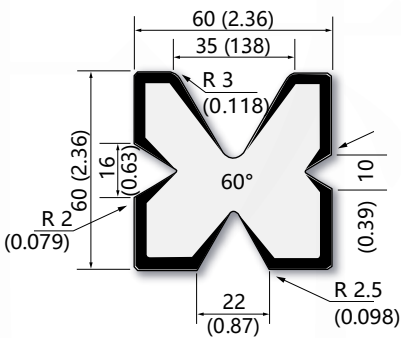
835 mm	32.87 in	15.7kg
415mm	16.34 in	7.7 kg
795 mm	31.29 in	15.1kg FX
805 mm	31.69 in	15.1kg F



C45: 560-710 N/mm² 800 kN/m max.

M.460

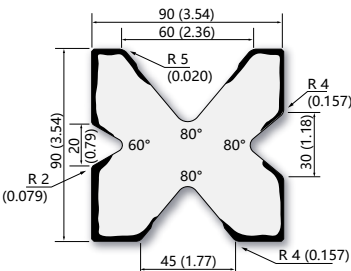
835 mm	32.87 in	15.7kg
415mm	16.34 in	7.7 kg
795 mm	31.29 in	15.5kg FX
805 mm	31.69 in	15.5kg F



C45: 560-710 N/mm² 600 kN/m max.

M.460.60

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



C45: 560-710 N/mm² 1000 kN/m max.

M.490

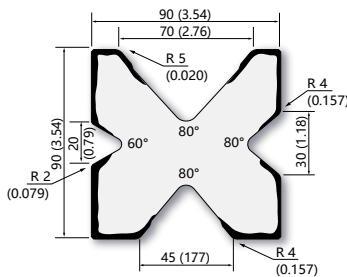
835 mm	32.87 in	38.9 kg
415mm	16.34 in	20.0 kg
795 mm	31.29 in	39.0 kg FX
805 mm	31.69 in	39.0 kg F



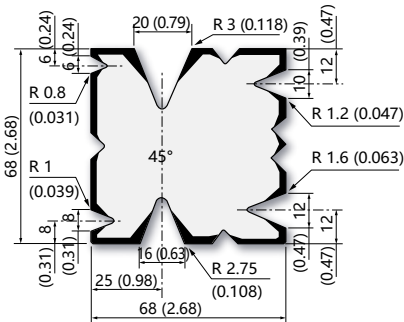
SEGMENTATION



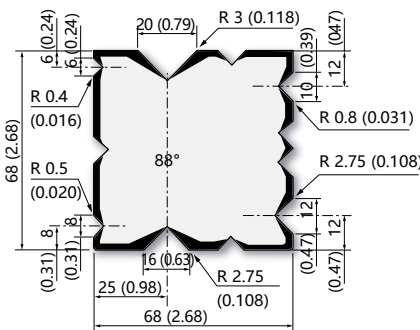
SEGMENTATION



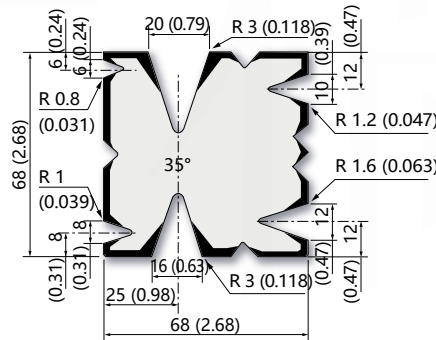
C45: 560-710 N/mm ²			600 kN/m max.		
M.490.70					
835 mm	32.87 in	35.8 kg			
415 mm	16.34 in	17.9 kg			
795 mm	31.29 in	36.0 kg	FX		
805 mm	31.69 in	36.0 kg	F		



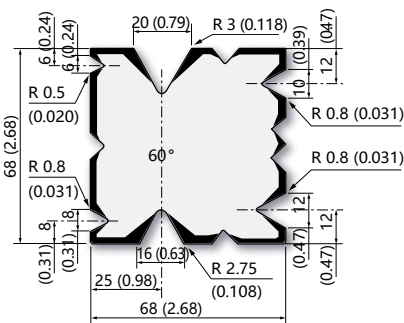
42Cr: 900-1150 N/mm ²			See table						
T70-45									
525 mm	20.67 in	16.1kg	V [mm]	6	8	10	12	16	20
495 mm	19.49 in	15.2kg	V [in]	0.24	0.31	0.39	0.47	0.63	0.79
			kN/m _{max}	400	400	500	500	700	700



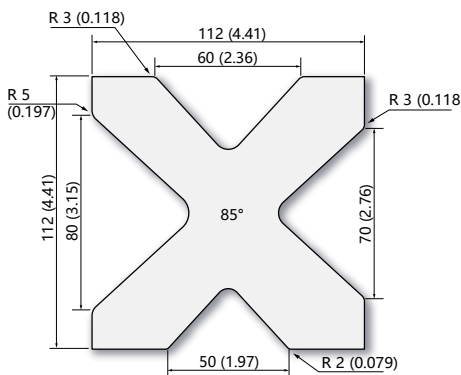
42Cr: 900-1150 N/mm²			1000 kN/m max.		
T70-88					
525 mm	20.67 in	17.5kg			
495 mm	19.49 in	16.5kg			



42Cr: 900-1150 N/mm ²			See table						
T70-35									
525 mm	20.67 in	15.3kg	V [mm]	6	8	10	12	16	20
495 mm	19.49 in	14.4 kg	V [in]	0.24	0.31	0.39	0.47	0.63	0.79
			kN/m _{max}	300	350	450	450	500	500

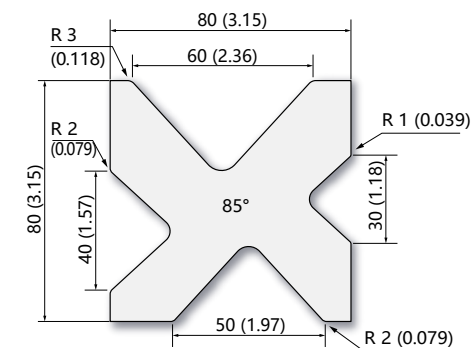


42Cr: 900-1150 N/mm ²			See table						
T70-60									
525 mm	20.67 in	16.8 kg	V [mm]	6	8	10	12	16	20
495 mm	19.49 in	15.8 kg	V [in]	0.24	0.31	0.39	0.47	0.63	0.79
			kN/m max.	600	600	600	600	800	800



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

C45: 560-710 N/mm ²		
MC112.3050		
3050 mm	120.08 in	188.0 kg



Technical drawing of the MC80.2050 / MC80.3050 profile. Dimensions include: overall width 80 (3.15), inner width 60 (2.36), height 80 (3.15), inner height 40 (1.57), and various radii R 1 (0.039), R 2 (0.079), and R 3 (0.118). The angle is 85°.

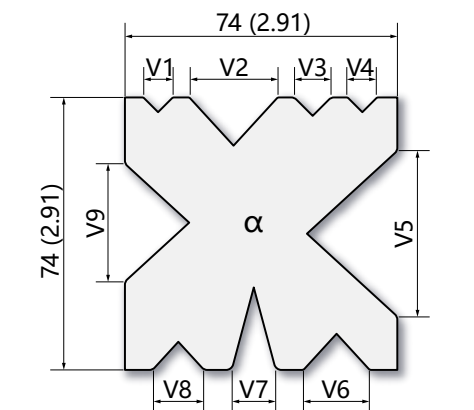
See table

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

C45: 560-710 N/mm²

MC80.2050 / MC80.3050

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



Technical drawing of the MC74.2050 / MC74.3050 profile. Dimensions include: overall width 74 (2.91), height 74 (2.91), and various radii R 1 (0.039), R 2 (0.079), and R 3 (0.118). The angle is 85°.

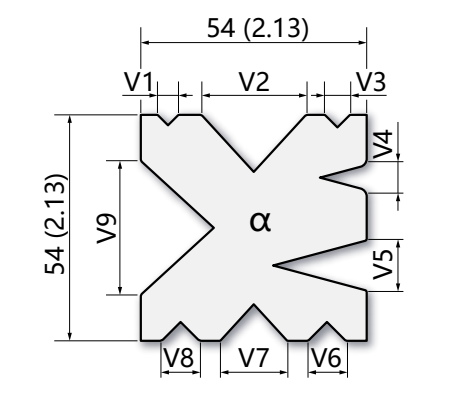
See table

C45: 560-710 N/mm²

MC74.2050 / MC74.3050

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

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



Technical drawing of the MC54.2050 / MC54.3050 profile. Dimensions include: overall width 54 (2.13), height 54 (2.13), and various radii R 1 (0.039), R 2 (0.079), and R 3 (0.118). The angle is 85°.

See table

C45: 560-710 N/mm²

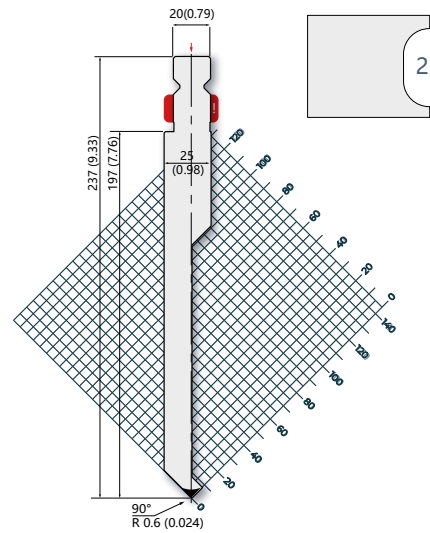
MC54.2050 / MC54.3050

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

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



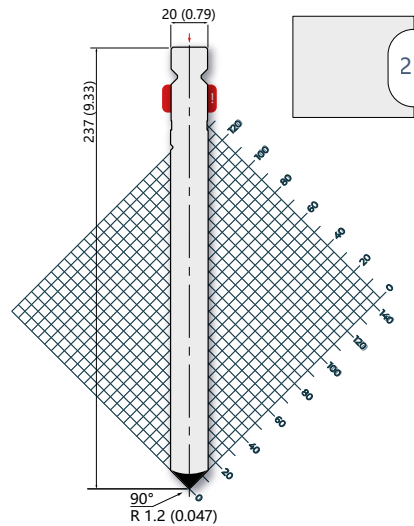
SEGMENTATION



42Cr: 900-1150 N/mm² 600 kN/m max.

TPR237.90.R06

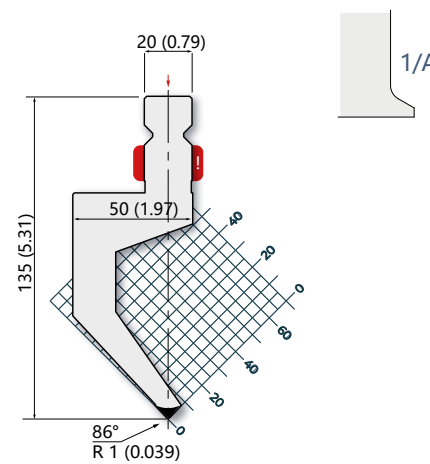
100 mm	3.93 in	3.4 kg
250 mm	9.84 in	8.5 kg
515 mm	20.82 in	17.5 kg
550 mm	21.65 in	18.7 kg FW



42Cr: 900-1150 N/mm² 1000 kN/m max.

TPR237.90.R12

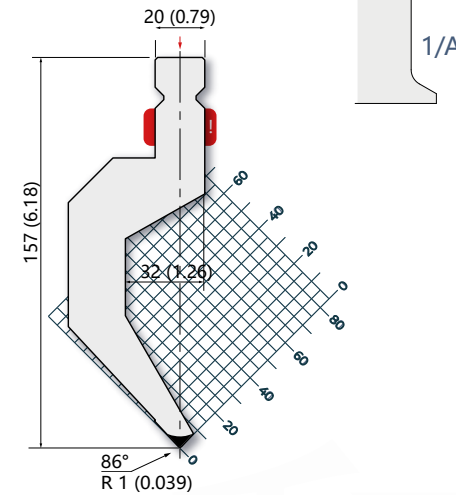
100 mm	3.93 in	3.7 kg
250 mm	9.84 in	9.2 kg
515 mm	20.82 in	19.0 kg
550 mm	21.65 in	20.3 kg FW



42Cr: 900-1150 N/mm² 650 kN/m max.

TPR135.86.R1

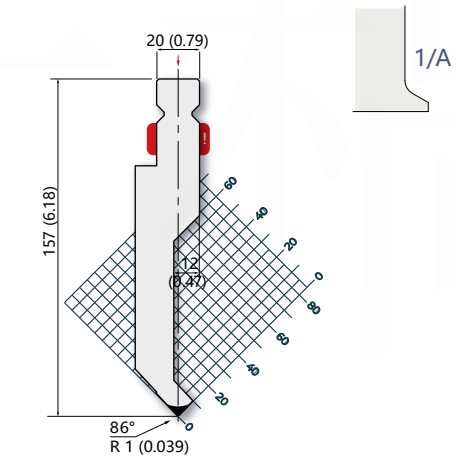
100 mm	3.93 in	2.4 kg
250 mm	9.84 in	6.0 kg
515 mm	20.82 in	12.3 kg
550 mm	21.65 in	13.1 kg FW



42Cr: 900-1150 N/mm² 800 kN/m max.

TPR157.86.R1

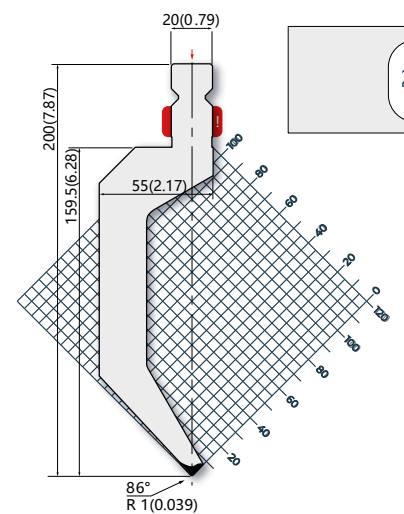
100 mm	3.93 in	3.0 kg
500 mm	19.68 in	14.0 kg
250 mm	9.84 in	7.5 kg FC
550 mm	21.65 in	15.0 kg FW



42Cr: 900-1150 N/mm² 800 kN/m max.

TPR157.86.R1-A

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



42Cr: 900-1150 N/mm² 500 kN/m max.

TPR200.86.R1

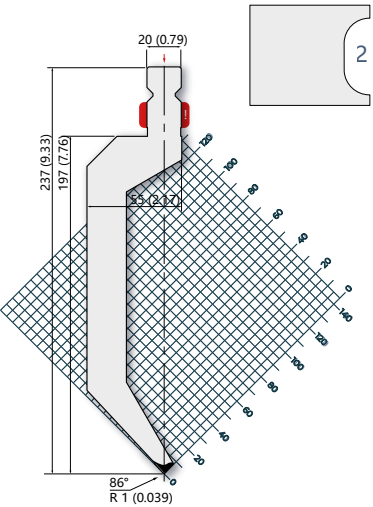
100 mm	3.93 in	3.7 kg
250 mm	9.84 in	6.1 kg
515 mm	20.82 in	19.1 kg
550 mm	21.65 in	20.4 kg FW



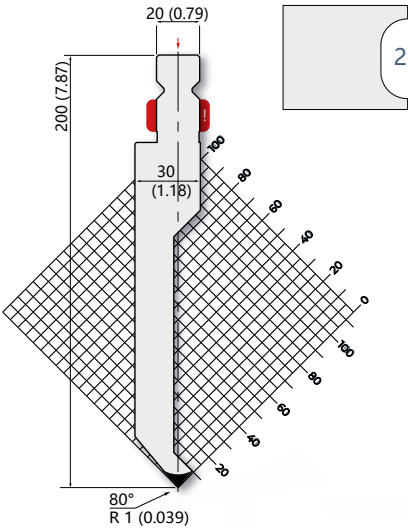
SEGMENTATION



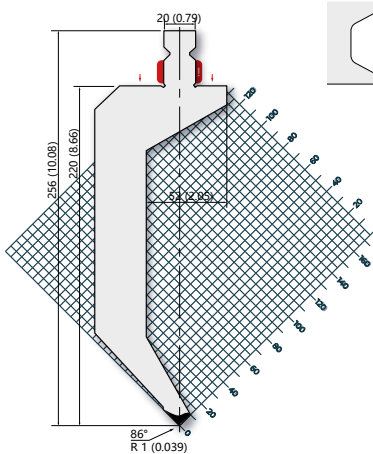
SEGMENTATION



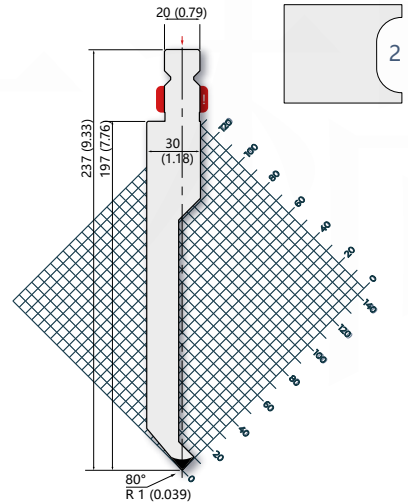
42Cr: 900-1150 N/mm ²			500 kN/m max.
TPR237.86.R1			
100 mm	3.93 in	4.5 kg	
250 mm	9.84 in	11.2 kg	
515 mm	20.82 in	23.0 kg	
550 mm	21.65 in	24.6 kg	FW



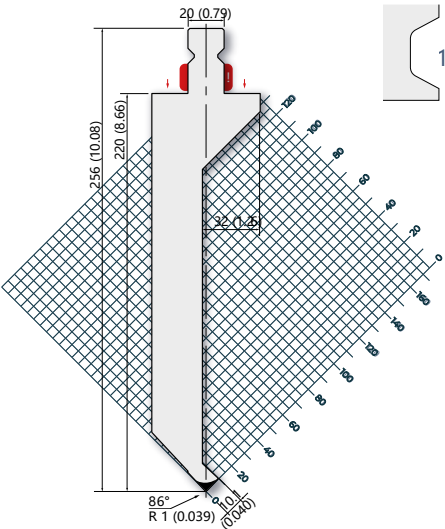
42Cr: 900-1150 N/mm ²			800 kN/m max.
TPR200.80.R1			
100 mm	3.93 in	3.7 kg	
250 mm	9.84 in	9.2 kg	
515 mm	20.82 in	19.0 kg	
550 mm	21.65 in	21.0 kg	FW



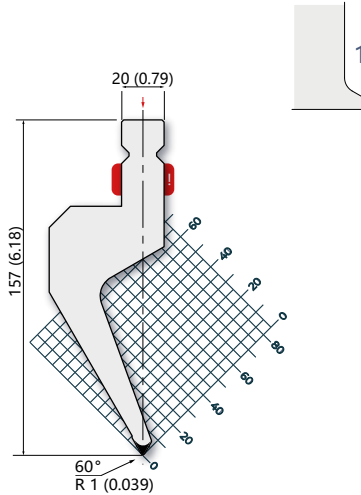
42Cr: 900-1150 N/mm ²			800 kN/m max.
TPR256.86.R1			
100 mm	3.93 in	6.5 kg	
500 mm	19.68 in	33.0 kg	
250 mm	9.84 in	16.5 kg	FC
550 mm	21.65 in	33.0 kg	FW



42Cr: 900-1150 N/mm ²			800 kN/m max.
TPR237.80.R1			
100 mm	3.93 in	3.8 kg	
250 mm	9.84 in	9.6 kg	
515 mm	20.82 in	19.7 kg	
550 mm	21.65 in	21.0 kg	FW



42Cr: 900-1150 N/mm ²			800 kN/m max.
TPR256.86.R1-A			
100 mm	3.93 in	4.7 kg	
500 mm	19.68 in	28.5 kg	
250 mm	9.84 in	12.5 kg	FC
550 mm	21.65 in	28.5 kg	FW

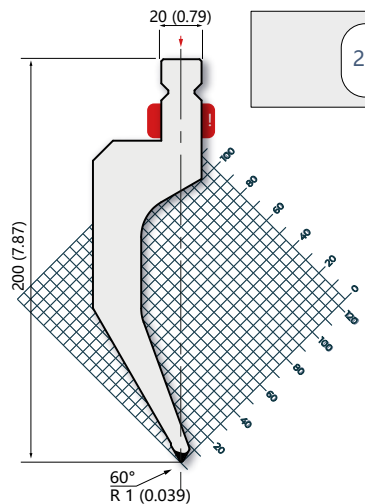


42Cr: 900-1150 N/mm ²			700 kN/m max.
TPR157.60.R1			
100 mm	3.93 in	3.0 kg	
500 mm	19.68 in	15.0 kg	
250 mm	9.84 in	7.5 kg	FC
550 mm	21.65 in	16.5 kg	FW



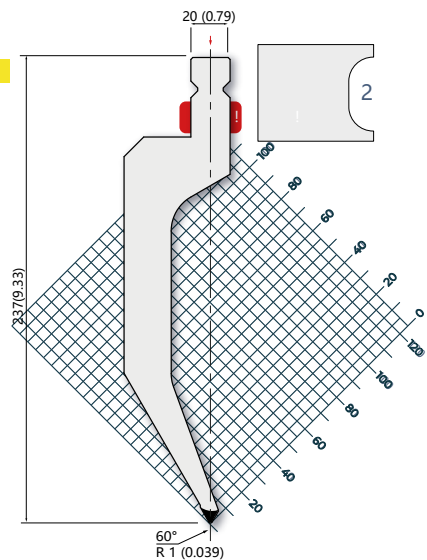
SEGMENTATION

NEW

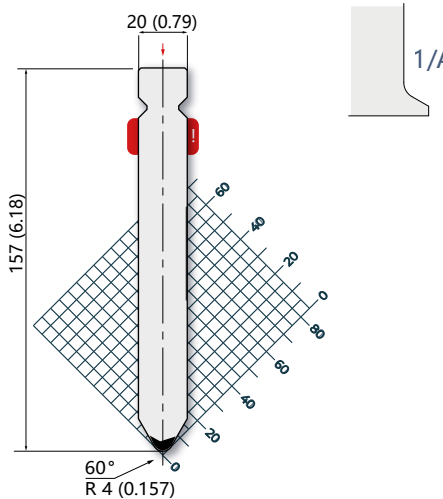


42Cr: 900-1150 N/mm ²			700 kN/m max.
TPR200.60.R1			
100 mm	3.93 in	3.7 kg	
500 mm	19.68 in	18.3 kg	
250 mm	9.84 in	9.2 kg	FC
550 mm	21.65 in	20.2 kg	FW

NEW

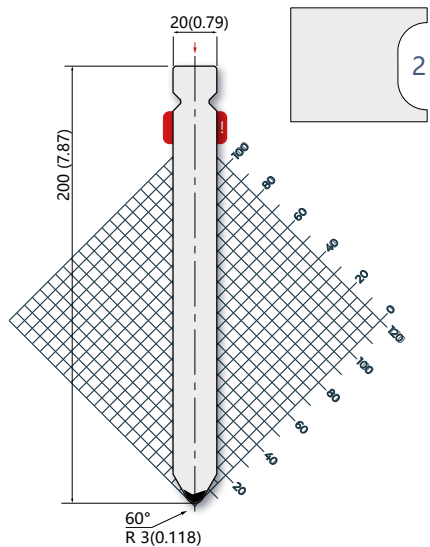


42Cr: 900-1150 N/mm ²			700 kN/m max.
TPR237.60.R1			
100 mm	3.93 in	4.3 kg	
500 mm	19.68 in	21.6 kg	
250 mm	9.84 in	10.8 kg	FC
550 mm	21.65 in	23.8 kg	FW

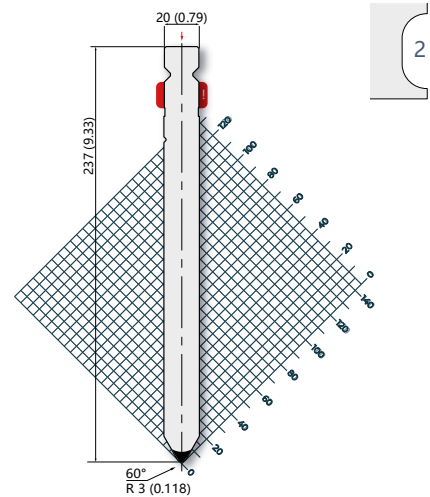


42Cr: 900-1150 N/mm ²			1300 kN/m max.
TPR157.60.R4			
100 mm	3.93 in	2.4 kg	
500 mm	19.68 in	12.0 kg	
250 mm	9.84 in	6.0 kg	FC
550 mm	21.65 in	12.0 kg	FW

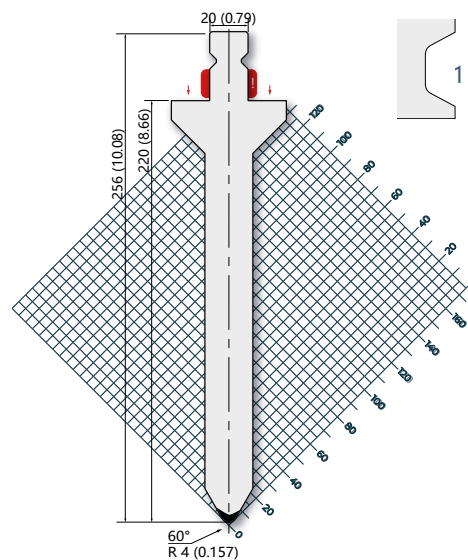
SEGMENTATION



42Cr: 900-1150 N/mm ²			1300 kN/m max.
TPR200.60.R3			
100 mm	3.93 in	3.0 kg	
250 mm	9.84 in	7.6 kg	
515 mm	20.82 in	15.6 kg	
550 mm	21.65 in	16.7 kg	FW



42Cr: 900-1150 N/mm ²			1300 kN/m max.
TPR237.60.R3			
100 mm	3.93 in	3.6 kg	
250 mm	9.84 in	9.1 kg	
515 mm	20.82 in	18.8 kg	
550 mm	21.65 in	20.1 kg	FW



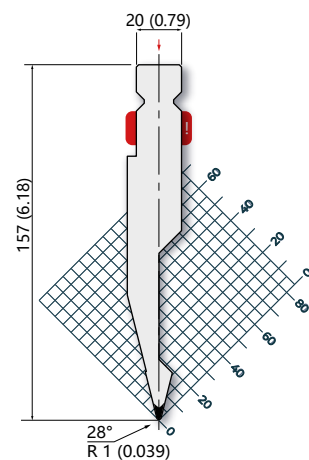
42Cr: 900-1150 N/mm ²			1300 kN/m max.
TPR256.60.R4			
100 mm	3.93 in	5.2 kg	
500 mm	19.68 in	26.1 kg	
250 mm	9.84 in	13.5 kg	FC
550 mm	21.65 in	27.0 kg	FW



SEGMENTATION

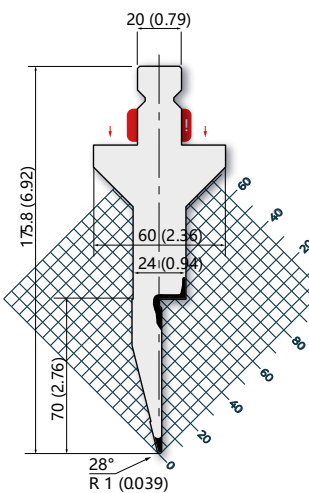


SEGMENTATION



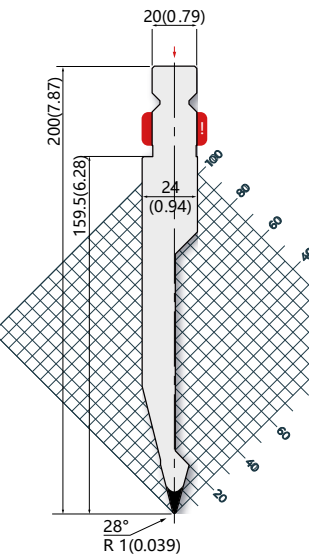
1/A

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



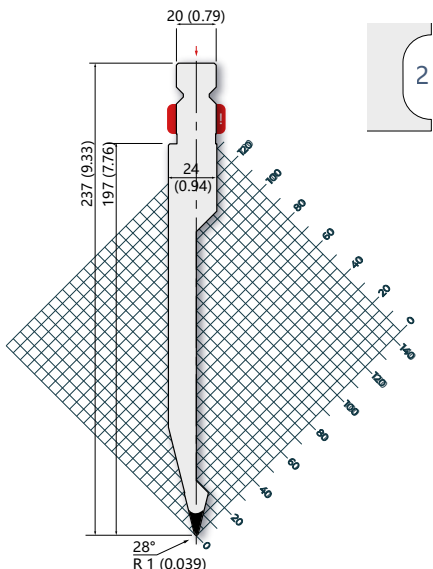
1/A

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



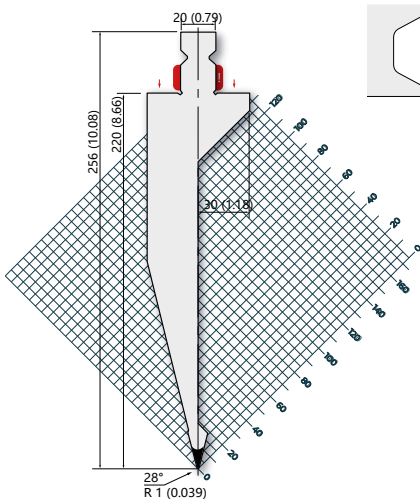
2

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



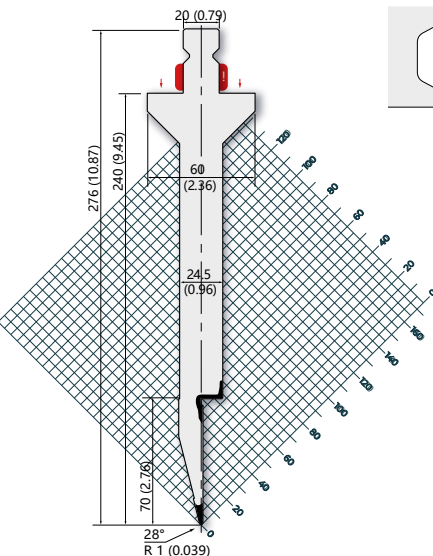
2

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



1

42Cr: 900-1150 N/mm ²			600 kN/m max.
TPR256.28.R1			
100 mm	3.93 in	5.0 kg	
500 mm	19.68 in	25.0 kg	
250 mm	9.84 in	12.5 kg	FC
550 mm	21.65 in	28.0 kg	FW

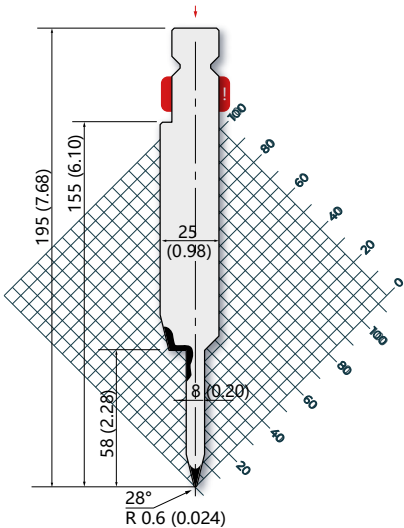


1

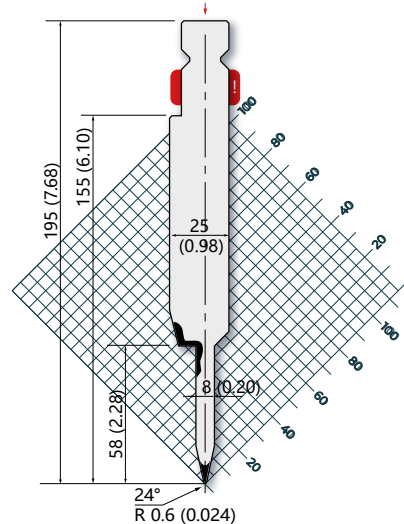
42Cr: 900-1150 N/mm ²			400 kN/m max.
TPR276.28.R1			
100 mm	3.93 in	4.8 kg	
500 mm	19.68 in	24.0 kg	
250 mm	9.84 in	12.0 kg	FC
550 mm	21.65 in	26.4 kg	FW



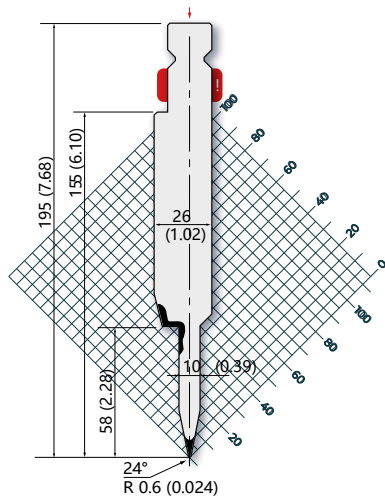
SEGMENTATION



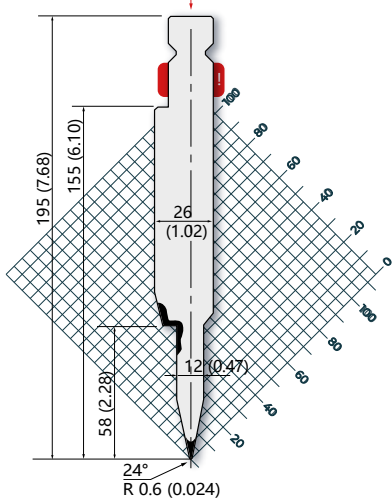
42Cr: 900-1150 N/mm ²			800 kN/m max. - 1000 kN/m max.	
TPR.SP.195.28.8				
100 mm	3.93 in	2.9 kg	To use with: TPR.SM.195.28.8 (page 142)	
525 mm	20.67 in	15.1 kg		
495 mm	19.49 in	8.9 kg		



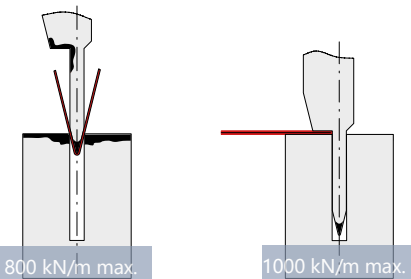
42Cr: 900-1150 N/mm ²			800 kN/m max. - 1000 kN/m max.	
TPR.SP.195.24.8				
100 mm	3.93 in	2.9 kg	To use with: TPR.SM.195.24.8 (page 142)	
525 mm	20.67 in	15.0 kg		
495 mm	19.49 in	8.9 kg		
			F	



42Cr: 900-1150 N/mm ²			800 kN/m max. - 1000 kN/m max.	
TPR.SP.195.24.10				
100 mm	3.93 in	3.0 kg	To use with: TPR.SM.195.24.10 (page 142)	
525 mm	20.67 in	15.5 kg		
495 mm	19.49 in	9.3 kg		



42Cr: 900-1150 N/mm ²			800 kN/m max. - 1000 kN/m max.	
TPR.SP.195.24.12				
100 mm	3.93 in	3.0 kg	To use with: TPR.SM.195.24.12 (page 142)	
525 mm	20.67 in	16.0 kg		
495 mm	19.49 in	9.5 kg		
		F		

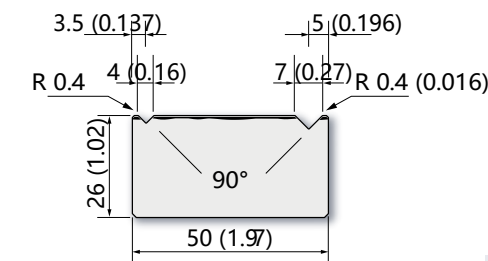


S		S		A		A		R.420		R.700	
[mm]	(in)	[mm]	(in)	[mm]	(in)	[mm]	(in)	kN/mm ²	kN/m	kN/mm ²	kN/m
0.6	0.02	3.0	0.12	90	150	0.6	0.02	1.2	0.05	230	350
0.8	0.03	3.0	0.12	120	200	0.8	0.03	1.6	0.06	320	500
1.0	0.04	3.5	0.14	150	250	1.0	0.04	1.0	0.04	400	600
1.25	0.05	3.5	0.14	170	260	1.25	0.05	2.5	0.10	500	800

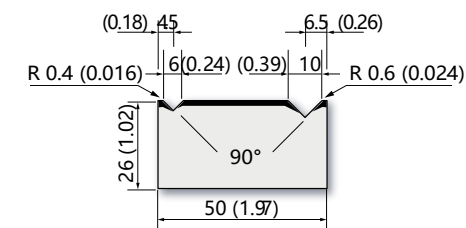
Ex. Application



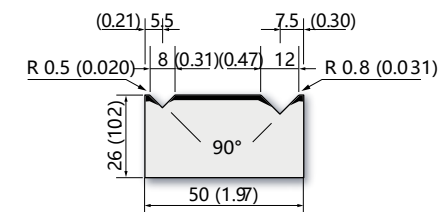
SEGMENTATION



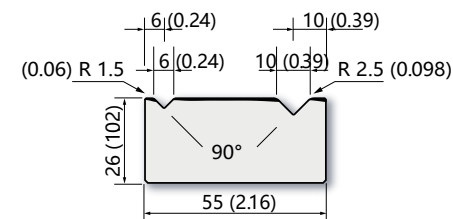
C45: 560-710 N/mm ²			600 kN/m max.		
12100					
835 mm	32.87 in	8.4 kg			
415mm	16.34 in	4.2 kg			



C45: 560-710 N/mm²			700 kN/m max.		
12300					
835 mm	32.87 in	8.0 kg			
415mm	16.34 in	3.9 kg			



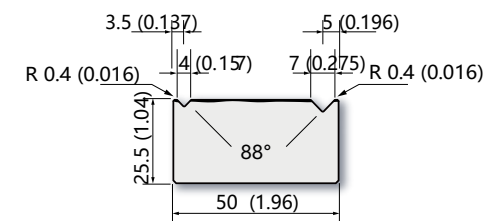
C45: 560-710 N/mm²		800 kN/m max.	
12400			
835 mm	32.87 in	8.0 kg	
415mm	16.34 in	3.9 kg	



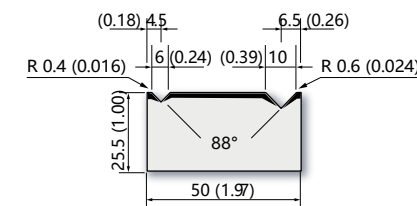
C45: 560-710 N/mm²			800 kN/m max.		
31100					
835 mm	32.87 in	9.1 kg			
415mm	16.34 in	4.5 kg			



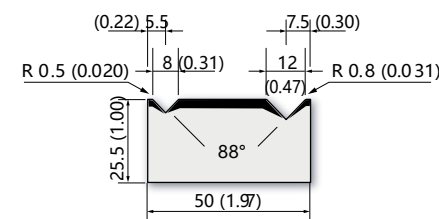
SEGMENTATION



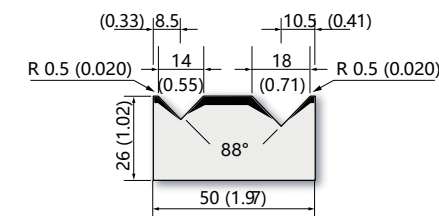
C45: 560-710 N/mm²			600 kN/m max.		
12106					
835 mm	32.87 in	8.4 kg			
415 mm	16.34 in	7.8 kg			



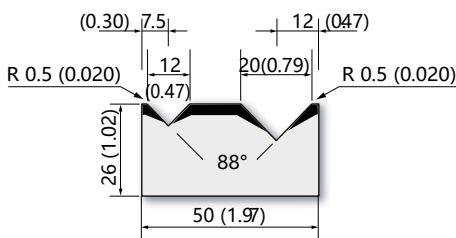
C45: 560-710 N/mm ²			700 kN/m max.		
12306					
835 mm	32.87 in	8.0 kg			
415 mm	16.34 in	3.9 kg			



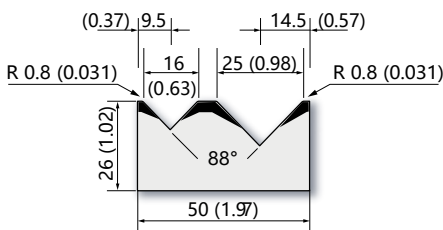
C45: 560-710 N/mm²			800 kN/m max.		
12406					
835 mm	32.87 in	8.0 kg			
415 mm	16.34 in	3.9 kg			



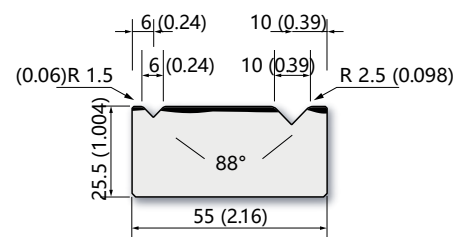
C45: 560-710 N/mm ²			1000 kN/m max.		
12500					
835 mm	32.87 in	7.7 kg			
415 mm	16.34 in	3.8 kg			



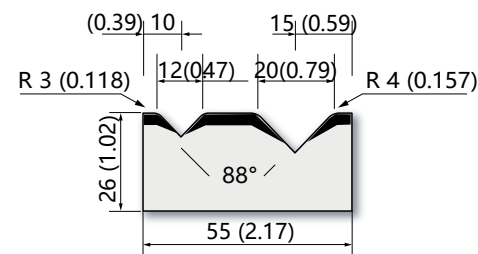
C45: 560-710 N/mm ²			1000 kN/m max.
12600			
835 mm	32.87 in	7.5 kg	
415 mm	16.34 in	3.7 kg	



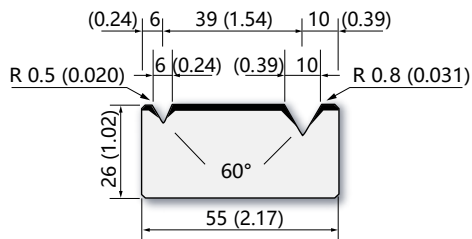
C45: 560-710 N/mm ²			700 kN/m max.
12700			
835 mm	32.87 in	7.0 kg	
415 mm	16.34 in	3.4 kg	



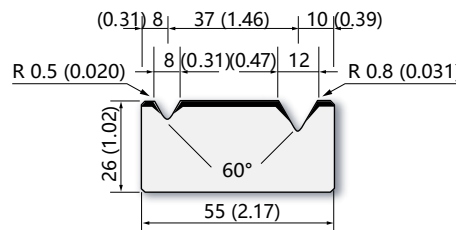
C45: 560-710 N/mm ²			800 kN/m max.
31106			
835 mm	32.87 in	8.9 kg	
415 mm	16.34 in	4.4 kg	



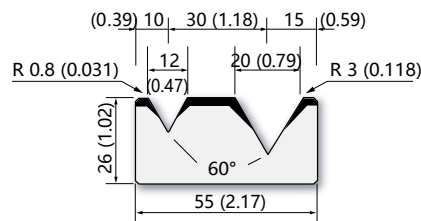
C45: 560-710 N/mm ²			1000 kN/m max.
31400			
835 mm	32.87 in	7.5 kg	
415 mm	16.34 in	3.7 kg	



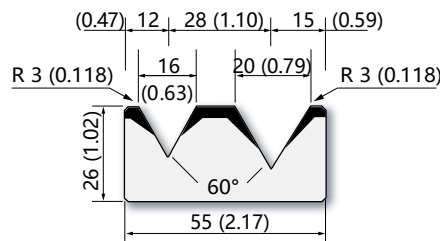
C45: 560-710 N/mm ²			600 kN/m max.
M26.60.01			
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
900 mm	35.43 in	10.0 kg	



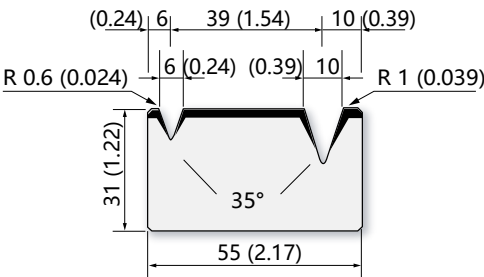
C45: 560-710 N/mm ²			800 kN/m max.
M26.60.02			
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	



C45: 560-710 N/mm ²			800 kN/m max.
M26.60.03			
835 mm	32.87 in	8.0 kg	
415 mm	16.34 in	4.0 kg	

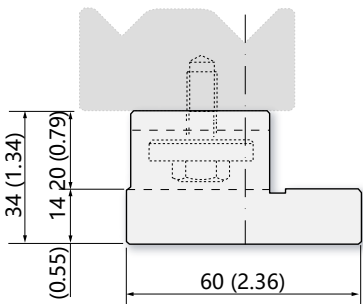


C45: 560-710 N/mm ²			800 kN/m max.
M26.60.05			
835 mm	32.87 in	8.0 kg	
415 mm	16.34 in	4.0 kg	



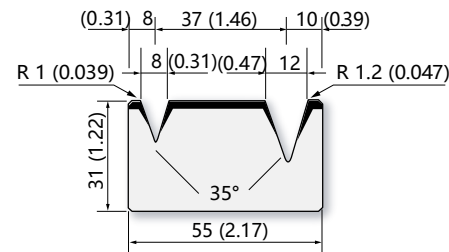
C45: 560-710 N/mm ²		
M31.35.01		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg

300 kN/m max.



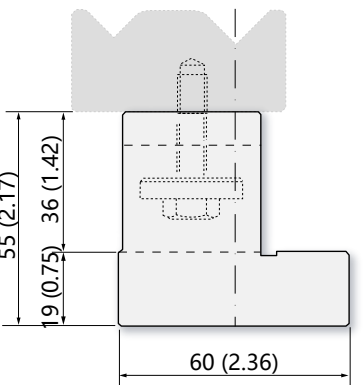
C45: 560-710 N/mm ²		
SU034		
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

300 kN/m max.



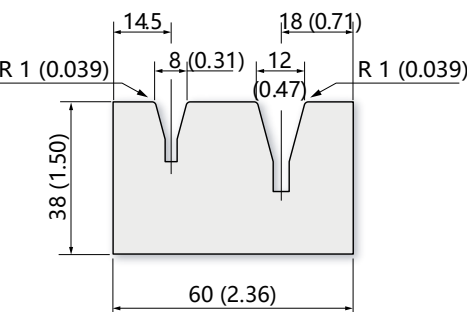
C45: 560-710 N/mm ²		
M31.35.02		
835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg

300 kN/m max.



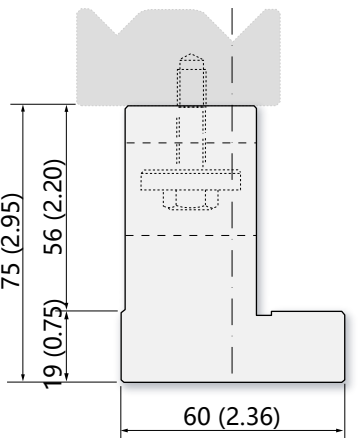
C45: 560-710 N/mm ²		
SU055		
835 mm	32.87 in	14.5 kg
415 mm	16.34 in	7.2 kg

300 kN/m max.



42Cr: 900-1150 N/mm ²		
33700		
835 mm	32.87 in	13.3 kg
415 mm	16.34 in	5.6 kg

300 kN/m max.



C45: 560-710 N/mm ²		
SU075		
830 mm	32.87 in	20.5 kg
410 mm	16.34 in	10.0 kg

300 kN/m max.

Content Explanation - R1



Welcome to Rolla-V, the home of Press Brake Tooling...

We are Rolla-V, the leading designers and manufacturers of specialist Press Brake Tools in the world.

Our state-of-the-art facilities reflect the tradition of generations of engineering in the industrial heart of the United Kingdom.

Based in the West Midlands, at the hub of the motorway network, it's easy to visit for a demonstration or to view your tools in action prior to delivery.

With over 80 years of experience, Rolla-V supplies the most comprehensive range of Press Brake Tools available today.

We are also the home of the revolutionary patented Rolla-V.

We supply Press Brake Tools, from stock, for every make of Press Brake in the world including Adira, Amada, Baykal, Bystronic, Durma, LVD, Safan and Trumpf.

Most of our products are available for immediate dispatch, enabling you to tackle any project, of any size with complete confidence.

We have full CNC Press Brake testing facilities and also supply guillotine blades and a comprehensive range of auxiliary equipment.

With continued investment and an unrivalled reputation for quality and service, Rolla-V is the global centre of excellence for Press Brake Tools and bending technology.

We designed and patented the revolutionary Rolla-V over fifteen years ago.

Since then, Rolla-V has become a favourite of every Press Brake manufacturer in the world, and won Innovative Product of the Year.

Rolla-V is now sold by all major press brake tooling companies.



Rolla-V provides the definitive answer if you need to:



- ▼ Bend stainless steel, aluminium (or any aesthetic materials) with little or no marking
- ▼ Bend small flanges
- ▼ Bend near to a hole or slot without distortion
- ▼ Avoid tool contamination
- ▼ Prevent secondary expensive and unnecessary rework.



Rolla-V Press Brake Tools supplied from stock for the following makes of Press Brakes:



Introducing our new ONYX range of Press Brake Tools



October 2015 saw the release of the new Rolla-V 'ONYX', our latest range of tooling. The Rolla-V has now fully evolved into the most advanced tooling solution available today. The ONYX has a very distinctive black finish that has many beneficial properties, including anti-rust and self lubrication. Throughout 2017 we are arranging demonstrations on site at

your premises, please call our sales team on 0845 500 1900 or send an email to sales@rolla-v.com if you'd like to arrange a visit.





Technical Specification

Non-Standard Lengths Are Available To Order On All Models

The Rolla-V range of tools

Rolla-V dies are available to suit any manufacturers machine.
Several fixed sizes are offered as well as adjustable models which are ideal for heavy plate or large radius work. Appropriate insert materials are used to suit the typical applications for each size of Rolla-V tool, although custom materials may be available on request.
Custom sizes and widths are also available for specific applications please call us to find out more

Application

RVP (models 1, 2 and 3) are; 60mm clamping widths
Suitable for Amada, Atlantic, Adira, Bystronic, Euro, Beyeler, Euro-B, CR Electronic, Durmazlar, Ermaskan, Gasparini, Guifil, Haco, Promecam

RVS (models 1, 2) are 14mm tang
Suitable for Amada style single V holder

RVT (models 1, 2 and 3) are 12.7mm / 13.0mm tang
Suitable for Bystronic, Hammerle, Beyeler, Edwards, Safan, SMD, Trumpf

RVT90 (models 1, 2 and 3) are 12.7mm offset tang
Suitable for LVD with offset tang

RVM (models 2.5, 3 and 4)
Universal clamping width base or tang – all styles are available – suitable for any machine brand

If you can't see your machine type listed here we can provide advice and make custom fittings to your specification – please call us

Rolla-V Materials		
Inserts	Body	
	Models 1, 2 and 2.5 Model 3 Model RVM4 Model V4 All models	thru' hardened to HRC44 thru' hardened to HRC44 + surface hardened to HRC55 thru' hardened to HRC44 + surface hardened to HRC55 thru' hardened to HRC55 42CrMo4 tensile strength 1100-1200M/mm2 surface hardened to HRC55
Non-standard insert materials and HRC values are available for specific applications – please call us		



Rolla-V Advantages

- ▼ Highly precision ground
- ▼ Modular
- ▼ Avoid traditional bending marks
- ▼ Minimal marking
- ▼ Extremely short flanges possible
- ▼ No tool material cross contamination
- ▼ Bend close to holes and cut-outs with no deformation
- ▼ Fewer tool changes
- ▼ Bends laser cut sheets with no tool damage
- ▼ Ideal for radius bending
- ▼ Exact inside radius
- ▼ Adjustable Rolla-V sizes
- ▼ Ideal for tapered or feathered edges
- ▼ Bends up to 30mm thick material (subject to model selected)

Application and Technical Data



	maximum load	material	minimum bend	A	B	C
	capacity (t/m)	thickness (mm)	angle (degrees)	tonnage required (t)	minimum outside flange (mm)	maximum outside radius
Model 1						
fixed style	100	0.7	40.0	5.0	3.0	3.0
Max recommended	100	1.1	35.0	13.0	3.9	2.6
thickness 1.5 mm 100 may be possible)		1.5	35.0	27.0	4.2	2.2
Model 2						
fixed style	150	2.0	59.0	21.0	8.5	6.0
Max recommended	150	3.0	47.0	55.0	9.3	5.0
thickness 3.0 mm 150 may be possible)		3.2	47.0	65.0	9.3	4.8
Model 2.5						
fixed style	250	2.0	46.0	10.0	18.6	13.2
Max recommended	250	4.0	46.0	47.0	18.6	12.0
thickness 6.3 mm	250	6.0	55.0	127.0	18.6	9.8
Model 3						
fixed style	250	2.0	68.0	7.0	22.5	13.9
Max recommended	250	4.0	47.0	34.0	22.5	11.9
thickness 6.3 mm 250 may be possible)		6.0	50.0	90.0	22.5	9.9
Model 4						
fixed style	300	6.0	78.0	26.0	56.6	36.4
Max recommended	300	8.0	76.0	50.0	56.6	36.4
thickness 16.0 mm	300	12.0	73.0	129.0	56.6	36.4



Technical Specification

Adjustable models

RVHD3 39mm - 118mm

350

RVHD4 70mm - 220mm

350

Adjustables usually used for bending thick materials or for bending large radii - because specific material specs vary we do not provide detailed bend data.

Flaring or hole distortion is much reduced, but is influenced by material specification. Radius work is greatly effected by spring-back of the specific material being bent.

Minimum flange sizes are greatly effected by the squareness of the component edge.

Notes:

It is NOT POSSIBLE to maintain values A and B and C simultaneously. These values are for guideline only and assume a tensile strength 420N/mm2. If these values are very close to your requirement a test bend may be appropriate. Practical testing may give more favourable results than shown in columns A, B and C. Please call to discuss specific applications. All specifications are subject to change without notice.



Model 1 Generation 7



Fixed Rolla-V Range

Non-Standard Lengths Are Available To Order On All Models

Model 1



- ▼ Castellated inserts
- ▼ Standard lengths 500mm, 100mm and 440mm segmented
- ▼ Segmented 440mm lengths includes 200mm, 100mm, 50mm, 30mm, 25mm, 20mm, 15mm
- ▼ Segmented 'Upgrade Kit' available – segments at 25mm, 40mm and 45mm

	maximum load capacity (t/m)	material thickness (mm)	minimum bend angle (degrees)	tonnage required (t)	minimum outside flange(mm)	max outside radius
Model 1 fixed style	100	0.7	40.0	5.0	3.0	3.0
	100	1.1	35.0	13.0	3.9	2.6
	100	1.5	35.0	27.0	4.2	2.2

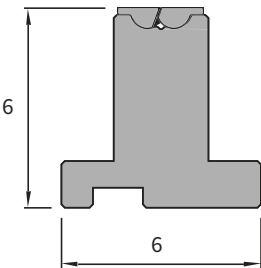
Max recommended thickness 1.5 mm (2.0 mm thickness may be possible)



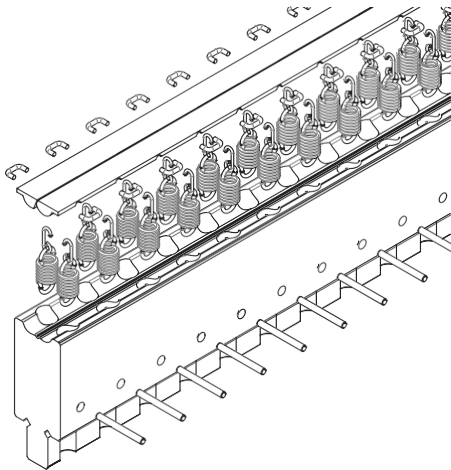
SEGMENTATION



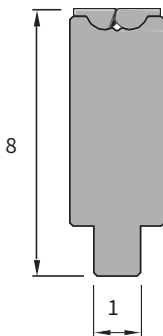
SEGMENTATION



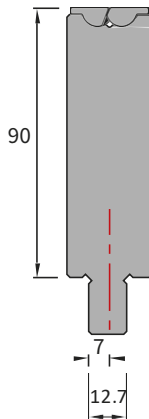
RVP60-1	
500 mm	6.9KG
440 mmSegmented	6.1KG
100 mm	1.4KG



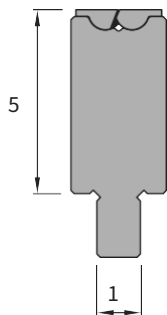
Typical construction for
Models 1, 2 and 2.5



RVS80-1	
500 mm	6.3KG
440 mmSegmented	5.8KG
100 mm	1.3KG



RVP60-1	
500 mm	8.5KG
440 mmSegmented	7.8KG
100 mm	1.7KG



RVT55-1	
500 mm	5.5KG
440 mmSegmented	5KG
100 mm	1.1KG



RVP60-1	
500 mm	9.4KG
440 mmSegmented	8.6KG
100 mm	1.8KG



Model 2 Generation 2

SEGMENTATION



Fixed Rolla-V Range

Non-Standard Lengths Are Available To Order On All Models

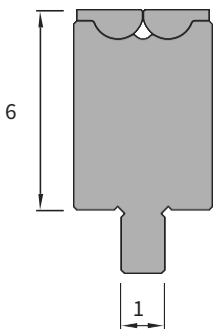
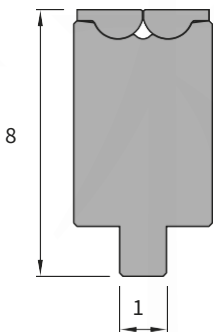
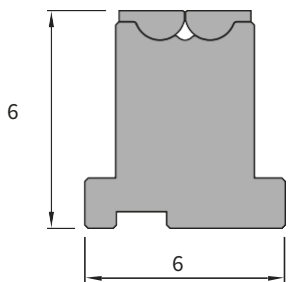


Model 2

- ▼ Standard lengths 500mm, 100mm and 450mm segmented
- ▼ Segmented 450mm lengths includes 200mm, 100mm, 40mm, 35mm, 30mm, 25mm, 20mm
- ▼ Segmented ‘Upgrade Kit’ available – segments at 25mm, 45mm and 50mm

	maximum load capacity (t/m)	material thickness (mm)	minimum bend angle (degrees)	tonnage required (t)	minimum outside flange(mm)	max outside radius
Model 2 fixed style	150	2.0	59.0	21.0	8.5	6.0
	150	3.0	47.0	55.0	9.3	5.0
	150	3.2	47.0	65.0	9.3	4.8

Max recommended thickness 3.0 mm (4.0 mm thickness may be possible)



RVP65-2

500 mm	7.9KG
450 mmSegmented	7.4KG
100 mm	1..6KG

RVS80-2

500 mm	8.3KG
450 mmSegmented	7.8KG
100 mm	1.7KG

RVT60-2

500 mm	7.9KG
450 mmSegmented	7.4KG
100 mm	1.6KG



SEGMENTATION

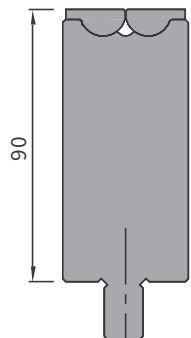
Model 2.5 Generation 1



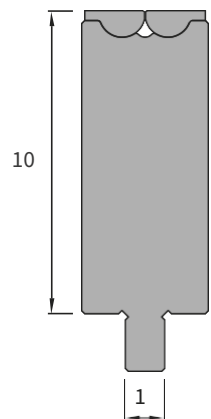
Fixed Rolla-V Range

Non-Standard Lengths Are Available To Order On All Models

Model 2.5



RVT90-2	
500 mm	11.3KG
450 mmSegmented	10.6KG
100 mm	2.2KG



RVT100-2	
500 mm	12.4KG
450 mmSegmented	11.7KG
100 mm	2.5KG



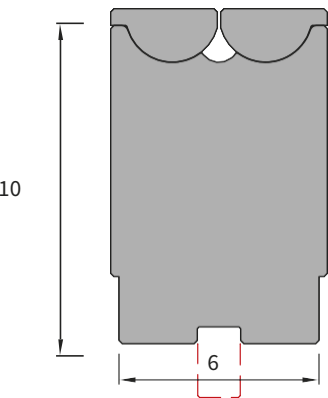
- ▼ Standard lengths 500mm, 100mm and 470mm segmented
- ▼ Segmented 470mm lengths include 200mm, 100mm, 50mm, 45mm, 40mm, 35mm
- ▼ Segmented ‘Upgrade Kit’ available – segments at 25mm, 25mm and 30mm

	maximum load capacity (t/m)	material thickness (mm)	minimum bend angle (degrees)	tonnage required (t)	minimum outside flange(mm)	max outside radius
Model 2.5 fixed style	250	2.0	46.0	10.0	18.6	13.2
	250	4.0	46.0	47.0	18.6	12.0
	250	6.0	55.0	127.0	18.6	9.8

Max recommended thickness 5 mm (6.0 mm may be possible)



SEGMENTATION



RVM-2.5	
500 mm	22.0KG
470 mmSegmented	21.0KG
100 mm	4.4KG



On-site demonstrations



We are proud to demonstrate our products, so please let us know if you want to see them in action.

We will visit you at your earliest convenience to demonstrate our fantastic tooling range in person. You will be able to test our tools on site and find out exactly how our range can work for you. To arrange a personalised on-site demonstration for your business, please call us today on

0845 500 1900



The Rolla-V Catalogue presents the most comprehensive range of press brake tools in the UK. The latest edition of our catalogue is available to download on our website. To request a free printed copy of a catalogue please call 0845 500 1900 or send an email to sales@rolla-v.com.





Model 3 Generation 2

SEGMENTATION



Fixed Rolla-V Range

Non-Standard Lengths Are Available To Order On All Models

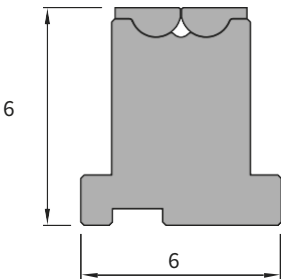


Model 3

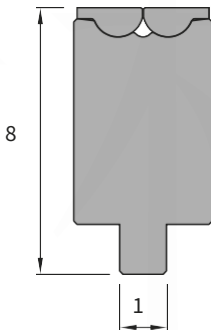
- ▼ Standard lengths 500mm, 100mm and 455mm segmented
- ▼ Segmented 455mm lengths includes 200mm, 100mm, 60mm, 50mm, 45mm
- ▼ RVM70-3 Tang sizes 60mm, 13mm, 12.7mm, 12.7mm offset

	maximum load capacity (t/m)	material thickness (mm)	minimum bend angle (degrees)	tonnage required (t)	minimum outside flange(mm)	max outside radius
Model 3 fixed style	250	2.0	68.0	7.0	22.5	13.9
	250	4.0	47.0	34.0	22.5	11.9
	250	6.0	50.0	90.0	22.5	9.9

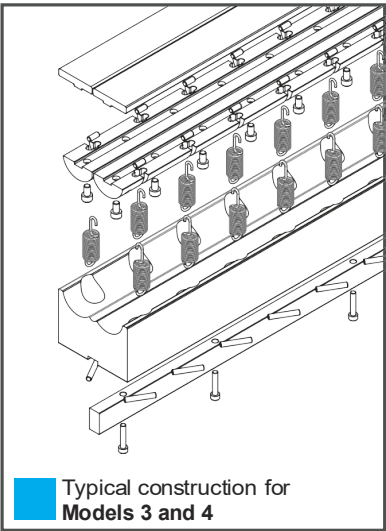
Max recommended thickness 6.0 mm (8.0 mm thickness may be possible)



RVP100-3	
500 mm	28.8KG
455 mmSegmented	26.2KG
100 mm	5.8KG



RVT100-3	
500 mm	30.9KG
455 mmSegmented	28.5KG
100 mm	6.2KG





SEGMENTATION

Model 4 Generation 2

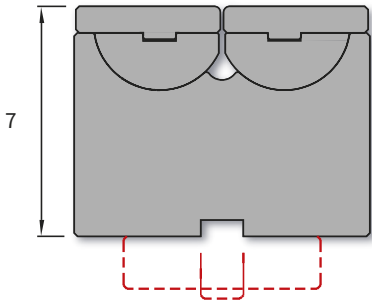


Fixed Rolla-V Range

Non-Standard Lengths Are Available To Order On All Models

Model 4





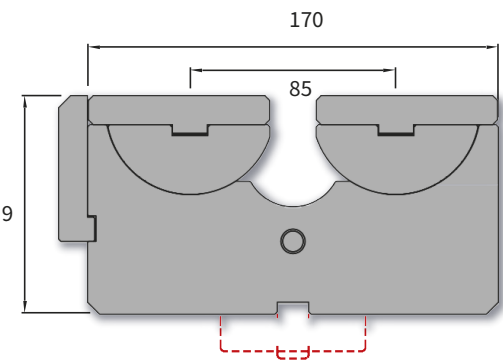
RVM70-3	
500 mm	20.6KG
455 mmSegmented	18.7KG
100 mm	4.2KG



- ▼ Tang fittings available to suit all manufacturers machines
- ▼ Standard lengths 500mm and 200mm
- ▼ Tang sizes 60mm, 13mm, 12.7mm, 12.7mm offset

	maximum load capacity (t/m)	material thickness (mm)	minimum bend angle (degrees)	tonnage required (t)	minimum outside flange(mm)	max outside radius
Model 4 fixed style	300	6.0	78.0	26.0	56.6	36.4
	300	8.0	76.0	50.0	56.6	36.4
	300	12.0	73.0	129.0	56.6	36.4

Max recommended thickness 16.0 mm



RVM90-4	
500 mm	56.6KG
200 mm	22.7KG



Rolla-V applications

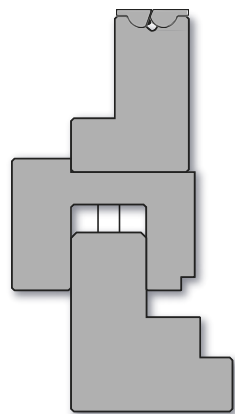
Adjustable Rolla-V range



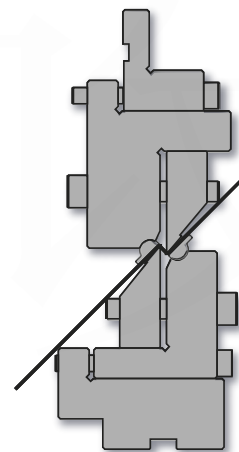
Rolla-V applications

- ▼ Minimise safety edge marking using the Rolla-V Hemming Tool
- ▼ Minimise Joggle Form marking
- ▼ Contact us if you have special applications

Hemming Tool



Adjustable Joggle



Recommended thickness 3.0 mm x 17 mm joggle
(4mm thickness may be possible)



Non-Standard Lengths Are Available To Order On All Models

Adjustable Rolla-V range



Insert with through hardened plate or nitride hardened surface

Standard lengths 500mm and 200mm

Non-standard lengths available to order

These tools are usually used for bending thicker materials or making large radius components

Specific material specifications vary greatly so it is not feasible to provide detailed data

eg, minimum flange sizes are greatly affected by squareness of component edge

eg, flaring or hole distortion is much reduced with these tools, but is influenced by specific material type

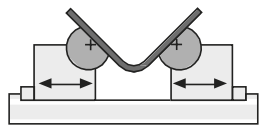
eg, radius work is greatly affected by springback of specific material and flange sizes

Please call us to discuss specific applications



Examples of use

SEGMENTATION



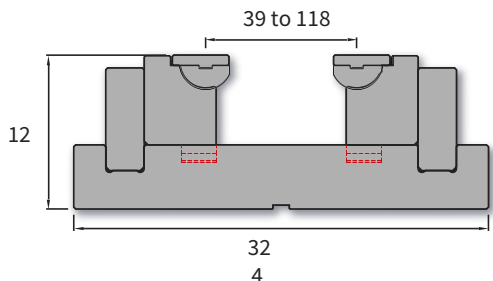
V-bending



flat inserts



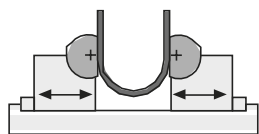
result



RVHD3

500 mm	98KG
200 mm	39KG

Max recommended thickness 20.0 mm



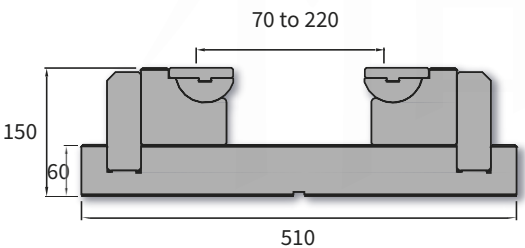
radius bending



flat inserts



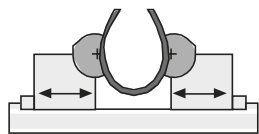
result



RVHD4

500 mm	200KG
200 mm	80KG

Max recommended thickness 30.0 mm



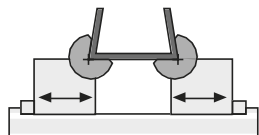
radius overbending



concave inserts



result



U-bending



V-inserts



result



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Subscribe to our YouTube channel to enjoy the latest news about Rolla-V, our products, applications and initiatives.

We've also got some great video footage of our range of Press Brake Tools in action.

Search for [Rolla-V](https://www.youtube.com/channel/UCvukB) on www.youtube.com to subscribe.

We also publish a FREE newsletter.

Send an email to sales@rolla-v.com to receive news, tips, resources and special offers to sign up.

Make sure you don't miss out.



Calculations



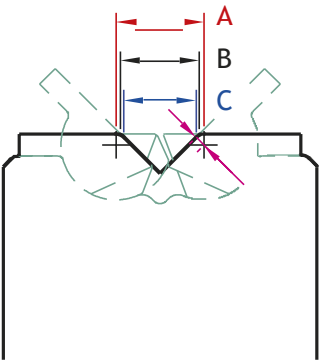
These formulae are for guideline purposes only – they will provide a good indicator of what tonnage or flange size or maximum outside radius is possible for a specific bend

Our experience shows that whilst these calculations provide theoretical values, in practice it is usually possible to obtain a more favourable result. We would recommend that if your requirement is close to the calculated value, a test bend using your material and tooling may be advisable to confirm what result is actually possible.

Key



- Dimension A
- Rotor centre distance (Equivalent V when flat)
- Dimension B
- Equivalent V-width for calculating flange sizes
- Dimension C
- Equivalent V-width for calculating tonnages
- Dimension Z
- Equivalent V-width for calculating tonnage s



	A (mm)	B (mm)	C (mm)	Z (mm)
Model 1	8.00	7.17	6.59	1.00
Model 2	15.00	13.92	13.16	1.30
Model 2.5	28.00	26.34	25.17	2.00
Model 3	38.00	33.44	30.22	5.50
Model 4	85.00	80.03	76.51	6.00

Content Explanation - R1



We suggest using Rm values as indicated here

Aluminium Rm 200 - 300 N/mm²

Mild Steel Rm 370 - 450 N/mm²

Stainless Rm 650 - 700 N/mm²



Force (tonnage) calculation

$$\text{Force (Kn/m)} = \frac{R_m \times T^2}{C} \times \left(1 + \frac{4 \times T}{C}\right)$$

Aluminium: Rm = 200-300 N/mm²

Mild Steel: Rm = 370-450 N/mm²

Stainless: Rm = 650-700 N/mm²

Example:

Bend force calculation example:

2mm Aluminium in a Model 2

$$\text{Force (Kn/m)} = \frac{300 \times 2^2}{13.16} \times \left(1 + \frac{4 \times 2}{13.16}\right)$$

$$91.185 \times 1.6079 = 146.62 \text{Kn/m}$$

Bending force = 146.62Kn/m



Min flange calculation

$$\text{Min flange (MF)} = \sqrt{(B^2/2)}$$

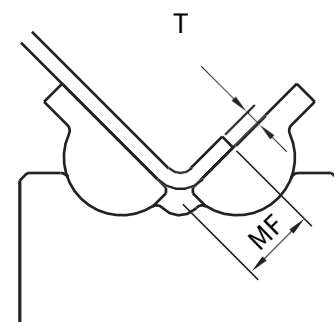
Example:

Min flange calculation example:

Model 1

$$\text{Min flange (MF)} = \frac{\sqrt{(7.17^2/2)}}{\sqrt{25.704}} = 5.07$$

Min flange = 5.07mm



Max outside radius calculation



$$\text{Rule 1) Max ER} = \sqrt{(C^2/2)} - (T + Z)$$

$$\text{Rule 2) IF ER IS} > B/2.2, \text{ER} = B/2.2$$

Note: Whichever value is the greater is the maximum outside radius possible.

Example:

3mm Material in Model 2.5

$$\text{Rule 1 ER} = \frac{\sqrt{(25.17^2/2)} - (3 + 2)}{17.8 - 5} = 12.8$$

$$\text{Rule 2} = 26.34 / 2.2 = 11.97$$

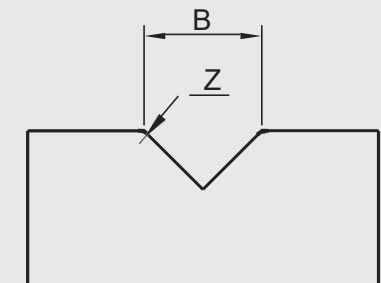
12.8 (Rule 1) is greater than 11.97 (Rule 2)

therefore Max ER = R11.97mm

General input on machine



Equivalent V construction for graphical machine controllers



To simulate the Rolla-V on a machine graphical input, use a v-width of B and v-corner radius of Z.