



ROLLERI®

**PROFESSIONAL
BENDING**

**DIRECTLY
FROM THE
MANUFACTURER!**



PRESS BRAKE TOOLS

**FAST CLAMPING SYSTEMS, ADAPTERS,
SERVICE/MODIFICATION,
SHEAR BLADES, ACCESSORIES**

ROLLERI

Rolleri Spa is one of the few real manufacturers of press brake tools, not a reseller nor a dealer and this guarantees some important advantages:

- no margin division
- direct access to the production
- reliable customer service both for standard and special tools and prompt information about prices and delivery times

COMPANY

Since 1987 we have been producing standard and special tooling. The family owned company (Francesco and Marco Rolleri) can nowadays be considered one of the largest press brake tooling manufacturers in Europe. We offer a fast and reliable service through our partners in all of Europe. The reorganization of our sales force, happened in 2012, has guaranteed a widespread presence of our products in every single market.



ROLLERI IN THE WORLD

- Rolleri Spa – Head Office 1
- Rolleri Baltic 2
- Rolleri Benelux 3
- Rolleri Do Brasil 4
- Rolleri Trading Co. 5
- Rolleri Česká Republika 6
- Rolleri Denmark 7
- Rolleri Finland 8
- Rolleri France 9
- Rolleri Deutschland GmbH 10
- Rolleri Tools of India 11
- Rolleri Polska 12
- Rolleri Slovensko 13
- Rolleri Ukraine LLC 14
- Rolleri USA 15

TEAM

The leitmotif of our activity is the fusion of dynamism and experience to reach the best result for our clients. Every department of our company – customer service, production, technical office, Research & Development, warehouse, administration – works in strict cooperation in a positive and motivated environment.

The positive company atmosphere is reflected in the customer service and the quality of our products.



Rolleri Videos

Company Presentation
www.rolleritools.com/videos/company-rolleri





PRODUCTION

Thanks to the use of our modern CNC-machines, every production phase is standardized and certified, and this guarantees the maximum quality.

All tools are laser marked with a serial number that allows an easy identification and an accurate reproduction. This is what we call accurate repeatability.



WAREHOUSE

With more than 20,000 press brake tools on stock, we hold one of the largest warehouses in Europe. Thanks to this, a large amount of tools is ready to be shipped all around the world.



Look for this symbol in the catalogue!



SERVICE

We know that finding the right tool for the right application is very important to you.

For this reason, we have invested hard work into our quality service and we can offer:

- Consulting,
- Technical assistance,
- Training for your bending specialists,

to give you great support is our daily business!

Check out our **website: www.rolleritools.com**



... also this is customer service: Rolleri provides you with immediate production after a purchase has been made to ensure the fastest delivery time!



ROLLERI

Professional Bending

MANUFACTURING

Besides manufacturing many special tools, our research and development team also designs fast clamping systems in order to increase your productivity.

Technicians and Engineers develop for you economical and practical solutions.

We work with highly complex 3D simulation models and we are able to create bending examples of various profiles.

Enquire with us today!



QUALITY

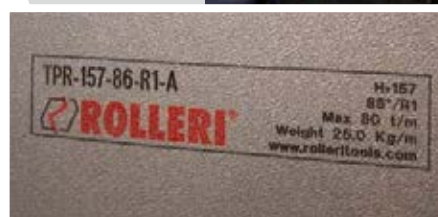
Rolleri is ISO 9001:2008 certified.

For us, to be your choice supplier means to help you in finding the best and most economic tool and to develop a large number of bending solutions. Furthermore, we offer training for your bending department employees.

QUALITY CONTROL

Our quality control department reviews and tests every single tool after a complete production cycle. After a careful inspection, every tool is marked with a serial number and a batch number. This process guarantees a complete tool traceability.

Rolleri also guarantees accurate reproduction, high-quality material, induction hardening and precision grinding.





RAW MATERIAL

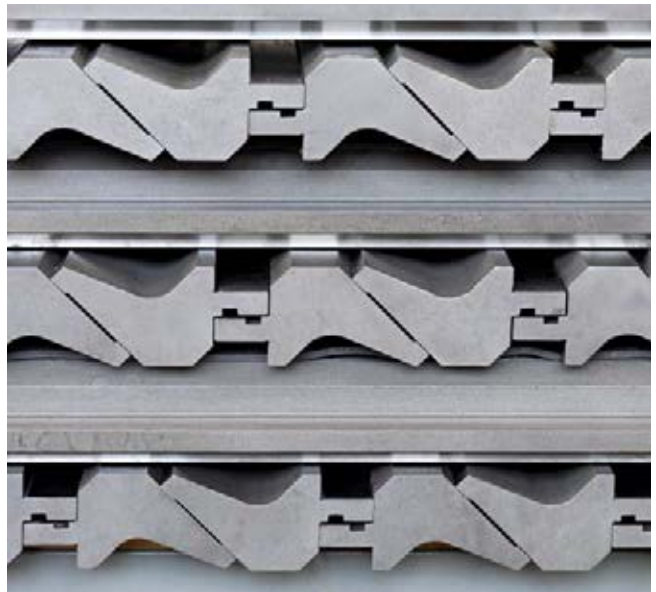
Raw material is obtained from qualified suppliers who use chemical formulas according to the international standards and this guarantees high resilience and tensile strength.

PRESS BRAKE TOOLS

Every tool is manufactured in Rolleri's production facilities.

This allows to give great importance to our precision grinding, guaranteeing accurate reproduction of tools and exact concurrence. We use induction hardening at 54-60 HRC for all tools to get the best results for your punches and dies.

Each tool is subjected to quality control and then provided with a serial number to simplify its tracking.



INNOVATIONS

Rolleri produces manual, pneumatic and hydraulic clamping systems for many press brakes manufacturers.

Our new QuickLock-System, compatible with Rolleri tools Type R2 and our new ROL100 compatible with Rolleri tools type R1, are innovations developed and manufactured in our production facilities.

Compatibility

■ Tools Rolleri Type R1

are **compatible** with press brake machines from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, JMT, LFK, Metfab, MVD, Newton, Oriance, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.

■ Tools Rolleri Type R2

are **compatible** with press brake machines from:
Hämmerle-Bystronic, LVD, Trumpf or on
press brakes with System NSCL
(New Standard Clamping)

■ Tools Rolleri Type R3

are **compatible** with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

■ Tools Rolleri Type RX

are **compatible** with press brake machines from:
EHT, Weinbrenner, American, Gasparini, Ajial-Axial, Colgar,
LVD, Colly, Hämmerle-Bystronic, etc.

With Adapter-Systems the tools Rolleri Type R1-RX are also applicable on all other press brake machines.



PUNCHES ROLLER TYPE R1

DIES ROLLER TYPE R1

PUNCHES ROLLER TYPE R2

DIES ROLLER TYPE R2

PUNCHES ROLLER TYPE R3

DIES ROLLER TYPE R3

TOOLS ROLLER TYPE RX

ROLLER DIES ROLLA-V

ROLLER CLAMPING SYSTEMS

ROLLER ADAPTERS

ROLLER MARK FREE BENDING

ROLLER SPECIAL AND HEAVY DUTY TOOLS

ROLLER SERVICE / MODIFICATIONS

ROLLER SHEAR BLADES / ACCESSORIES

PUNCHES ROLLERI TYPE R1

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Compatibility

Punches Roller Type R1 are compatible with press brake machines from:

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

With Adapter-Systems the punches Roller Type R1 are also applicable on all other press brake machines.



R1 ROLLERI TYPE R1

Content Explanation Punches

Compatibility

Punches Rolleri Type R1 are:

- **compatible** with press brake machines from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, JMT, LFK, Metfab, MVD, Newton, Oriance, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brake machines **with adapter-systems** (see pages 220-225).

Material

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

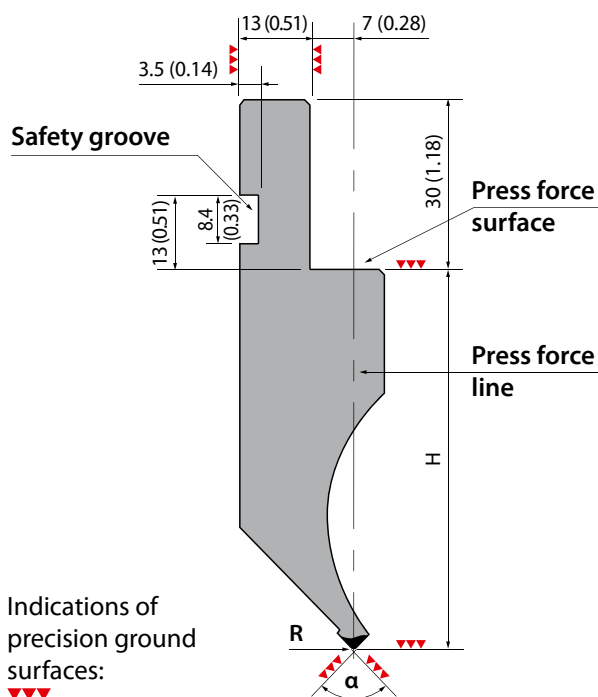
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

All punches Rolleri Type R1:

- are standardized with a **8.4 x 3.5 mm (0.331 x 0.138 in) safety groove**, that keeps the tool from falling out.
- depending on the clamping system: **horizontal** or **vertical**, tool exchange is possible (see pages 206-213)



Our Advantages – Your Convenience

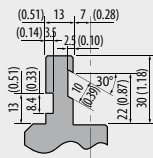
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 256-257)
- very large stock availability

Modifications from Safety Grooves

A1

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

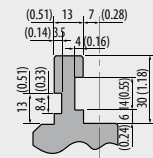
- Pneumatic clamping



A6

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

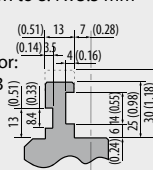
- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan



A7

Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:

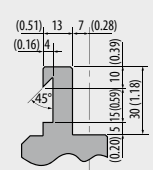
- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan



A8

Groove for:

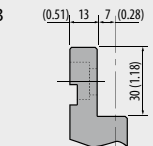
- hydraulic clamping Gasparini



A9

Modified groove for:

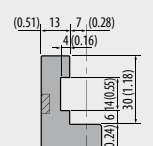
- Rolleri Type R3



A41

Modified groove for:

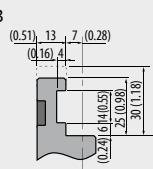
- Rolleri Type R3



A42

Modified groove for:

- Rolleri Type R3



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

Tool lengths and sectioning

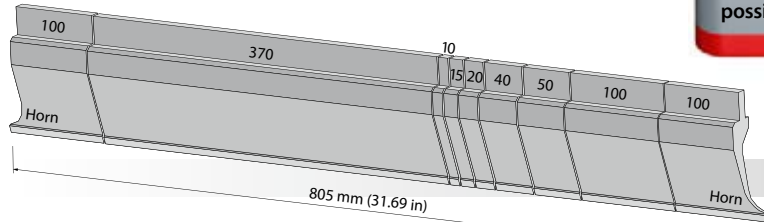
Standard

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

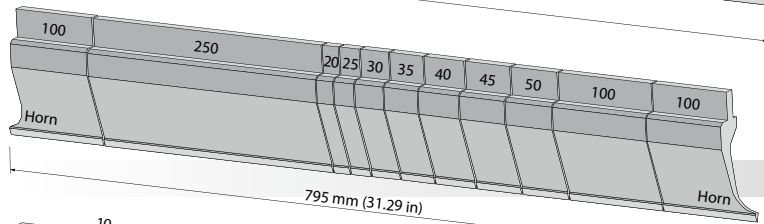
835 mm (32.87 in)

415 mm (16.34 in)

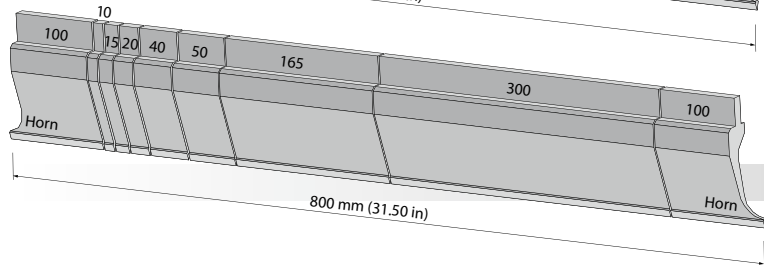
900 mm (35.43 in)



805 mm (31.69 in) segmented (9 segments)



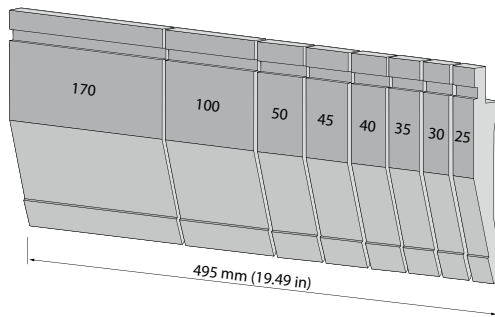
795 mm (31.29 in) segmented (11 segments)



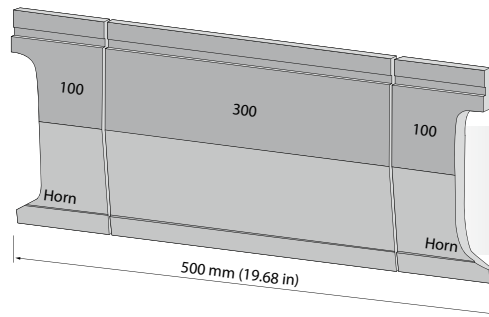
800 mm (31.50 in) segmented (9 segments)

Rolleri TOP-System

525 mm (20.67 in)

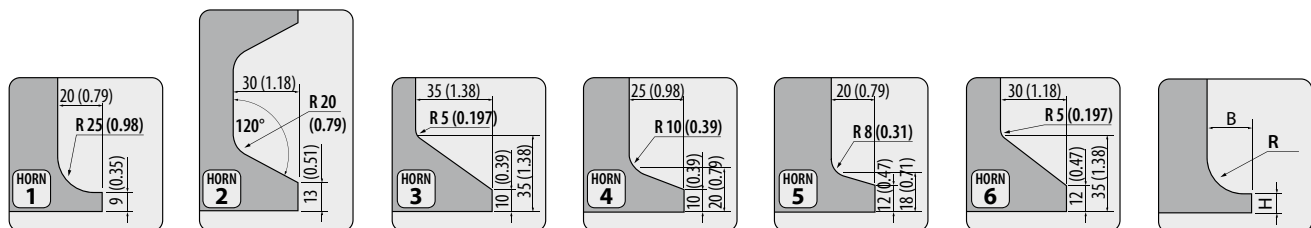


495 mm (19.49 in) segmented (8 segments)



500 mm (19.68 in) segmented (3 segments)

Horn Types



Horn 1
Standard
for all segm.
Punches
Rolleri Type R1

Horn 2
TOP
for all segm.
TOP Punches
Rolleri Type R1

Horn 3
for punches:
00402
00430
11700
04702

Horn 4
for punches:
20000
20200
10900
10906

Horn 5
for punches:
10300

Horn 6
for punches:
00300

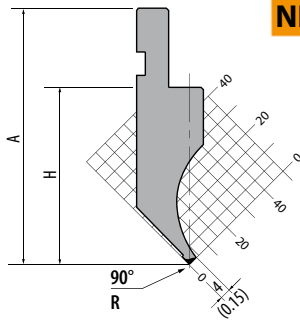
Horn individual
produced according to your specifications

R1 ROLLERI TYPE R1

90° Punches

PK.97.90.R06 / P.97.90.R025

350 kN/m max.



NEW

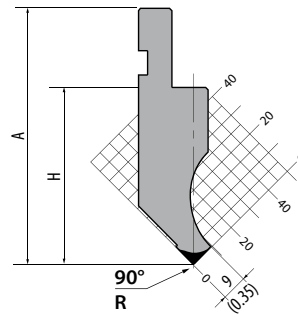
PK.97.90.R06		
H=66.80 / A=96.80 / R=0.6 (H=2.63 / A=3.81 / R=0.024)		
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.69 in segmented	10.1 kg

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

42Cr: 900-1150 N/mm² **HORN 1**

PK.97.90.R08 / R025

1000 kN/m max.



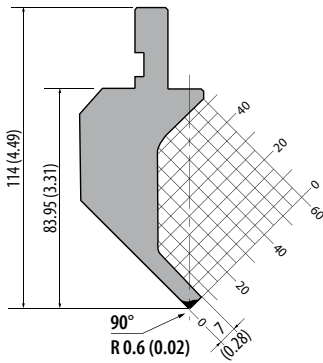
PK.97.90.R08		
H=66.35 / A=96.35 / R=0.8 (H=2.61 / A=3.79 / R=0.031)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.5 kg

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

C45: 560-710 N/mm² **HORN 1**

PK.114.90.R06

200 kN/m max.



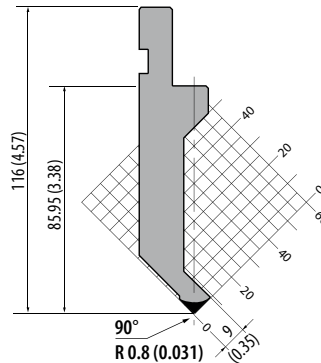
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm²

HORN 1

PK.116.90.R08

400 kN/m max.



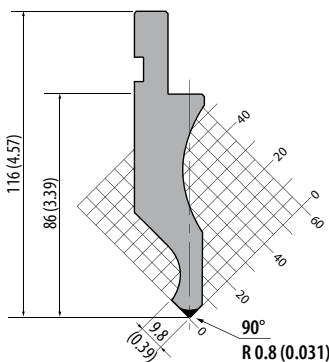
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

HORN 1

DK.116.90.R08

500 kN/m max.



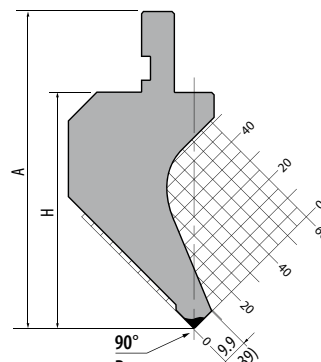
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.4 kg

C45: 560-710 N/mm²

HORN 1

PK.120.90.R08 / R025

600 kN/m max.



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

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

C45: 560-710 N/mm² **HORN 1**



Rolleri Videos

find updated and helpful videos at:
[www.rolleritools.com/
videos/overview](http://www.rolleritools.com/videos/overview)

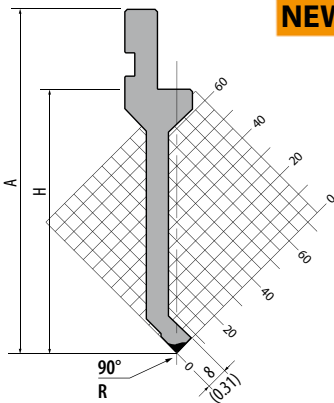


Articles on stock – Please note that delivery time varies according to your location.



P.130.90.R06 / R025

350 kN/m max.



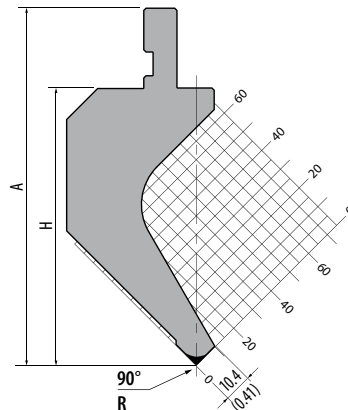
NEW

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

42Cr: 900-1150 N/mm² **HORN 1**

PK.135.90.R08 / R025

500 kN/m max.



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

C45: 560-710 N/mm² **HORN 1**

90° Segmented Punches with Mobile Horns

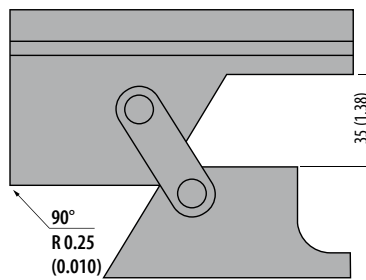
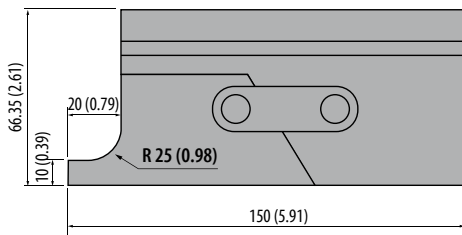


Area of Application

- for easy bending of special box profiles

SCA.M.90.R08

150 kN/m max.



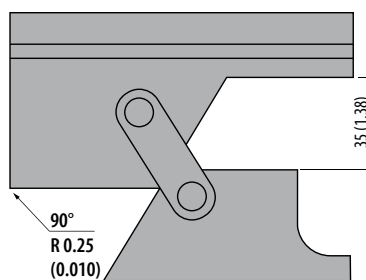
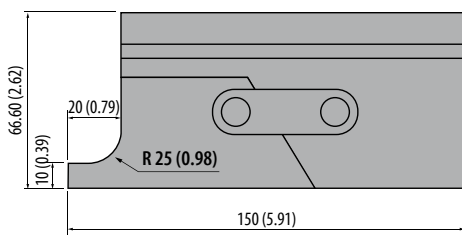
NEW

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

C45: 560-710 N/mm²

SCA.M.90.R025

150 kN/m max.



NEW

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

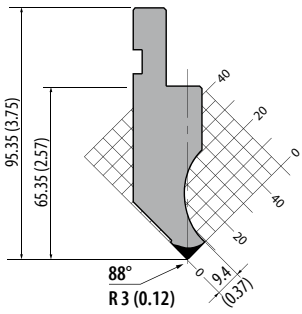
C45: 560-710 N/mm²

R1 ROLLER TYPE R1

88° Punches

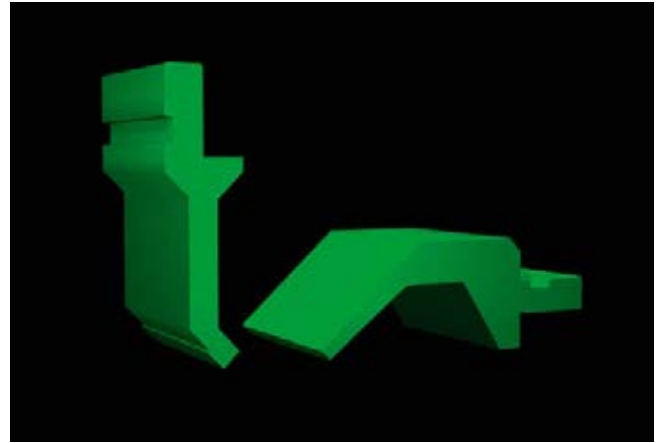
P.95.88.R3

1000 kN/m max.



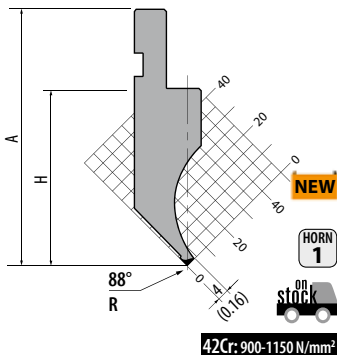
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.97.88.R06 / R025

350 kN/m max.



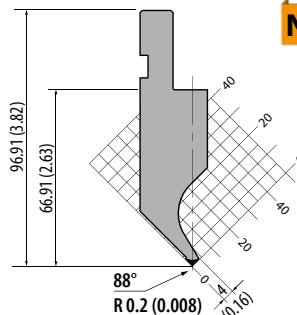
H=67.00 / A=97.00 / R=0.6 (H=2.64 / A=3.82 / R=0.024)		
835 mm	32.87 in	9.5 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.0 kg
805 mm segmented	31.69 in segmented	9.2 kg
900 mm	35.43 in	11.0 kg
H=66.95 / A=96.95 / R=0.25 (H=2.64 / A=3.82 / R=0.010)		
835 mm	32.87 in	9.5 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.0 kg
805 mm segmented	31.69 in segmented	9.2 kg
900 mm	35.43 in	11.0 kg

42Cr: 900-1150 N/mm²



11700

200 kN/m max.



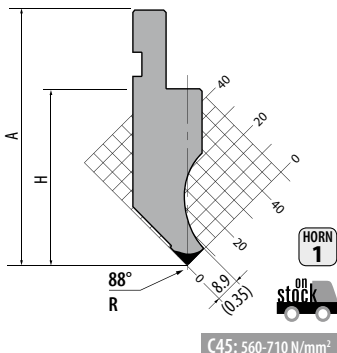
835 mm	32.87 in	10.7 kg
415 mm	16.34 in	5.3 kg
795 mm segmented	31.29 in segmented	10.2 kg
800 mm segmented	31.50 in segmented	10.3 kg

42Cr: 900-1150 N/mm²



P.97.88.R08 / PK.97.88.R025

1000 kN/m max.



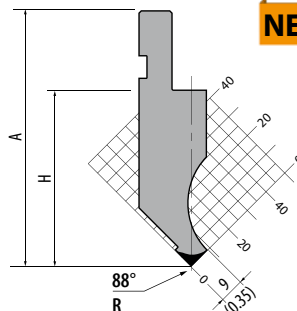
H=66.65 / A=96.65 / R=0.8 (H=2.62 / A=3.81 / R=0.031)		
835 mm	32.87 in	11.1 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.6 kg
805 mm segmented	31.69 in segmented	10.7 kg
900 mm	35.43 in	11.9 kg
H=66.60 / A=96.60 / R=0.25 (H=2.62 / A=3.80 / R=0.010)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.6 kg
900 mm	35.43 in	11.8 kg

C45: 560-710 N/mm²



00402 / 00430

1000 kN/m max.



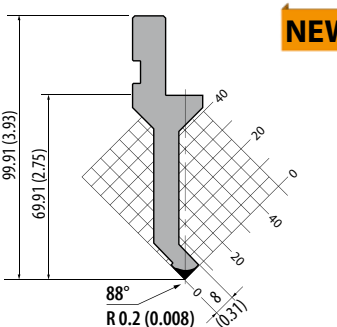
H=66.90 / A=96.90 / R=0.2 (H=2.63 / A=3.81 / R=0.008)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
800 mm segmented	31.50 in segmented	10.5 kg
H=65.68 / A=95.68 / R=3 (H=2.59 / A=3.77 / R=0.118)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
800 mm segmented	31.50 in segmented	10.5 kg

C45: 560-710 N/mm²



20000

300 kN/m max.



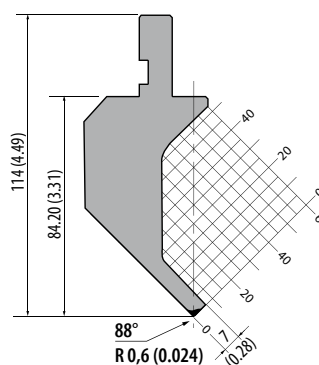
835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
800 mm segmented	31.50 in segmented	7.6 kg

42Cr: 900-1150 N/mm²



P.114.88.R06

200 kN/m max.



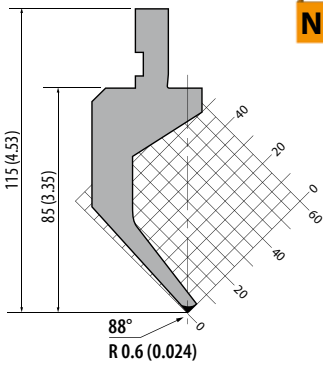
835 mm	32.87 in	15.6 kg
415 mm	16.34 in	7.7 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	15.0 kg

42Cr: 900-1150 N/mm²



P.115.88.R06

130 kN/m max.



NEW

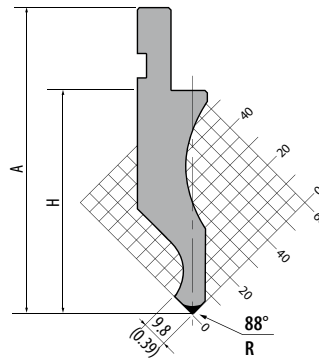
835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.7 kg
805 mm segmented	31.69 in segmented	5.8 kg

42Cr: 900-1150 N/mm²



D.116.88.R08 / R3

500 kN/m max.



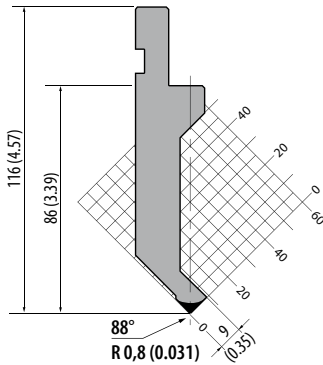
D.116.88.R08			H=86.00 / A=116.00 / R=0.8 (H=3.39 / A=4.57 / R=0.031)
835 mm	32.87 in	11.9 kg	
415 mm	16.34 in	5.8 kg	
795 mm segmented	31.29 in segmented	11.3 kg	
805 mm segmented	31.69 in segmented	11.5 kg	
D.116.88.R3			H=85.00 / A=115.00 / R=3.0 (H=3.35 / A=4.53 / R=0.118)
835 mm	32.87 in	11.9 kg	
415 mm	16.34 in	5.9 kg	
795 mm segmented	31.29 in segmented	11.3 kg	
805 mm segmented	31.69 in segmented	11.5 kg	

C45: 560-710 N/mm²



P.116.88.R08

400 kN/m max.



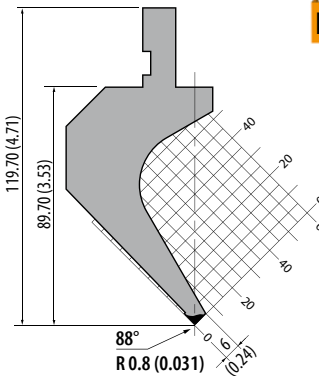
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.4 kg
805 mm segmented	31.69 in segmented	11.5 kg

C45: 560-710 N/mm²



PS.120.88.R08

450 kN/m max.



NEW

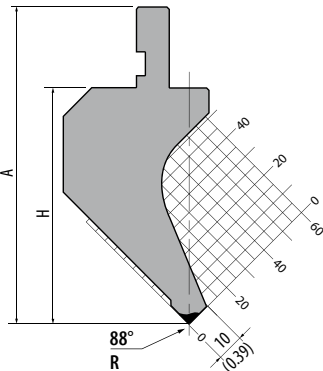
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg

C45: 560-710 N/mm²



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

600 kN/m max.



P.120.88.R08			H=89.65 / A=120.00 / R=0.8 (H=3.53 / A=4.72 / R=0.031)
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm segmented	31.29 in segmented	20.0 kg	
805 mm segmented	31.69 in segmented	20.2 kg	

P.120.88.R3			H=88.50 / A=118.50 / R=3.0 (H=3.48 / A=4.67 / R=0.118)
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm segmented	31.29 in segmented	20.0 kg	
805 mm segmented	31.69 in segmented	20.2 kg	

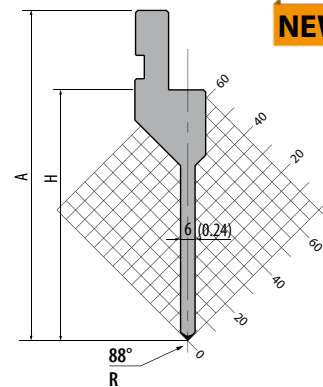
PK.120.88.R025			H=89.60 / A=120.00 / R=0.25 (H=3.53 / A=4.72 / R=0.010)
835 mm	32.87 in	21.0 kg	
415 mm	16.34 in	10.5 kg	
795 mm segmented	31.29 in segmented	20.0 kg	
805 mm segmented	31.69 in segmented	20.2 kg	

C45: 560-710 N/mm²



10900 / 10906

500 kN/m max.



NEW

10900			H=94.91 / A=124.91 / R=0.2 (H=3.74 / A=4.92 / R=0.008)
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm segmented	31.29 in segmented	8.5 kg	
800 mm segmented	31.50 in segmented	8.6 kg	

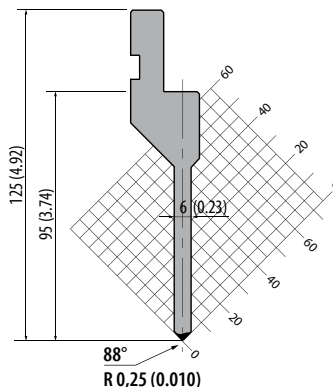
10906			H=94.74 / A=124.74 / R=0.6 (H=3.73 / A=4.91 / R=0.024)
835 mm	32.87 in	9.0 kg	
415 mm	16.34 in	4.5 kg	
795 mm segmented	31.29 in segmented	8.5 kg	
800 mm segmented	31.50 in segmented	8.6 kg	

42Cr: 900-1150 N/mm²



P.125.88.R025

500 kN/m max.



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

42Cr: 900-1150 N/mm²

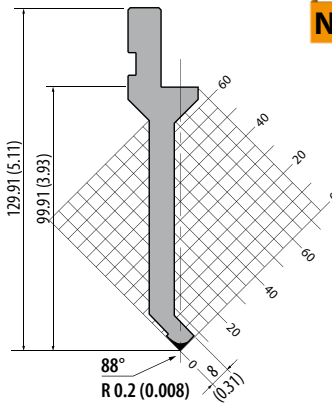


R1 ROLLER TYPE R1

88° Punches

20200

300 kN/m max.



NEW

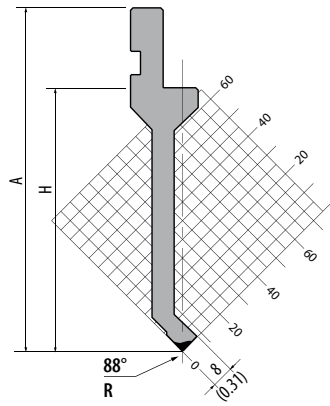
835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
800 mm segmented	31.50 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



P.130.88.R06 / PK.130.88.R025

350 kN/m max.



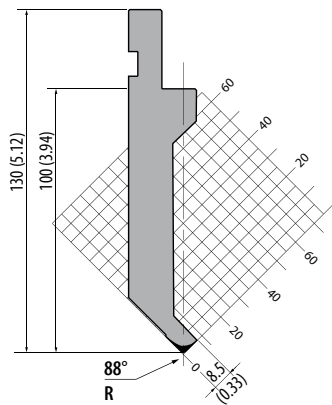
P.130.88.R06	H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024)	835 mm	32.87 in	9.8 kg
		415 mm	16.34 in	4.9 kg
		795 mm segmented	31.29 in segmented	9.3 kg
		805 mm segmented	31.69 in segmented	9.4 kg
		900 mm	35.43 in	10.5 kg

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

42Cr: 900-1150 N/mm² **HORN 1**

P.130.88.R08 / R025

400 kN/m max.



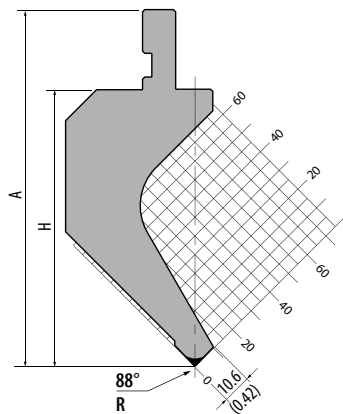
P.130.88.R08	H=100.00 / A=130.00 / R=0.8 (H=3.94 / A=5.12 / R=0.031)	835 mm	32.87 in	14.0 kg
		415 mm	16.34 in	7.0 kg
		795 mm segmented	31.29 in segmented	13.3 kg
		805 mm segmented	31.69 in segmented	13.4 kg

P.130.88.R025	H=100.00 / A=130.00 / R=0.25 (H=3.94 / A=5.12 / R=0.010)	835 mm	32.87 in	13.7 kg
		415 mm	16.34 in	6.8 kg
		795 mm segmented	31.29 in segmented	13.0 kg
		805 mm segmented	31.69 in segmented	13.2 kg

C45: 560-710 N/mm² **HORN 1**

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

500 kN/m max.



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

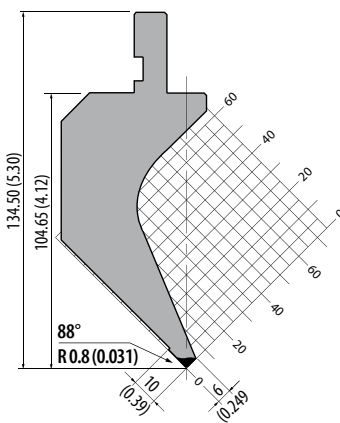
P.135.88.R3	H=103.40 / A=133.40 / R=3.0 (H=4.07 / A=5.25 / R=0.118)	835 mm	32.87 in	22.5 kg
		415 mm	16.34 in	11.2 kg
		795 mm segmented	31.29 in segmented	21.4 kg
		805 mm segmented	31.69 in segmented	21.7 kg

PK.135.88.R025	H=104.60 / A=134.50 / R=0.25 (H=4.12 / A=5.30 / R=0.010)	835 mm	32.87 in	22.7 kg
		415 mm	16.34 in	11.5 kg
		795 mm segmented	31.29 in segmented	21.6 kg
		805 mm segmented	31.69 in segmented	21.8 kg

C45: 560-710 N/mm² **HORN 1**

PS.135.88.R08

450 kN/m max.



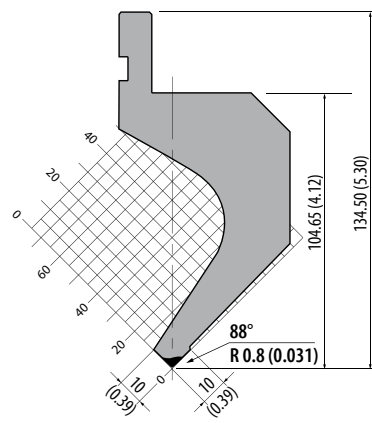
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	12.5 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



PR.135.88.R08

450 kN/m max.



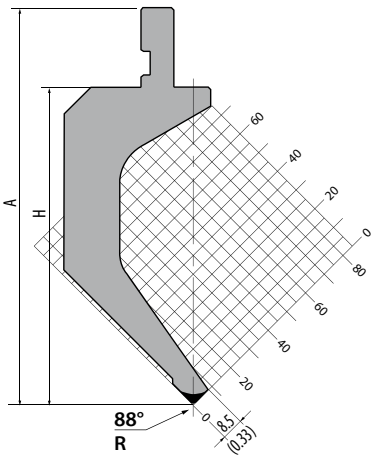
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	11.5 kg
795 mm segmented	31.29 in segmented	23.8 kg
805 mm segmented	31.69 in segmented	24.1 kg

C45: 560-710 N/mm²



P.150.88.R08 / R3

500 kN/m max.

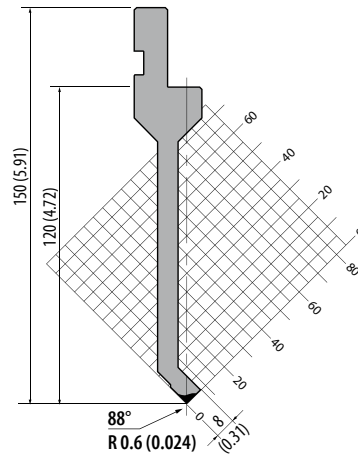


P.150.88.R08	H=120.00 / A=150.00 / R=0.8 (H=4.72 / A=5.91 / R=0.031)		
	835 mm	32.87 in	21.5 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.4 kg
	805 mm segmented	31.69 in segmented	20.7 kg
900 mm	35.43 in	23.1 kg	
P.150.88.R3	H=119.00 / A=149.00 / R=3.0 (H=4.69 / A=5.87 / R=0.118)		
	835 mm	32.87 in	21.0 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	19.9 kg
	805 mm segmented	31.69 in segmented	20.2 kg
900 mm	35.43 in	22.6 kg	

42Cr: 900-1150 N/mm²

P.150.88.R06

350 kN/m max.

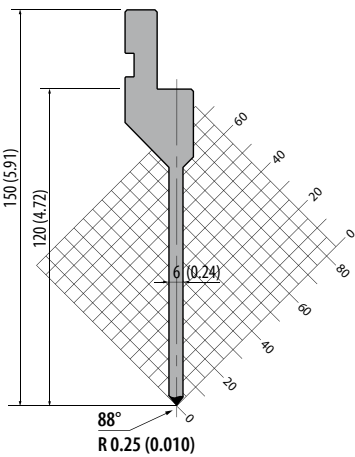


900 mm	35.43 in	12.9 kg
415 mm	16.34 in	5.9 kg
795 mm segmented	31.29 in segmented	12.2 kg
805 mm segmented	31.69 in segmented	12.4 kg

42Cr: 900-1150 N/mm²

P.150.88.R025

500 kN/m max.

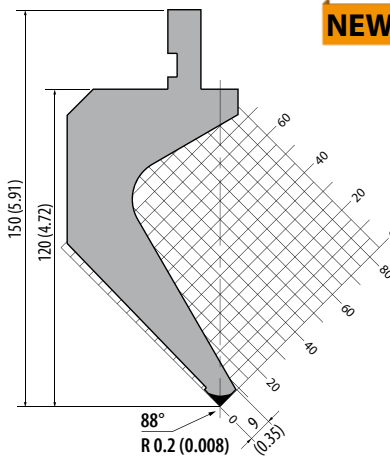


900 mm	32.87 in	10.0 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.6 kg

42Cr: 900-1150 N/mm²

04702

500 kN/m max.



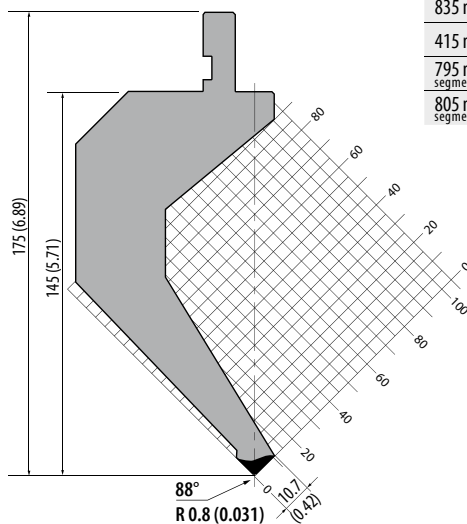
NEW

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

42Cr: 900-1150 N/mm²

P.175.88.R08

500 kN/m max.



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

C45: 560-710 N/mm²

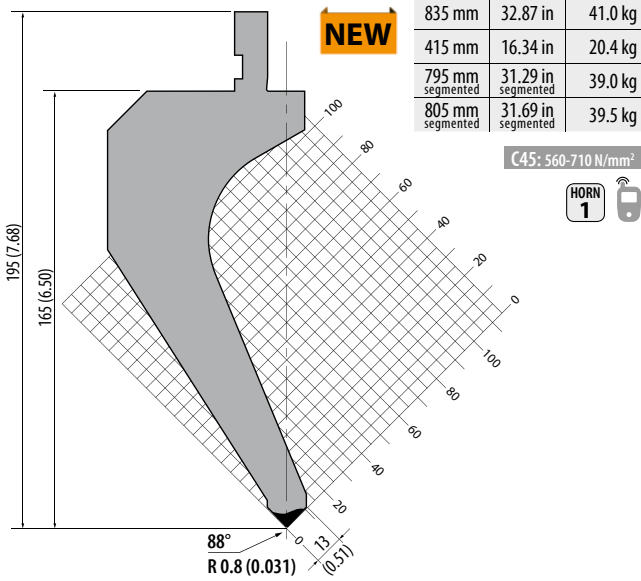


R1 ROLLER TYPE R1

88° Punches

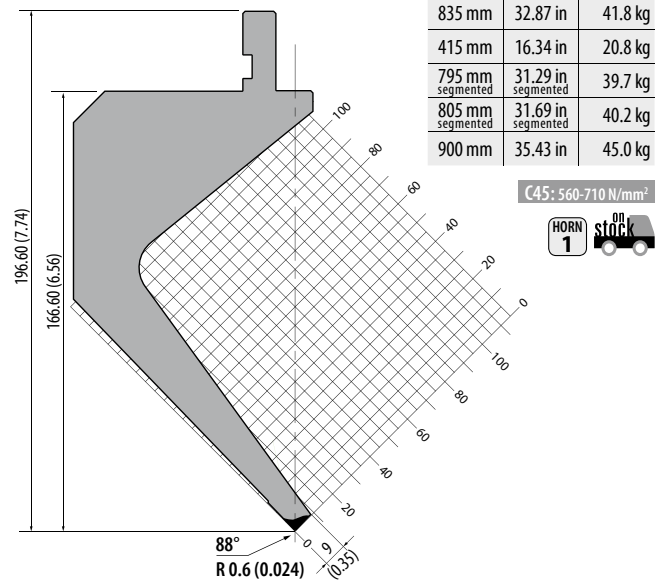
P.195.88.R08

600 kN/m max.

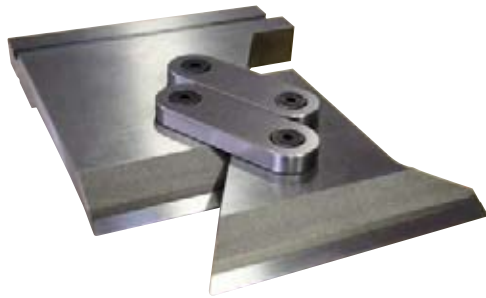


P.196.88.R06

300 kN/m max.



88° Segmented Punches with Mobile Horns

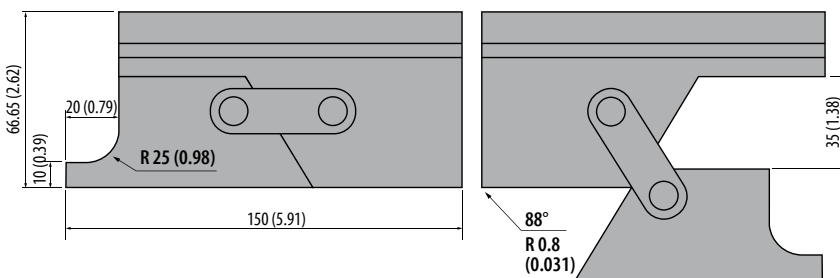


Area of Application

- for easy bending of special box profiles

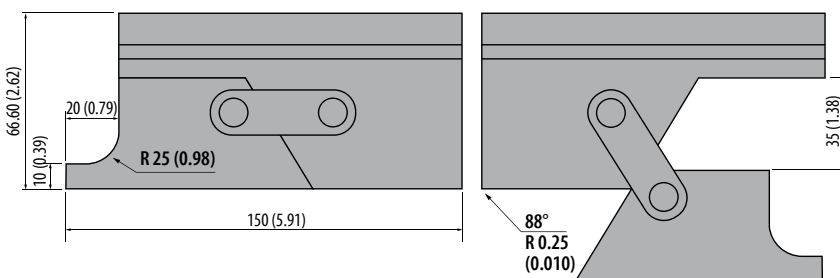
SCA.M.88.R08

150 kN/m max.



SCA.M.88.R025

150 kN/m max.



R1 ROLLER TYPE R1

88° Punches for closed profiles



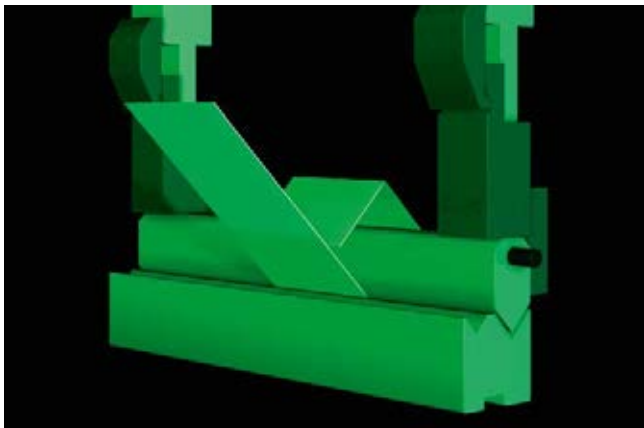
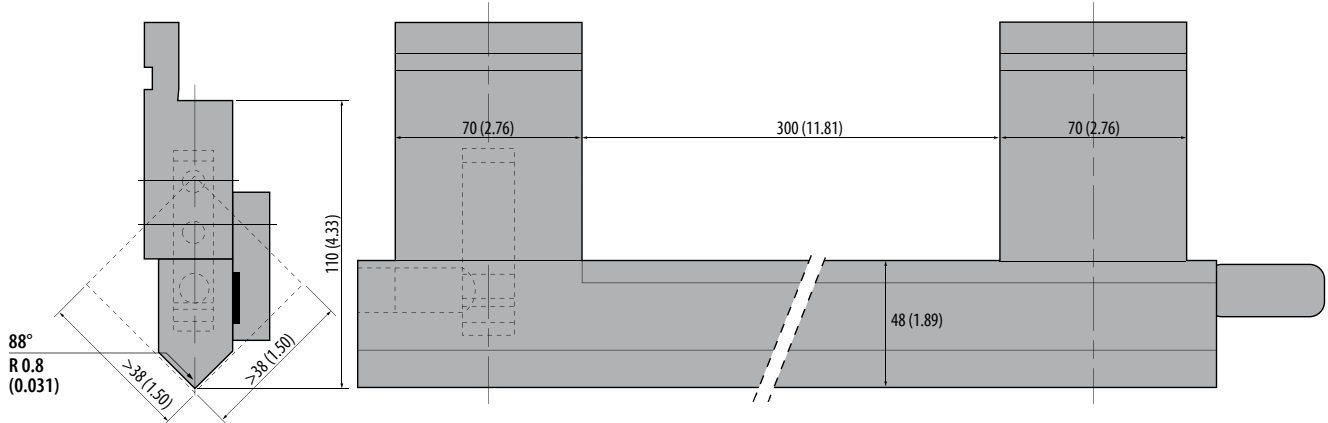
1
R1

SPE.11

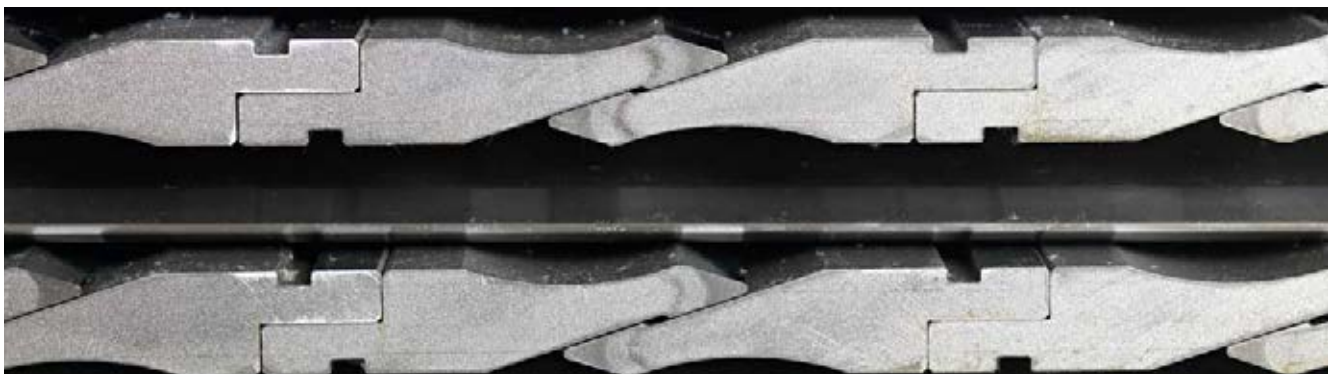
150 kN/m.max.

per piece 7.0 kg

42Cr-900-1150N/mm²



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



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



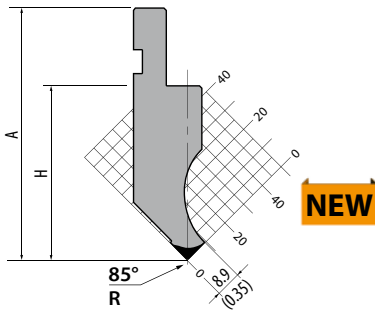
Articles on stock – Please note that delivery time depends on your location.

R1 ROLLER TYPE R1

85° Punches

P.97.85.R08 / PK.95.85.R3

1000 kN/m max.

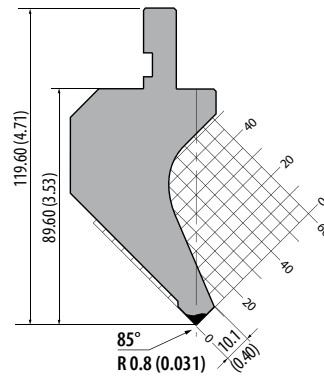


P.97.85.R08		
H=66.60 / A=96.50 / R=0.8 (H=2.62 / A=3.80 / R=0.031)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg
PK.95.85.R3		
H=65.45 / A=95.45 / R=3.0 (H=2.58 / A=3.76 / R=0.118)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm² **HORN 1**

PK.120.85.R08

600 kN/m max.



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

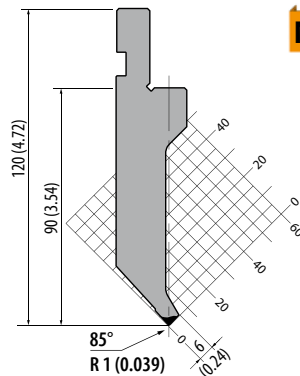
C45: 560-710 N/mm²

HORN 1



P.120.85.R1

800 kN/m max.



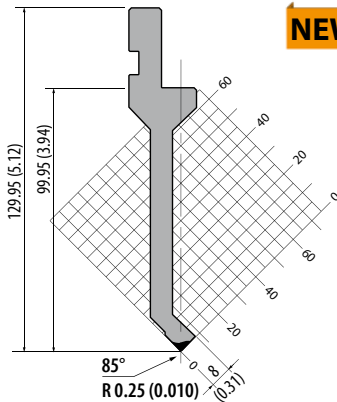
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.7 kg
795 mm segmented	31.29 in segmented	12.9 kg
805 mm segmented	31.69 in segmented	13.0 kg

42Cr: 900-1150 N/mm²

HORN 1

P.130.85.R025

350 kN/m max.



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

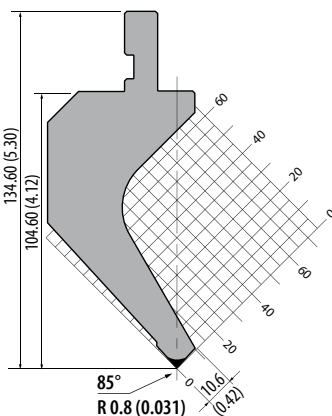
42Cr: 900-1150 N/mm²

HORN 1



PK.135.85.R08

500 kN/m max.



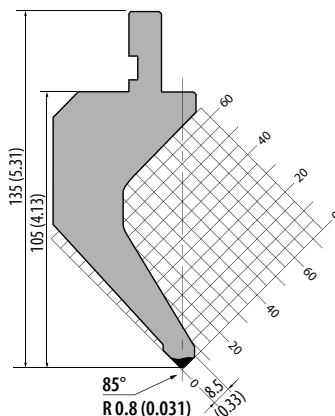
835 mm	32.87 in	22.2 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	21.1 kg
805 mm segmented	31.69 in segmented	21.4 kg

C45: 560-710 N/mm²

HORN 1

P.135.85.R08

800 kN/m max.



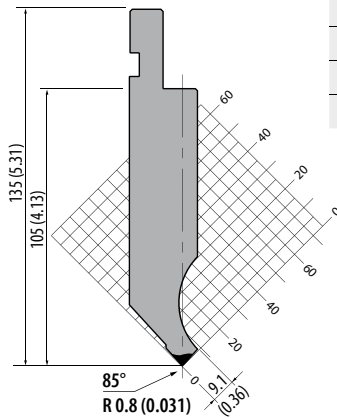
835 mm	32.87 in	20.9 kg
415 mm	16.34 in	10.4 kg
795 mm segmented	31.29 in segmented	19.9 kg
805 mm segmented	31.69 in segmented	20.1 kg

42Cr: 900-1150 N/mm²

HORN 1

PS.135.85.R08

1000 kN/m max.



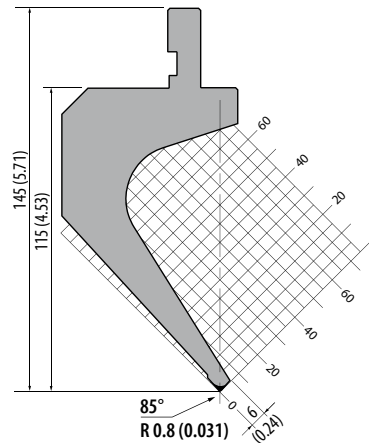
835 mm	32.87 in	17.7 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	16.8 kg
805 mm segmented	31.69 in segmented	17.0 kg

C45: 560-710 N/mm²



P.145.85.R08

600 kN/m max.



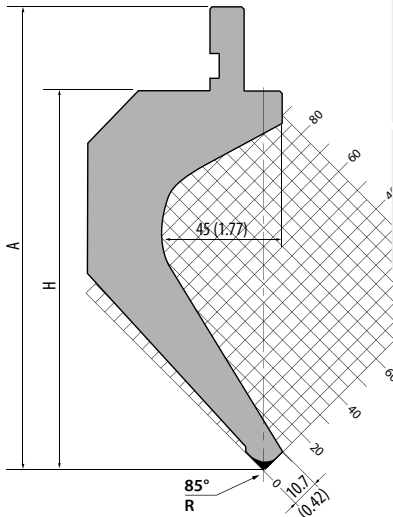
835 mm	32.87 in	22.6 kg
415 mm	16.34 in	11.2 kg
795 mm segmented	31.29 in segmented	21.5 kg
805 mm segmented	31.69 in segmented	21.7 kg

42Cr: 900-1150 N/mm²



TOP.175.85.R08 / R2

900 kN/m max.



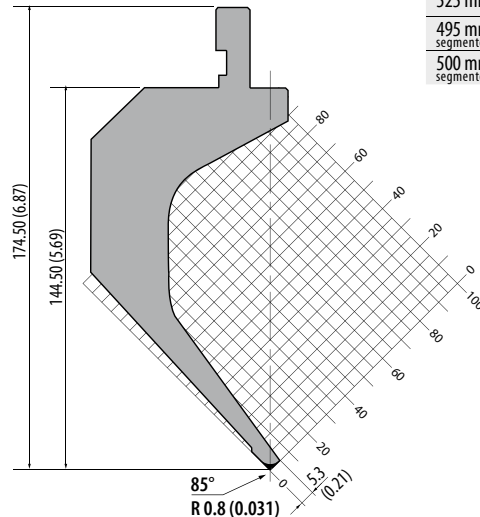
TOP.175.85.R08		
H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
525 mm	20.67 in	20.9 kg
495 mm segmented	19.49 in segmented	19.7 kg
500 mm segmented	19.68 in segmented	19.9 kg
TOP.175.85.R2		
H=144.30 / A=174.30 / R=2.0 (H=5.68 / A=6.86 / R=0.079)		
525 mm	20.67 in	20.9 kg
495 mm segmented	19.49 in segmented	19.7 kg
500 mm segmented	19.68 in segmented	19.9 kg

42Cr: 900-1150 N/mm²



TOP.175.85.R08.S

200 kN/m max.



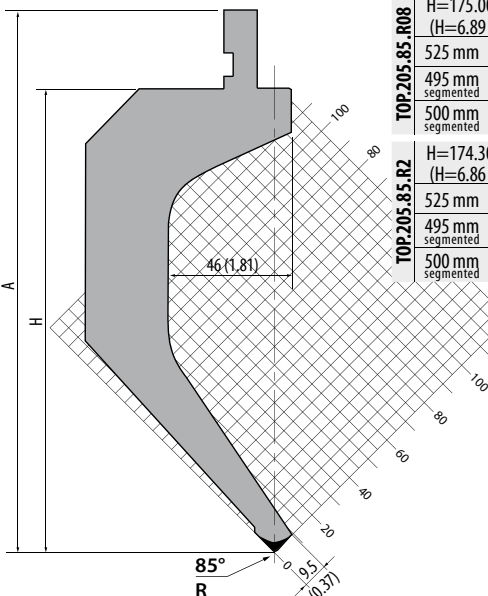
525 mm	20.67 in	18.5 kg
495 mm segmented	19.49 in segmented	17.4 kg
500 mm segmented	19.68 in segmented	17.6 kg

42Cr: 900-1150 N/mm²



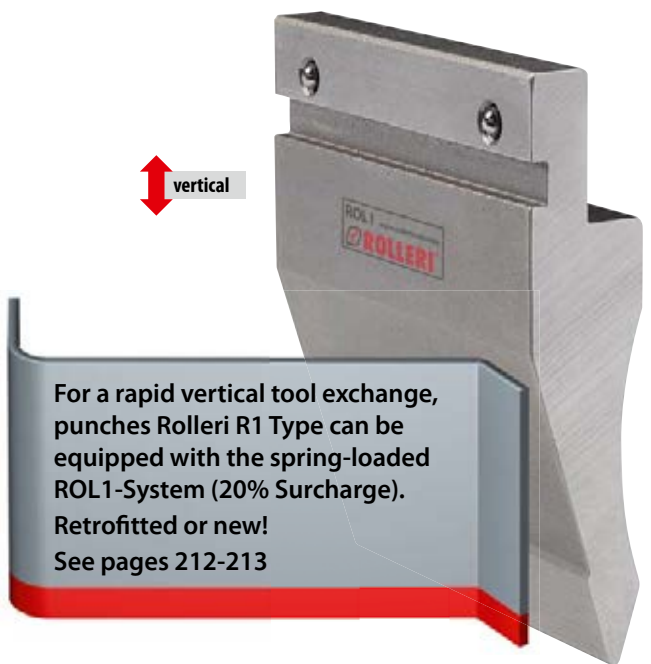
TOP.205.85.R08 / R2

700 kN/m max.



TOP.205.85.R08		
H=175.00 / A=205.00 / R=0.8 (H=6.89 / A=8.07 / R=0.031)		
525 mm	20.67 in	24.0 kg
495 mm segmented	19.49 in segmented	22.6 kg
500 mm segmented	19.68 in segmented	22.9 kg
TOP.205.85.R2		
H=174.30 / A=204.30 / R=2.0 (H=6.86 / A=8.04 / R=0.079)		
525 mm	20.67 in	24.0 kg
495 mm segmented	19.49 in segmented	22.6 kg
500 mm segmented	19.68 in segmented	22.9 kg

42Cr: 900-1150 N/mm²



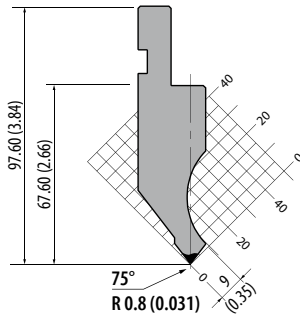
For a rapid vertical tool exchange, punches Rolleri R1 Type can be equipped with the spring-loaded ROL1-System (20% Surcharge).
Retrofitted or new!
See pages 212-213

R1 ROLLER TYPE R1

75° Punches

P.97.75.R08

1000 kN/m max.



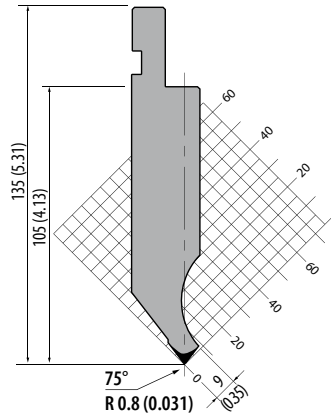
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

42Cr: 900-1150 N/mm²



P.135.75.R08

1000 kN/m max.



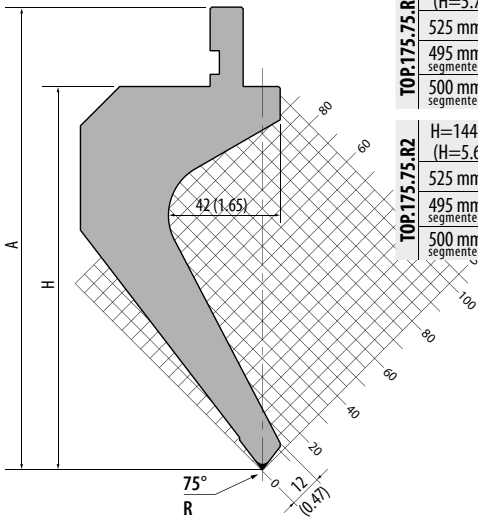
835 mm	32.87 in	17.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	16.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



TOP.175.75.R08 / R2

750 kN/m max.



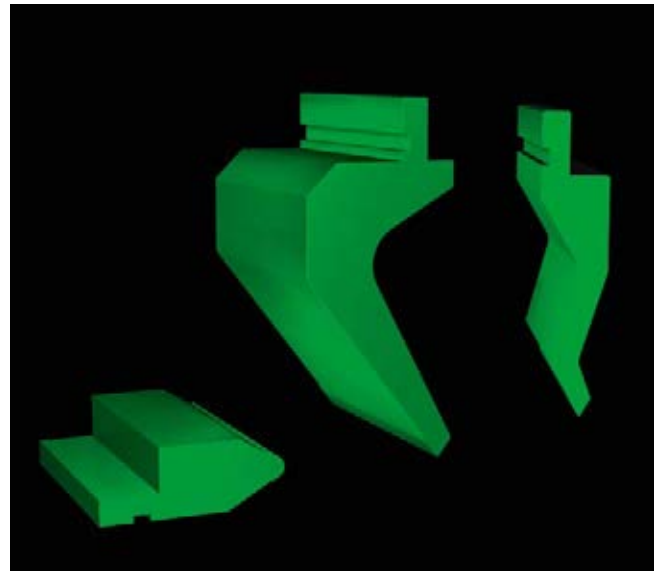
TOP.175.75.R08 H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)

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

TOP.175.75.R2 H=144.20 / A=174.20 / R=2.0 (H=5.68 / A=6.86 / R=0.079)

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

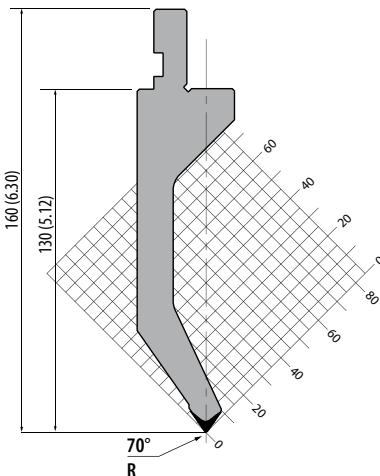
42Cr: 900-1150 N/mm²



70° Punches

P.160.70.R08 / R3

450 kN/m max.



R=0.8 (0.031)

835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

R=3.0 (0.118)

835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

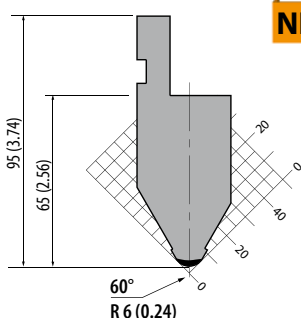
42Cr: 900-1150 N/mm²



Modifications of Standard Tools: rapid and precise, directly from the manufacturer!
See pages 256-261

00300

1000 kN/m max.



NEW

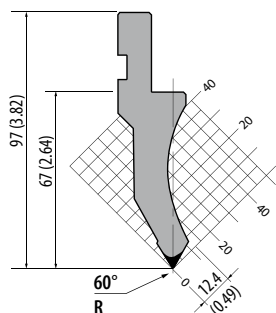
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.2 kg
800 mm segmented	31.50 in segmented	14.4 kg

C45: 560-710 N/mm²



P.97.60.R08 / R2

600 kN/m max.



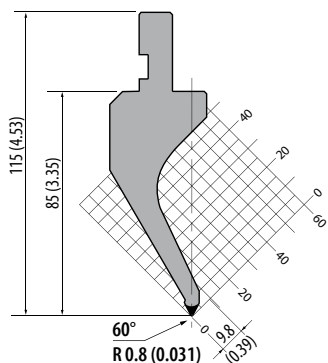
R=0.8 (0.031)			
P.97.60.R08	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	805 mm segmented	31.69 in segmented	8.7 kg
R=2.0 (0.079)			
P.97.60.R2	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	5.0 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	805 mm segmented	31.69 in segmented	8.7 kg

C45: 560-710 N/mm²



P.115.60.R08

400 kN/m max.



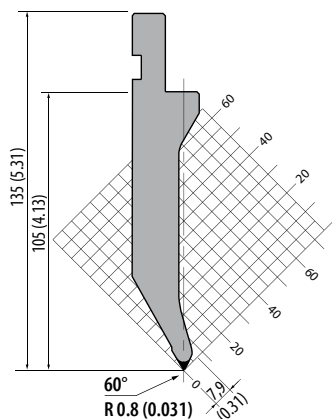
835 mm	32.87 in	11.9 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.3 kg
805 mm segmented	31.69 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



P.135.60.R08

800 kN/m max.



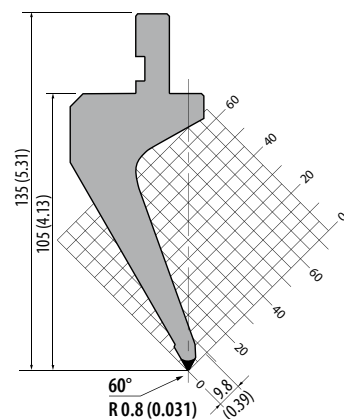
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm²



PG.135.60.R08

700 kN/m max.



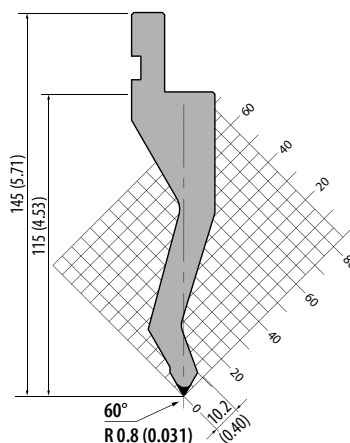
835 mm	32.87 in	16.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	15.7 kg
805 mm segmented	31.69 in segmented	15.9 kg

42Cr: 900-1150 N/mm²



P.145.60.R08

700 kN/m max.



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

42Cr: 900-1150 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



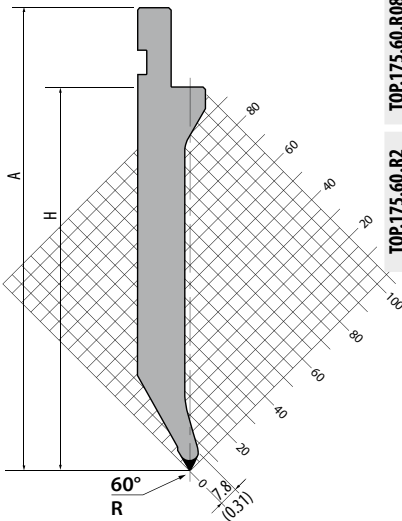
Articles on stock – Please note that delivery time depends on your location.

R1 ROLLERI TYPE R1

60° Punches

TOP.175.60.R08 / R2

800 kN/m max.



TOP.175.60.R08		
H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

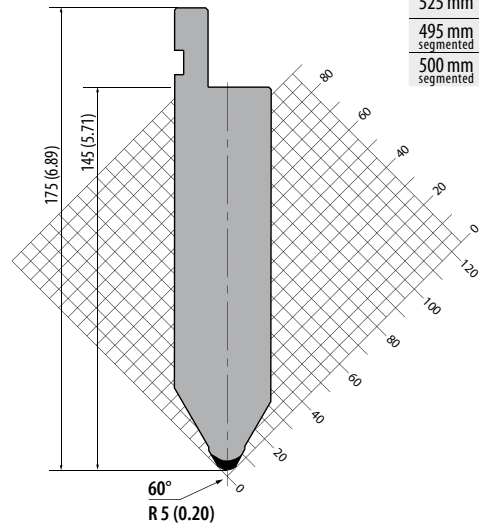
TOP.175.60.R2		
H=143.80 / A=173.80 / R=2.0 (H=5.66 / A=6.84 / R=0.079)		
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



TOP.175.60.R5

1600 kN/m max.



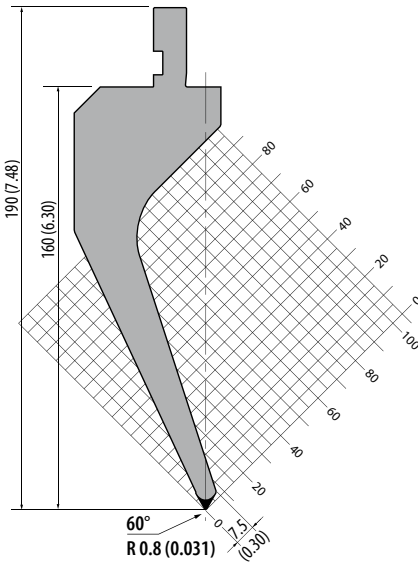
525 mm	20.67 in	22.0 kg
495 mm segmented	19.49 in segmented	20.7 kg
500 mm segmented	19.68 in segmented	20.9 kg

42Cr: 900-1150 N/mm²



P.190.60.R08

400 kN/m max.



835 mm	32.87 in	41.8 kg
415 mm	16.34 in	27.0 kg
795 mm segmented	31.29 in segmented	39.8 kg
805 mm segmented	31.69 in segmented	40.2 kg

C45: 800-850 N/mm²

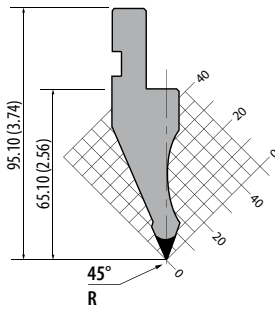


Take advantage of the wide range of Rolleri R1 Type punches by using our extensive number of adapters. See pages 220-225



P.95.45.R08 / R15

800 kN/m max.



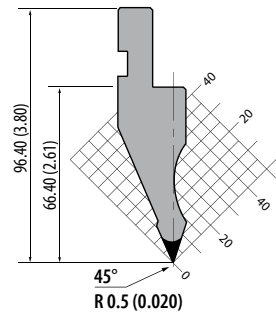
R=0.8 (0.031)			
P.95.45.R08	835 mm	32.87 in	9.5 kg
	415 mm	16.34 in	4.2 kg
	795 mm segmented	31.29 in segmented	9.0 kg
	805 mm segmented	31.69 in segmented	9.0 kg
R=1.5 (0.059)			
P.95.45.R15	835 mm	32.87 in	9.5 kg
	415 mm	16.34 in	4.2 kg
	795 mm segmented	31.29 in segmented	9.5 kg
	805 mm segmented	31.69 in segmented	9.5 kg

C45: 560-710 N/mm²



P.97.45.R05

800 kN/m max.



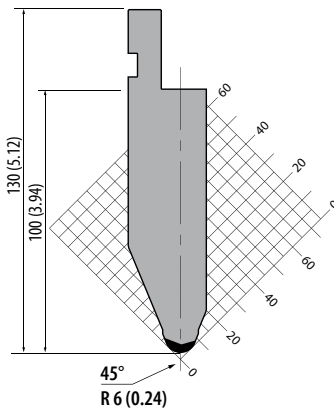
835 mm	32.87 in	10.2 kg
415 mm	16.34 in	5.1 kg
795 mm segmented	31.29 in segmented	9.7 kg
805 mm segmented	31.69 in segmented	9.8 kg
900 mm	35.43 in	10.9 kg

C45: 560-710 N/mm²



P.130.45.R6

1000 kN/m max.



835 mm	32.87 in	19.5 kg
415 mm	16.34 in	9.6 kg
795 mm segmented	31.29 in segmented	18.6 kg
805 mm segmented	31.69 in segmented	18.8 kg

C45: 560-710 N/mm²



Faster vertical tool exchange with ROL100
See pages 210-211

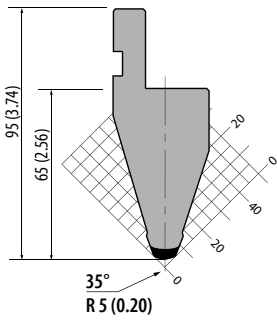


R1 ROLLER TYPE R1

35° Punches

P.95.35.R5

1000 kN/m max.



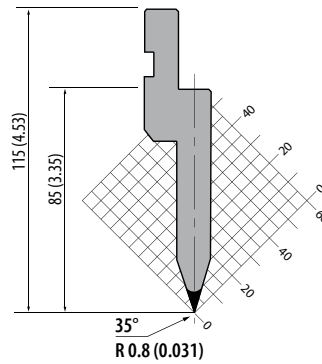
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm²



PU.85.35.R08

1000 kN/m max.



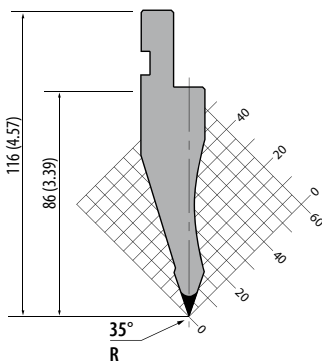
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.116.35.R08 / R15

700 kN/m max.



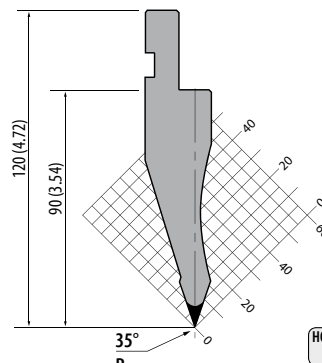
R=0.8 (0.031)			
P.116.35.R08	835 mm	32.87 in	10.5 kg
	415 mm	16.34 in	5.7 kg
	795 mm segmented	31.29 in segmented	10.0 kg
	805 mm segmented	31.69 in segmented	10.1 kg
R=1.5 (0.059)			
P.116.35.R15	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.7 kg
	795 mm segmented	31.29 in segmented	10.4 kg
	805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.120.35.R08 / R15 / R3

700 kN/m max.



R=0.8 (0.031)			
P.120.35.R08	835 mm	32.87 in	12.3 kg
	415 mm	16.34 in	6.0 kg
	795 mm segmented	31.29 in segmented	11.7 kg
	805 mm segmented	31.69 in segmented	11.9 kg
R=1.5 (0.059)			
P.120.35.R15	835 mm	32.87 in	12.5 kg
	415 mm	16.34 in	6.0 kg
	795 mm segmented	31.29 in segmented	11.9 kg
	805 mm segmented	31.69 in segmented	12.1 kg
R=3.0 (0.118)			
P.120.35.R3	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.4 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg

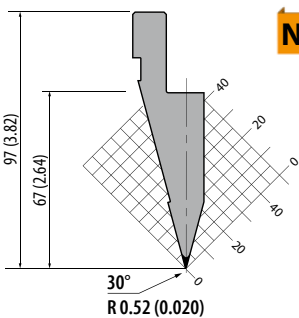
C45: 560-710 N/mm²



30° Punches

10300

1000 kN/m max.



NEW

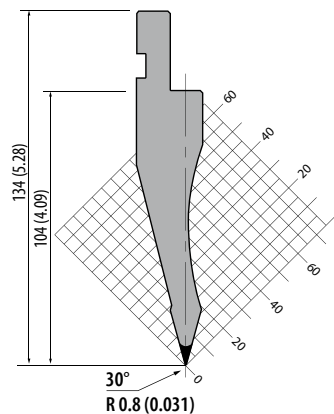
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
800 mm segmented	31.50 in segmented	10.6 kg

42Cr: 900-1150 N/mm²



PS.134.30.R08

700 kN/m max.



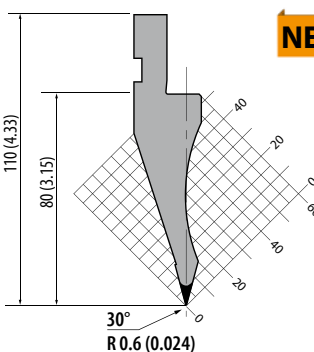
835 mm	32.87 in	13.3 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.6 kg
805 mm segmented	31.69 in segmented	12.8 kg

C45: 560-710 N/mm²



P.110.30.R06

500 kN/m max.



NEW

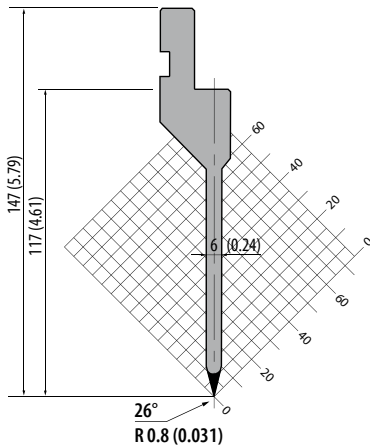
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.50 in segmented	10.1 kg

C45: 560-710 N/mm²



P.147.26.R08

500 kN/m max.



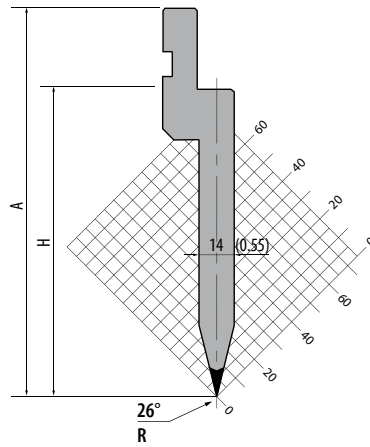
835 mm	32.87 in	9.8 kg
415 mm	16.34 in	4.9 kg
795 mm segmented	31.29 in segmented	9.3 kg
805 mm segmented	31.69 in segmented	9.4 kg

42Cr: 900-1150 N/mm²



PU.117.26.R08 / R3

1000 kN/m max.



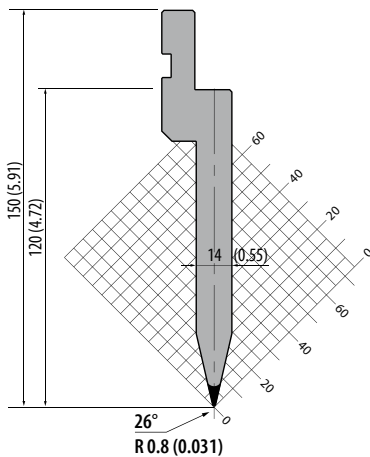
H=117.00 / A=147.00 / R=0.8 (H=4.61 / A=5.79 / R=0.031)		
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

H=109.00 / A=139.00 / R=3.0 (H=4.29 / A=5.47 / R=0.118)		
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.7 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm² HORN 1 stock icon

PU.150.26.R08.L

1000 kN/m max.



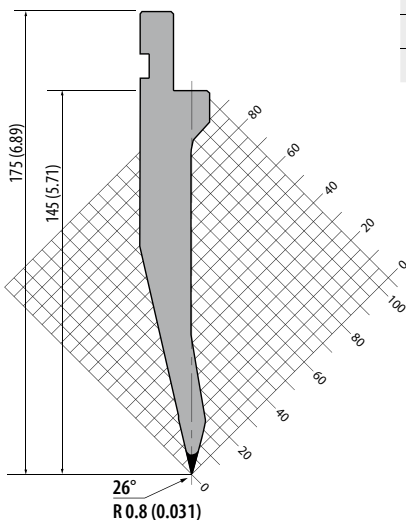
900 mm	35.43 in	15.0 kg
415 mm	16.34 in	6.2 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



TOP.175.26.R08

950 kN/m max.



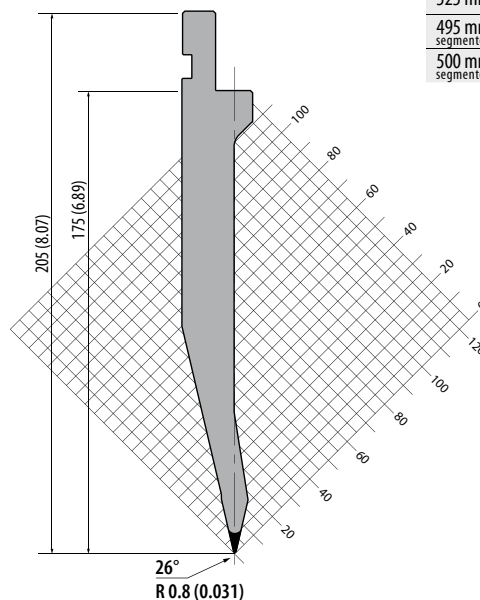
525 mm	20.67 in	11.0 kg
495 mm segmented	19.49 in segmented	10.4 kg
500 mm segmented	19.68 in segmented	10.5 kg

42Cr: 900-1150 N/mm²



TOP.205.26.R08

950 kN/m max.



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

42Cr: 900-1150 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

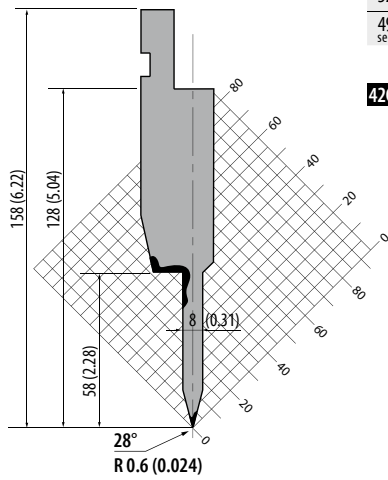


Articles on stock – Please note that delivery time depends on your location.

R1 ROLLER TYPE R1

28°/24° Hemming tools

TOP.SP.134.28.8

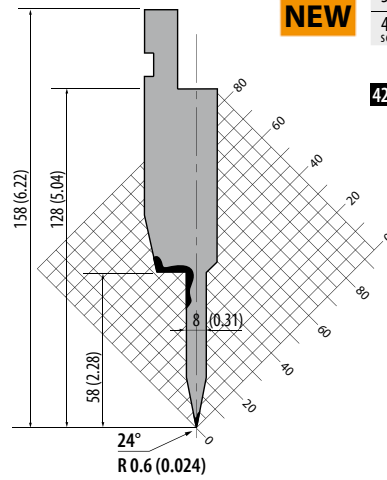


525 mm	20.67 in	11.0 kg
495 mm segmented	19.49 in segmented	10.3 kg

42Cr: 900-1150 N/mm²



TOP.SP.134.24.8



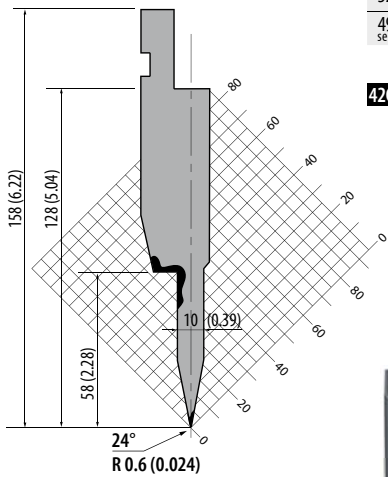
NEW

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

42Cr: 900-1150 N/mm²



TOP.SP.134.24.10

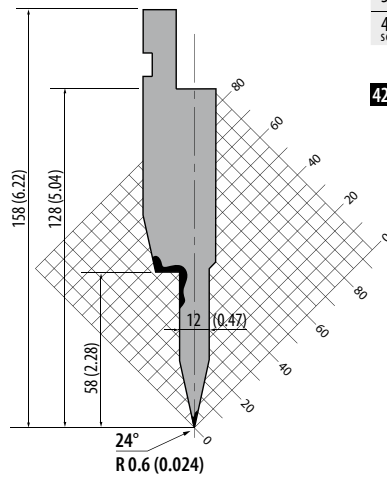


525 mm	20.67 in	11.0 kg
495 mm segmented	19.49 in segmented	10.3 kg

42Cr: 900-1150 N/mm²



TOP.SP.134.24.12



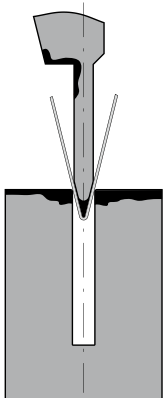
525 mm	20.67 in	11.6 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

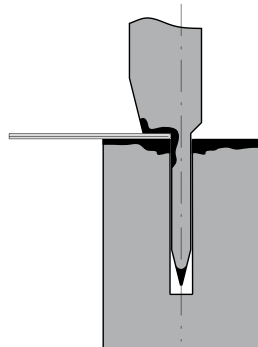


Only for thin material!
Hemming Dies
See page 75

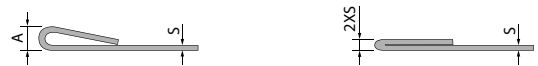
Example of application



800 kN/m max.



1000 kN/m max.



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

R1 ROLLER TYPE R1

Z-Profile Tools



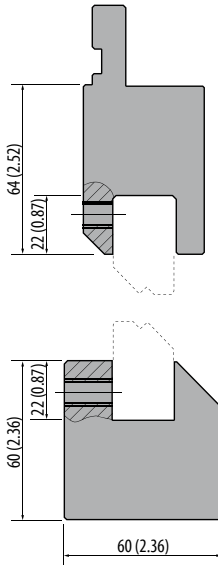
1
R1

CPZ

1000 kN/m max.

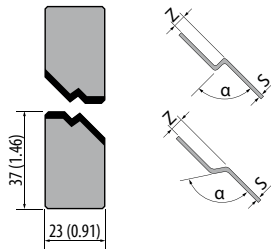
835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.7 kg

C45: 560-710 N/mm²



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

1000 kN/m max.



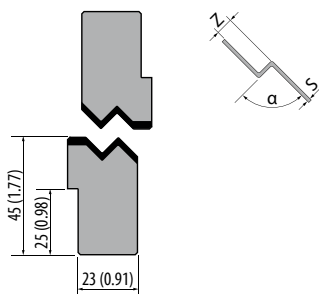
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°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

C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

Z-Tool Inserts 90°

1000 kN/m max.



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

C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



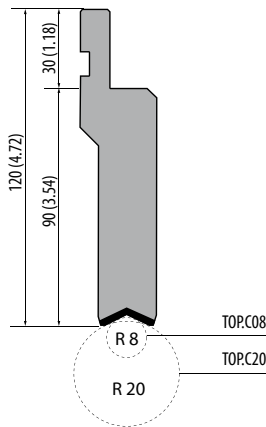
Articles on stock – Please note that delivery time depends on your location.

R1 ROLLERI TYPE R1

Radius Tools

TOP.PC.120-08

1000 kN/m max.



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

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

42Cr: 900-1150 N/mm²

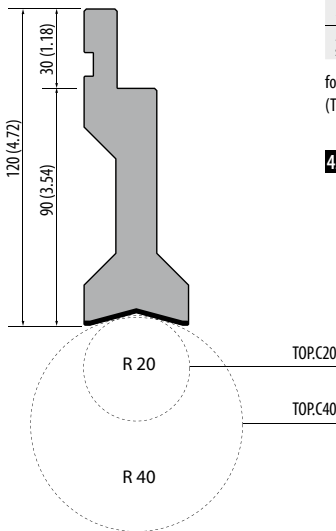


Radius Punches by Rolleri also sectioned on stock! Take advantage of this flexibility!



TOP.PC.120-20

1000 kN/m max.



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

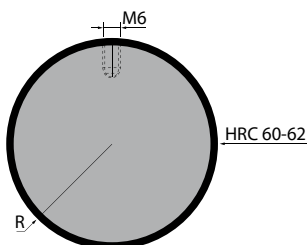
for Radius tools with R20-R40 (TOP.C20-TOP.C40) see below

42Cr: 900-1150 N/mm²



TOP-Radius Tools: R8-40

1000 kN/m max.



Material: C53 induction hardened 60-62 HRC

C53: 610-760 N/mm²



Model	R mm	R in	Weight	
TOP.C08	8	0.31	0.8 kg	1.9 kg
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg

R1 ROLLER TYPE R1

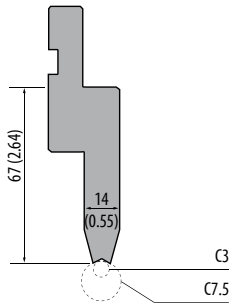
Radius Tools



1
R1

PU.67.14-S

400 kN/m max.



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

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

C45: 560-710 N/mm²



Mark-free bending
with PU-Upholstery
See pages 234-235

C3 - C7.5

400 kN/m max.



C45: 560-710 N/mm²

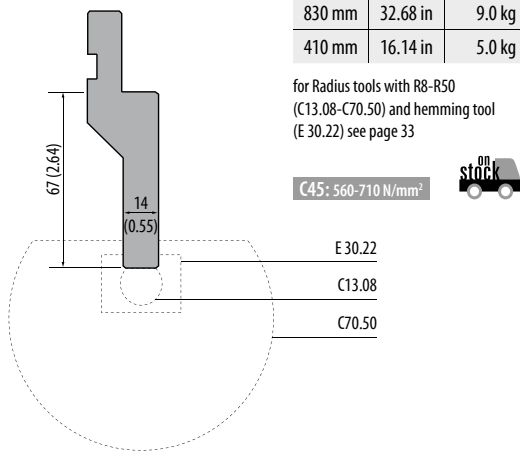
Model	R mm	R in	Weight	
C3	3.0	0.12	0.20 kg	0.10 kg
C3.5	3.5	0.14	0.20 kg	0.10 kg
C4	4.0	0.16	0.35 kg	0.17 kg
C4.5	4.5	0.18	0.50 kg	0.25 kg
C5	5.0	0.20	0.60 kg	0.30 kg
C5.5	5.5	0.22	0.70 kg	0.35 kg
C6	6.0	0.24	0.80 kg	0.40 kg
C6.5	6.5	0.26	1.00 kg	0.50 kg
C7	7.0	0.28	0.80 kg	0.40 kg
C7.5	7.5	0.30	1.00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

R1 ROLLER TYPE R1

Radius Tools

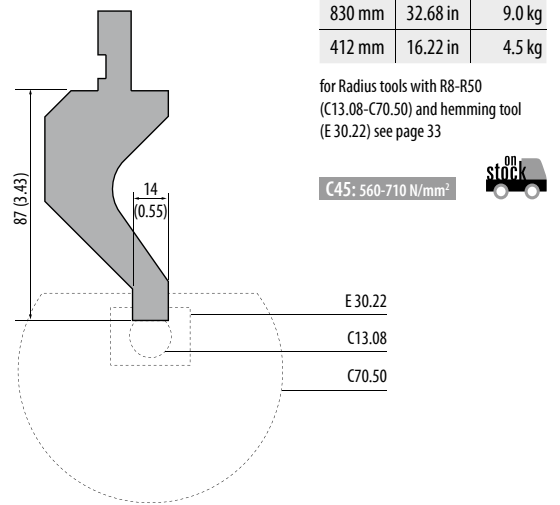
PU.67.14

800 kN/m max.



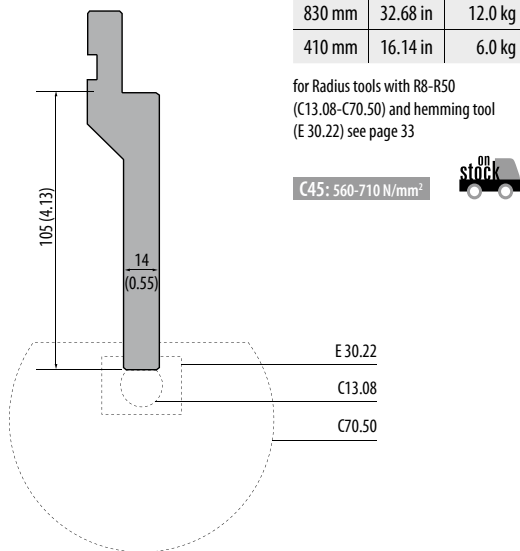
PU.87.14

500 kN/m max.



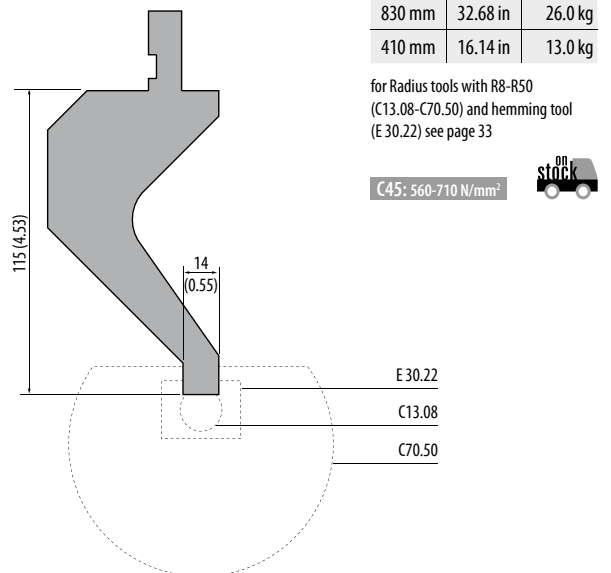
PU.105.14

800 kN/m max.



PU.115.14

500 kN/m max.



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



R1 ROLLER TYPE R1

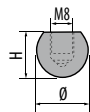
Radius Tools



1
R1

Radius Tool: Ø 16-20 mm (0.63-0.79 in)

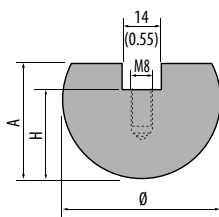
800 kN/m max.



Model	Ø mm	Ø in	H mm	H in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight
C13.08	16	0.63	13	0.51	835 mm / 32.87 in	2.00 kg	415 mm / 16.34 in	1.00 kg
C13.09	18	0.71	16	0.63		2.00 kg		1.00 kg
C16.10	20	0.79	16	0.63		2.00 kg		1.00 kg

Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.

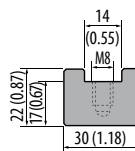
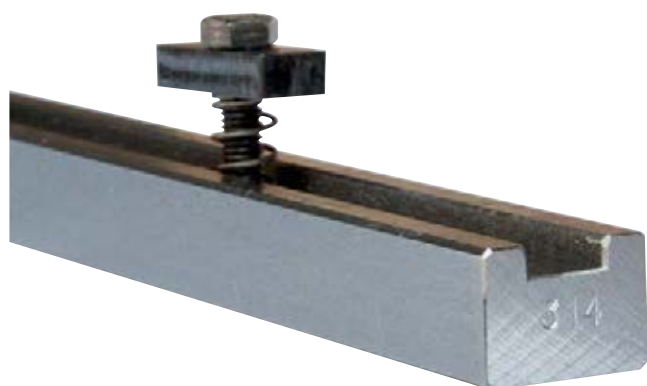


Model	Ø mm	Ø in	H mm	H in	A mm	A in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight
C17.12	25	0.98	17	0.67	22	0.87	835 mm / 32.87 in	2.5 kg	415 mm / 16.34 in	1.2 kg
C20.15	30	1.18	20	0.79	27	1.06		3.7 kg		1.8 kg
C22.17	35	1.38	22	0.87	32	1.26		5.0 kg		2.4 kg
C24.20	40	1.57	24	0.94	34	1.34		7.0 kg		3.5 kg
C29.25	50	1.97	29	1.14	39	1.54		10.0 kg		4.7 kg
C34.30	60	2.36	34	1.34	44	1.73		13.5 kg		6.7 kg
C45.35	70	2.76	45	1.77	55	2.17		20.3 kg		10.0 kg
C45.40	80	3.15	45	1.77	55	2.17		23.0 kg		11.5 kg
C60.45	90	3.54	60	2.36	70	2.76		34.0 kg		17.0 kg
C70.50	100	3.94	70	2.76	80	3.15		43.5 kg		21.7 kg

Hemming Tool

E30.22

800 kN/m max.



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

C45: 560-710 N/mm²



R1 ROLLER TYPE R1

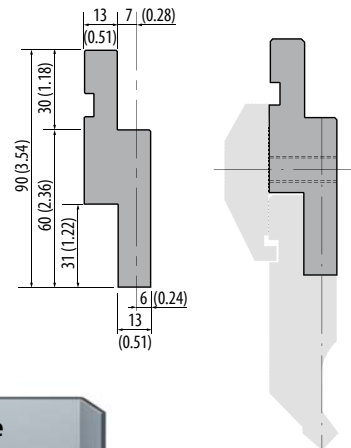
Punch extensions / Intermediates

Our Advantages – Your Convenience

- Wedge crowning prevents deflection
- Increase in leg length
- for special increase in leg length see SPE-p4 in the area of special tools on page 245

AD4

1000 kN/m max.



per piece	1.8 kg
-----------	--------

L=150 mm
Punch extension
without wedge crowning

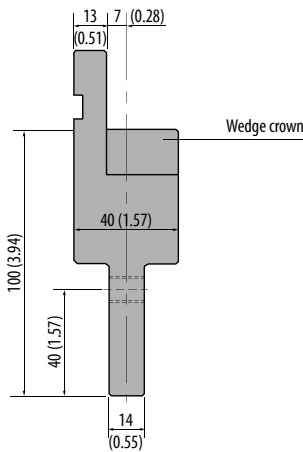
C45: 560-710 N/mm²



Compatible
tensioner
see page 208

INT100

1000 kN/m max.



per piece	3.5 kg
-----------	--------

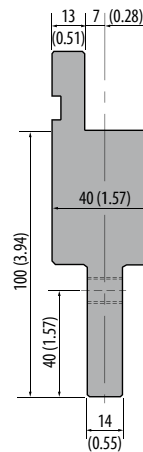
L=150 mm

C45: 560-710 N/mm²



INT100 FISSO

1000 kN/m max.



per piece	4.0 kg
-----------	--------

L=150 mm

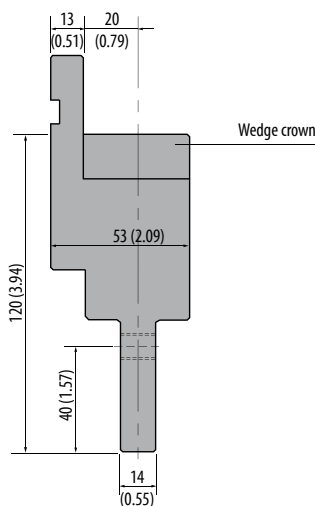
Punch extension
without wedge crowning

C45: 560-710 N/mm²



INT120-40

1000 kN/m max.



per piece	5.2 kg
-----------	--------

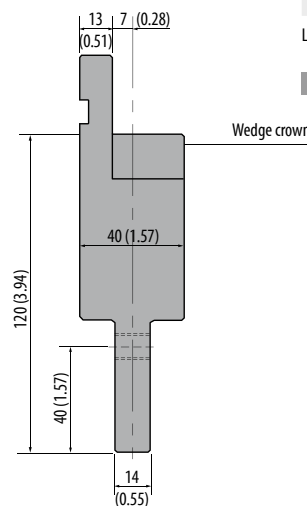
L=150 mm

C45: 560-710 N/mm²



INT120

1000 kN/m max.



per piece	4.5 kg
-----------	--------

L=150 mm

C45: 560-710 N/mm²

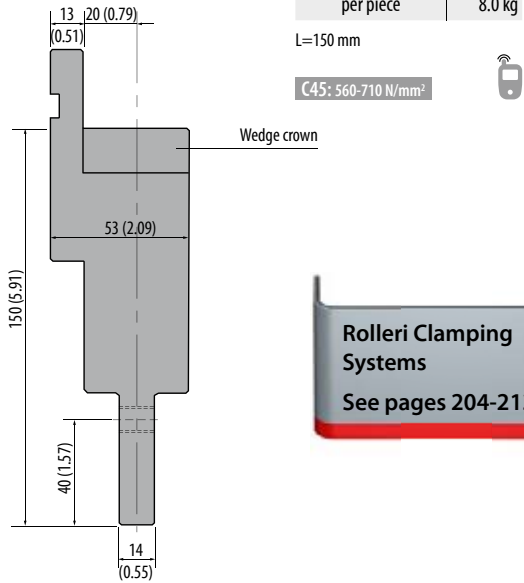


Intermediates also
available in L=70 mm
upon request.

INT150-40

1000 kN/m max.

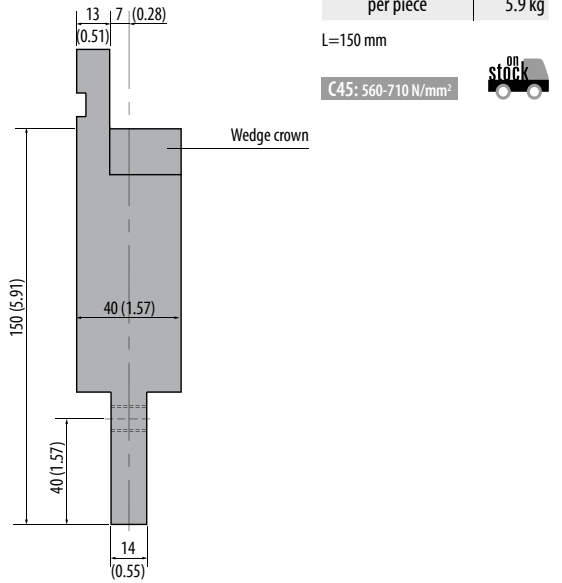
NEW



Rolleri Clamping Systems
See pages 204-213

INT150

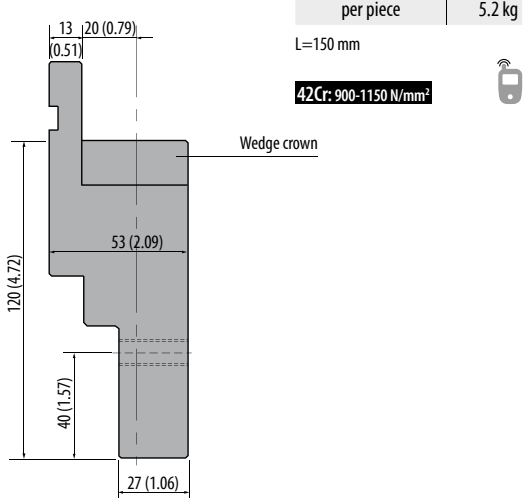
1000 kN/m max.



INT120-40-HD (Heavy Duty)

1600 kN/m max.

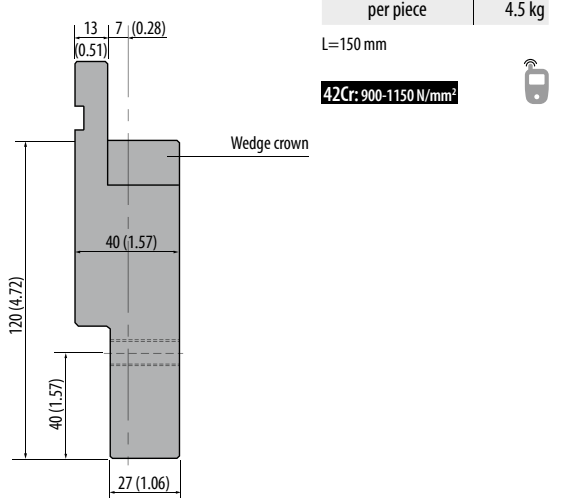
NEW



INT120-HD (Heavy Duty)

1600 kN/m max.

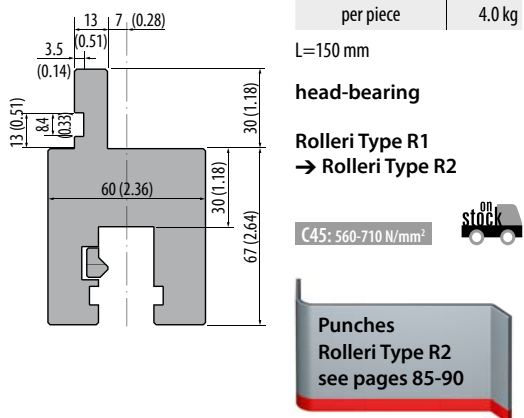
NEW



Punch Adapters

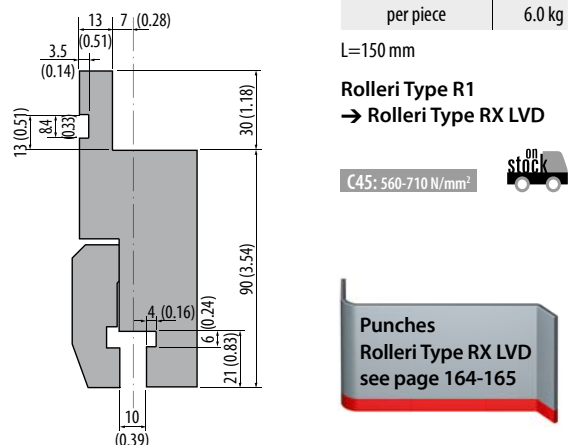
AD20

1000 kN/m max.



AD19-A

1000 kN/m max.



DIES ROLLERI TYPE R1

Content Explanation	38 - 39	1-V Dies, 70°	70
2-V Dies 90°	40	1-V Dies, 60°	71
2-V Dies 88°	40 - 41	1-V Dies, 45°	71
2-V Dies 60°	42	Multi-V Dies	72 - 73
2-V Dies 35°	42	Synthetic Dies	74
2-V Dies 30°	42	Hemming Dies	75
Die Holders for 2-V Dies	43	Spring-Loaded Hemming Dies	76
Self Centering 2-V Dies 90°	44	Pneumatic Hemming Dies	77
Self Centering 2-V Dies 88°	44 - 45	Adapter Rails for Dies	78
Self Centering 2-V Dies 85°	45	Die Adapters	79
Self Centering 2-V Dies 30°	45	Die Extensions	79
Die Holder for Self Centering 2-V Dies	46		
Clamping Piece for Self Centering 2-V Dies	46		
Self Centering 1-V Dies 90°	47		
Self Centering 1-V Dies 88°	47 - 49		
Self Centering 1-V Dies 85°	50		
Self Centering 1-V Dies 30°	51		
Die Holder for Self Centering 1-V Dies	52		
T-Dies 90°, H=80 (3.15), H=120 (4.72)	53		
T-Dies 88°, H=80 (3.15)	54		
T-Dies 88°, H=120 (4.72)	55		
T-Dies 85°, H=80 (3.15)	56		
T-Dies 85°, H=120 (4.72)	57		
T-Dies 80°, H=80 (3.15)	58		
T-Dies 80°, H=120 (4.72)	59		
T-Dies 60°, H=80 (3.15)	60		
T-Dies 60°, H=120 (4.72)	61		
T-Dies 45°, H=80 (3.15) / H=120 (4.72)	62		
T-Dies 35°, H=80 (3.15) / H=120 (4.72)	63		
T-Dies 30°, H=80 (3.15)	64		
T-Dies 30°, H=120 (4.72)	65		
T-Dies 26°, H=80 (3.15)	66		
T-Dies 26°, H=120 (4.72)	67		
1-V Dies, 85°	68		
1-V Dies, 80°	69		

Compatibility

Dies Roller Type R1 are compatible with press brake machines from:

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

With Adapter-Systems the dies Roller Type R1 are also applicable on all other press brake machines.



R1 ROLLER TYPE R1

Content Explanation Dies

Compatibility

Dies Roller Type R1 are:

- **compatible** with press brake machines (60 mm clamping-width) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, JMT, LFK, Metfab, MVD, Newton, Oriance, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brake machines **with Adapter-Systems and Adapter Rails** (see pages 226-229).

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 258-261)
- very large stock availability

Material

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

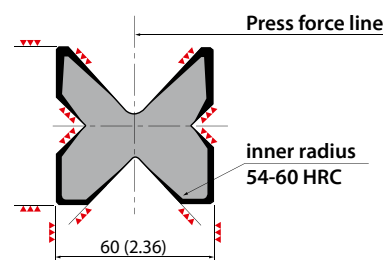
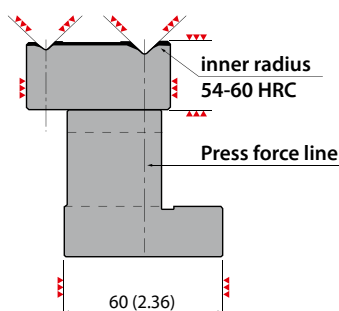
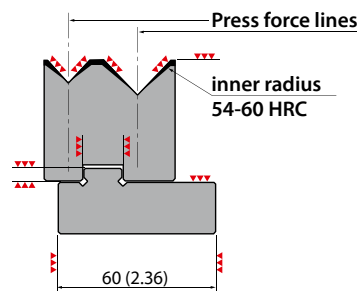
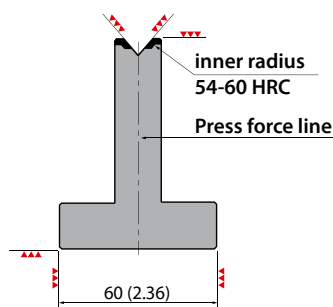
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

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

Indications of precision ground surfaces:



■ Tool lengths and sectioning

Standard

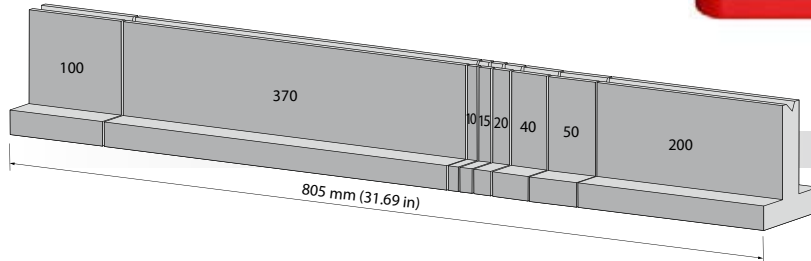
Segmented tools are delivered in complete sets. Single pieces are also available!

More lengths and sectionings are possible upon request.

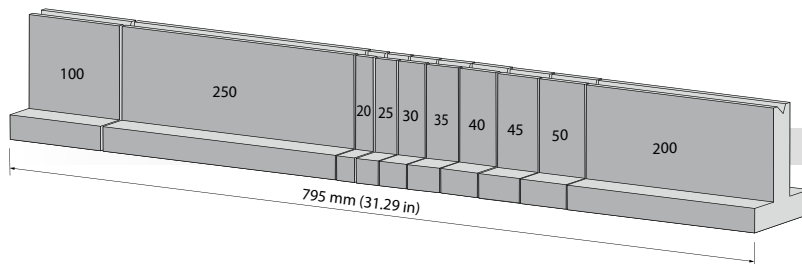
835 mm (32.87 in)

415 mm (16.34 in)

900 mm (35.43 in)



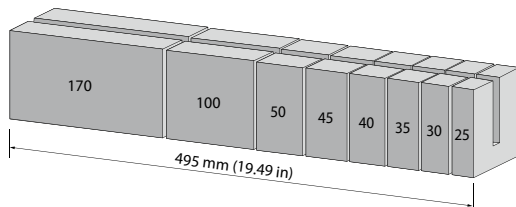
805 mm (31.69 in) segmented (8 segments)



795 mm (31.29 in) segmented (10 segments)

Rolleri TOP-System

525 mm (20.67 in)



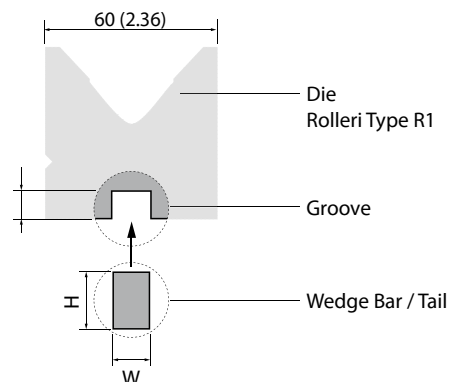
495 mm (19.49 in) segmented (8 segments)

■ Modification: Wedge Bar / Tail

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

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

Mounting example



Specific information and prizes are found in the Rolleri Service / Modifications Chapter (see page 260)

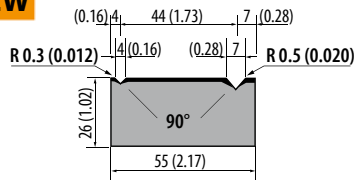
R1 ROLLER TYPE R1

2-V Dies 90°

M26.90.03

1000 kN/m max.

NEW



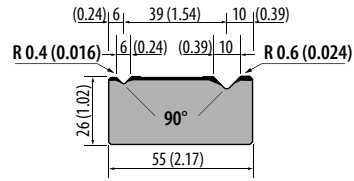
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.90.01

1000 kN/m max.



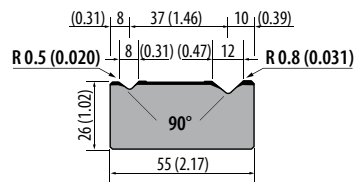
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
900 mm	35.43 in	10.0 kg

C45: 560-710 N/mm²



M26.90.02

1000 kN/m max.



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

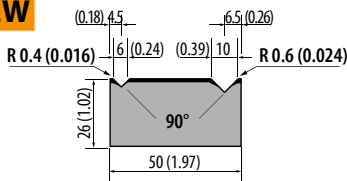
C45: 560-710 N/mm²



12300

700 kN/m max.

NEW



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

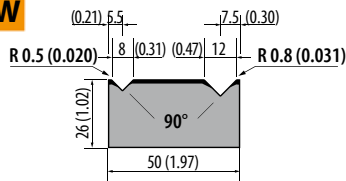
C45: 560-710 N/mm²



12400

800 kN/m max.

NEW



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

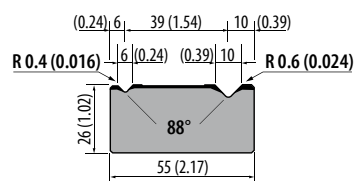
C45: 560-710 N/mm²



2-V Dies 88°

M26.88.01

1000 kN/m max.



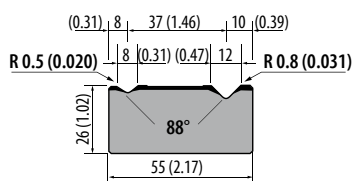
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.88.02

1000 kN/m max.



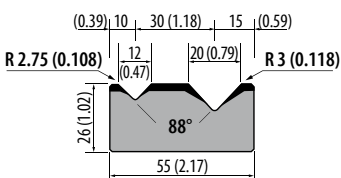
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.88.03

1000 kN/m max.



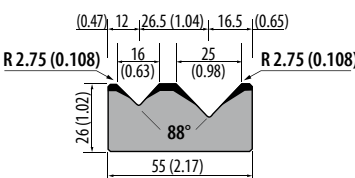
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.88.04

1000 kN/m max.



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

C45: 560-710 N/mm²



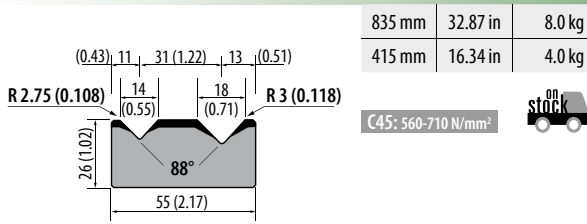
R1 ROLLERI TYPE R1

2-V Dies 88°



M26.88.05

1000 kN/m max.

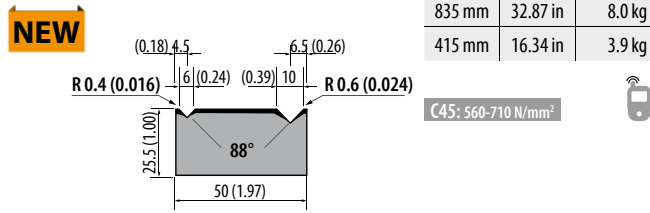


Take advantage of our adapters on pages 226-229 when using dies RollerI Type R1.

2
R1

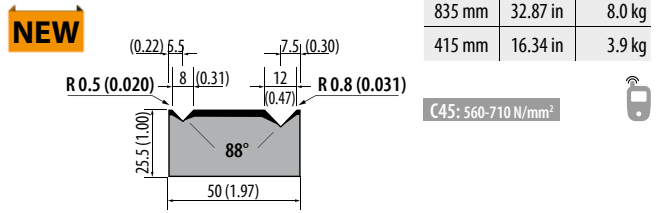
12306

700 kN/m max.



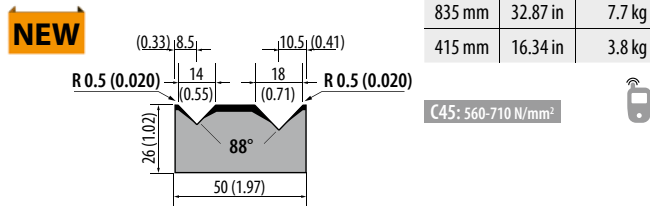
12406

800 kN/m max.



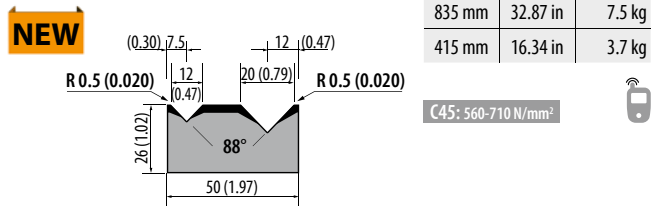
12500

1000 kN/m max.



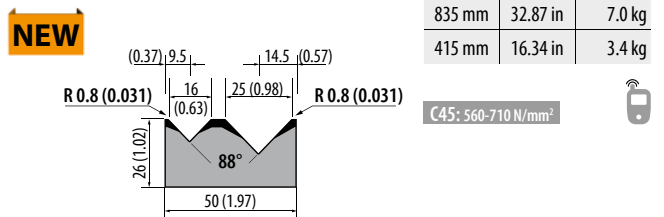
12600

1000 kN/m max.



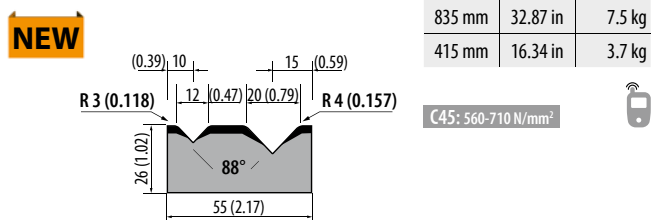
12700

700 kN/m max.



31400

1000 kN/m max.

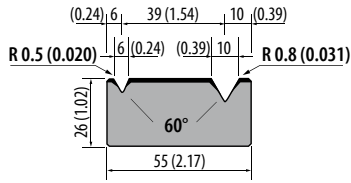


R1 ROLLER TYPE R1

2-V Dies 60°

M26.60.01

600 kN/m max.



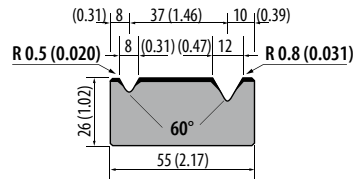
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
900 mm	35.43 in	10.0 kg

C45: 560-710 N/mm²



M26.60.02

800 kN/m max.



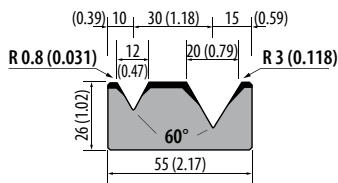
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.60.03

800 kN/m max.



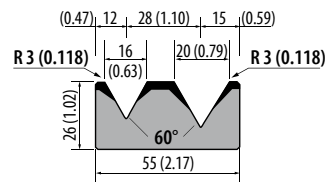
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg

C45: 560-710 N/mm²



M26.60.05

800 kN/m max.



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

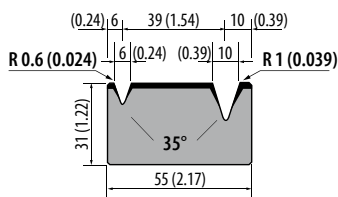
C45: 560-710 N/mm²



2-V Dies 35°

M31.35.01

300 kN/m max.



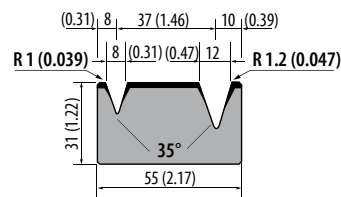
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg

C45: 560-710 N/mm²



M31.35.02

300 kN/m max.



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

C45: 560-710 N/mm²

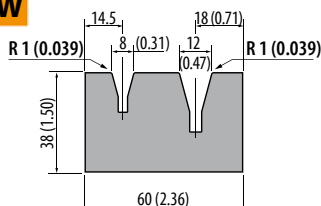


2-V Dies 30°

33700

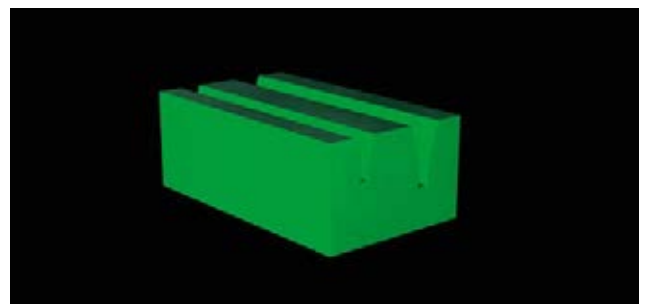
300 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

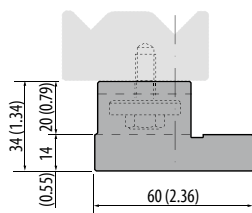


R1 ROLLERI TYPE R1

Die Holders for 2-V Dies



SU034



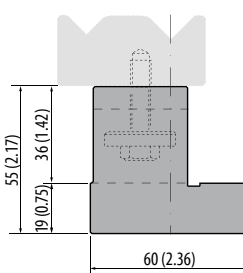
830 mm	32.68 in	9.0 kg
410 mm	16.14 in	4.5 kg

for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²



SU055



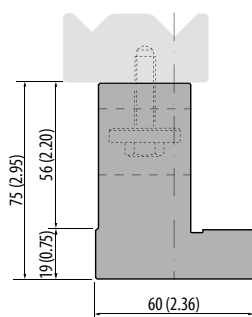
830 mm	32.68 in	14.5 kg
410 mm	16.14 in	7.2 kg

for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²



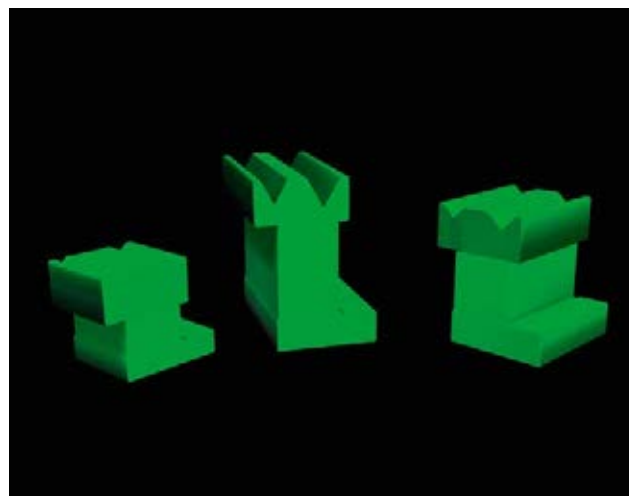
SU075



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

for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²



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



Rolleri Videos

find updated and helpful videos at:
www.rolleritools.com/videos/overview



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



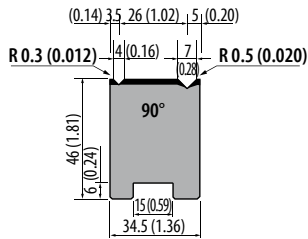
Articles on stock – Please note that delivery time depends on your location.

R1 ROLLER TYPE R1

Self Centering 2-V Dies 90°

46-10

800 kN/m max.



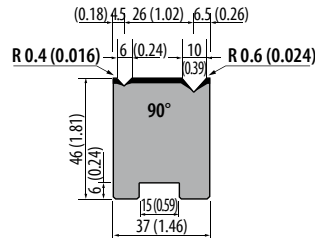
835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
795 mm segmented	31.29 in segmented	9.2 kg
805 mm segmented	31.69 in segmented	9.4 kg

C45: 800-850 N/mm²



46-11

800 kN/m max.



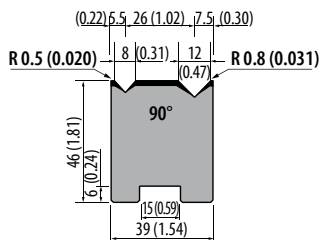
835 mm	32.87 in	10.3 kg
415 mm	16.34 in	5.1 kg
795 mm segmented	31.29 in segmented	9.8 kg
805 mm segmented	31.69 in segmented	9.9 kg

C45: 800-850 N/mm²



46-12

800 kN/m max.



835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.6 kg

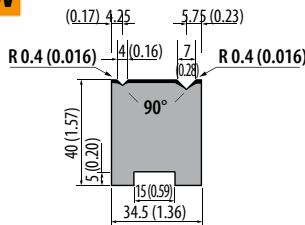
C45: 800-850 N/mm²



50190

600 kN/m max.

NEW



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

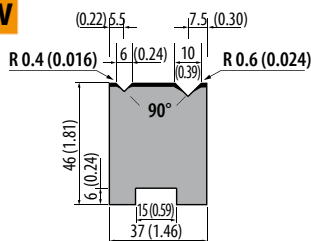
C45: 800-850 N/mm²



50290

700 kN/m max.

NEW



835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.69 in segmented	10.1 kg

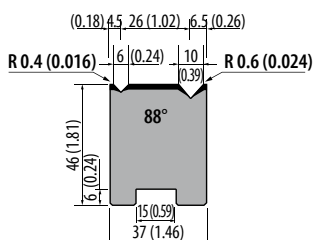
C45: 800-850 N/mm²



Self Centering 2-V Dies 88°

46.11.88

800 kN/m max.



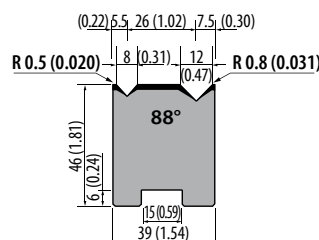
835 mm	32.87 in	10.3 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	9.8 kg
805 mm segmented	31.69 in segmented	9.9 kg

C45: 800-850 N/mm²



46.13

800 kN/m max.



835 mm	32.87 in	10.9 kg
415 mm	16.34 in	5.4 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.5 kg

C45: 800-850 N/mm²



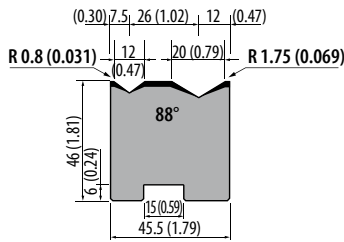
R1 ROLLER TYPE R1

Self Centering 2-V Dies 88°



46.14

800 kN/m max.



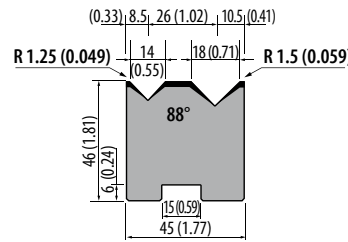
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.4 kg
805 mm segmented	31.69 in segmented	11.6 kg

C45: 800-850 N/mm²



46.15

800 kN/m max.



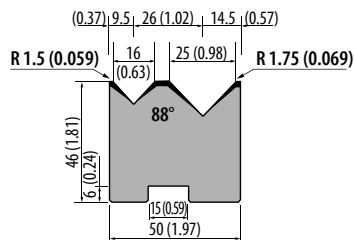
835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	12.0 kg
805 mm segmented	31.69 in segmented	12.1 kg

C45: 800-850 N/mm²



46.16

800 kN/m max.



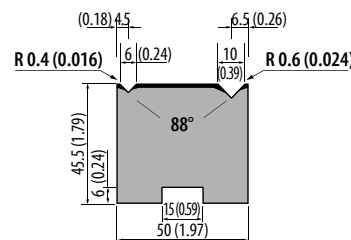
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 800-850 N/mm²



30247

700 kN/m max.



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

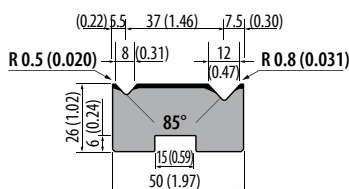
C45: 800-850 N/mm²



Self Centering 2-V Dies 85°

M26.85.02

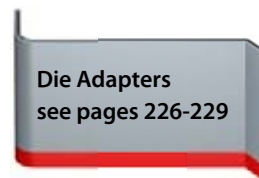
1000 kN/m max.



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

PM50 + Support is needed

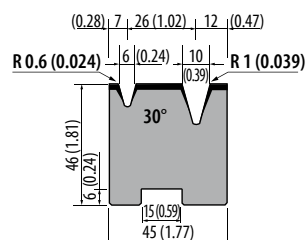
42Cr: 900-1150 N/mm²



Self Centering 2-V Dies 30°

46.17

400 kN/m max.



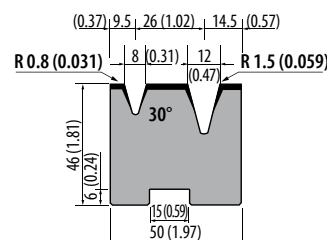
835 mm	32.87 in	12.2 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.6 kg
805 mm segmented	31.69 in segmented	11.8 kg

C45: 800-850 N/mm²



46.18

400 kN/m max.



835 mm	32.87 in	13.2 kg
415 mm	16.34 in	6.6 kg
795 mm segmented	31.29 in segmented	12.6 kg
805 mm segmented	31.69 in segmented	12.7 kg

C45: 800-850 N/mm²



R1 ROLLER TYPE R1

Die Holders for Self Centering 2-V Dies



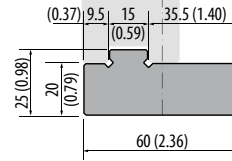
PM60

1000 kN/m max.

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

for self centering 2-V dies
pages 44-45

C45: 560-710 N/mm²



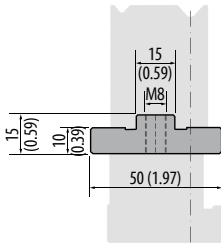
PM50

1000 kN/m max.

835 mm	32.87 in	4.0 kg
415 mm	16.34 in	2.0 kg

for all self centering 2-V dies
pages 44-45

C45: 560-710 N/mm²



PM50.20

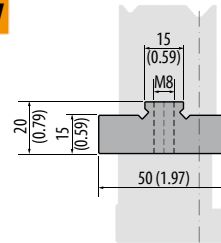
1000 kN/m max.

NEW

835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.6 kg

for all self centering 2-V dies
pages 44-45

C45: 800-850 N/mm²

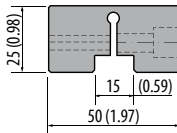


Clamping Piece for Self Centering 2-V Dies

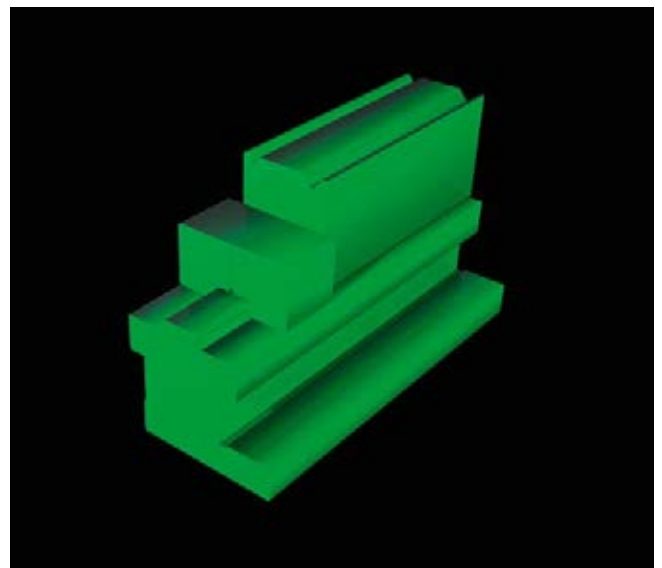
PB60

pair | 0.2 kg

Fe37



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



R1 ROLLER TYPE R1

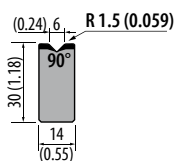
Self Centering 1-V Dies 90°



32000

950 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

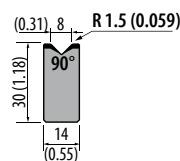
C45: 560-710 N/mm²



32100

950 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

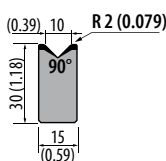
C45: 560-710 N/mm²



32300

950 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

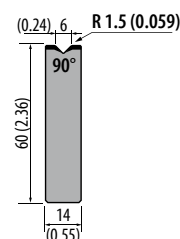
C45: 560-710 N/mm²



07000

950 kN/m max.

NEW



835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg

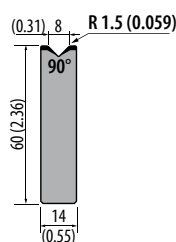
C45: 560-710 N/mm²



07100

950 kN/m max.

NEW



835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg

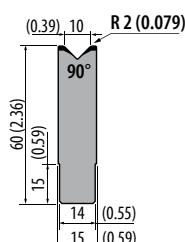
C45: 560-710 N/mm²



07300

950 kN/m max.

NEW



835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg

C45: 560-710 N/mm²

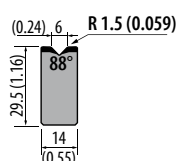


Self Centering 1-V Dies 88°

32006

950 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

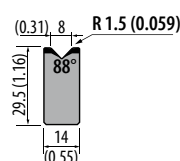
C45: 560-710 N/mm²



32106

950 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

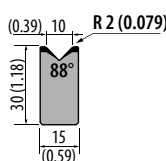
C45: 560-710 N/mm²



32200

950 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

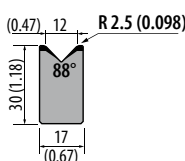
C45: 560-710 N/mm²



32400

1000 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

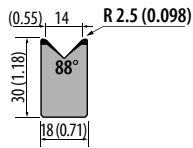
R1 ROLLERI TYPE R1

Self Centering 1-V Dies 88°

32500

1000 kN/m max.

NEW



835 mm	32.87 in	3.3 kg
415 mm	16.34 in	1.6 kg

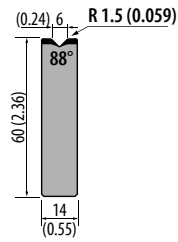
C45: 560-710 N/mm²



07006

950 kN/m max.

NEW



835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg

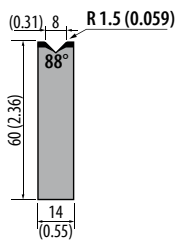
C45: 560-710 N/mm²



07106

950 kN/m max.

NEW



835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg

C45: 560-710 N/mm²

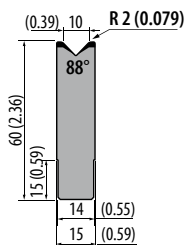


Compatible Die Holders
for bolted 1-V Dies
see page 52,
Article-No. 33000

07200

950 kN/m max.

NEW



835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg

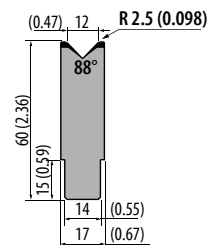
C45: 560-710 N/mm²



07400

950 kN/m max.

NEW



835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg

C45: 560-710 N/mm²



R1 ROLLER TYPE R1

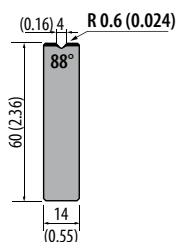
Self Centering 1-V Dies 88°



2
R1

AMR60.04.88

1000 kN/m max.



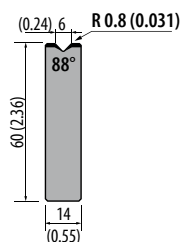
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.06.88

1000 kN/m max.



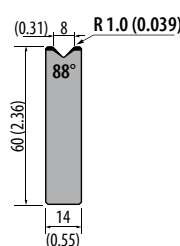
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.08.88

1000 kN/m max.



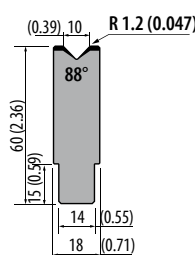
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.10.88

1000 kN/m max.



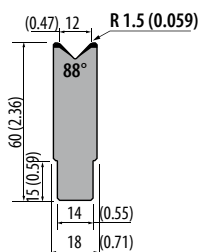
835 mm	32.87 in	5.6 kg
415 mm	16.34 in	2.8 kg
795 mm segmented	31.29 in segmented	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

C45: 560-710 N/mm²



AMR60.12.88

1000 kN/m max.



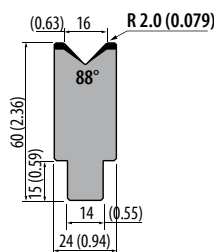
835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

C45: 560-710 N/mm²



AMR60.16.88

1000 kN/m max.



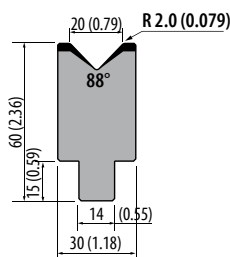
835 mm	32.87 in	7.1 kg
415 mm	16.34 in	3.5 kg
795 mm segmented	31.29 in segmented	6.8 kg
805 mm segmented	31.69 in segmented	6.9 kg

C45: 560-710 N/mm²



AMR60.20.88

1000 kN/m max.



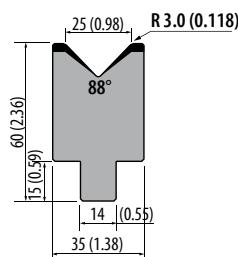
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
795 mm segmented	31.29 in segmented	7.6 kg
805 mm segmented	31.69 in segmented	7.7 kg

C45: 560-710 N/mm²



AMR60.25.88

1000 kN/m max.



835 mm	32.87 in	9.2 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	8.8 kg
805 mm segmented	31.69 in segmented	8.9 kg

C45: 560-710 N/mm²



Compatible Die Holders
for bolted 1-V Dies
see page 52,
Article No. SU61F



Article on stock
Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

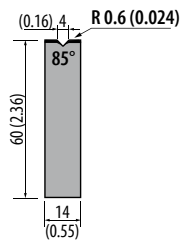
R1 ROLLER TYPE R1

Self Centering 1-V Dies 85°

AMR60.04.85

1000 kN/m max.

NEW



835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

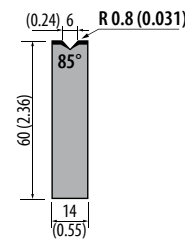
C45: 560-710 N/mm²



AMR60.06.85

1000 kN/m max.

NEW



835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

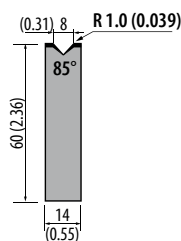
C45: 560-710 N/mm²



AMR60.08.85

1000 kN/m max.

NEW



835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

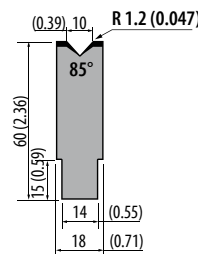
C45: 560-710 N/mm²



AMR60.10.85

1000 kN/m max.

NEW



835 mm	32.87 in	5.6 kg
415 mm	16.34 in	2.8 kg
795 mm segmented	31.29 in segmented	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

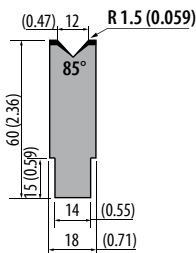
C45: 560-710 N/mm²



AMR60.12.85

1000 kN/m max.

NEW



835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

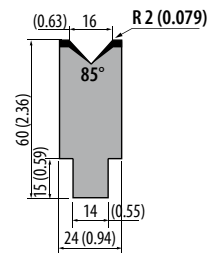
C45: 560-710 N/mm²



AMR60.16.85

1000 kN/m max.

NEW



835 mm	32.87 in	7.1 kg
415 mm	16.34 in	3.5 kg
795 mm segmented	31.29 in segmented	6.8 kg
805 mm segmented	31.69 in segmented	6.9 kg

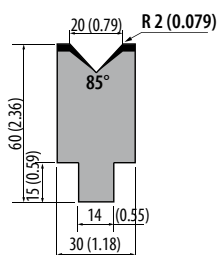
C45: 560-710 N/mm²



AMR60.20.85

1000 kN/m max.

NEW



835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
795 mm segmented	31.29 in segmented	7.6 kg
805 mm segmented	31.69 in segmented	7.7 kg

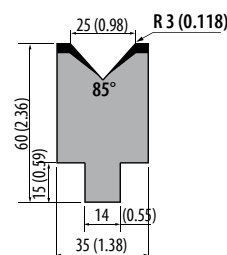
C45: 560-710 N/mm²



AMR60.25.85

1000 kN/m max.

NEW



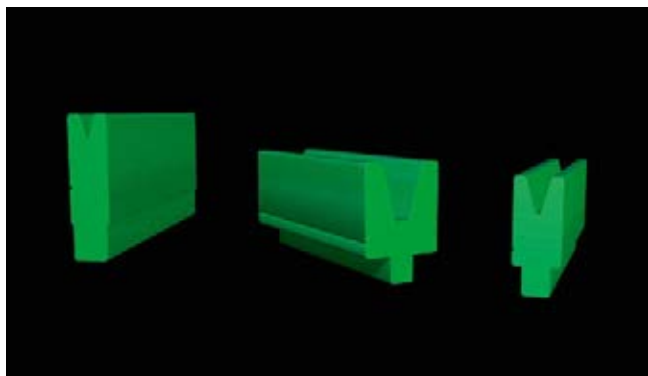
835 mm	32.87 in	9.2 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	8.8 kg
805 mm segmented	31.69 in segmented	8.9 kg

C45: 560-710 N/mm²



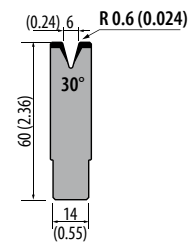
R1 ROLLER TYPE R1

Self Centering 1-V Dies 30°



AMR60.06.30

350 kN/m max.



835 mm	32.87 in	5.9 kg
415 mm	16.34 in	2.9 kg
795 mm segmented	31.29 in segmented	5.6 kg
805 mm segmented	31.69 in segmented	5.7 kg

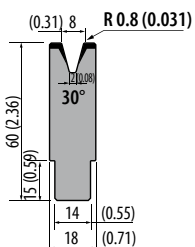
C45: 560-710 N/mm²



2
R1

AMR60.08.30

350 kN/m max.



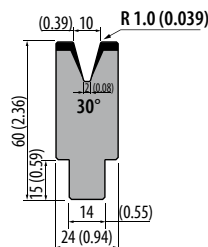
835 mm	32.87 in	6.6 kg
415 mm	16.34 in	3.3 kg
795 mm segmented	31.29 in segmented	6.3 kg
805 mm segmented	31.69 in segmented	6.4 kg

C45: 560-710 N/mm²



AMR60.10.30

500 kN/m max.



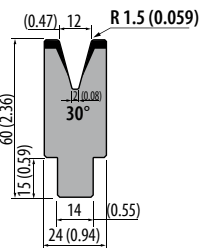
835 mm	32.87 in	7.8 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.4 kg
805 mm segmented	31.69 in segmented	7.5 kg

C45: 560-710 N/mm²



AMR60.12.30

400 kN/m max.



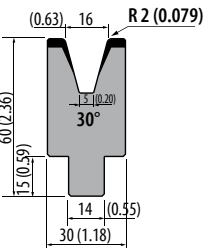
835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
805 mm segmented	31.69 in segmented	7.6 kg

C45: 560-710 N/mm²



AMR60.16.30

450 kN/m max.



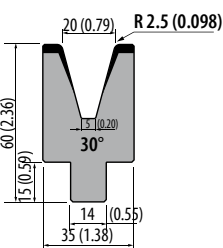
835 mm	32.87 in	8.8 kg
415 mm	16.34 in	4.7 kg
795 mm segmented	31.29 in segmented	8.4 kg
805 mm segmented	31.69 in segmented	8.5 kg

C45: 560-710 N/mm²



AMR60.20.30

500 kN/m max.



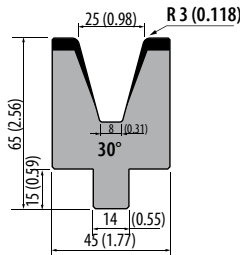
835 mm	32.87 in	15.9 kg
415 mm	16.34 in	7.9 kg
795 mm segmented	31.29 in segmented	15.1 kg
805 mm segmented	31.69 in segmented	15.3 kg

C45: 560-710 N/mm²



AMR65.25.30

500 kN/m max.



835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.3 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



Article on stock Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

R1 ROLLERI TYPE R1

Die Holders for Self Centering 1-V Dies

33000

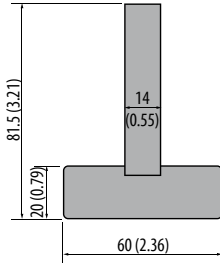
NEW

1000 kN/m max.

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

for self centering, bolted 1-V Dies,
pages 47-48

C45: 560-710 N/mm²



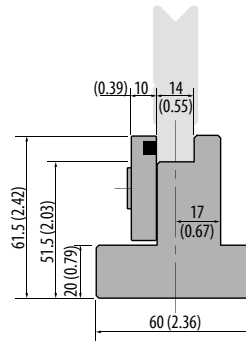
SU61F

1000 kN/m max.

835 mm	32.87 in	14.8 kg
415 mm	16.34 in	7.3 kg

for self centering 1-V Dies,
pages 49-51

C45: 560-710 N/mm²



08000

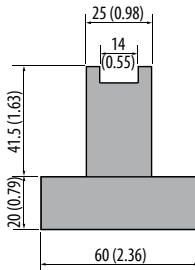
NEW

950 kN/m max.

1050 mm	41.34 in	17.8 kg
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for self centering 1-V Dies,
pages 47-51

C45: 560-710 N/mm²



08100

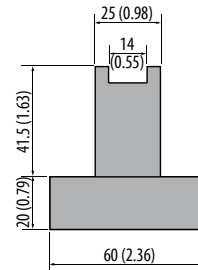
NEW

950 kN/m max.

1260 mm	49.61 in	21.4 kg
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for self centering 1-V Dies,
pages 47-51

C45: 560-710 N/mm²



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

- Protective Sheets
- PU-Upholstery
- Synthetic Dies

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

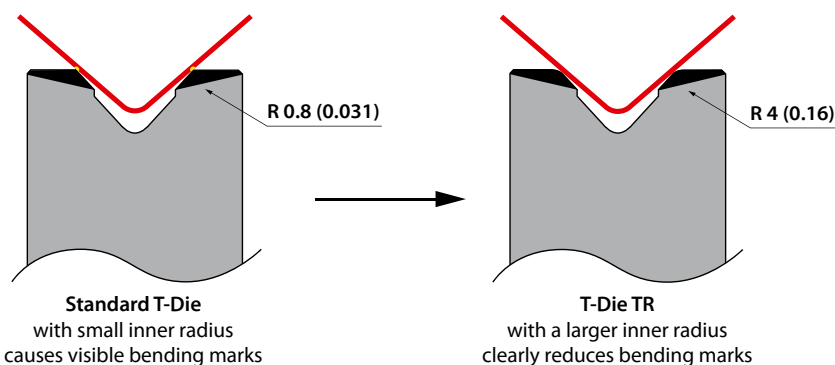
- **enlargement of the dies' inner radius**
(Retrofitting of new or existing dies)

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

Our Advantages – Your Convenience

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

2
R1

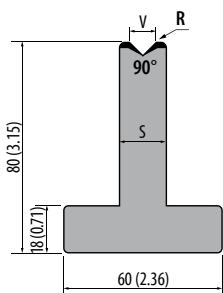


Specific information for mark-free bending see pages 230-237

T-Dies 90°, H=80 (3.15), H=120 (4.72)

T-Dies 90°, H=80 mm (3.15 in)

1000 kN/m max.



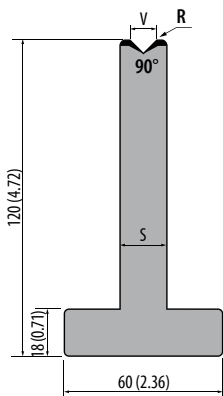
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight	Weight	Weight				
T80.06.90	6	0.24	0.4	0.02	14	0.55	835 mm / 32.87 in	13.0 kg	415 mm / 16.34 in	6.5 kg	795 mm / 31.30 in segmented	12.4 kg	805 mm / 31.69 in segmented	12.5 kg	900 mm / 35.43 in	14.0 kg
T80.08.90	8	0.31	0.5	0.02	14	0.55	835 mm / 32.87 in	13.0 kg	415 mm / 16.34 in	6.5 kg	795 mm / 31.30 in segmented	12.4 kg	805 mm / 31.69 in segmented	12.5 kg	900 mm / 35.43 in	14.0 kg
T80.10.90	10	0.39	0.6	0.02	18	0.71	835 mm / 32.87 in	14.2 kg	415 mm / 16.34 in	7.0 kg	795 mm / 31.30 in segmented	13.5 kg	805 mm / 31.69 in segmented	13.7 kg	900 mm / 35.43 in	14.0 kg
T80.12.90	12	0.47	0.8	0.03	18	0.71	835 mm / 32.87 in	15.0 kg	415 mm / 16.34 in	7.5 kg	795 mm / 31.30 in segmented	14.3 kg	805 mm / 31.69 in segmented	14.5 kg	900 mm / 35.43 in	14.0 kg

C45: 560-710 N/mm²



T-Dies 90°, H=120 mm (4.72 in)

1000 kN/m max.



Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight	Weight			
T120.06.90	6	0.24	0.4	0.02	14	0.55	835 mm / 32.87 in	16.0 kg	415 mm / 16.34 in	8.0 kg	795 mm / 31.30 in segmented	15.2 kg	805 mm / 31.69 in segmented	15.4 kg
T120.08.90	8	0.31	0.5	0.02	14	0.55	835 mm / 32.87 in	16.0 kg	415 mm / 16.34 in	8.0 kg	795 mm / 31.30 in segmented	15.2 kg	805 mm / 31.69 in segmented	15.4 kg
T120.10.90	10	0.39	0.6	0.02	18	0.71	835 mm / 32.87 in	19.0 kg	415 mm / 16.34 in	9.0 kg	795 mm / 31.30 in segmented	18.1 kg	805 mm / 31.69 in segmented	18.3 kg
T120.12.90	12	0.47	0.8	0.03	18	0.71	835 mm / 32.87 in	19.0 kg	415 mm / 16.34 in	9.0 kg	795 mm / 31.30 in segmented	18.1 kg	805 mm / 31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



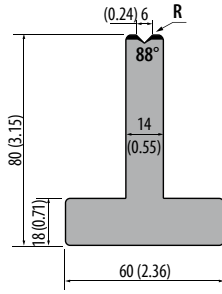
Articles on stock – Please note that delivery time depends on your location.

R1 ROLLER TYPE R1

T-Dies 88°, H=80 (3.15)

T80.06.88 / TR80.06.88

1000 kN/m max.



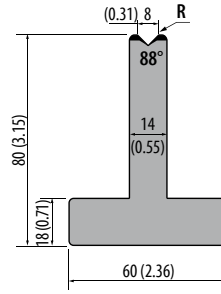
R=0.4 (0.016)			
T80.06.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=2.75 (0.108)			
TR80.06.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.08.88 / TR80.08.88

1000 kN/m max.



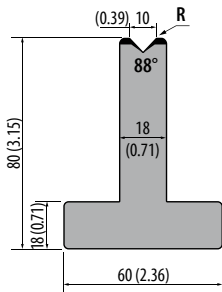
R=0.5 (0.020)			
T80.08.88	835 mm	32.87 in	12.6 kg
	415 mm	16.34 in	6.3 kg
	795 mm segmented	31.29 in segmented	12.0 kg
	805 mm segmented	31.69 in segmented	12.1 kg
R=2.75 (0.108)			
TR80.08.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.10.88 / TR80.10.88

1000 kN/m max.



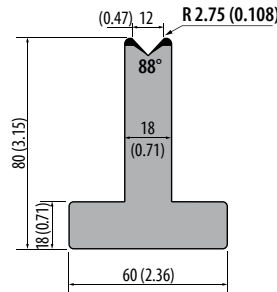
R=0.8 (0.031)			
T80.10.88	835 mm	32.87 in	14.2 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.5 kg
	805 mm segmented	31.69 in segmented	13.7 kg
R=2.75 (0.108)			
TR80.10.88	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented	31.69 in segmented	14.5 kg

C45: 560-710 N/mm²



T80.12.88

1000 kN/m max.



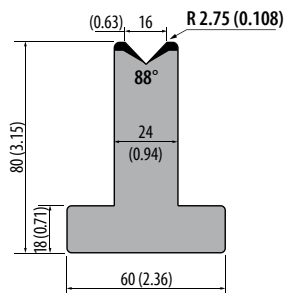
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

C45: 560-710 N/mm²



T80.16.88

1000 kN/m max.



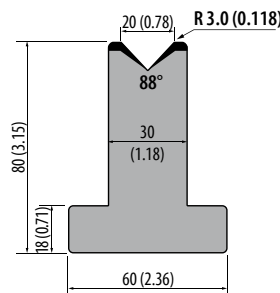
835 mm	32.87 in	16.6 kg
415 mm	16.34 in	8.3 kg
795 mm segmented	31.29 in segmented	15.8 kg
805 mm segmented	31.69 in segmented	16.0 kg

C45: 560-710 N/mm²



T80.20.88

1000 kN/m max.



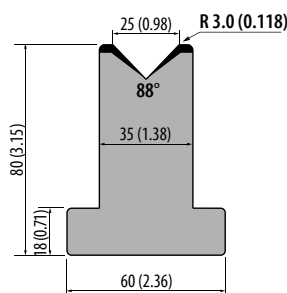
835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg
795 mm segmented	31.29 in segmented	17.6 kg
805 mm segmented	31.69 in segmented	17.8 kg

C45: 560-710 N/mm²



T80.25.88

1000 kN/m max.



835 mm	32.87 in	20.2 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.2 kg
805 mm segmented	31.69 in segmented	19.5 kg

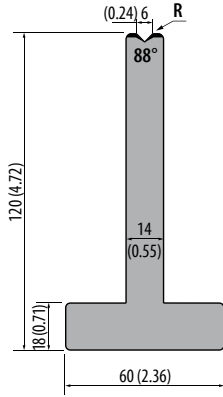
C45: 560-710 N/mm²



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



T120.06.88 / TR120.06.88 1000 kN/m max.

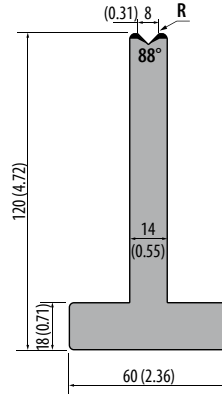


		R=0.4 (0.016)		
T120.06.88	835 mm	32.87 in	16.5 kg	
	415 mm	16.34 in	8.0 kg	
	795 mm segmented	31.29 in segmented	15.7 kg	
	805 mm segmented	31.69 in segmented	16.0 kg	
TR120.06.88			R=2.75 (0.108)	
	835 mm	32.87 in	16.0 kg	
	415 mm	16.34 in	8.0 kg	
	795 mm segmented	31.29 in segmented	15.2 kg	
		805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T120.08.88 / TR120.08.88 1000 kN/m max.

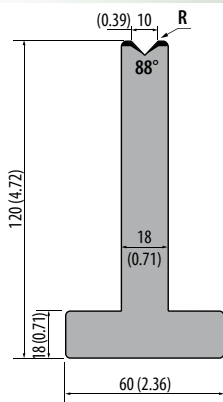


		R=0.5 (0.020)		
T120.08.88	835 mm	32.87 in	16.0 kg	
	415 mm	16.34 in	8.0 kg	
	795 mm segmented	31.29 in segmented	15.2 kg	
	805 mm segmented	31.69 in segmented	15.4 kg	
TR120.08.88			R=2.75 (0.108)	
	835 mm	32.87 in	16.0 kg	
	415 mm	16.34 in	8.0 kg	
	795 mm segmented	31.29 in segmented	15.2 kg	
		805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T120.10.88 / TR120.10.88 1000 kN/m max.

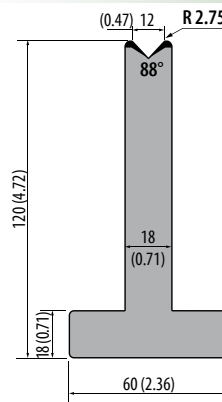


		R=0.8 (0.031)		
T120.10.88	835 mm	32.87 in	19.0 kg	
	415 mm	16.34 in	9.5 kg	
	795 mm segmented	31.29 in segmented	18.0 kg	
	805 mm segmented	31.69 in segmented	18.3 kg	
TR120.10.88			R=2.75 (0.108)	
	835 mm	32.87 in	18.0 kg	
	415 mm	16.34 in	9.0 kg	
	795 mm segmented	31.29 in segmented	17.1 kg	
		805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.12.88 1000 kN/m max.

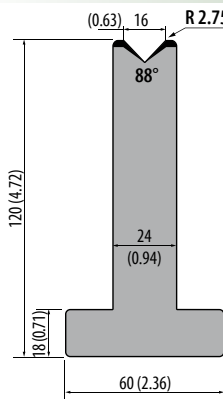


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	18.0 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.16.88 1000 kN/m max.

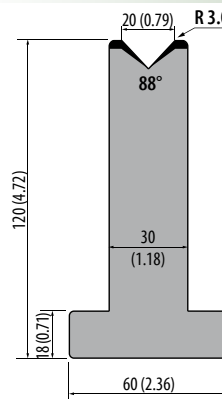


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



T120.20.88 1000 kN/m max.

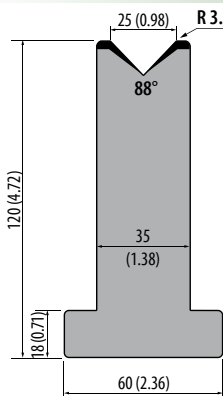


835 mm	32.87 in	27.0 kg
415 mm	16.34 in	13.5 kg
795 mm segmented	31.29 in segmented	25.7 kg
805 mm segmented	31.69 in segmented	26.0 kg

C45: 560-710 N/mm²



T120.25.88 1000 kN/m max.



835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

C45: 560-710 N/mm²



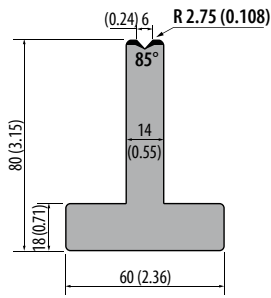
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www.rolleritools.com

R1 ROLLER TYPE R1

T-Dies 85°, H=80 (3.15)

T80.06.85

1000 kN/m max.



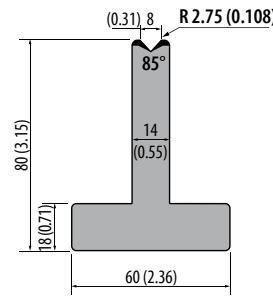
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.08.85

1000 kN/m max.



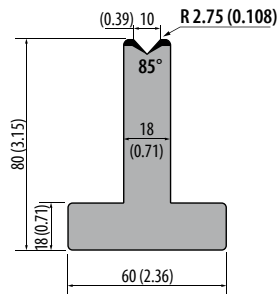
835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.2 kg
795 mm segmented	31.29 in segmented	12.0 kg
805 mm segmented	31.69 in segmented	12.1 kg

C45: 560-710 N/mm²



T80.10.85

1000 kN/m max.



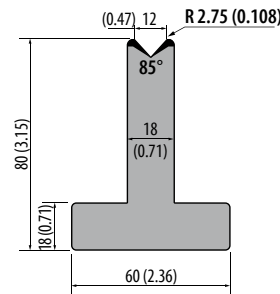
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

C45: 560-710 N/mm²



T80.12.85

1000 kN/m max.



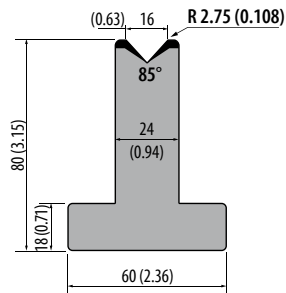
835 mm	32.87 in	14.1 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.4 kg
805 mm segmented	31.69 in segmented	13.6 kg

C45: 560-710 N/mm²



T80.16.85

1000 kN/m max.



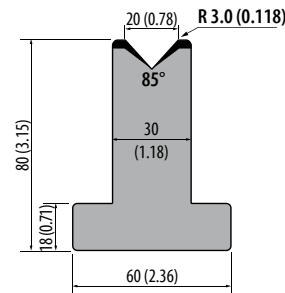
835 mm	32.87 in	16.4 kg
415 mm	16.34 in	8.2 kg
795 mm segmented	31.29 in segmented	15.6 kg
805 mm segmented	31.69 in segmented	15.8 kg

C45: 560-710 N/mm²



T80.20.85

1000 kN/m max.



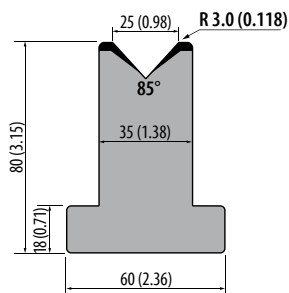
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T80.25.85

1000 kN/m max.



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

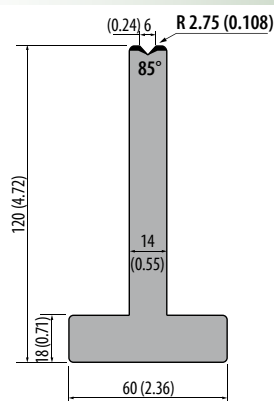
C45: 560-710 N/mm²



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

T120.06.85

1000 kN/m max.



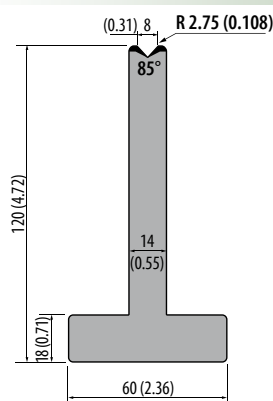
835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

C45: 560-710 N/mm²



T120.08.85

1000 kN/m max.



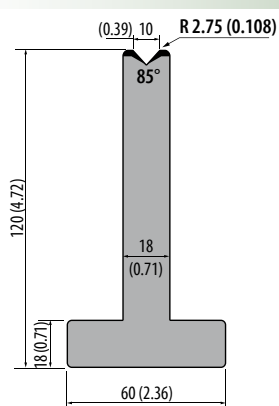
835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

C45: 560-710 N/mm²



T120.10.85

1000 kN/m max.



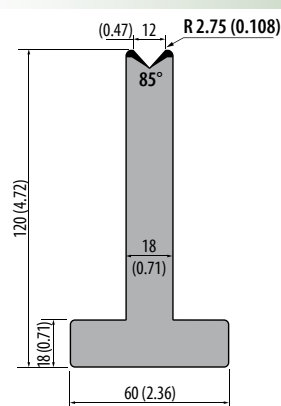
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.12.85

1000 kN/m max.



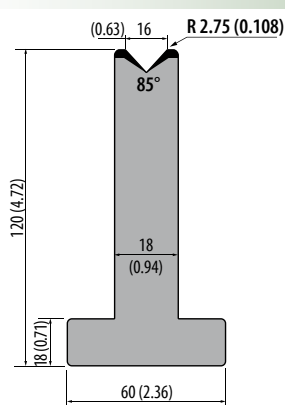
835 mm	32.87 in	18.9 kg
415 mm	16.34 in	9.4 kg
795 mm segmented	31.29 in segmented	18.0 kg
805 mm segmented	31.69 in segmented	18.2 kg

C45: 560-710 N/mm²



T120.16.85

1000 kN/m max.



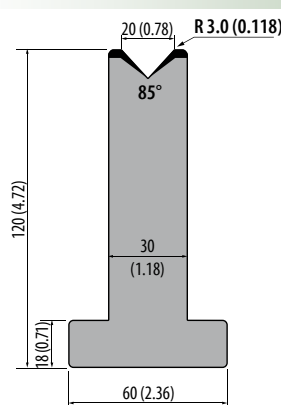
835 mm	32.87 in	22.7 kg
415 mm	16.34 in	11.3 kg
795 mm segmented	31.29 in segmented	21.7 kg
805 mm segmented	31.69 in segmented	21.9 kg

C45: 560-710 N/mm²



T120.20.85

1000 kN/m max.



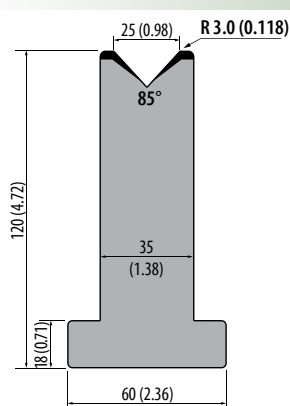
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

C45: 560-710 N/mm²



T120.25.85

1000 kN/m max.



835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

C45: 560-710 N/mm²

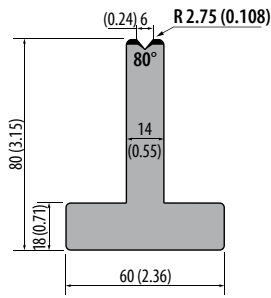


R1 ROLLER TYPE R1

T-Dies 80°, H=80 (3.15)

T80.06.80

950 kN/m max.



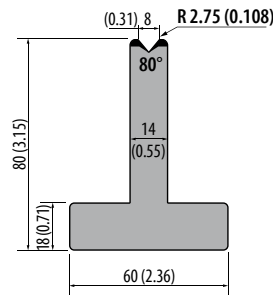
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.08.80

950 kN/m max.



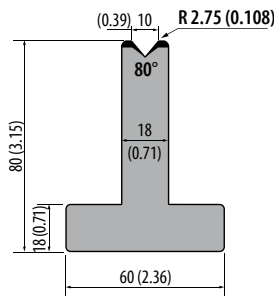
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.10.80

950 kN/m max.



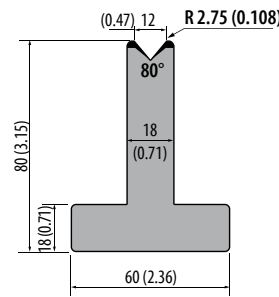
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.12.80

950 kN/m max.



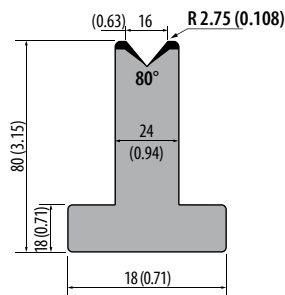
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.16.80

950 kN/m max.



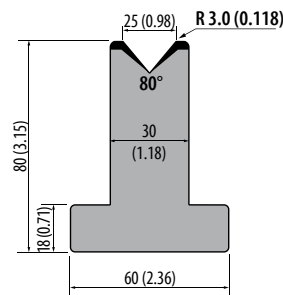
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.20.80

950 kN/m max.



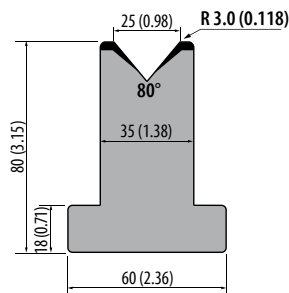
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.25.80

950 kN/m max.



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

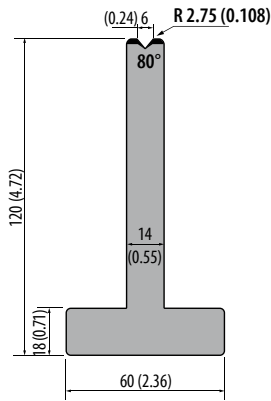
C45: 560-710 N/mm²



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T120.06.80

950 kN/m max.



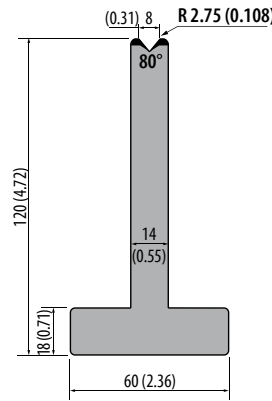
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.08.80

950 kN/m max.



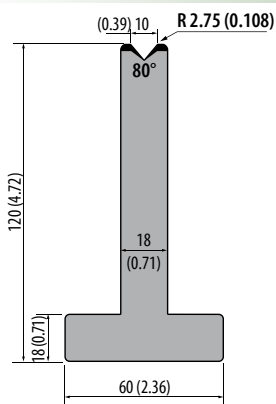
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.10.80

950 kN/m max.



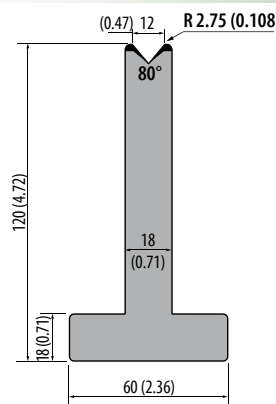
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.12.80

950 kN/m max.



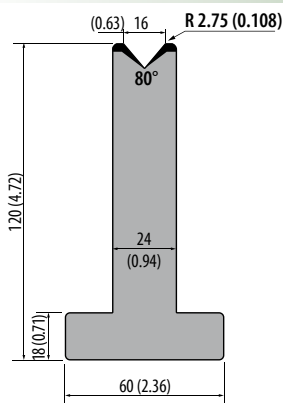
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.16.80

950 kN/m max.



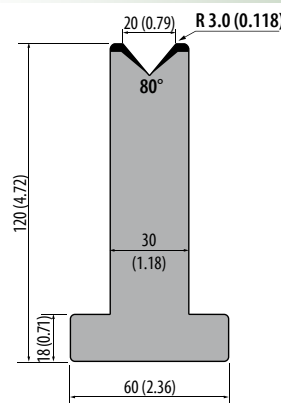
835 mm	32.87 in	18.8 kg
415 mm	16.34 in	9.3 kg
795 mm segmented	31.29 in segmented	17.9 kg
805 mm segmented	31.69 in segmented	18.1 kg

C45: 560-710 N/mm²



T120.20.80

950 kN/m max.



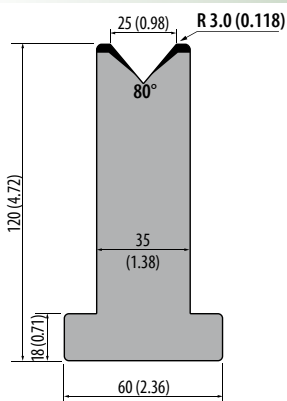
835 mm	32.87 in	26.3 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	25.0 kg
805 mm segmented	31.69 in segmented	25.4 kg

C45: 560-710 N/mm²



T120.25.80

950 kN/m max.



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

C45: 560-710 N/mm²

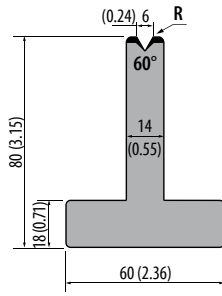


R1 ROLLER TYPE R1

T-Dies 60°, H=80 (3.15)

T80.06.60 / TR80.06.60

600 kN/m max.



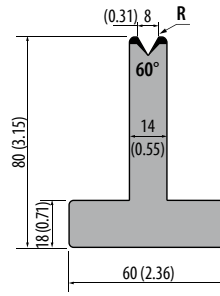
R=0.5 (0.020)			
T80.06.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=1.5 (0.059)			
TR80.06.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.08.60 / TR80.08.60

600 kN/m max.



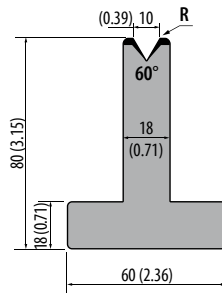
R=0.8 (0.031)			
T80.08.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=1.5 (0.059)			
TR80.08.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.10.60 / TR80.10.60

600 kN/m max.



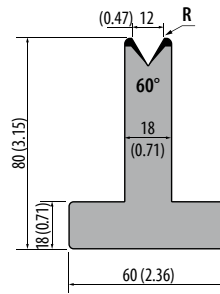
R=0.8 (0.031)			
T80.10.60	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
R=2.75 (0.108)			
TR80.10.60	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented	31.69 in segmented	14.5 kg

C45: 560-710 N/mm²



T80.12.60 / TR80.12.60

600 kN/m max.



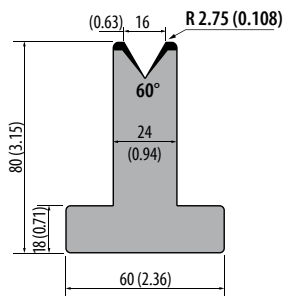
R=0.8 (0.031)			
T80.12.60	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
R=2.75 (0.108)			
TR80.12.60	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented	31.69 in segmented	14.5 kg

C45: 560-710 N/mm²



T80.16.60

600 kN/m max.



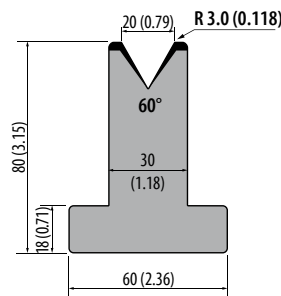
835 mm	32.87 in	15.6 kg
415 mm	16.34 in	8.7 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	15.0 kg

C45: 560-710 N/mm²



T80.20.60

600 kN/m max.



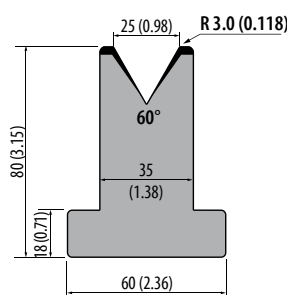
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T80.25.60

600 kN/m max.

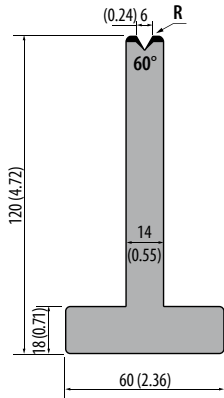


835 mm	32.87 in	19.5 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	18.6 kg
805 mm segmented	31.69 in segmented	18.8 kg

C45: 560-710 N/mm²



T120.06.60 / TR120.06.60 600 kN/m max.

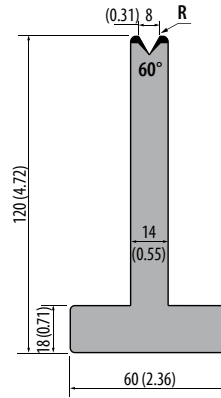


		R=0.5 (0.020)	
T120.06.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
		R=1.5 (0.059)	
TR120.06.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T120.08.60 / TR120.08.60 600 kN/m max.

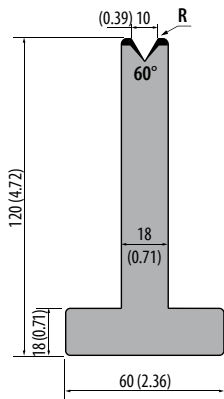


		R=0.8 (0.031)	
T120.08.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
		R=1.5 (0.059)	
TR120.08.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T120.10.60 / TR120.10.60 600 kN/m max.

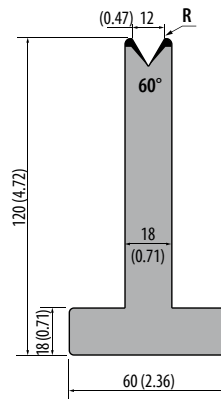


		R=0.8 (0.031)	
T120.10.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
		R=2.75 (0.108)	
TR120.10.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.12.60 / TR120.12.60 600 kN/m max.

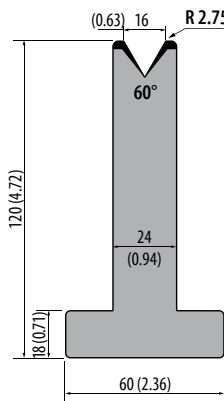


		R=0.8 (0.031)	
T120.12.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
		R=2.75 (0.108)	
TR120.12.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.16.60 600 kN/m max.

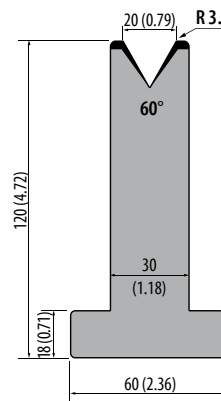


835 mm	32.87 in	22.4 kg
415 mm	16.34 in	11.1 kg
795 mm segmented	31.29 in segmented	21.3 kg
805 mm segmented	31.69 in segmented	21.6 kg

C45: 560-710 N/mm²



T120.20.60 600 kN/m max.

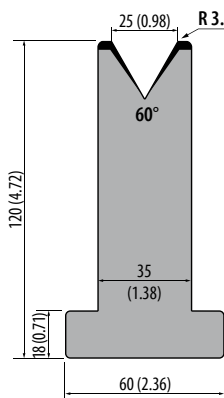


835 mm	32.87 in	26.0 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	24.8 kg
805 mm segmented	31.69 in segmented	25.0 kg

C45: 560-710 N/mm²



T120.25.60 600 kN/m max.



835 mm	32.87 in	28.5 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	27.1 kg
805 mm segmented	31.69 in segmented	27.5 kg

C45: 560-710 N/mm²



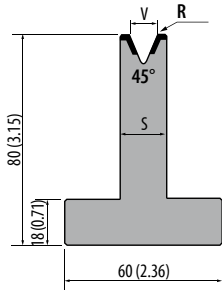
For modifications on dies see pages 258-261

R1 ROLLER TYPE R1

T-Dies 45°, H=80 (3.15), H=120 (4.72)

T-Dies 45°, H=80 mm (3.15 in)

500 kN/m max.



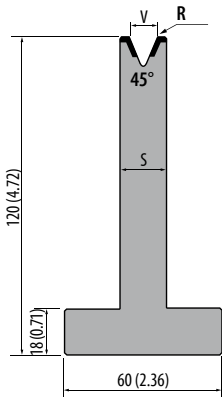
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight
T80.06.45	6	0.24	0.8	0.03	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.45	8	0.31	1.0	0.04	18	0.71	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.10.45	10	0.39	1.2	0.05	18	0.71	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.12.45	12	0.47	1.6	0.06	24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

C45: 560-710 N/mm²



T-Dies 45°, H=120 mm (4.72 in)

500 kN/m max.



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

C45: 560-710 N/mm²



R1 ROLLERI TYPE R1

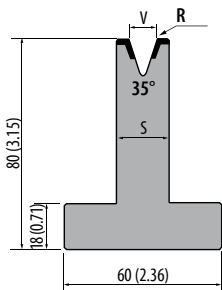
T-Dies 35°, H=80 (3.15), H=120 (4.72)



2
R1



T-Dies 35°, H=80 mm (3.15 in)

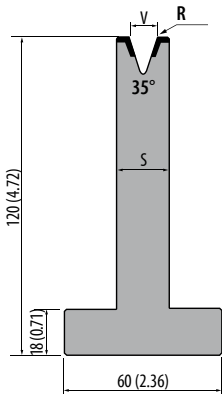


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	Weight	Weight	Weight	Weight
T80.06.35	6	0.24	0.8	0.03	14	0.55	350	12.5 kg	6.5 kg	11.9 kg	12.0 kg
T80.08.35	8	0.31	1.0	0.04	16	0.63	350	13.0 kg	7.0 kg	12.4 kg	12.6 kg
T80.10.35	10	0.39	1.2	0.05	20	0.79	400	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.12.35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

C45: 560-710 N/mm²



T-Dies 35°, H=120 mm (4.72 in)



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

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



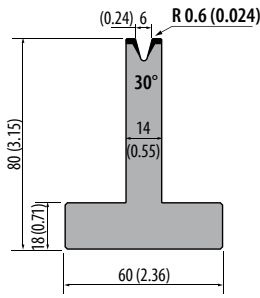
Articles on stock – Please note that delivery time depends on your location.

R1 ROLLER TYPE R1

T-Dies 30°, H=80 (3.15)

T80.06.30

350 kN/m max.



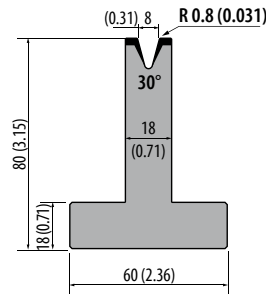
835 mm	32.87 in	12.4 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	11.8 kg
805 mm segmented	31.69 in segmented	12.0 kg

C45: 560-710 N/mm²



T80.08.30

350 kN/m max.



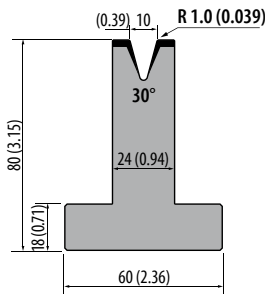
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.6 kg

C45: 560-710 N/mm²



T80.10.30

500 kN/m max.



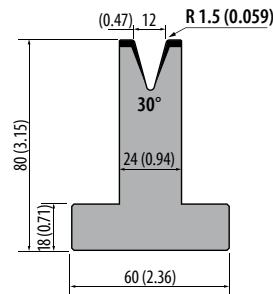
835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T80.12.30

400 kN/m max.



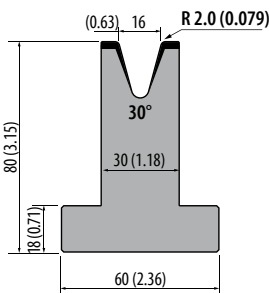
835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T80.16.30

450 kN/m max.



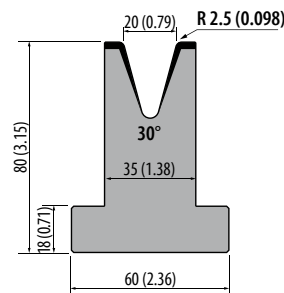
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



T80.20.30

500 kN/m max.



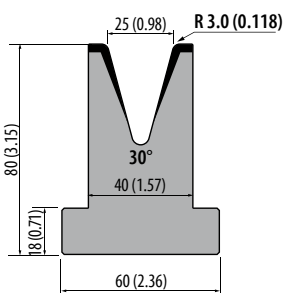
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



T80.25.30

500 kN/m max.



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

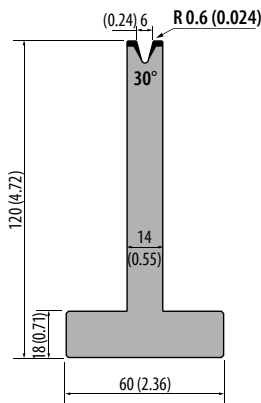
C45: 560-710 N/mm²



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

T120.06.30

350 kN/m max.



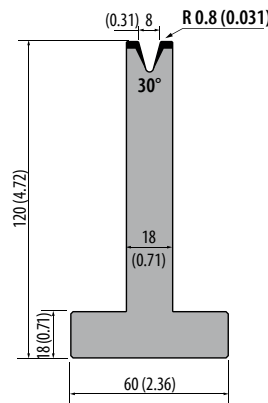
835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T120.08.30

350 kN/m max.



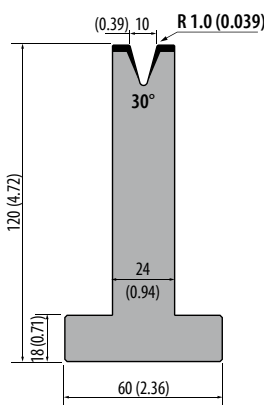
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.10.30

500 kN/m max.



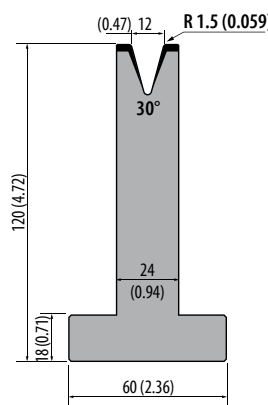
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.9 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



T120.12.30

400 kN/m max.



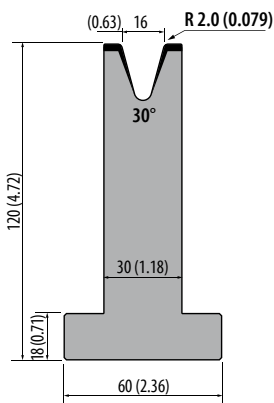
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



T120.16.30

450 kN/m max.



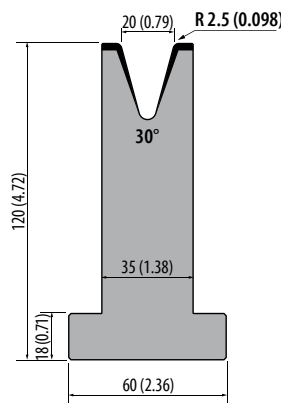
835 mm	32.87 in	25.8 kg
415 mm	16.34 in	12.8 kg
795 mm segmented	31.29 in segmented	24.6 kg
805 mm segmented	31.69 in segmented	24.9 kg

C45: 560-710 N/mm²



T120.20.30

500 kN/m max.



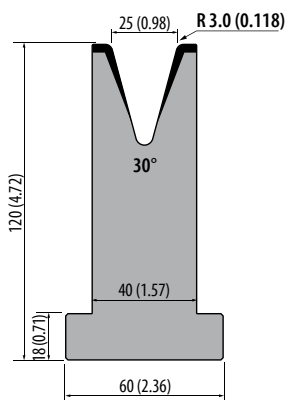
835 mm	32.87 in	28.0 kg
415 mm	16.34 in	14.0 kg
795 mm segmented	31.29 in segmented	26.7 kg
805 mm segmented	31.69 in segmented	27.0 kg

C45: 560-710 N/mm²



T120.25.30

500 kN/m max.



835 mm	32.87 in	30.5 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	29.0 kg
805 mm segmented	31.69 in segmented	29.4 kg

C45: 560-710 N/mm²



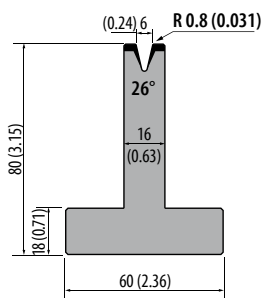
R1 ROLLERI TYPE R1

T-Dies 26°, H=80 (3.15)



T80.06.26

200 kN/m max.



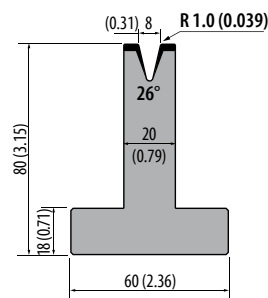
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

C45: 560-710 N/mm²



T80.08.26

200 kN/m max.



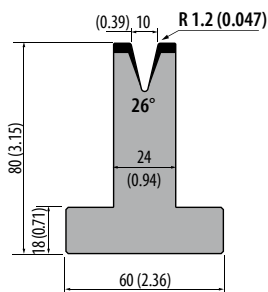
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	14.5 kg

C45: 560-710 N/mm²



T80.10.26

200 kN/m max.



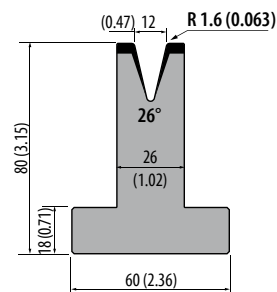
835 mm	32.87 in	15.5 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	14.9 kg

C45: 560-710 N/mm²



T80.12.26

200 kN/m max.



835 mm	32.87 in	16.6 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	15.8 kg
805 mm segmented	31.69 in segmented	16.0 kg

C45: 560-710 N/mm²



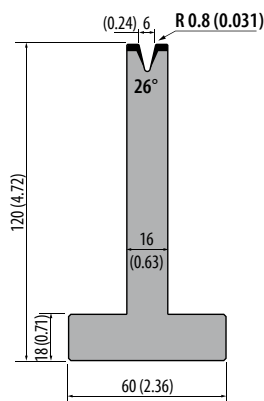
R1 ROLLER TYPE R1

T-Dies 26°, H=120 (4.72)



T120.06.26

200 kN/m max.



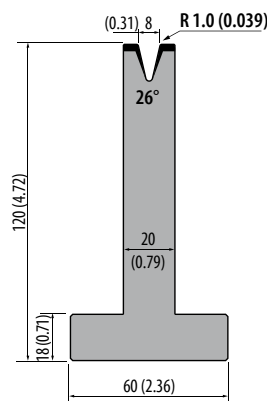
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



T120.08.26

200 kN/m max.



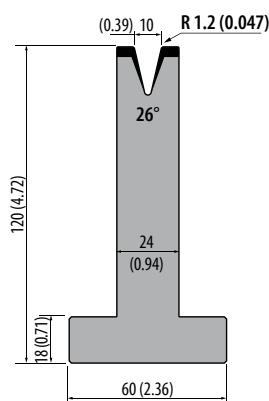
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.10.26

200 kN/m max.



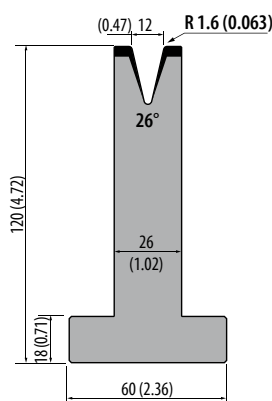
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



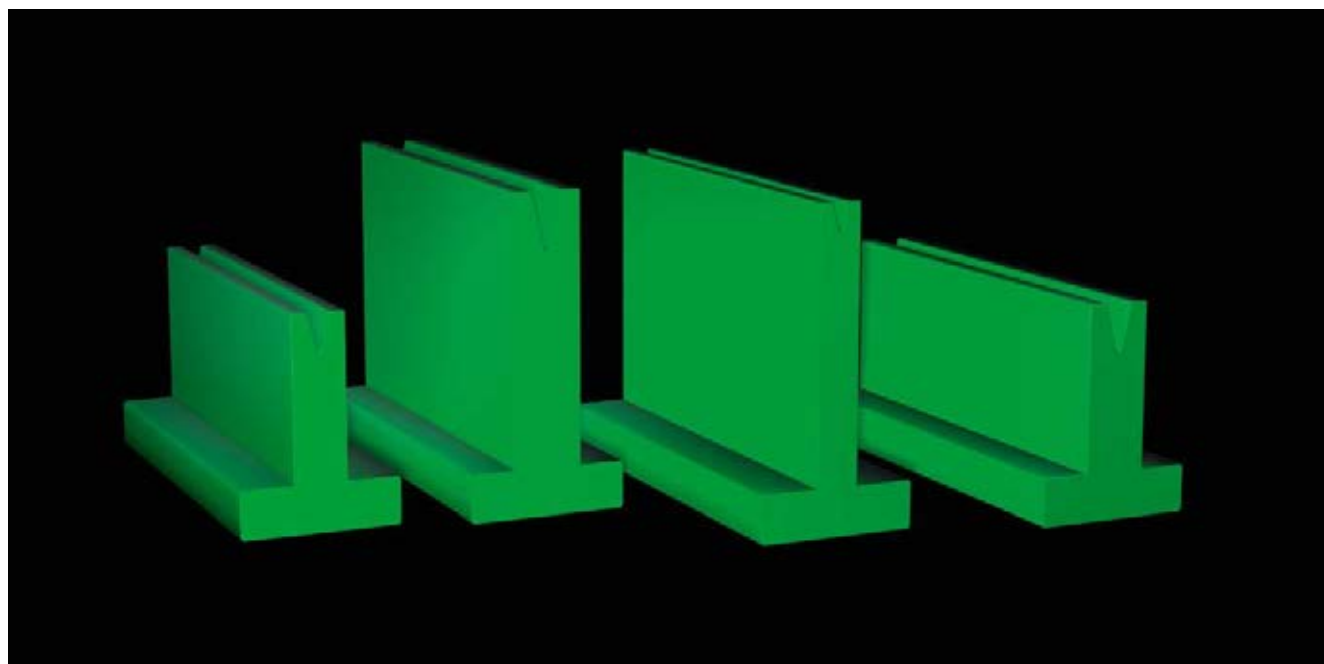
T120.12.26

200 kN/m max.



835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

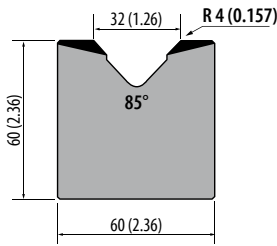
2
R1

R1 ROLLER TYPE R1

1-V Dies, 85°

M60.85.32

1000 kN/m max.



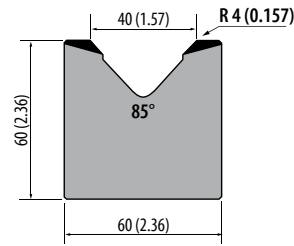
835 mm	32.87 in	21.6 kg
415 mm	16.34 in	10.7 kg
795 mm segmented	31.29 in segmented	20.6 kg
805 mm segmented	31.69 in segmented	20.8 kg

C45: 560-710 N/mm²



M60.85.40

1000 kN/m max.



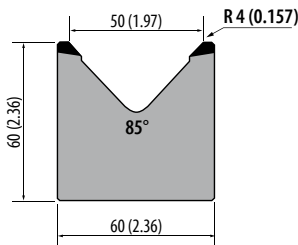
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M60.85.50

1000 kN/m max.



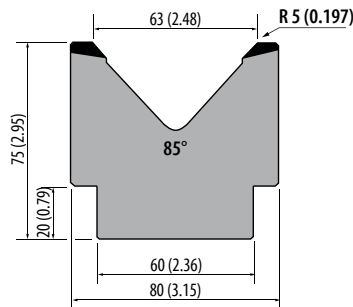
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



M75.85.63

1000 kN/m max.



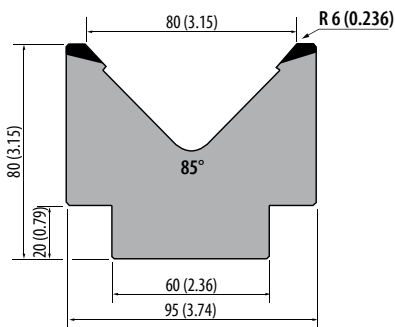
835 mm	32.87 in	29.2 kg
415 mm	16.34 in	14.5 kg
795 mm segmented	31.29 in segmented	27.8 kg
805 mm segmented	31.69 in segmented	28.0 kg

C45: 560-710 N/mm²



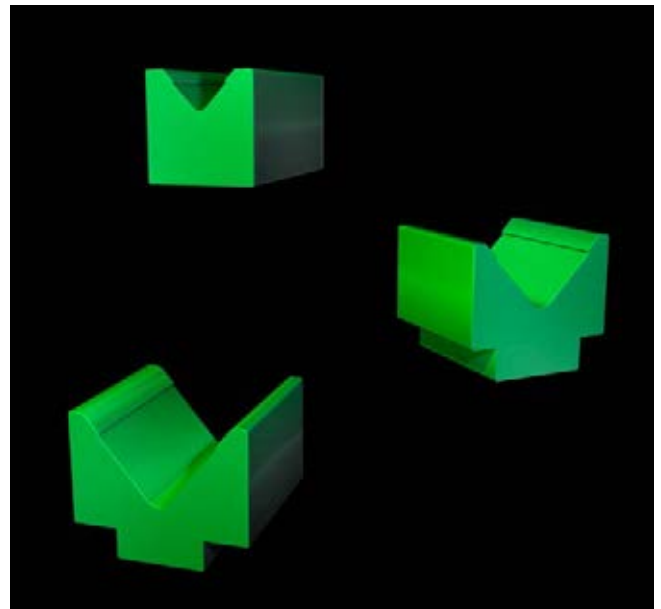
M80.85.80

1000 kN/m max.



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

C45: 560-710 N/mm²



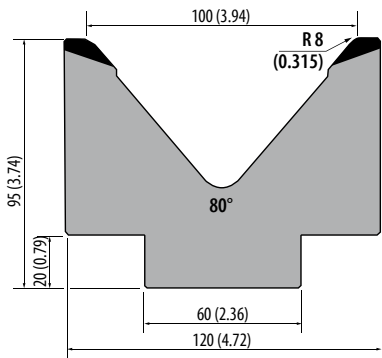
R1 ROLLER TYPE R1

1-V Dies, 80°



M95.80.100

1000 kN/m max.



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

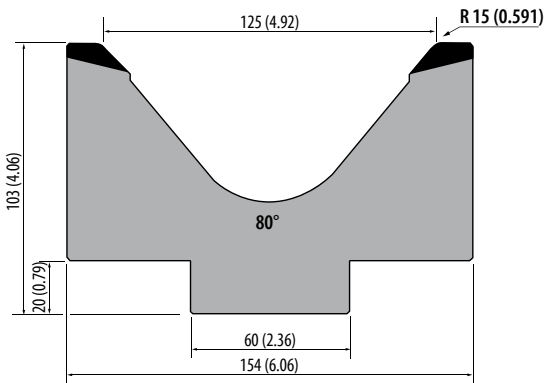
C45: 560-710 N/mm²



2
R1

MK103.80.125

700 kN/m max.



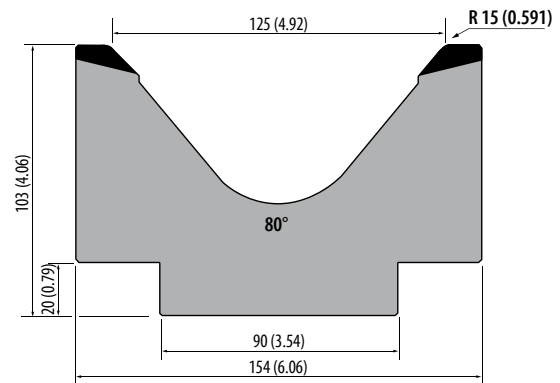
835 mm	32.87 in	62.0 kg
415 mm	16.34 in	31.0 kg
795 mm segmented	31.29 in segmented	59.0 kg
805 mm segmented	31.69 in segmented	59.8 kg



C45: 560-710 N/mm²

M103.80.125

1000 kN/m max.



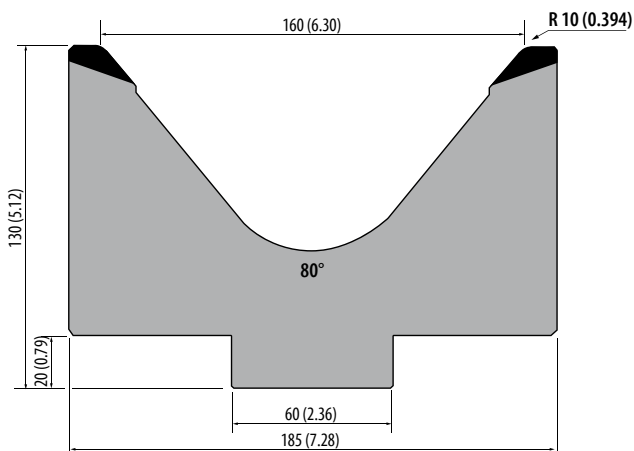
835 mm	32.87 in	64.9 kg
415 mm	16.34 in	32.2 kg
795 mm segmented	31.29 in segmented	61.4 kg
805 mm segmented	31.69 in segmented	62.5 kg



C45: 560-710 N/mm²

MK130.80.160

700 kN/m max.



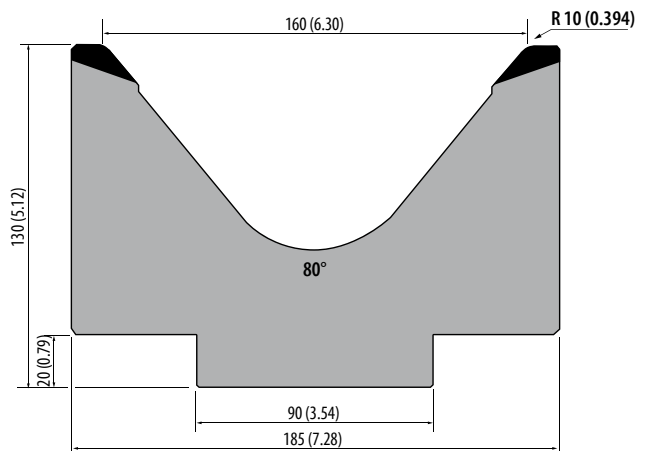
835 mm	32.87 in	93.0 kg
415 mm	16.34 in	46.5 kg
795 mm segmented	31.29 in segmented	88.5 kg
805 mm segmented	31.69 in segmented	89.7 kg



C45: 560-710 N/mm²

M130.80.160

1000 kN/m max.



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



C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

R1 ROLLERI TYPE R1

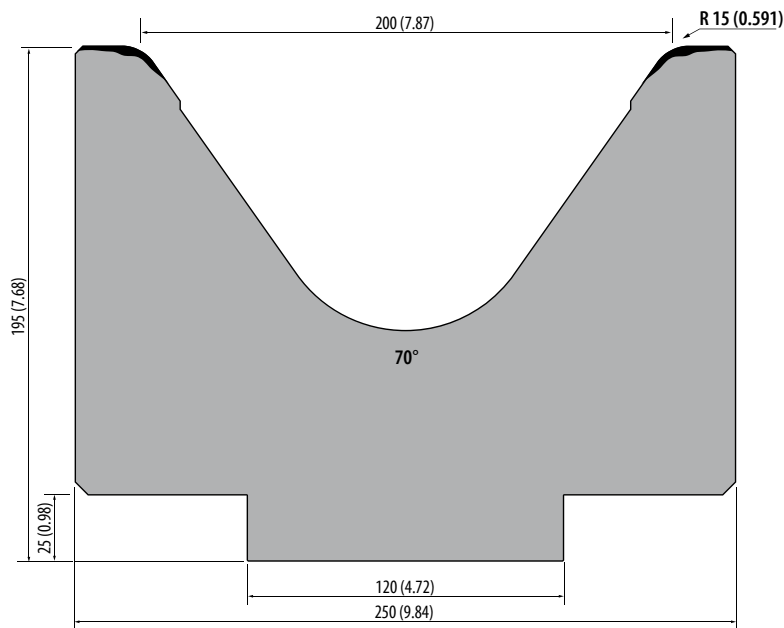
1-V Dies, 70°

M195.70.200

1800 kN/m max.

415 mm | 16.34 in | 104.0 kg

42Cr: 900-1150 N/mm²



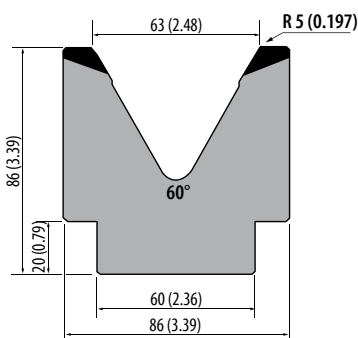
R1 ROLLERI TYPE R1

1-V Dies, 60°



M86.60.63

1000 kN/m max.



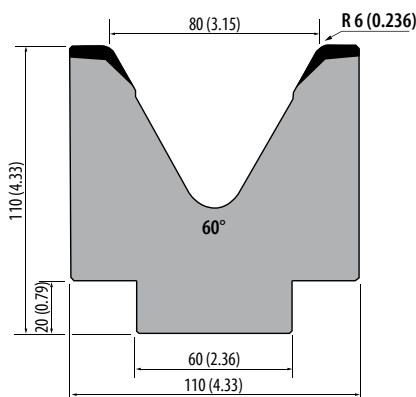
835 mm	32.87 in	34.0 kg
415 mm	16.34 in	17.0 kg
795 mm segmented	31.29 in segmented	32.4 kg
805 mm segmented	31.69 in segmented	32.8 kg

C45: 560-710 N/mm²



M110.60.80

1000 kN/m max.



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

C45: 560-710 N/mm²

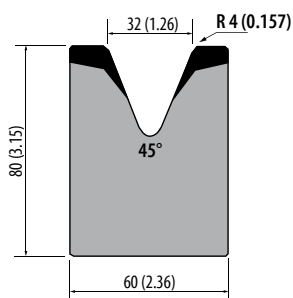


2
R1

1-V Dies, 45°

M80.45.32

1000 kN/m max.



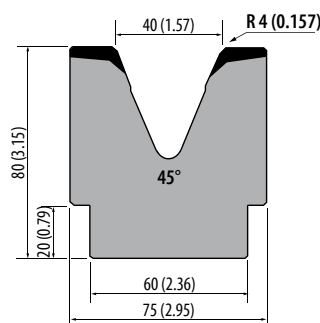
835 mm	32.87 in	27.5 kg
415 mm	16.34 in	13.7 kg
795 mm segmented	31.29 in segmented	26.2 kg
805 mm segmented	31.69 in segmented	26.5 kg

C45: 560-710 N/mm²



M80.45.40

1000 kN/m max.



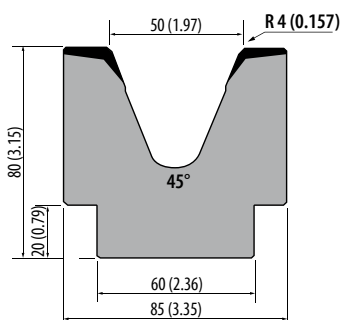
835 mm	32.87 in	30.9 kg
415 mm	16.34 in	16.5 kg
795 mm segmented	31.29 in segmented	29.4 kg
805 mm segmented	31.69 in segmented	29.8 kg

C45: 560-710 N/mm²



M80.45.50

950 kN/m max.



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

C45: 560-710 N/mm²



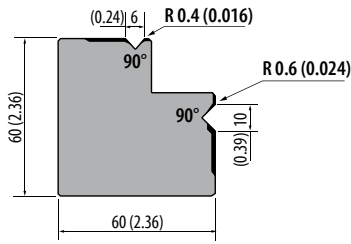
For the application of dies Rolleri Type R1 use the adapters on pages 226-229

R1 ROLLER TYPE R1

Multi-V Dies

M60.90.01

1000 kN/m max.



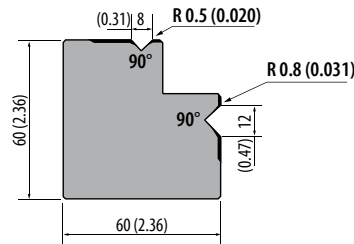
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M60.90.02

800 kN/m max.



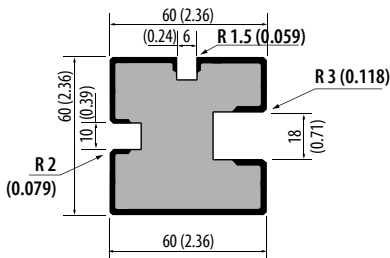
835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.0 kg
805 mm segmented	31.69 in segmented	20.2 kg

C45: 560-710 N/mm²



M.360.R

1000 kN/m max.



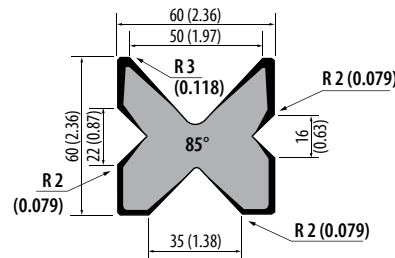
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M.460.R

800 kN/m max.



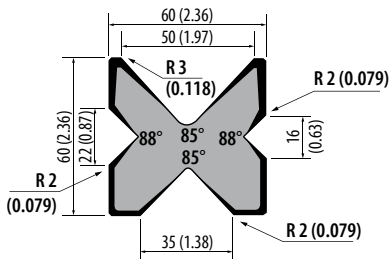
835 mm	32.87 in	15.7 kg
415 mm	16.34 in	7.7 kg
795 mm segmented	31.29 in segmented	14.9 kg
805 mm segmented	31.69 in segmented	15.1 kg

C45: 560-710 N/mm²



M.460

800 kN/m max.



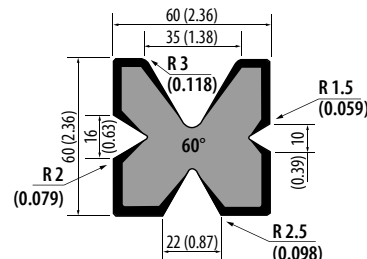
835 mm	32.87 in	15.8 kg
415 mm	16.34 in	7.8 kg
795 mm segmented	31.29 in segmented	15.0 kg
805 mm segmented	31.69 in segmented	15.2 kg

C45: 560-710 N/mm²



M.460.60

600 kN/m max.



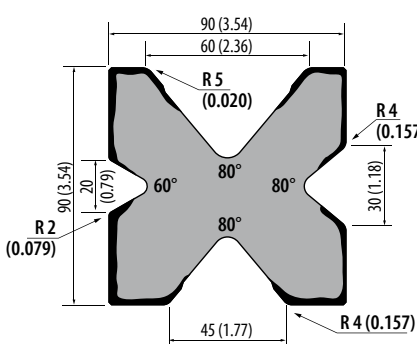
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



M.490

1000 kN/m max.



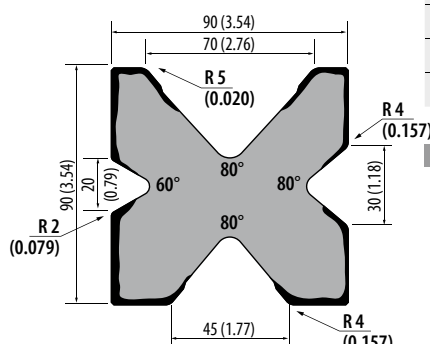
835 mm	32.87 in	38.9 kg
415 mm	16.34 in	20.0 kg
795 mm segmented	31.29 in segmented	37.0 kg
805 mm segmented	31.69 in segmented	37.5 kg

C45: 560-710 N/mm²



M.490.70

600 kN/m max.



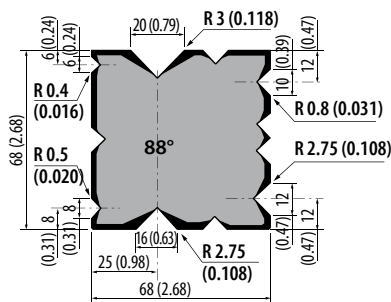
835 mm	32.87 in	35.9 kg
415 mm	16.34 in	18.0 kg
795 mm segmented	31.29 in segmented	34.2 kg
805 mm segmented	31.69 in segmented	34.6 kg

C45: 560-710 N/mm²



T70-88

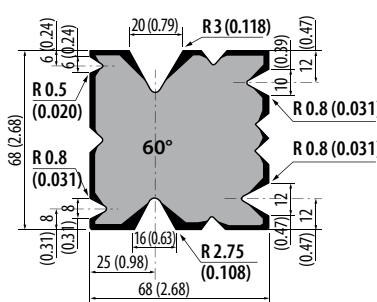
1000 kN/m max.



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

42Cr: 900-1150 N/mm²

T70-60

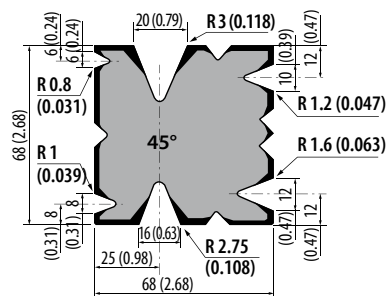


525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.8 kg

42Cr: 900-1150 N/mm²

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

T70-45

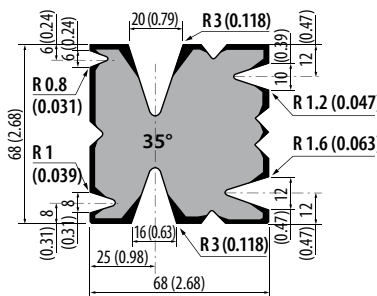


525 mm	20.67 in	16.1 kg
495 mm segmented	19.49 in segmented	15.2 kg

42Cr: 900-1150 N/mm²

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

T70-35

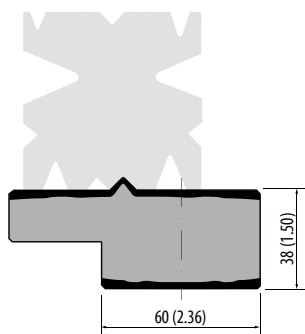


525 mm	20.67 in	15.3 kg
495 mm segmented	19.49 in segmented	14.4 kg

42Cr: 900-1150 N/mm²

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

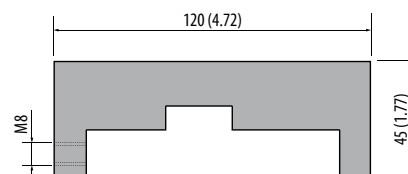
SU-T70



525 mm	20.67 in	12.4 kg
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C45: 560-710 N/mm²

PB-T70



20 mm	0.79 in	0.2 kg
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per pair

Fe37

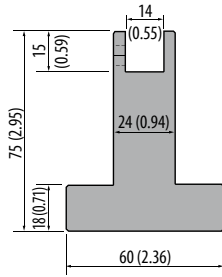
Special Punches and Dies
see pages 244-249

R1 ROLLER TYPE R1

Synthetic Dies

TN80.14

1000 kN/m max.



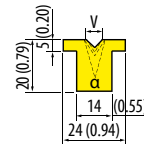
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg

C45: 560-710 N/mm²



INS14...

200 kN/m max.



835 mm	32.87 in	0.30 kg
415 mm	16.34 in	0.15 kg

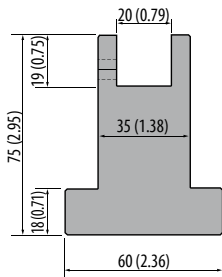


Model	α	V (mm)	V (in)
INS14.06.88	88°	6	0.24
INS14.08.88	88°	8	0.31
INS14.10.88	88°	10	0.39
INS14.06.60	60°	6	0.24
INS14.08.60	60°	8	0.31
INS14.10.60	60°	10	0.39

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

TN80.20

1000 kN/m max.



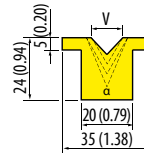
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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

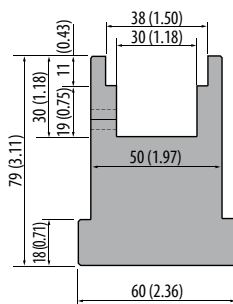


Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

TN80.30

1000 kN/m max.



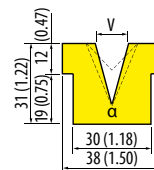
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

C45: 560-710 N/mm²



INS30...

200 kN/m max.



835 mm	32.87 in	0.50 kg
415 mm	16.34 in	0.25 kg

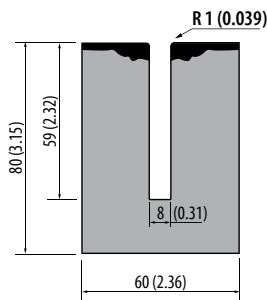


Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.99
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16	0.63
INS30.20.60	60°	20	0.79

Model	α	V (mm)	V (in)
INS30.06.45	45°	6	0.24
INS30.08.45	45°	8	0.31
INS30.10.45	45°	10	0.39
INS30.12.45	45°	12	0.47
INS30.16.45	45°	16	0.63
INS30.20.45	45°	20	0.79
INS30.06.30	30°	6	0.24
INS30.08.30	30°	8	0.31
INS30.10.30	30°	10	0.39
INS30.12.30	30°	12	0.47
INS30.16.30	30°	16	0.63

For advantages and mounting examples see Mark-Free bending Chapter on pages 236-237

TOP.SM-134.28.8 / TOP.SM-134.24.8

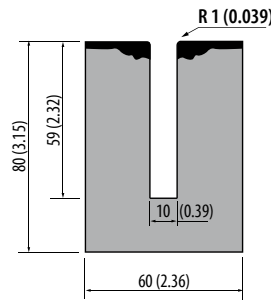


525 mm	20.67 in	17.5 kg
495 mm segmented	19.49 in segmented	16.5 kg

42Cr: 900-1150 N/mm²



TOP.SM-134.24.10

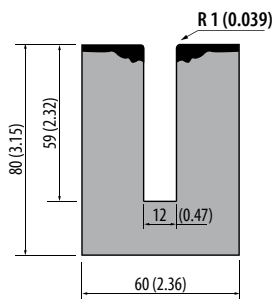


525 mm	20.67 in	18.0 kg
495 mm segmented	19.49 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



TOP.SM-134.24.12



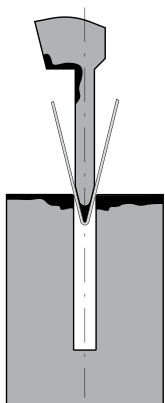
525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.9 kg

42Cr: 900-1150 N/mm²

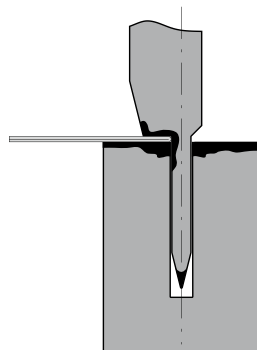


Compatible Hemming Punches see page 28

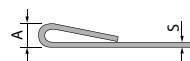
Example of application



500 kN/m max.



1000 kN/m max.



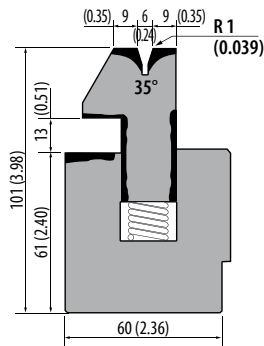
S mm	S in	A mm	A in	R.45 Kg/mm ² t/m	R.70 Kg/mm ² t/m	S mm	S in	A mm	A in	R.45 Kg/mm ² t/m	R.70 Kg/mm ² t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

R1 ROLLER TYPE R1

Spring-loaded Hemming Dies

S101.35.06

600 kN/m max.



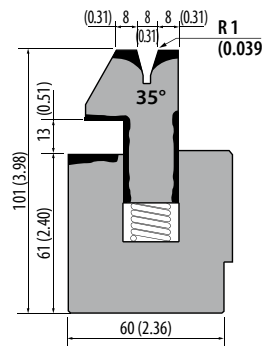
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.4 kg

C45: 800-850 N/mm²



S101.35.08

600 kN/m max.



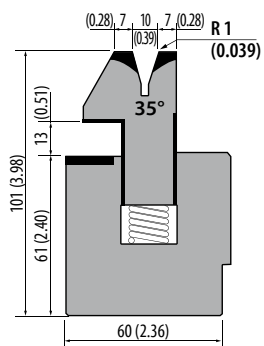
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²



S101.35.10

600 kN/m max.



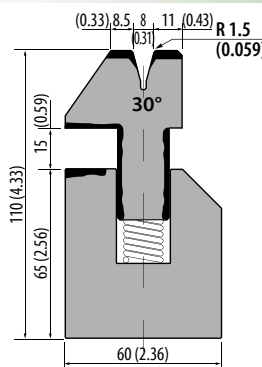
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 800-850 N/mm²



S110.30.08

800 kN/m max.



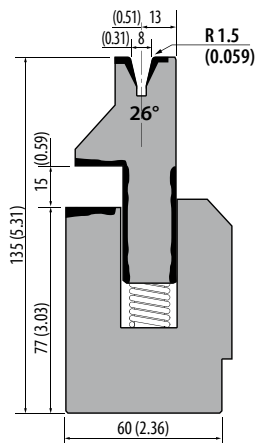
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²



S135.26.08

400 kN/m max.



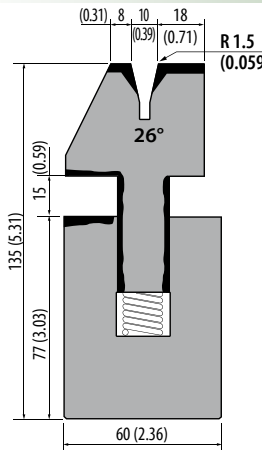
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

C45: 800-850 N/mm²



S135.26.10

1000 kN/m max.



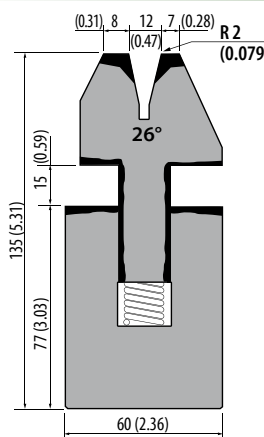
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

C45: 800-850 N/mm²



SA135.26.12

1000 kN/m max.



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

C45: 800-850 N/mm²



Our Advantage – Your Convenience

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



Rolleri Videos

demonstration of hemming dies at:
[www.rolleritools.com/
 videos/hemming-dies](http://www.rolleritools.com/videos/hemming-dies)



R1 ROLLER TYPE R1

Pneumatic Hemming Dies



KPN



per piece 1.0 kg

Accessories for pneumatic hemming dies

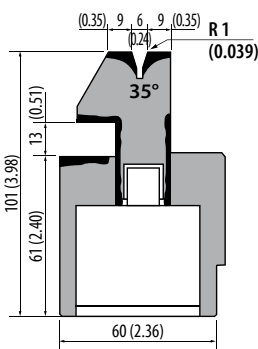


S mm	S in	A mm	A in	R.45 Kg/mm ² t/m	R.70 Kg/mm ² t/m	S mm	S in	A mm	A in	R.45 Kg/mm ² t/m	R.70 Kg/mm ² t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80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

2
R1

S101PN.35.06

600 kN/m max.



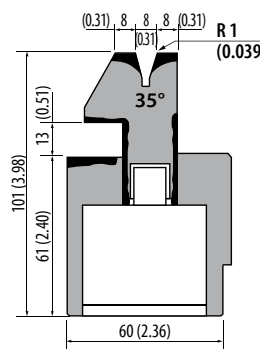
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S101PN.35.08

600 kN/m max.



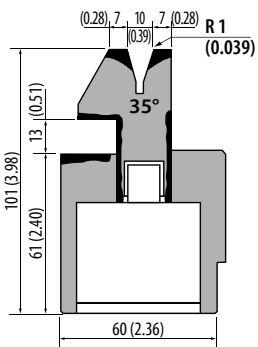
835 mm	32.87 in	31.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S101PN.35.10

600 kN/m max.



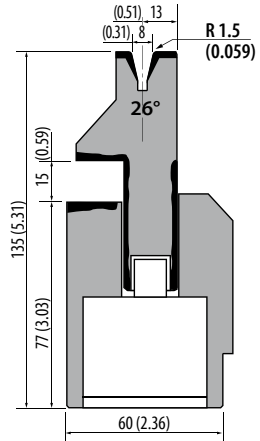
835 mm	32.87 in	29.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S135PN.26.08

400 kN/m max.



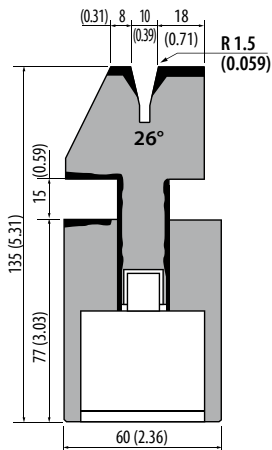
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

42Cr: 900-1150 N/mm²



S135PN.26.10

1000 kN/m max.



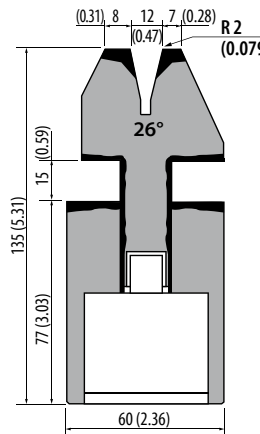
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

C45: 560-710 N/mm²



SA135PN.26.12

1000 kN/m max.



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

C45: 560-710 N/mm²



The complete pneumatic system is located within the die.



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

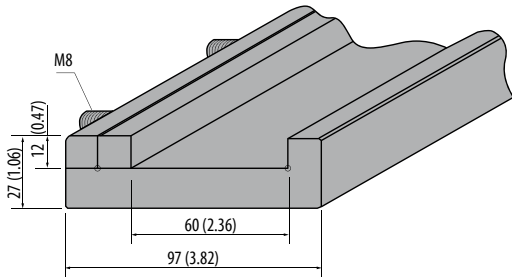


Articles on stock – Please note that delivery time depends on your location.

R1 ROLLER TYPE R1

Adapter Rails for Dies

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



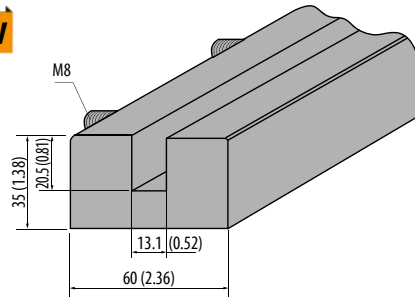
Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm²

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

NEW

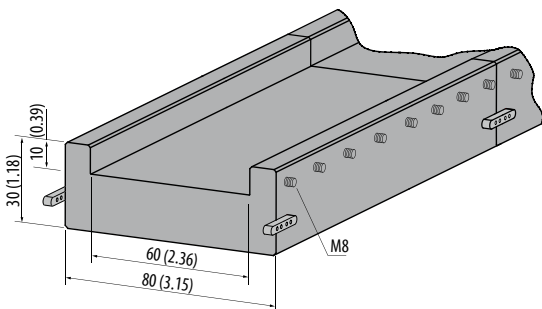


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm²

C 1050/R

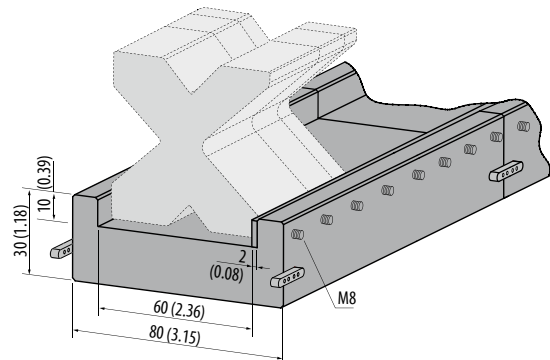


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg



C45: 560-710 N/mm²

C 1050/RS

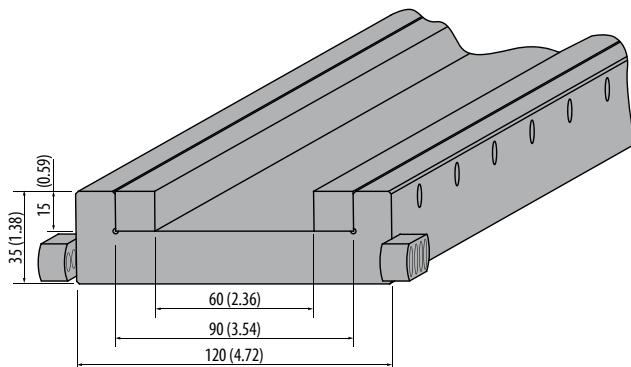


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



C45: 560-710 N/mm²

C 1050-90



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



C45: 560-710 N/mm²

R1 ROLLERI TYPE R1

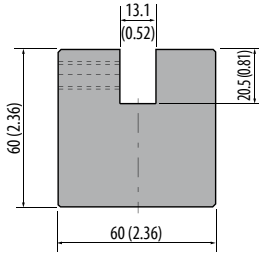
Die Adapters



AD5

1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

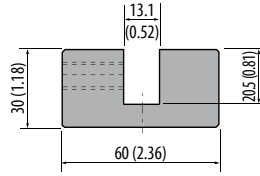
C45: 560-710 N/mm²



AD6

1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

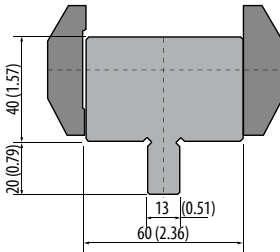


2
R1

AD7

1000 kN/m max.

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



Rolleri Type R2/R3
→ Rolleri Type R1

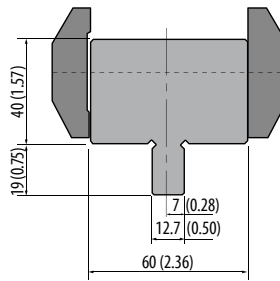
C45: 560-710 N/mm²



AD9-12.7

1000 kN/m max.

835 mm	32.87 in	19.6 kg
415 mm	16.34 in	9.7 kg



Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



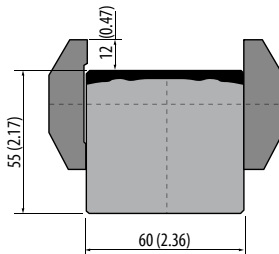
Do you have further queries about delivery times, operational areas, and other options?
Give us a call!

Die Extensions

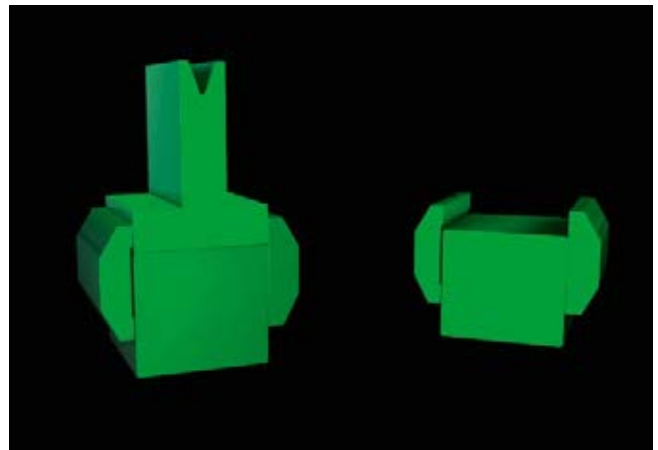
CTS60

1000 kN/m max.

835 mm	32.87 in	29.0 kg
415 mm	16.34 in	14.5 kg



C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

PUNCHES ROLLERI TYPE R2

Content Explanation	82 - 84
90° Punches	85
86° Punches	85 - 86
80° Punches	87
60° Punches	88
28° Punches	89 - 90
28°/24° Hemming Tools	91
Z-Profile Tools	92
Radius Tools	93 - 94
Punch Extensions	95
Punch Adapters	95

■ Compatibility

Punches Rolleri Type R2 are **compatible** with press brake machines from: Hämmerle-Bystronic, LVD, Trumpf or on press brake machines with System NSCL (New Standard Clamping)

With Adapter-Systems the punches Rolleri Type R2 are also applicable on all other press brake machines.



3
R2

Compatibility

Punches Rolleri Type R2 are:

- **compatible** with press brake machines from: Bystronic-Hämmerle, LVD, Trumpf or on press brake machines with System NSCL (New Standard Clamping)
- also applicable on all other press brake machines **with adapter-systems** (see page 222).

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 256-257)
- very large stock availability

Material

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

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

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

Tang

All punches Rolleri Type R2 can be equipped with three different clamping systems.

1. QuickLock \updownarrow
2. Safety Pins \leftrightarrow
3. ROL-System \updownarrow

ATTENTION:

QuickLock

By default, all tools are delivered with the QuickLock system, provided that these weigh less than 12 kg. This applies to most sectioned tools and to some standard length tools. If you prefer the QuickLock-System on tools which weigh more than 12 kg, it is possible to section the tool for a small surcharge.

Safety Pins

All tools that weigh more than 12 kg, are delivered by default with safety pins. This applies to all standard tool lengths and some segmented tools.

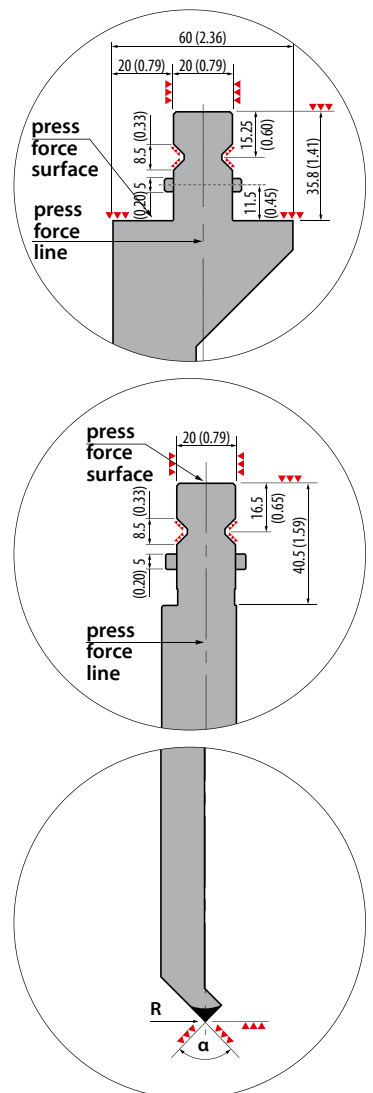
ROL1-System

Alternatively, you have the option of using tools with spring-loaded balls. Also here the max. weight is 12.5 kg per tool.

If you have any questions, please call to be assisted by one of our representatives!

Depending on each type, the punches are either head-bearing or shoulder-bearing.

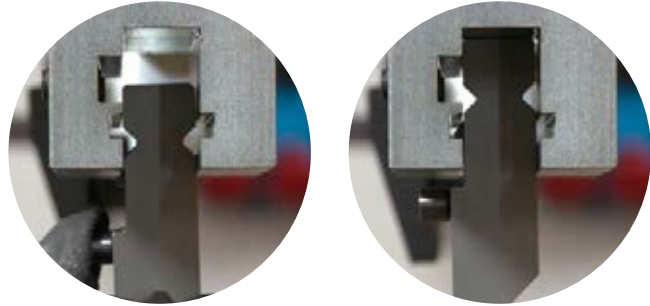
Indications of precision ground surfaces:



■ Clamping Systems

QuickLock (Standard)

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



QuickLock



3
R2



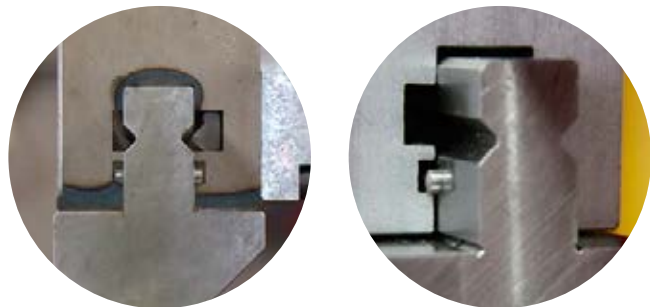
Rolleri Videos

QuickLock System:
[www.rolleritools.com/
videos/quicklock](http://www.rolleritools.com/videos/quicklock)



Safety Pins (Standard)

- horizontal tool exchange



ROL1-System

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



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

R2 ROLLER TYPE R2

Content Explanation Punches

Tool Lengths and Sectioning

Standard

More lengths and sectionings are possible upon request.

500 mm (19.68 in)

515 mm (20.28 in)

525 mm (20.67 in)

Sectioning FA

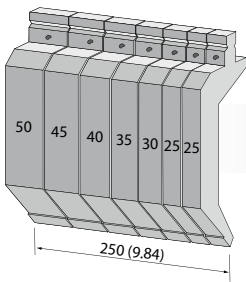
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

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

Sectioning FB

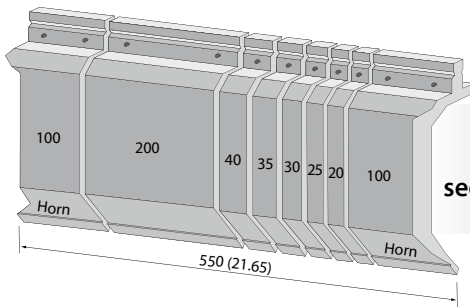
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94) Horn l.	100 (3.94) Horn r.	100 (3.94)	200 (7.87)	300 (11.81)
1250 (49.21)	2	1	1	1	1	1	1	1	1	2	1
2050 (80.71)	2	1	1	1	1	1	1	1	1	3	3
2550 (100.39)	2	1	1	1	1	1	1	1	1	4	4
3050 (120.08)	2	1	1	1	1	1	1	1	1	5	5
4050 (159.45)	2	1	1	1	1	1	1	1	1	7	7

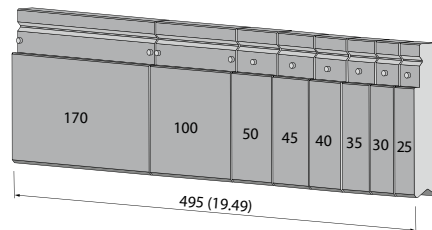


250 mm (9.84 in) segmented / FC
(7 segments)

Segmented tools are delivered in complete sets. Single pieces are also available!

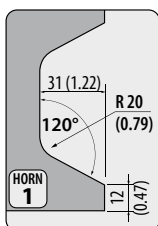


550 mm (21.65 in) segmented / FW
(8 segments)

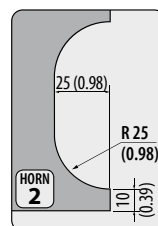


495 mm (19.49 in) segmented / F
(8 segments)

Horn Types



Horn 1
Standard for all segmented Punches Roller Type R2

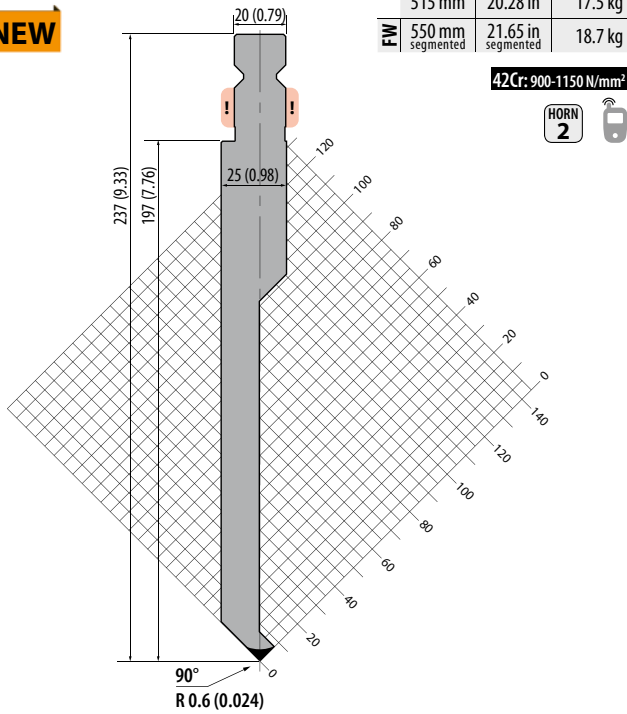


Horn 2
for all segmented Punches Roller Type R2 of Length 550 mm (21.65 in)

TPR237.90.R06

600 kN/m max.

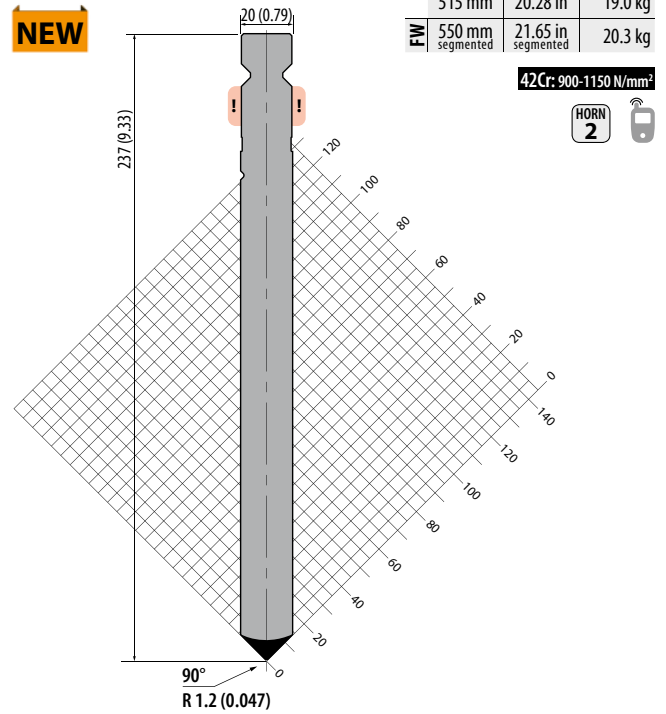
NEW



TPR237.90.R12

1000 kN/m max.

NEW



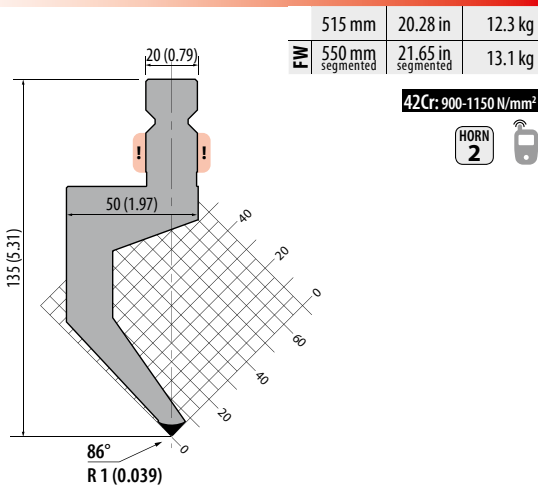
3
R2

86° Punches

TPR135.86.R1

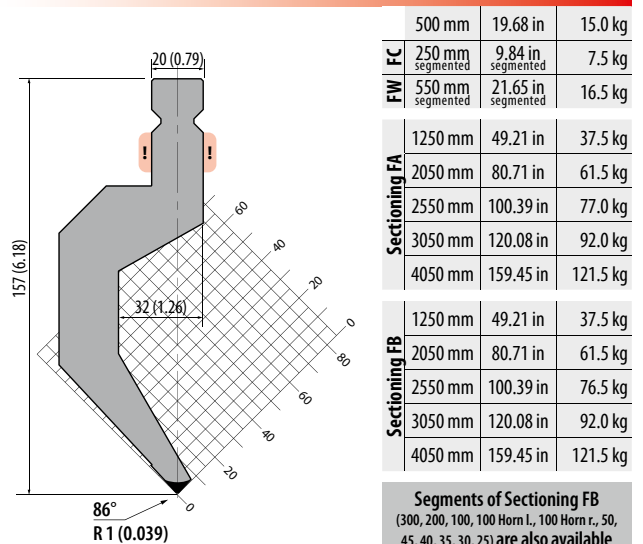
650 kN/m max.

NEW



TPR157.86.R1

800 kN/m max.



Please choose the clamping system!
Standard-Equipping:
< 12 kg QuickLock
> 12 kg safety pins
Also available: ROL1-System see pages 82-83 for more information.

42Cr: 900-1150 N/mm²

HORN 1

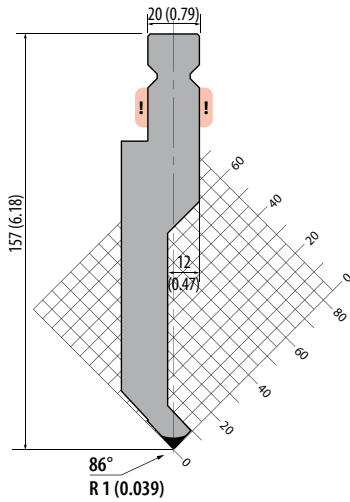
HORN 2 only for 550 mm (21.65 in) segm.

R2 ROLLER TYPE R2

86° Punches

TPR157.86.R1-A

800 kN/m max.



FW	FC	500 mm	19.68 in	12.5 kg
	250 mm segmented	9.84 in segmented	6.3 kg	
	550 mm segmented	21.65 in segmented	13.8 kg	
Sectioning FA	1250 mm	49.21 in	31.3 kg	
	2050 mm	80.71 in	51.3 kg	
	2550 mm	100.39 in	63.8 kg	
	3050 mm	120.08 in	76.3 kg	
	4050 mm	159.45 in	101.3 kg	
Sectioning FB	1250 mm	49.21 in	31.3 kg	
	2050 mm	80.71 in	51.3 kg	
	2550 mm	100.39 in	63.8 kg	
	3050 mm	120.08 in	76.3 kg	
	4050 mm	159.45 in	101.3 kg	

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r., 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

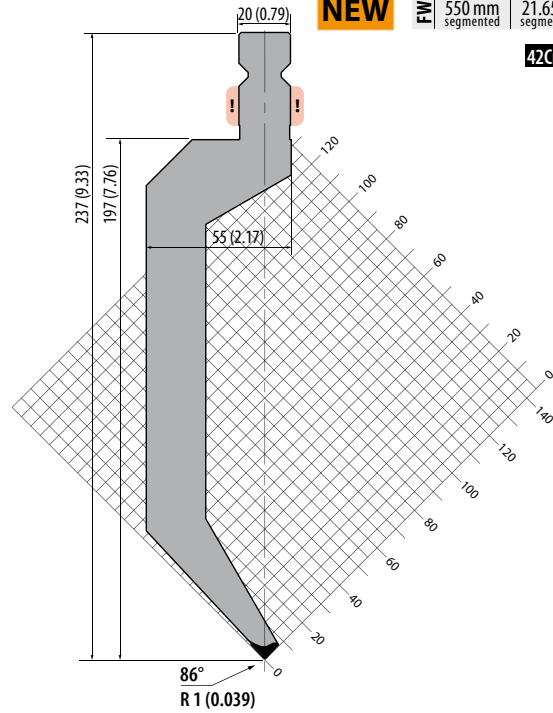
42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.

TPR237.86.R1

500 kN/m max.



NEW

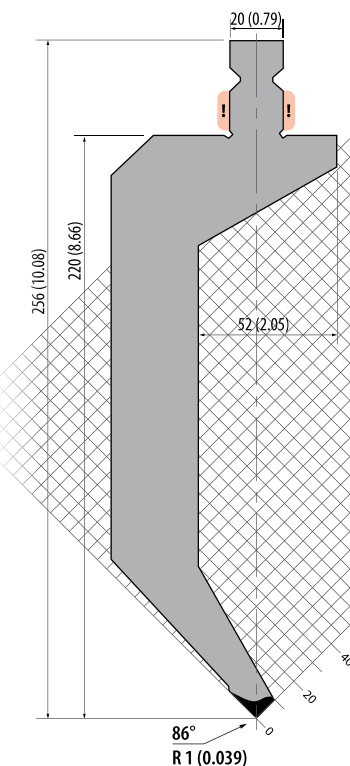
FW	FC	515 mm	20.28 in	23.0 kg
	550 mm segmented	21.65 in segmented	24.6 kg	

42Cr: 900-1150 N/mm²



TPR256.86.R1

800 kN/m max.



FW	FC	500 mm	19.68 in	33.0 kg
	250 mm segmented	9.84 in segmented	16.5 kg	
	550 mm segmented	21.65 in segmented	36.3 kg	
Sectioning FA	1250 mm	49.21 in	82.5 kg	
	2050 mm	80.71 in	136.0 kg	
	2550 mm	100.39 in	189.0 kg	
	3050 mm	120.08 in	202.0 kg	
	4050 mm	159.45 in	268.0 kg	
Sectioning FB	1250 mm	49.21 in	82.5 kg	
	2050 mm	80.71 in	136.0 kg	
	2550 mm	100.39 in	169.0 kg	
	3050 mm	120.08 in	201.3 kg	
	4050 mm	159.45 in	267.3 kg	

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r., 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

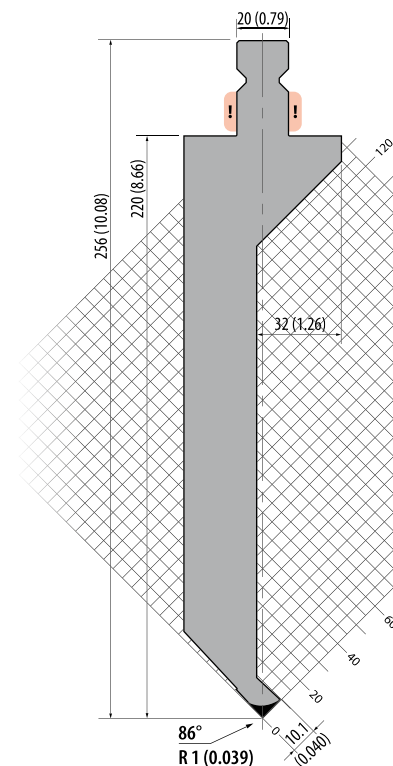
42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.

TPR256.86.R1-A

800 kN/m max.



FW	FC	500 mm	19.68 in	28.5 kg
	250 mm segmented	9.84 in segmented	12.5 kg	
550 mm segmented	21.65 in segmented	31.4 kg		

Sectioning FA	1250 mm	49.21 in	62.5 kg	
	2050 mm	80.71 in	102.5 kg	
	2550 mm	100.39 in	127.5 kg	
	3050 mm	120.08 in	152.5 kg	
	4050 mm	159.45 in	202.5 kg	

Sectioning FB	1250 mm	49.21 in	62.5 kg	
	2050 mm	80.71 in	102.5 kg	
	2550 mm	100.39 in	127.5 kg	
	3050 mm	120.08 in	152.5 kg	
	4050 mm	159.45 in	202.5 kg	

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r., 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

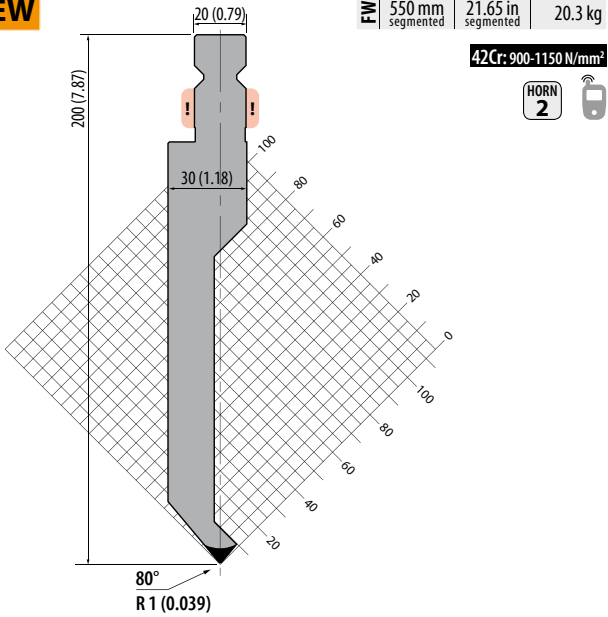


HORN 2 only for 550 mm (21.65 in) segm.

TPR200.80.R1

800 kN/m max.

NEW

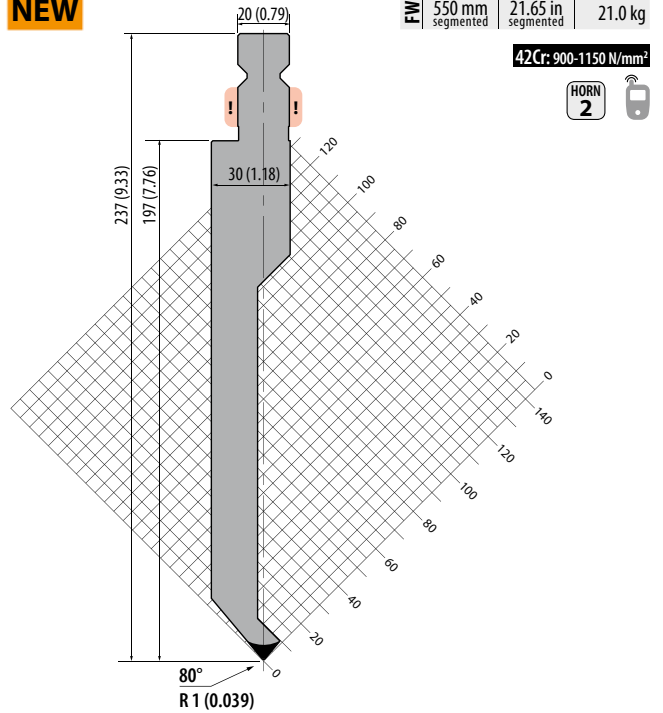


	515 mm	20.28 in	19.0 kg
FW	550 mm segmented	21.65 in segmented	20.3 kg

TPR237.80.R1

800 kN/m max.

NEW



	515 mm	20.28 in	19.7 kg
FW	550 mm segmented	21.65 in segmented	21.0 kg

Please choose the clamping system!
Standard-Equipping:
 < 12 kg QuickLock
 > 12 kg safety pins
 Also available: ROL1-System see pages 82-83 for more information.

**3
R2**



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
 100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



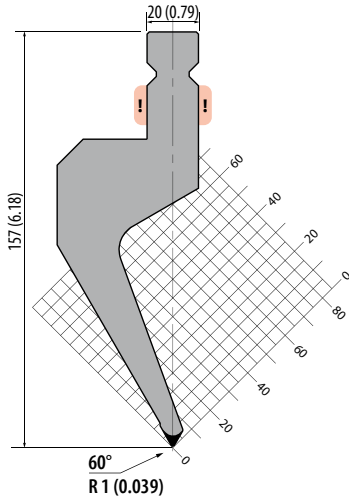
Articles on stock – Please note that delivery time depends on your location.

R2 ROLLER TYPE R2

60° Punches

TPR157.60.R1

700 kN/m max.



FW	FC	500 mm	19.68 in	15.0 kg
FW	250 mm segmented	9.84 in segmented		7.5 kg
	550 mm segmented	21.65 in segmented		16.5 kg
Sectioning FA	1250 mm	49.21 in		37.5 kg
	2050 mm	80.71 in		61.5 kg
	2550 mm	100.39 in		77.0 kg
	3050 mm	120.08 in		92.0 kg
	4050 mm	159.45 in		121.5 kg
Sectioning FB	1250 mm	49.21 in		37.5 kg
	2050 mm	80.71 in		61.5 kg
	2550 mm	100.39 in		76.5 kg
	3050 mm	120.08 in		92.0 kg
	4050 mm	159.45 in		121.5 kg

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r., 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

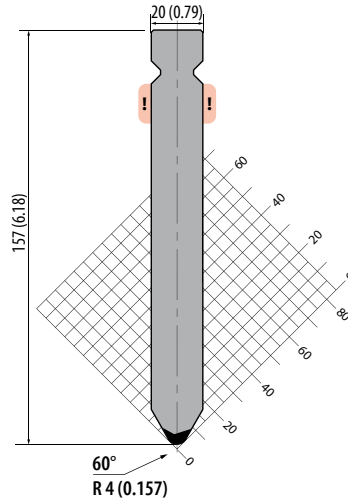
42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.

TPR157.60.R4

1300 kN/m max.



FW	FC	500 mm	19.68 in	12.0 kg
FW	250 mm segmented	9.84 in segmented		6.0 kg
	550 mm segmented	21.65 in segmented		13.2 kg
Sectioning FA	1250 mm	49.21 in		30.0 kg
	2050 mm	80.71 in		49.2 kg
	2550 mm	100.39 in		61.2 kg
	3050 mm	120.08 in		73.2 kg
	4050 mm	159.45 in		97.2 kg
Sectioning FB	1250 mm	49.21 in		30.0 kg
	2050 mm	80.71 in		49.2 kg
	2550 mm	100.39 in		61.2 kg
	3050 mm	120.08 in		73.2 kg
	4050 mm	159.45 in		97.2 kg

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r., 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

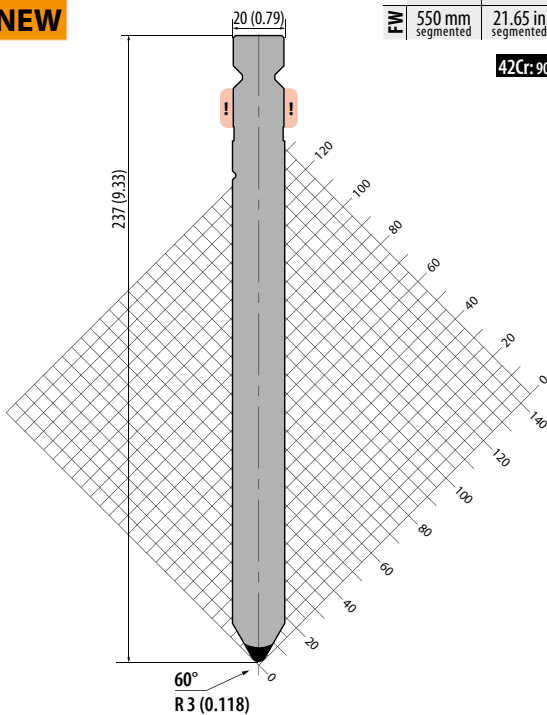


HORN 2 only for 550 mm (21.65 in) segm.

TPR237.60.R3

1300 kN/m max.

NEW



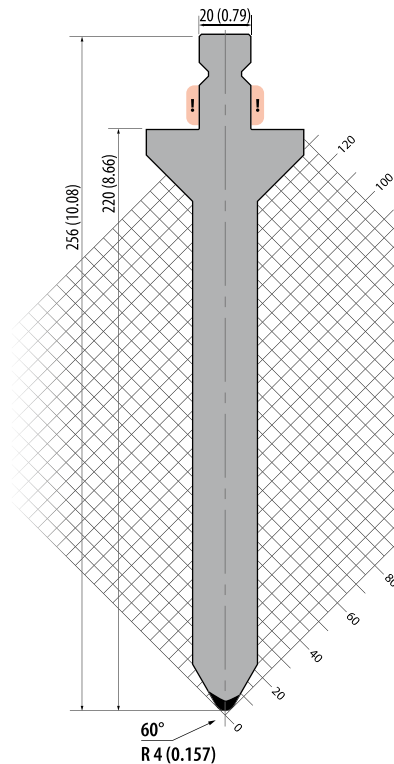
FW	515 mm	20.28 in	18.8 kg
FW	550 mm segmented	21.65 in segmented	20.1 kg

42Cr: 900-1150 N/mm²



TPR256.60.R4

1300 kN/m max.



FW	FC	500 mm	19.68 in	26.1 kg
FW	250 mm segmented	9.84 in segmented		13.5 kg
	550 mm segmented	21.65 in segmented		28.7 kg
Sectioning FA	1250 mm	49.21 in		68.0 kg
	2050 mm	80.71 in		111.0 kg
	2550 mm	100.39 in		138.0 kg
	3050 mm	120.08 in		165.0 kg
	4050 mm	159.45 in		219.0 kg
Sectioning FB	1250 mm	49.21 in		68.0 kg
	2050 mm	80.71 in		111.0 kg
	2550 mm	100.39 in		138.0 kg
	3050 mm	120.08 in		165.0 kg
	4050 mm	159.45 in		219.0 kg

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r., 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

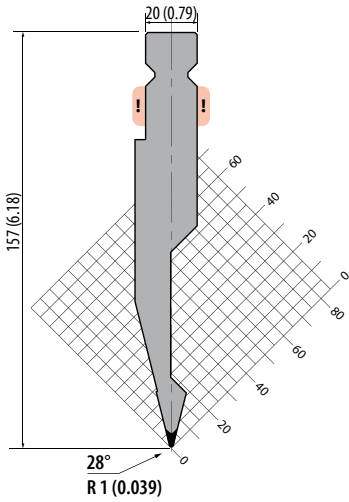
42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.

TPR157.28.R1

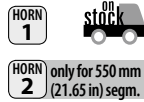
600 kN/m max.



	500 mm	19.68 in	10.0 kg
FC	250 mm segmented	9.84 in segmented	5.0 kg
	550 mm segmented	21.65 in segmented	11.0 kg
Sectioning FA	1250 mm	49.21 in	25.0 kg
	2050 mm	80.71 in	41.0 kg
	2550 mm	100.39 in	51.0 kg
	3050 mm	120.08 in	61.0 kg
	4050 mm	159.45 in	81.0 kg
Sectioning FB	1250 mm	49.21 in	25.0 kg
	2050 mm	80.71 in	41.0 kg
	2550 mm	100.39 in	51.0 kg
	3050 mm	120.08 in	61.0 kg
	4050 mm	159.45 in	81.0 kg

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

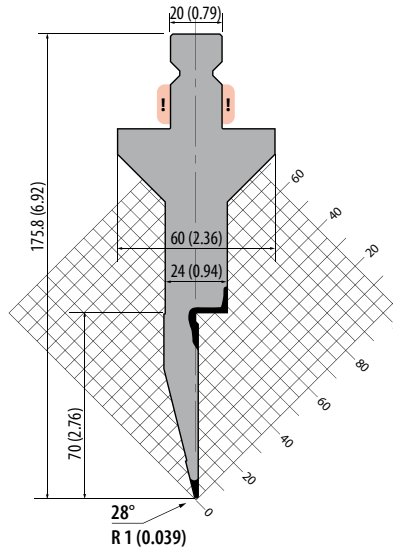
42Cr: 900-1150 N/mm²



Please choose the clamping system!
 Standard-Equipping:
 < 12 kg QuickLock
 > 12 kg safety pins
 Also available: ROL1-System see pages 82-83 for more information.

TPR176.28.R1

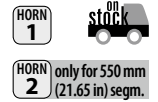
400 kN/m max.



	500 mm	19.68 in	15.0 kg
FC	250 mm segmented	9.84 in segmented	7.5 kg
	550 mm segmented	21.65 in segmented	16.5 kg
Sectioning FA	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg
	4050 mm	159.45 in	121.5 kg
Sectioning FB	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg
	4050 mm	159.45 in	121.5 kg

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

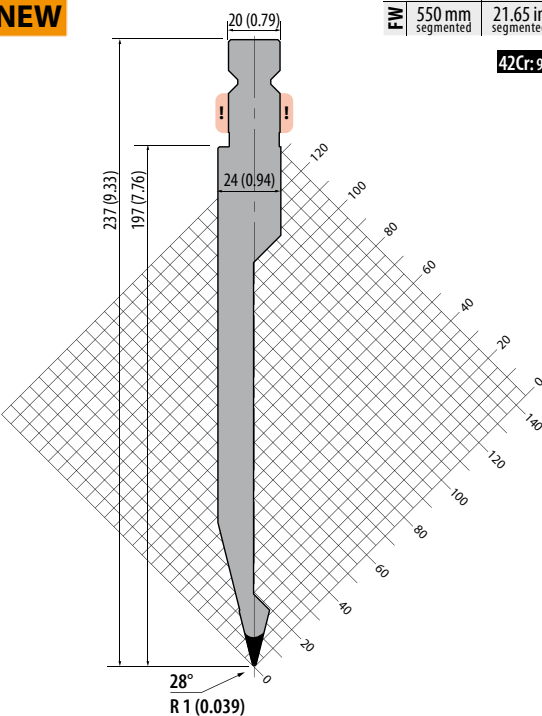
42Cr: 900-1150 N/mm²



TPR237.28.R1

600 kN/m max.

NEW



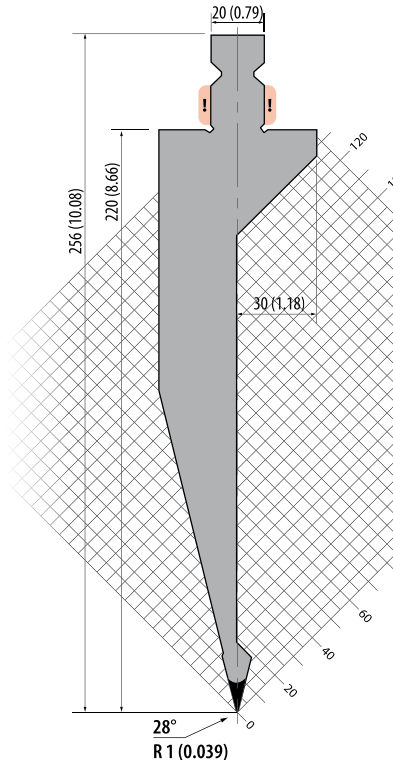
	515 mm	20.28 in	15.0 kg
FW	550 mm segmented	21.65 in segmented	16.0 kg

42Cr: 900-1150 N/mm²



TPR256.28.R1

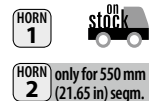
600 kN/m max.



	500 mm	19.68 in	25.0 kg
FC	250 mm segmented	9.84 in segmented	5.0 kg
	550 mm segmented	21.65 in segmented	27.5 kg
Sectioning FA	1250 mm	49.21 in	62.5 kg
	2050 mm	80.71 in	102.5 kg
	2550 mm	100.39 in	127.5 kg
	3050 mm	120.08 in	152.5 kg
	4050 mm	159.45 in	202.5 kg
Sectioning FB	1250 mm	49.21 in	62.5 kg
	2050 mm	80.71 in	102.5 kg
	2550 mm	100.39 in	127.5 kg
	3050 mm	120.08 in	152.5 kg
	4050 mm	159.45 in	202.5 kg

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

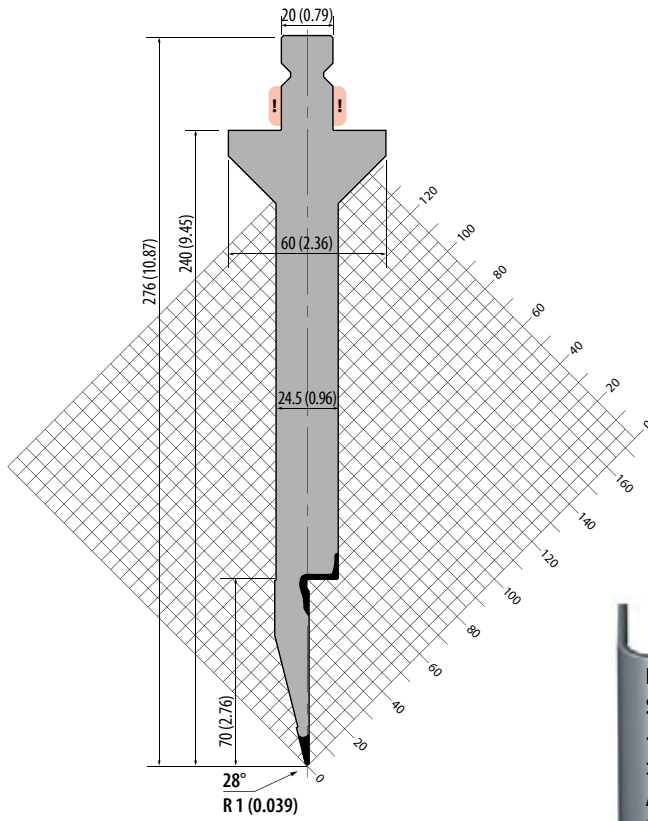
42Cr: 900-1150 N/mm²



R2 ROLLERI TYPE R2

28° Punches

TPR276.28.R1

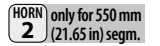


400 kN/m max.

FW FC	500 mm	19.68 in	24.0 kg
250 mm segmented	9.84 in segmented	12.0 kg	
550 mm segmented	21.65 in segmented	26.4 kg	
Sectioning FA	1250 mm	49.21 in	60.0 kg
2050 mm	80.71 in	98.4 kg	
2550 mm	100.39 in	122.4 kg	
3050 mm	120.08 in	146.4 kg	
4050 mm	159.45 in	194.4 kg	
Sectioning FB	1250 mm	49.21 in	60.0 kg
2050 mm	80.71 in	98.4 kg	
2550 mm	100.39 in	122.4 kg	
3050 mm	120.08 in	146.4 kg	
4050 mm	159.45 in	194.4 kg	

Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²



Please choose the clamping system!
Standard-Equipping:
 < 12 kg QuickLock
 > 12 kg safety pins
 Also available: ROL1-System see pages 82-83 for more information.



Rolleri Videos

find updated and helpful videos at:
www.rolleritools.com/videos/overview

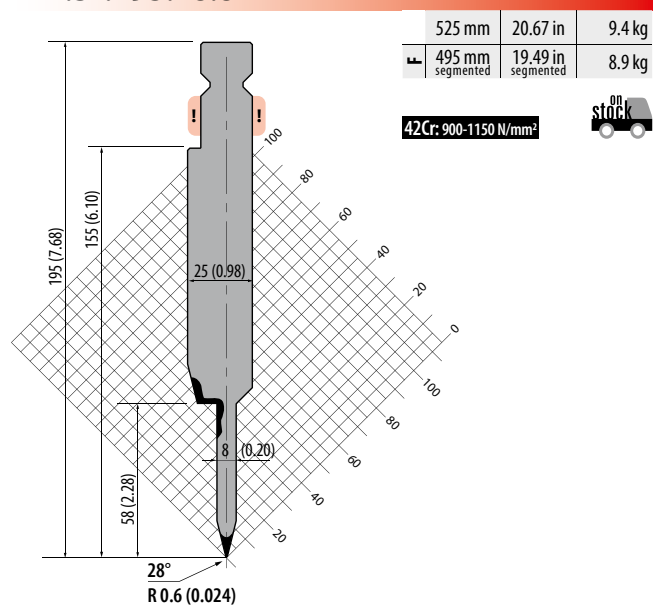


R2 ROLLER TYPE R2

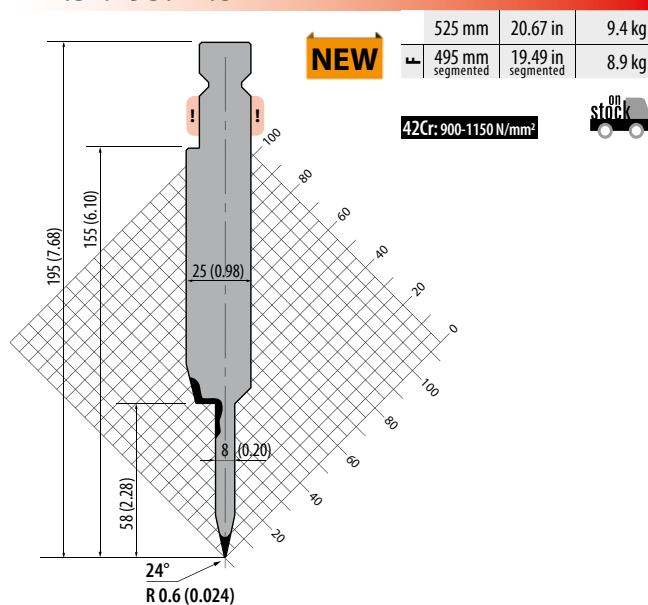
28°/24° Hemming Punches



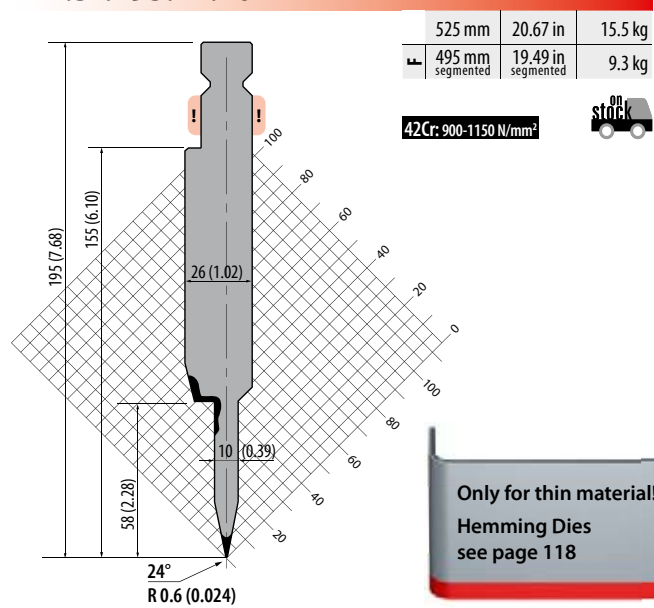
TPR.SP.195.28.8



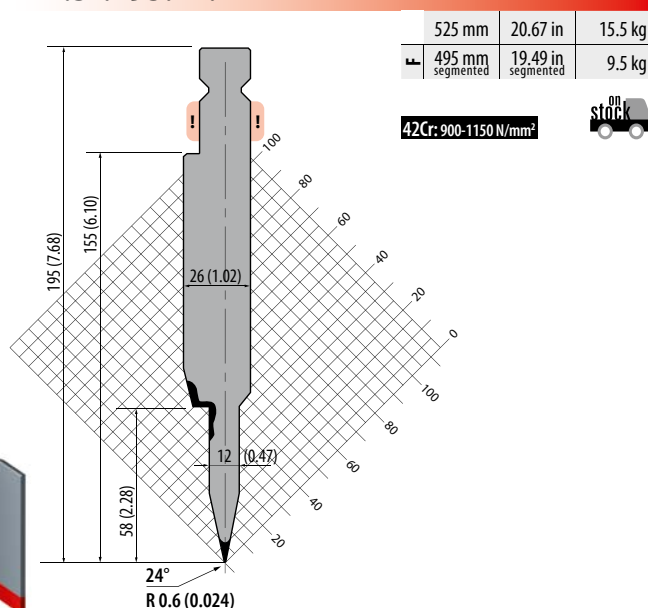
TPR.SP.195.24.8



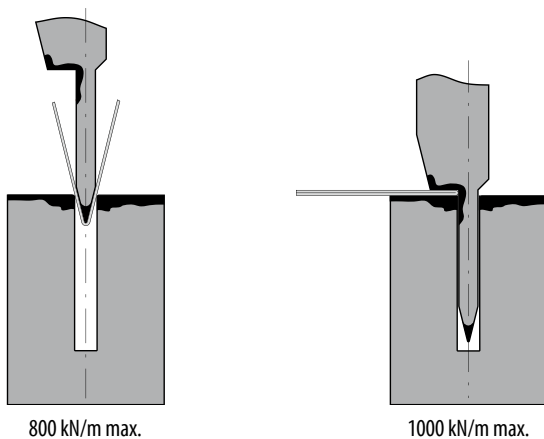
TPR.SP.195.24.10



TPR.SP.195.24.12



Example of application



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

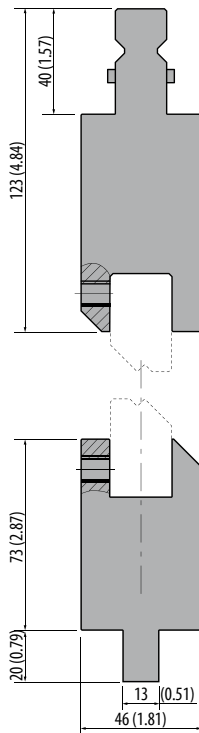
3
R2

R2 ROLLER TYPE R2

Z-Profile Tools

TPZ

1000 kN/m max.



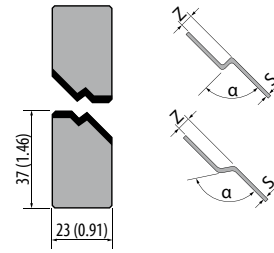
835 mm	32.87 in	46.0 kg
415 mm	16.34 in	23.0 kg

C45: 560-710 N/mm²



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

1000 kN/m max.



C45: 560-710 N/mm²



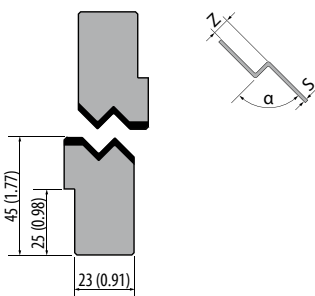
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°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

* Fe Rmax = 42 Kg/mm²

Please choose the clamping system!
Standard-Equipping:
< 12 kg QuickLock
> 12 kg safety pins
Also available: ROL1-System see pages 82-83 for more information.

Z- Profile Tool Inserts 90°

1000 kN/m max.



C45: 560-710 N/mm²



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



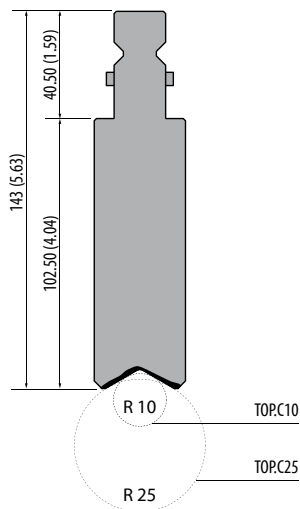
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	6.5 kg
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	6.5 kg
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	6.5 kg
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	6.5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

* Fe Rmax = 42 Kg/mm²



TPR143.10

1000 kN/m max.



	525 mm	20.67 in	18.0 kg
L	495 mm segmented	19.49 in segmented	17.0 kg

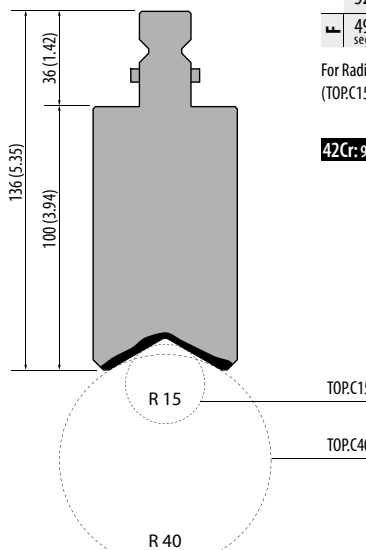
For Radius tools with R10-R25 (TOP.C10-TOP.C25) see below

42Cr: 900-1150 N/mm²



TPR136.15

1000 kN/m max.



	525 mm	20.67 in	25.0 kg
L	495 mm segmented	19.49 in segmented	23.7 kg

For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm²



Do you prefer the QuickLock or ROL1-System? Send us an email or give us a call!

Radius punches: R10-40

1000 kN/m max.

Material C53 induction hardened 60-62 HRC

C53: 610-760 N/mm²



Model	R mm	R in	Weight	Weight
TOP.C10	10	0.39		
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg

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



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



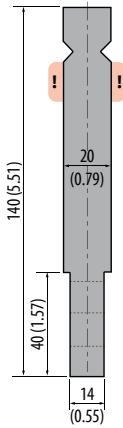
Articles on stock – Please note that delivery time depends on your location.

R2 ROLLER TYPE R2

Radius Tools

TPR140-14

800 kN/m max.



830 mm	32.68 in	17.0 kg
412 mm	16.22 in	9.0 kg

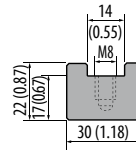
For Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see below

C45: 560-710 N/mm²



E30.22

800 kN/m max.



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

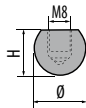
Hemming tool

C45: 560-710 N/mm²



Radius Tool: Ø 16-20 mm (0.63-0.79 in)

800 kN/m max.



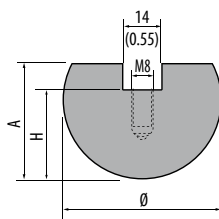
C45: 560-710 N/mm²



Model	Ø mm	Ø in	H mm	H in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight
C13.08	16	0.63	13	0.51	835 mm / 32.87 in	2.00 kg	415 mm / 16.34 in	1.00 kg
C13.09	18	0.71	16	0.63		2.00 kg		1.00 kg
C16.10	20	0.79	16	0.63		2.00 kg		1.00 kg

Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.



C45: 560-710 N/mm²



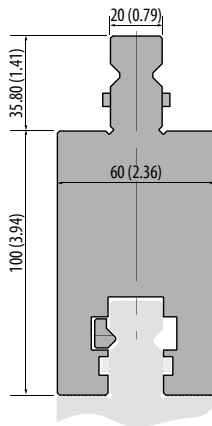
Model	Ø mm	Ø in	H mm	H in	A mm	A in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight
C17.12	25	0.98	17	0.67	22	0.87	835 mm / 32.87 in	2.5 kg	415 mm / 16.34 in	1.2 kg
C20.15	30	1.18	20	0.79	27	1.06		3.7 kg		1.8 kg
C22.17	35	1.38	22	0.87	32	1.26		5.0 kg		2.4 kg
C24.20	40	1.57	24	0.94	34	1.34		7.0 kg		3.5 kg
C29.25	50	1.97	29	1.14	39	1.54		10.0 kg		4.7 kg
C34.30	60	2.36	34	1.34	44	1.73		13.5 kg		6.7 kg
C45.35	70	2.76	45	1.77	55	2.17		20.3 kg		10.0 kg
C45.40	80	3.15	45	1.77	55	2.17		23.0 kg		11.5 kg
C60.45	90	3.54	60	2.36	70	2.76		34.0 kg		17.0 kg
C70.50	100	3.94	70	2.76	80	3.15		43.5 kg		21.7 kg

AD21

1500 kN/m max.

150 mm	5.91 in	7.0 kg
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42Cr: 900-1150 N/mm²



3
R2

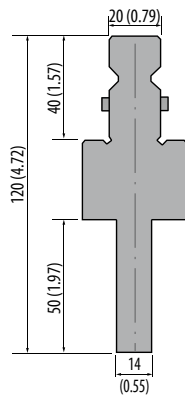
Punch Adapters

AD11

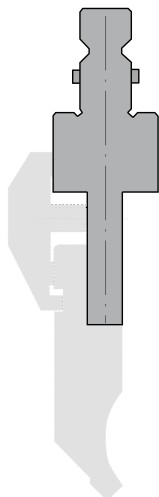
1000 kN/m max.

150 mm	5.91 in	3.0 kg
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C45: 560-710 N/mm²



Example of application



For more Adpaters
see pages 220-225

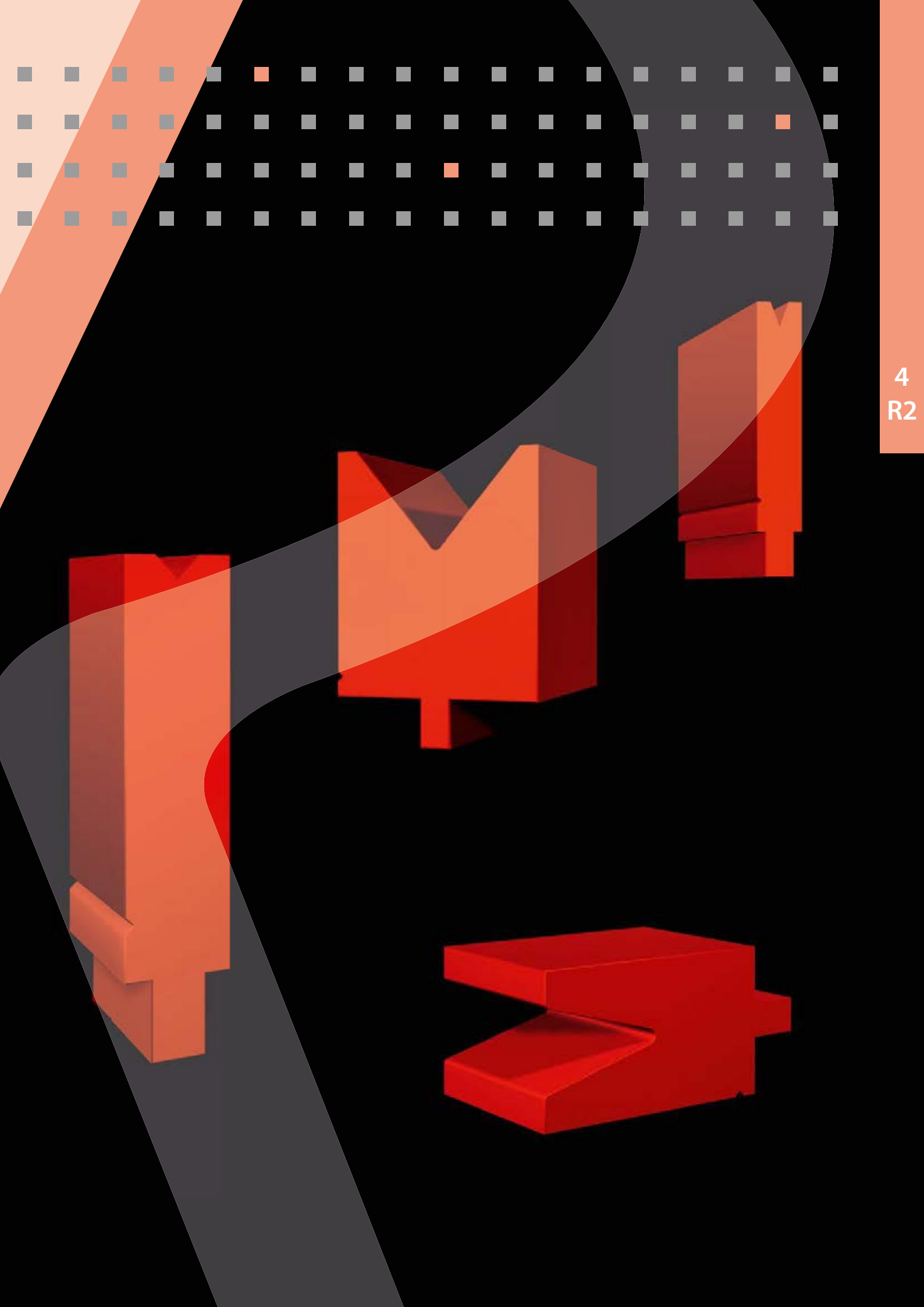
DIES ROLLERI TYPE R2

Content Explanation	98 - 99
Dies H=55 (2.17) - 85 (3.35)	100 - 101
Dies 90°, H=100 (3.94)	102
Dies 86°, H=100 (3.94)	102 - 104
Dies 84°, H=100 (3.94)	104 - 105
Dies 80°, H=100 (3.94)	106
Dies 60°, H=120 (4.72)	107
Dies 30°, H=100 (3.94)	107 - 109
Dies 86°, H=150 (5.91)	110 - 111
Dies 84°, H=150 (5.91)	111 - 112
Dies 80°, H=150 (5.91)	113
Dies 30°, H=150 (5.91)	114 - 115
Die Adapters	116
Synthetic Dies, H=100 (3.94)	117
Hemming Dies	118 - 119

Compatibility

Dies Roller Type R2 are **compatible** with press brake machines from: Hämmerle-Bystronic, LVD, Trumpf or on press brake machines with System NSCL (New Standard Clamping)

With Adapter-Systems the dies Roller Type R2 are also applicable on all other press brake machines.



4
R2

Compatibility

Dies Roller Type R2 are:

- **compatible** with press brake machines with a table groove for pins 13 x 20 mm (0.51 x 0.79 in): Bystronic-Hämmerle, Trumpf
- also applicable on all other press brake machines **with Adapter-Systems and Adapter Rails** (see pages 226-229).

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 258-261)
- very large stock availability

Material

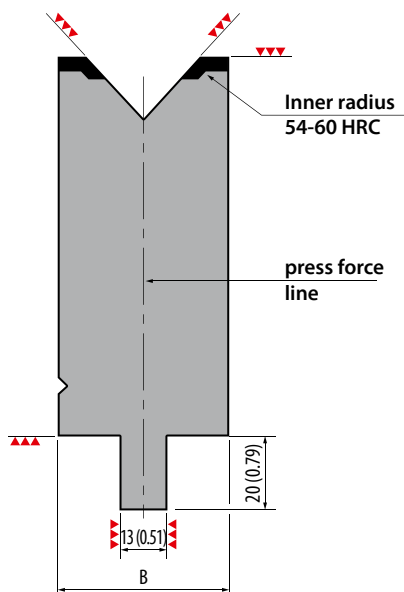
The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

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

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

Tang

All dies Roller Type R2 are by default equipped with a **13 x 20 mm (0.51 x 0.79 in) tail**.



Indications of precision ground surfaces:

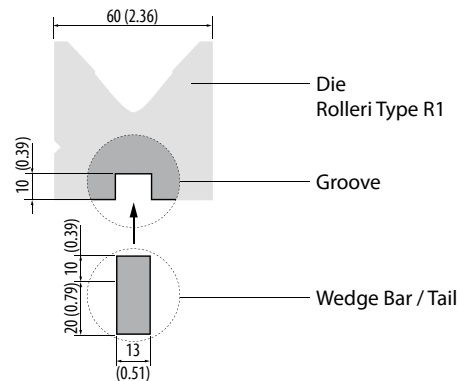


Modification: Wedge Bar / Tail

In order to also use Roller Type R1 Dies, a 10 mm (0.39 in) groove is milled and a precise grounded wedge bar /tail in 13 x 30 mm (0.51 x 1.18 in) is inserted.

For more specific information and prices go to page 260 in the Service Chapter.

A30 (Mounting example)



Tool lengths and sectioning

Standard

More lengths and sectionings are possible upon request.

500 mm (19.68 in)

515 mm (20.28 in)

525 mm (20.67 in)

1000 mm (39.37 in)

Sectioning FA

1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

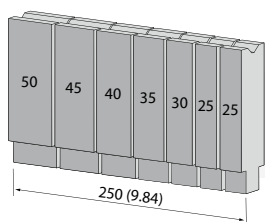
Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94)
1250 (49.21)	2	1	1	1	1	1	10
2050 (80.71)	2	1	1	1	1	1	18
2550 (100.39)	2	1	1	1	1	1	23
3050 (120.08)	2	1	1	1	1	1	28
4050 (159.45)	2	1	1	1	1	1	38

Sectioning FB

1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

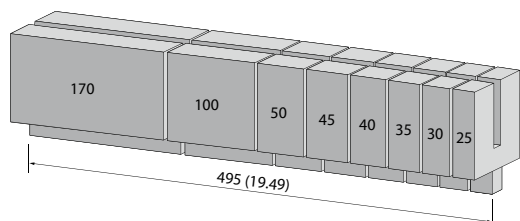
Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94)	200 (7.87)	300 (11.81)	500 (19.68)
1250 (49.21)	2	1	1	1	1	1	3	2	1	0
2050 (80.71)	2	1	1	1	1	1	3	1	1	2
2550 (100.39)	2	1	1	1	1	1	3	1	1	3
3050 (120.08)	2	1	1	1	1	1	3	1	1	4
4050 (159.45)	2	1	1	1	1	1	3	1	1	6

4
R2

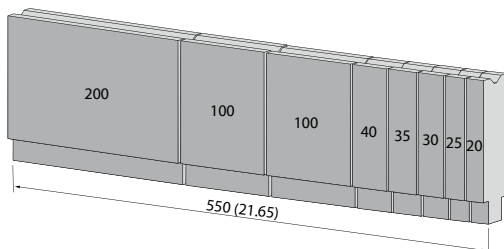


250 mm (9.84 in) segmented / FC (7 segments)

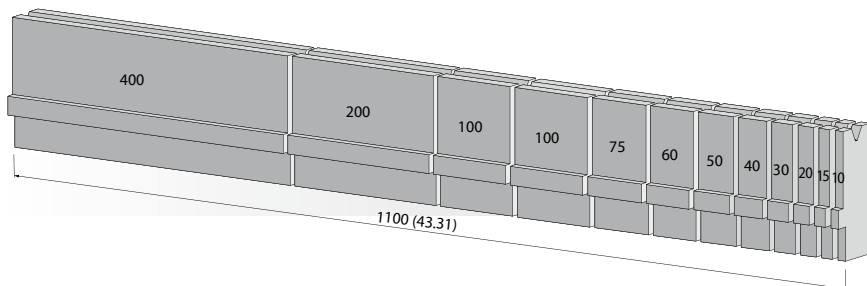
Segmented tools are delivered in complete sets. Single pieces are also available!



495 mm (19.49 in) segmented / F (8 segments)



550 mm (21.65 in) segmented / FW (8 segments)

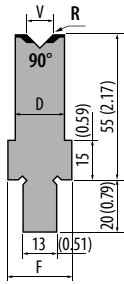


1100 mm (43.31 in) segmented (12 segments)

R2 ROLLER TYPE R2

Dies, H=55 (2.17)

90° Dies, H=55 (2.17)



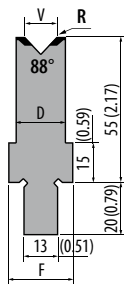
Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in	Weight	500 mm / 19.68 in	Weight	1100 mm / 43.31 in segmented	Weight
BMR55.06.90	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg			
BMR55.08.90	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg			
BMR55.10.90	10	0.39	1.0	0.04	20	0.79	25	0.98	1100	10.5 kg	5.2 kg	10.0 kg			
BMR55.12.90	12	0.47	1.5	0.06	20	0.79	25	0.98	1200	10.5 kg	5.2 kg	10.0 kg			
BMR55.16.90	16	0.63	2.0	0.08	30	1.18	30	1.18	1200	14.5 kg	7.2 kg	14.0 kg			

42Cr: 900-1150 N/mm²



For individual drawings and availability see pages 138-144

88° Dies, H=55 (2.17)

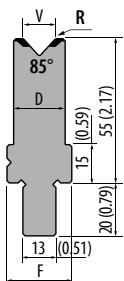


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in	Weight	500 mm / 19.68 in	Weight	1100 mm / 43.31 in segmented	Weight
BMR55.06.88	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg			
BMR55.08.88	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg			
BMR55.10.88	10	0.39	1.0	0.04	20	0.79	25	0.98	1100	11.0 kg	5.0 kg	12.0 kg			
BMR55.12.88	12	0.47	1.5	0.06	20	0.79	25	0.98	1200	10.5 kg	5.2 kg	10.0 kg			
BMR55.16.88	16	0.63	2.0	0.08	30	1.18	30	1.18	1200	14.5 kg	7.2 kg	14.0 kg			
BMR55.20.88	20	0.79	2.0	0.08	30	1.18	30	1.18	1100	14.5 kg	7.2 kg	14.0 kg			
BMR55.24.88	24	0.94	3.0	0.12	40	1.57	40	1.57	1200	18.5 kg	9.2 kg	18.0 kg			

42Cr: 900-1150 N/mm²



85° Dies, H=55 (2.17)

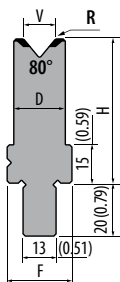


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in	Weight	500 mm / 19.68 in	Weight	1100 mm / 43.31 in segmented	Weight
BMR55.06.85	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg			
BMR55.08.85	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg			
BMR55.10.85	10	0.39	1.0	0.04	20	0.79	25	0.98	1100	11.0 kg	5.0 kg	12.0 kg			
BMR55.12.85	12	0.47	1.5	0.06	20	0.79	25	0.98	1200	10.5 kg	5.2 kg	10.0 kg			
BMR55.16.85	16	0.63	2.0	0.08	30	1.18	30	1.18	1200	14.5 kg	7.2 kg	14.0 kg			
BMR55.20.85	20	0.79	2.0	0.08	30	1.18	30	1.18	1100	14.5 kg	7.2 kg	14.0 kg			
BMR55.24.85	24	0.94	3.0	0.12	40	1.57	40	1.57	1200	18.5 kg	9.2 kg	18.0 kg			
BMR55.32.85	32	1.26	4.0	0.16	50	1.97	50	1.97	1200	21.0 kg	10.5 kg	20.5 kg			
BMR55.40.85	40	1.57	4.0	0.16	55	2.17	55	2.17	1200	21.5 kg	10.7 kg	25.0 kg			

42Cr: 900-1150 N/mm²



80° Dies, H=55 (2.17) / H=65 (2.56) / H=85 (3.35)



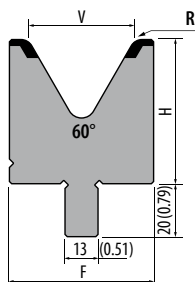
Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	H (mm)	H (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.06.80	6	0.24	0.4	0.02	15	0.59	55	2.17	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg
BMR55.08.80	8	0.31	0.5	0.02	15	0.59	55	2.17	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg
BMR55.10.80	10	0.39	1.0	0.04	20	0.79	55	2.17	25	0.98	1100	11.0 kg	5.0 kg	12.0 kg
BMR55.12.80	12	0.47	1.5	0.06	20	0.79	55	2.17	25	0.98	1200	10.5 kg	5.2 kg	10.0 kg
BMR55.16.80	16	0.63	2.0	0.08	30	1.18	55	2.17	30	1.18	1200	14.5 kg	7.2 kg	14.0 kg
BMR55.20.80	20	0.79	2.0	0.08	30	1.18	55	2.17	30	1.18	1100	14.5 kg	7.2 kg	14.0 kg
BMR55.24.80	24	0.94	3.0	0.12	40	1.57	55	2.17	40	1.57	1200	18.5 kg	9.2 kg	18.0 kg
BMR55.32.80	32	1.26	4.0	0.16	50	1.97	55	2.17	50	1.97	1200	21.0 kg	10.5 kg	20.5 kg
BMR55.40.80	40	1.57	4.0	0.16	55	2.17	55	2.17	55	2.17	1200	21.5 kg	10.7 kg	25.0 kg
BMR65.80.80	80	3.15	10.0	0.39	100	3.94	65	2.56	100	3.94	1700	39.0 kg	20.0 kg	43.0 kg
BMR85.100.80	100	3.94	12.0	0.47	125	4.92	85	3.35	125	4.92	2300	62.0 kg	31.0 kg	69.0 kg

42Cr: 900-1150 N/mm²



4
R2

60° Dies, H=55 (2.17) / H=65 (2.56)

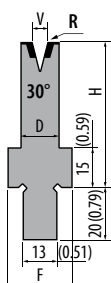


Model	V (mm)	V (in)	R (mm)	R (in)	H (mm)	H (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.40.60	40	1.57	5.0	0.20	55	2.17	55	2.17	1300	20.3 kg	10.5 kg	22.3 kg
BMR55.50.60	50	1.97	5.0	0.20	55	2.17	70	2.76	1200	25.0 kg	12.0 kg	21.0 kg
BMR65.60.60	60	2.36	7.0	0.28	65	2.56	80	3.15	1100	31.0 kg	15.5 kg	34.1 kg

42Cr: 900-1150 N/mm²



30° Dies, H=55 (2.17) / H=60 (2.36) / H=70 (2.76)



Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	H (mm)	H (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.06.30	6	0.24	0.6	0.02	15	0.59	55	2.17	25	0.98	350	8.0 kg	4.0 kg	9.0 kg
BMR55.08.30	8	0.31	0.8	0.03	15	0.59	55	2.17	25	0.98	200	9.2 kg	4.0 kg	10.1 kg
BMR55.10.30	10	0.39	1.0	0.04	20	0.79	55	2.17	25	0.98	350	10.0 kg	5.0 kg	11.0 kg
BMR55.12.30	12	0.47	1.5	0.06	20	0.79	55	2.17	25	0.98	300	10.0 kg	5.0 kg	11.0 kg
BMR55.16.30	16	0.63	2.0	0.08	30	1.18	55	2.17	30	1.18	450	13.5 kg	6.7 kg	14.9 kg
BMR55.20.30	20	0.79	2.5	0.10	35	1.38	55	2.17	35	1.38	500	14.0 kg	7.0 kg	13.5 kg
BMR55.24.30	24	0.94	3.0	0.12	40	1.57	55	2.17	40	1.57	550	15.5 kg	7.8 kg	17.0 kg
BMR60.32.30	32	1.26	4.0	0.16	60	2.36	60	2.36	60	2.36	650	23.0 kg	11.5 kg	22.5 kg
BMR70.08.30	08	0.31	0.75	0.03	20	0.79	70	2.76	25	0.98	200	13.1 kg	6.5 kg	14.0 kg
BMR70.10.30	10	0.39	1.0	0.04	20	0.79	70	2.76	25	0.98	350	12.8 kg	6.4 kg	12.4 kg
BMR70.12.30	12	0.47	1.5	0.06	25	0.98	70	2.76	25	0.98	300	14.7 kg	7.3 kg	14.3 kg
BMR70.16.30	16	0.63	2.0	0.08	30	1.18	70	2.76	30	1.18	450	16.7 kg	8.3 kg	16.2 kg

42Cr: 900-1150 N/mm²



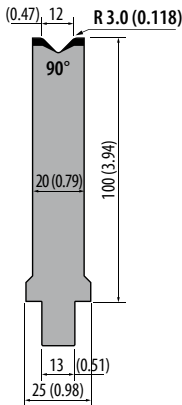
R2 ROLLER TYPE R2

Dies 90°, H=100 (3.94)

WMR100.12.90

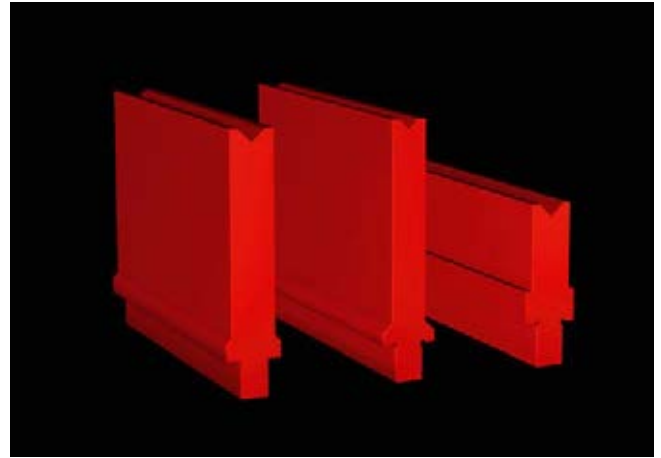
1200 kN/m max.

NEW



	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²

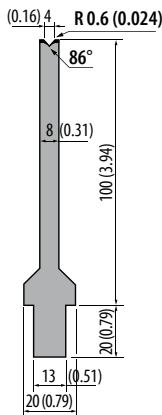


Dies 86°, H=100 (3.94)

TMR100.04.86

250 kN/m max.

NEW



	500 mm	19.68 in	4.5 kg
FC	250 mm segmented	9.84 in segmented	2.3 kg
FW	550 mm segmented	21.65 in segmented	4.9 kg

Sectioning FA	1250 mm	49.21 in	11.3 kg
	2050 mm	80.71 in	18.5 kg
	2550 mm	100.39 in	23.0 kg
	3050 mm	120.08 in	27.5 kg
	4050 mm	159.45 in	36.5 kg

Sectioning FB	1250 mm	49.21 in	11.3 kg
	2050 mm	80.71 in	18.5 kg
	2550 mm	100.39 in	23.0 kg
	3050 mm	120.08 in	27.5 kg
	4050 mm	159.45 in	36.5 kg

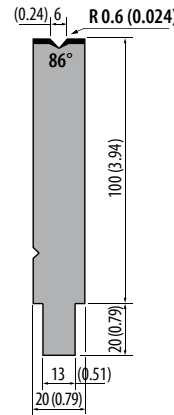
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²



TMR100.06.86

1200 kN/m max.



	500 mm	19.68 in	8.9 kg
FC	250 mm segmented	9.84 in segmented	4.5 kg
FW	550 mm segmented	21.65 in segmented	9.8 kg

Sectioning FA	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg

Sectioning FB	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg

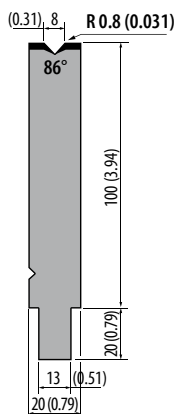
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²



TMR100.08.86

1150 kN/m max.



	500 mm	19.68 in	7.9 kg
FC	250 mm segmented	9.84 in segmented	3.0 kg
FW	550 mm segmented	21.65 in segmented	8.7 kg

Sectioning FA	1250 mm	49.21 in	15.0 kg
	2050 mm	80.71 in	24.6 kg
	2550 mm	100.39 in	30.6 kg
	3050 mm	120.08 in	36.6 kg
	4050 mm	159.45 in	48.6 kg

Sectioning FB	1250 mm	49.21 in	15.0 kg
	2050 mm	80.71 in	24.6 kg
	2550 mm	100.39 in	30.6 kg
	3050 mm	120.08 in	36.6 kg
	4050 mm	159.45 in	48.6 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

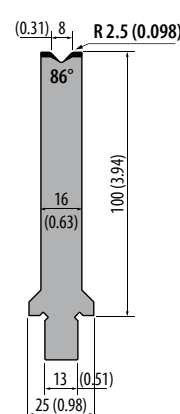
42Cr: 900-1150 N/mm²



WMR100.08.86

400 kN/m max.

NEW



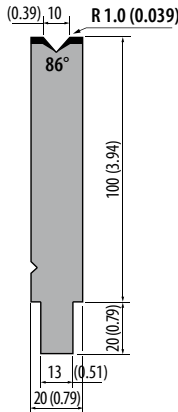
	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



TMR100.10.86

1100 kN/m max.



	500 mm	19.68 in	8.7 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
	550 mm segmented	21.65 in segmented	9.6 kg
Sectioning FA	1250 mm	49.21 in	21.8 kg
	2050 mm	80.71 in	35.7 kg
	2550 mm	100.39 in	44.4 kg
	3050 mm	120.08 in	53.1 kg
	4050 mm	159.45 in	70.5 kg
Sectioning FB	1250 mm	49.21 in	21.8 kg
	2050 mm	80.71 in	35.7 kg
	2550 mm	100.39 in	44.4 kg
	3050 mm	120.08 in	53.1 kg
	4050 mm	159.45 in	70.5 kg

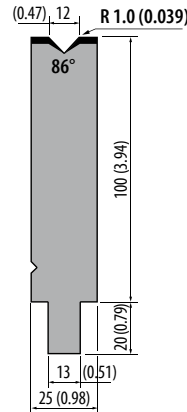


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.12.86

1200 kN/m max.



	500 mm	19.68 in	10.0 kg
FC	250 mm segmented	9.84 in segmented	5.0 kg
	550 mm segmented	21.65 in segmented	11.0 kg
Sectioning FA	1250 mm	49.21 in	26.6 kg
	2050 mm	80.71 in	43.7 kg
	2550 mm	100.39 in	54.3 kg
	3050 mm	120.08 in	65.0 kg
	4050 mm	159.45 in	86.3 kg
Sectioning FB	1250 mm	49.21 in	26.6 kg
	2050 mm	80.71 in	43.7 kg
	2550 mm	100.39 in	54.3 kg
	3050 mm	120.08 in	65.0 kg
	4050 mm	159.45 in	86.3 kg



42Cr: 900-1150 N/mm²

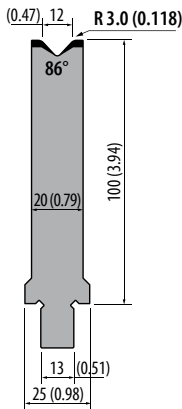
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

4
R2

WMR100.12.86

1200 kN/m max.

NEW



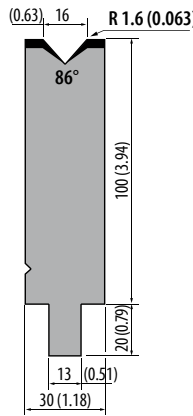
	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



TMR100.16.86

1200 kN/m max.



	500 mm	19.68 in	12.5 kg
FC	250 mm segmented	9.84 in segmented	5.5 kg
	550 mm segmented	21.65 in segmented	13.8 kg
Sectioning FA	1250 mm	49.21 in	27.5 kg
	2050 mm	80.71 in	45.0 kg
	2550 mm	100.39 in	56.0 kg
	3050 mm	120.08 in	67.0 kg
	4050 mm	159.45 in	89.0 kg
Sectioning FB	1250 mm	49.21 in	27.5 kg
	2050 mm	80.71 in	45.0 kg
	2550 mm	100.39 in	56.0 kg
	3050 mm	120.08 in	67.0 kg
	4050 mm	159.45 in	89.0 kg

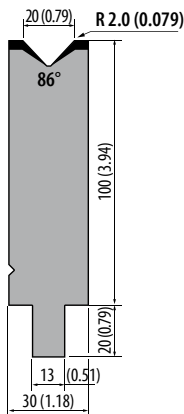


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.20.86

1150 kN/m max.



	500 mm	19.68 in	12.2 kg
FC	250 mm segmented	9.84 in segmented	6.0 kg
	550 mm segmented	21.65 in segmented	13.4 kg
Sectioning FA	1250 mm	49.21 in	30.5 kg
	2050 mm	80.71 in	50.0 kg
	2550 mm	100.39 in	62.2 kg
	3050 mm	120.08 in	74.4 kg
	4050 mm	159.45 in	98.8 kg
Sectioning FB	1250 mm	49.21 in	30.5 kg
	2050 mm	80.71 in	50.0 kg
	2550 mm	100.39 in	62.2 kg
	3050 mm	120.08 in	74.4 kg
	4050 mm	159.45 in	98.8 kg

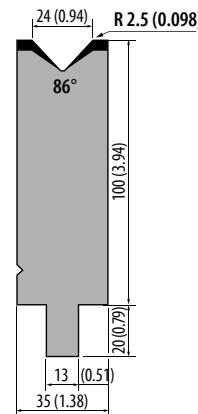


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.24.86

1200 kN/m max.



	500 mm	19.68 in	14.0 kg
FC	250 mm segmented	9.84 in segmented	7.0 kg
	550 mm segmented	21.65 in segmented	15.4 kg
Sectioning FA	1250 mm	49.21 in	35.0 kg
	2050 mm	80.71 in	57.4 kg
	2550 mm	100.39 in	71.4 kg
	3050 mm	120.08 in	85.4 kg
	4050 mm	159.45 in	113.0 kg
Sectioning FB	1250 mm	49.21 in	35.0 kg
	2050 mm	80.71 in	57.4 kg
	2550 mm	100.39 in	71.4 kg
	3050 mm	120.08 in	85.4 kg
	4050 mm	159.45 in	113.0 kg



42Cr: 900-1150 N/mm²

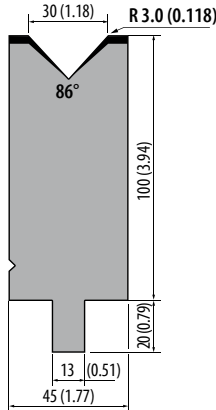
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

R2 ROLLER TYPE R2

Dies 86°, H=100 (3.94)

TMR100.30.86

1200 kN/m max.



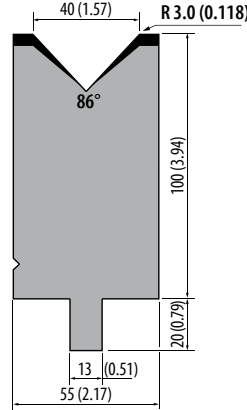
FC	500 mm	19.68 in	17.6 kg
	250 mm segmented	9.84 in segmented	9.0 kg
FW	550 mm segmented	21.65 in segmented	19.4 kg
	1250 mm	49.21 in	45.0 kg
Sectioning FA	2050 mm	80.71 in	74.0 kg
	2550 mm	100.39 in	92.0 kg
	3050 mm	120.08 in	110.0 kg
	4050 mm	159.45 in	146.0 kg
Sectioning FB	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	74.0 kg
	2550 mm	100.39 in	92.0 kg
	3050 mm	120.08 in	110.0 kg
	4050 mm	159.45 in	146.0 kg

42Cr: 900-1150 N/mm²

Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

TMR100.40.86

1200 kN/m max.



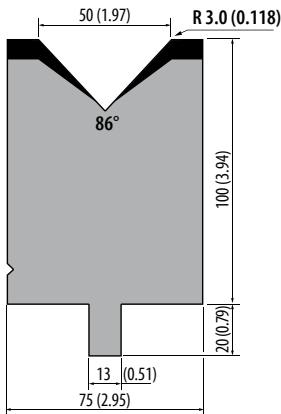
FC	500 mm	19.68 in	20.0 kg
	250 mm segmented	9.84 in segmented	10.0 kg
FW	550 mm segmented	21.65 in segmented	22.0 kg
	1250 mm	49.21 in	50.0 kg
Sectioning FA	2050 mm	80.71 in	82.0 kg
	2550 mm	100.39 in	102.0 kg
	3050 mm	120.08 in	122.0 kg
	4050 mm	159.45 in	162.0 kg
Sectioning FB	1250 mm	49.21 in	50.0 kg
	2050 mm	80.71 in	82.0 kg
	2550 mm	100.39 in	102.0 kg
	3050 mm	120.08 in	122.0 kg
	4050 mm	159.45 in	162.0 kg

42Cr: 900-1150 N/mm²

Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

TMR100.50.86

1500 kN/m max.



FC	500 mm	19.68 in	27.5 kg
	250 mm segmented	9.84 in segmented	13.8 kg
FW	550 mm segmented	21.65 in segmented	30.3 kg
	1250 mm	49.21 in	50.0 kg
Sectioning FA	2050 mm	80.71 in	82.0 kg
	2550 mm	100.39 in	102.0 kg
	3050 mm	120.08 in	122.0 kg
	4050 mm	159.45 in	162.0 kg
Sectioning FB	1250 mm	49.21 in	50.0 kg
	2050 mm	80.71 in	82.0 kg
	2550 mm	100.39 in	102.0 kg
	3050 mm	120.08 in	122.0 kg
	4050 mm	159.45 in	162.0 kg

42Cr: 900-1150 N/mm²

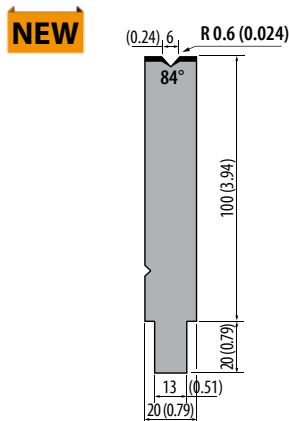
Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

Die Adapters see pages 226-229

Dies 84°, H=100 (3.94)

TMR100.06.84

1200 kN/m max.



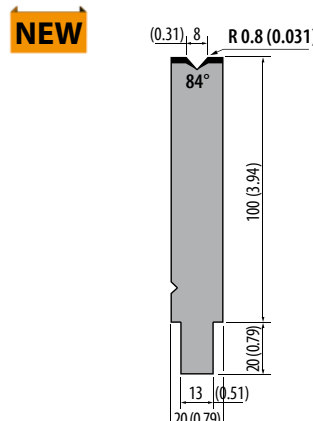
FC	500 mm	19.68 in	8.8 kg
	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.7 kg
	1250 mm	49.21 in	22.0 kg
Sectioning FA	2050 mm	80.71 in	36.1 kg
	2550 mm	100.39 in	44.9 kg
	3050 mm	120.08 in	53.7 kg
	4050 mm	159.45 in	71.3 kg
Sectioning FB	1250 mm	49.21 in	22.0 kg
	2050 mm	80.71 in	36.1 kg
	2550 mm	100.39 in	44.9 kg
	3050 mm	120.08 in	53.7 kg
	4050 mm	159.45 in	71.3 kg

42Cr: 900-1150 N/mm²

Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

TMR100.08.84

1150 kN/m max.



FC	500 mm	19.68 in	8.8 kg
	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.7 kg
	1250 mm	49.21 in	22.0 kg
Sectioning FA	2050 mm	80.71 in	36.1 kg
	2550 mm	100.39 in	44.9 kg
	3050 mm	120.08 in	53.7 kg
	4050 mm	159.45 in	71.3 kg
Sectioning FB	1250 mm	49.21 in	22.0 kg
	2050 mm	80.71 in	36.1 kg
	2550 mm	100.39 in	44.9 kg
	3050 mm	120.08 in	53.7 kg
	4050 mm	159.45 in	71.3 kg

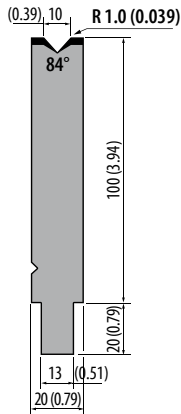
42Cr: 900-1150 N/mm²

Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

TMR100.10.84

1100 kN/m max.

NEW



	500 mm	19.68 in	8.7 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
	550 mm segmented	21.65 in segmented	9.7 kg
Sectioning FA	1250 mm	49.21 in	21.8 kg
	2050 mm	80.71 in	35.7 kg
	2550 mm	100.39 in	44.4 kg
	3050 mm	120.08 in	53.1 kg
	4050 mm	159.45 in	70.5 kg
Sectioning FB	1250 mm	49.21 in	21.8 kg
	2050 mm	80.71 in	35.7 kg
	2550 mm	100.39 in	44.4 kg
	3050 mm	120.08 in	53.1 kg
	4050 mm	159.45 in	70.5 kg



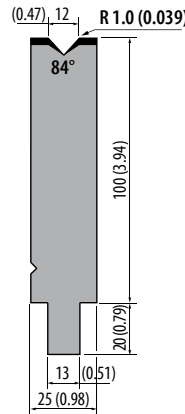
42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.12.84

1200 kN/m max.

NEW



	500 mm	19.68 in	10.0 kg
FC	250 mm segmented	9.84 in segmented	5.0 kg
	550 mm segmented	21.65 in segmented	11.0 kg
Sectioning FA	1250 mm	49.21 in	25.0 kg
	2050 mm	80.71 in	41.0 kg
	2550 mm	100.39 in	51.0 kg
	3050 mm	120.08 in	61.0 kg
	4050 mm	159.45 in	81.0 kg
Sectioning FB	1250 mm	49.21 in	25.0 kg
	2050 mm	80.71 in	41.0 kg
	2550 mm	100.39 in	51.0 kg
	3050 mm	120.08 in	61.0 kg
	4050 mm	159.45 in	81.0 kg



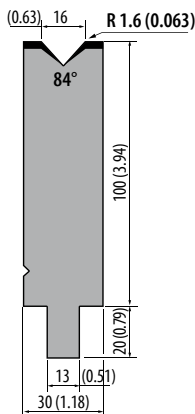
42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.16.84

1200 kN/m max.

NEW



	500 mm	19.68 in	12.5 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
	550 mm segmented	21.65 in segmented	13.8 kg
Sectioning FA	1250 mm	49.21 in	31.3 kg
	2050 mm	80.71 in	51.3 kg
	2550 mm	100.39 in	63.8 kg
	3050 mm	120.08 in	76.3 kg
	4050 mm	159.45 in	101.3 kg
Sectioning FB	1250 mm	49.21 in	31.3 kg
	2050 mm	80.71 in	51.3 kg
	2550 mm	100.39 in	63.8 kg
	3050 mm	120.08 in	76.3 kg
	4050 mm	159.45 in	101.3 kg



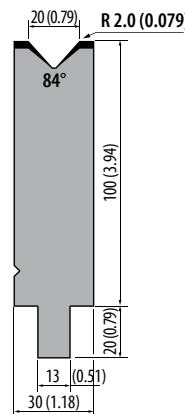
42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.20.84

1150 kN/m max.

NEW



	500 mm	19.68 in	12.2 kg
FC	250 mm segmented	9.84 in segmented	6.1 kg
	550 mm segmented	21.65 in segmented	13.4 kg
Sectioning FA	1250 mm	49.21 in	30.5 kg
	2050 mm	80.71 in	50.0 kg
	2550 mm	100.39 in	62.2 kg
	3050 mm	120.08 in	74.4 kg
	4050 mm	159.45 in	98.8 kg
Sectioning FB	1250 mm	49.21 in	30.5 kg
	2050 mm	80.71 in	50.0 kg
	2550 mm	100.39 in	62.2 kg
	3050 mm	120.08 in	74.4 kg
	4050 mm	159.45 in	98.8 kg



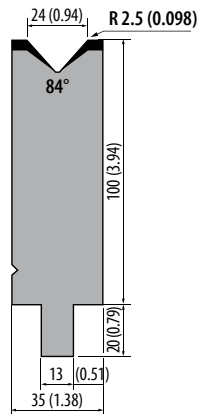
42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.24.84

1200 kN/m max.

NEW



	500 mm	19.68 in	14.0 kg
FC	250 mm segmented	9.84 in segmented	7.0 kg
	550 mm segmented	21.65 in segmented	15.4 kg
Sectioning FA	1250 mm	49.21 in	35.0 kg
	2050 mm	80.71 in	57.4 kg
	2550 mm	100.39 in	71.4 kg
	3050 mm	120.08 in	85.4 kg
	4050 mm	159.45 in	113.4 kg
Sectioning FB	1250 mm	49.21 in	35.0 kg
	2050 mm	80.71 in	57.4 kg
	2550 mm	100.39 in	71.4 kg
	3050 mm	120.08 in	85.4 kg
	4050 mm	159.45 in	113.4 kg



42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

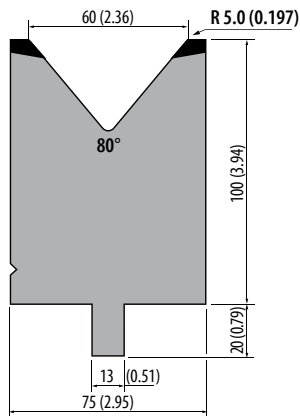
Articles on stock – Please note that delivery time varies according to your location.

R2 ROLLER TYPE R2

Dies 80°, H=100 (3.94)

TMR100.60.80

1500 kN/m max.



FW FC	500 mm	19.68 in	26.0 kg
	250 mm segmented	9.84 in segmented	13.0 kg
	550 mm segmented	21.65 in segmented	28.6 kg
Sectioning FA	1250 mm	49.21 in	65.0 kg
	2050 mm	80.71 in	107.0 kg
	2550 mm	100.39 in	133.0 kg
	3050 mm	120.08 in	159.0 kg
	4050 mm	159.45 in	210.0 kg
Sectioning FB	1250 mm	49.21 in	65.0 kg
	2050 mm	80.71 in	107.0 kg
	2550 mm	100.39 in	133.0 kg
	3050 mm	120.08 in	159.0 kg
	4050 mm	159.45 in	210.0 kg

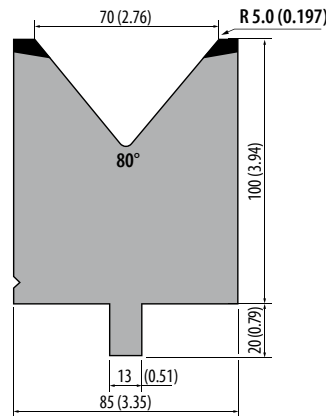


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.70.80

1500 kN/m max.



FW FC	500 mm	19.68 in	28.5 kg
	250 mm segmented	9.84 in segmented	14.3 kg
	550 mm segmented	21.65 in segmented	31.4 kg
Sectioning FA	1250 mm	49.21 in	71.3 kg
	2050 mm	80.71 in	117.0 kg
	2550 mm	100.39 in	145.0 kg
	3050 mm	120.08 in	174.0 kg
	4050 mm	159.45 in	231.0 kg
Sectioning FB	1250 mm	49.21 in	71.3 kg
	2050 mm	80.71 in	117.0 kg
	2550 mm	100.39 in	145.0 kg
	3050 mm	120.08 in	174.0 kg
	4050 mm	159.45 in	231.0 kg

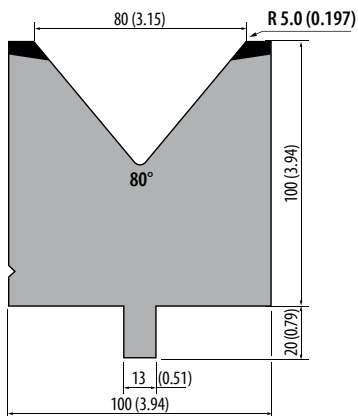


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.80.80

1500 kN/m max.



FW FC	500 mm	19.68 in	33.0 kg
	250 mm segmented	9.84 in segmented	16.5 kg
	550 mm segmented	21.65 in segmented	36.3 kg
Sectioning FA	1250 mm	49.21 in	82.5 kg
	2050 mm	80.71 in	135.0 kg
	2550 mm	100.39 in	168.0 kg
	3050 mm	120.08 in	201.0 kg
	4050 mm	159.45 in	267.0 kg
Sectioning FB	1250 mm	49.21 in	82.5 kg
	2050 mm	80.71 in	135.0 kg
	2550 mm	100.39 in	168.0 kg
	3050 mm	120.08 in	201.0 kg
	4050 mm	159.45 in	267.0 kg



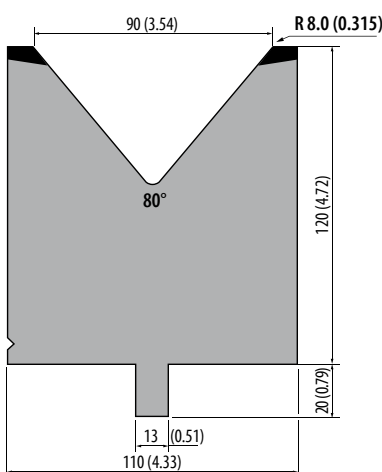
42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!



TMR120.90.80

1500 kN/m max.



FW FC	500 mm	19.68 in	43.0 kg
	250 mm segmented	9.84 in segmented	21.5 kg
	550 mm segmented	21.65 in segmented	47.3 kg
Sectioning FA	1250 mm	49.21 in	168.0 kg
	2050 mm	80.71 in	176.0 kg
	2550 mm	100.39 in	219.0 kg
	3050 mm	120.08 in	262.0 kg
	4050 mm	159.45 in	348.0 kg
Sectioning FB	1250 mm	49.21 in	168.0 kg
	2050 mm	80.71 in	176.0 kg
	2550 mm	100.39 in	219.0 kg
	3050 mm	120.08 in	262.0 kg
	4050 mm	159.45 in	348.0 kg

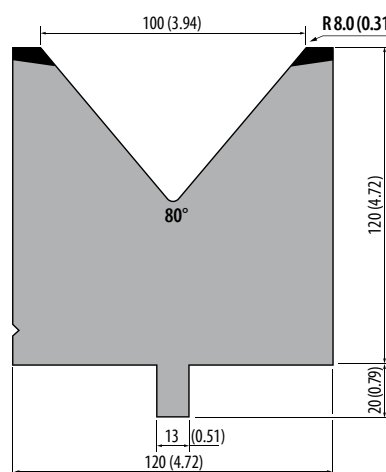


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR120.100.80

1500 kN/m max.



FW FC	500 mm	19.68 in	45.0 kg
	250 mm segmented	9.84 in segmented	22.5 kg
	550 mm segmented	21.65 in segmented	49.5 kg
Sectioning FA	1250 mm	49.21 in	113.0 kg
	2050 mm	80.71 in	185.0 kg
	2550 mm	100.39 in	230.0 kg
	3050 mm	120.08 in	275.0 kg
	4050 mm	159.45 in	365.0 kg
Sectioning FB	1250 mm	49.21 in	113.0 kg
	2050 mm	80.71 in	185.0 kg
	2550 mm	100.39 in	230.0 kg
	3050 mm	120.08 in	275.0 kg
	4050 mm	159.45 in	365.0 kg



42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

R2 ROLLERI TYPE R2

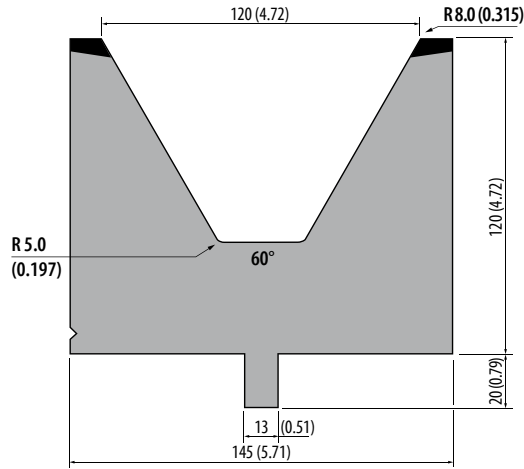
Dies 60°, H=120 (4.72)



TMR120.120.60

1600 kN/m max.

NEW



	500 mm	19.68 in	45.5 kg
FW FC	250 mm segmented	9.84 in segmented	22.8 kg
	550 mm segmented	21.65 in segmented	50.1 kg
Sectioning FA	1250 mm	49.21 in	113.8 kg
	2050 mm	80.71 in	186.6 kg
	2550 mm	100.39 in	232.1 kg
	3050 mm	120.08 in	277.6 kg
	4050 mm	159.45 in	368.6 kg
Sectioning FB	1250 mm	49.21 in	113.8 kg
	2050 mm	80.71 in	186.6 kg
	2550 mm	100.39 in	232.1 kg
	3050 mm	120.08 in	277.6 kg
	4050 mm	159.45 in	368.6 kg



42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

4 R2



Rolleri Videos

find updated and helpful videos at:
www.rolleritools.com/videos/overview

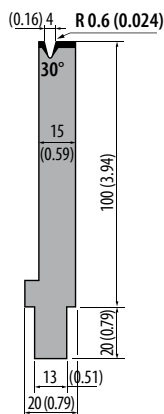


Dies 30°, H=100 (3.94)

TMR100.04.30

150 kN/m max.

NEW



	500 mm	19.68 in	7.0 kg
FW FC	250 mm segmented	9.84 in segmented	3.5 kg
	550 mm segmented	21.65 in segmented	7.7 kg
Sectioning FA	1250 mm	49.21 in	17.5 kg
	2050 mm	80.71 in	28.7 kg
	2550 mm	100.39 in	35.7 kg
	3050 mm	120.08 in	42.7 kg
	4050 mm	159.45 in	56.7 kg
Sectioning FB	1250 mm	49.21 in	17.5 kg
	2050 mm	80.71 in	28.7 kg
	2550 mm	100.39 in	35.7 kg
	3050 mm	120.08 in	42.7 kg
	4050 mm	159.45 in	56.7 kg

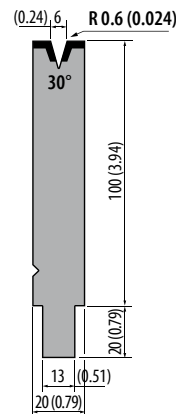


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.06.30

400 kN/m max.



	500 mm	19.68 in	8.7 kg
FW FC	250 mm segmented	9.84 in segmented	4.3 kg
	550 mm segmented	21.65 in segmented	9.6 kg
Sectioning FA	1250 mm	49.21 in	21.8 kg
	2050 mm	80.71 in	34.9 kg
	2550 mm	100.39 in	43.4 kg
	3050 mm	120.08 in	51.9 kg
	4050 mm	159.45 in	68.9 kg
Sectioning FB	1250 mm	49.21 in	21.8 kg
	2050 mm	80.71 in	34.9 kg
	2550 mm	100.39 in	43.4 kg
	3050 mm	120.08 in	51.9 kg
	4050 mm	159.45 in	68.9 kg



42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

Article on stock

Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

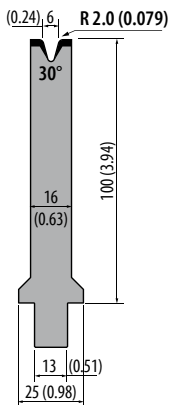
R2 ROLLER TYPE R2

Dies 30°, H=100 (3.94)

WMR100.06.30

400 kN/m max.

NEW



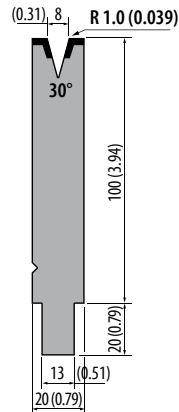
	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



TMR100.08.30

400 kN/m max.



	500 mm	19.68 in	8.5 kg
FW FC	250 mm segmented	9.84 in segmented	4.3 kg
	550 mm segmented	21.65 in segmented	9.4 kg

Sectioning FA	1250 mm	49.21 in	21.3 kg
	2050 mm	80.71 in	34.9 kg
	2550 mm	100.39 in	43.4 kg
	3050 mm	120.08 in	51.9 kg

Sectioning FB	1250 mm	49.21 in	21.3 kg
	2050 mm	80.71 in	34.9 kg
	2550 mm	100.39 in	43.4 kg
	3050 mm	120.08 in	51.9 kg
	4050 mm	159.45 in	68.9 kg



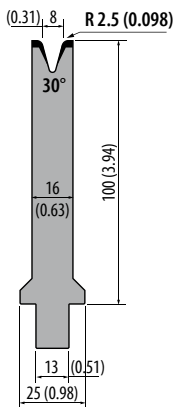
42Cr: 900-1150 N/mm²

Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

WMR100.08.30

400 kN/m max.

NEW



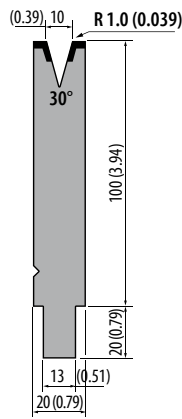
	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



TMR100.10.30

400 kN/m max.



	500 mm	19.68 in	8.5 kg
FW FC	250 mm segmented	9.84 in segmented	3.5 kg
	550 mm segmented	21.65 in segmented	9.4 kg

Sectioning FA	1250 mm	49.21 in	17.5 kg
	2050 mm	80.71 in	28.7 kg
	2550 mm	100.39 in	35.7 kg
	3050 mm	120.08 in	42.7 kg
	4050 mm	159.45 in	56.7 kg

Sectioning FB	1250 mm	49.21 in	17.5 kg
	2050 mm	80.71 in	28.7 kg
	2550 mm	100.39 in	35.7 kg
	3050 mm	120.08 in	42.7 kg
	4050 mm	159.45 in	56.7 kg



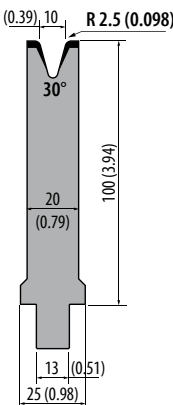
42Cr: 900-1150 N/mm²

Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

WMR100.10.30

400 kN/m max.

NEW



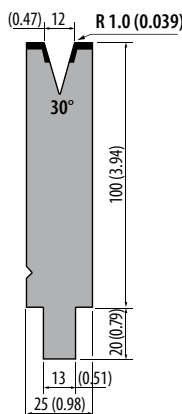
	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



TMR100.12.30

400 kN/m max.



	500 mm	19.68 in	10.3 kg
FW FC	250 mm segmented	9.84 in segmented	5.3 kg
	550 mm segmented	21.65 in segmented	11.3 kg

Sectioning FA	1250 mm	49.21 in	26.3 kg
	2050 mm	80.71 in	43.1 kg
	2550 mm	100.39 in	53.6 kg
	3050 mm	120.08 in	64.1 kg
	4050 mm	159.45 in	85.1 kg

Sectioning FB	1250 mm	49.21 in	26.3 kg
	2050 mm	80.71 in	43.1 kg
	2550 mm	100.39 in	53.6 kg
	3050 mm	120.08 in	64.1 kg
	4050 mm	159.45 in	85.1 kg



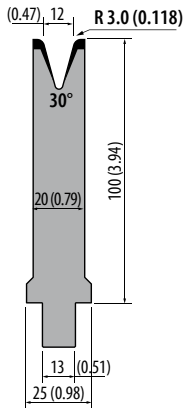
42Cr: 900-1150 N/mm²

Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

WMR100.12.30

400 kN/m max.

NEW



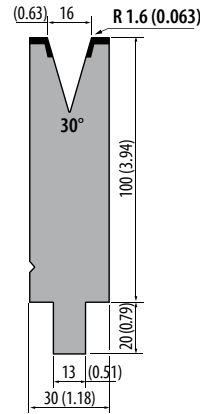
	515 mm	20.28 in	8.9 kg
FW	550 mm segmented	21.65 in segmented	9.5 kg

42Cr: 900-1150 N/mm²



TMR100.16.30

500 kN/m max.



	500 mm	19.68 in	11.8 kg
FW	250 mm segmented	9.84 in segmented	6.0 kg
FC	550 mm segmented	21.65 in segmented	12.9 kg

Sectioning FA	1250 mm	49.21 in	29.5 kg
	2050 mm	80.71 in	48.4 kg
	2550 mm	100.39 in	60.2 kg
	3050 mm	120.08 in	72.0 kg

Sectioning FB	1250 mm	49.21 in	29.5 kg
	2050 mm	80.71 in	48.4 kg
	2550 mm	100.39 in	60.2 kg
	3050 mm	120.08 in	72.0 kg
	4050 mm	159.45 in	95.6 kg



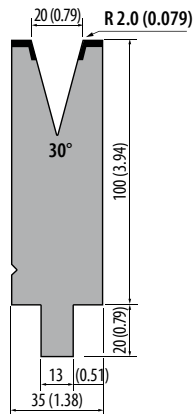
42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

4 R2

TMR100.20.30

600 kN/m max.



	500 mm	19.68 in	13.0 kg
FW	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.0 kg

Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.0 kg

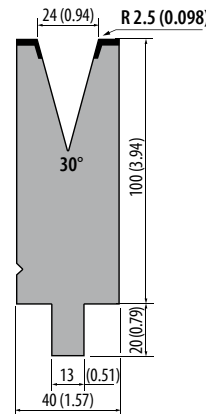


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.24.30

650 kN/m max.



	500 mm	19.68 in	15.0 kg
FW	250 mm segmented	9.84 in segmented	7.5 kg
FC	550 mm segmented	21.65 in segmented	16.5 kg

Sectioning FA	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg
	4050 mm	159.45 in	122.0 kg

Sectioning FB	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg
	4050 mm	159.45 in	122.0 kg

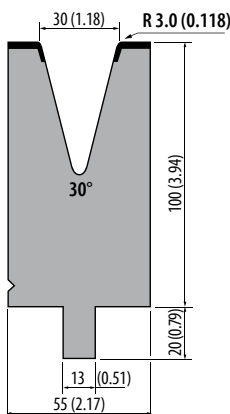


42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.30.30

900 kN/m max.



	500 mm	19.68 in	19.0 kg
FW	250 mm segmented	9.84 in segmented	9.5 kg
FC	550 mm segmented	21.65 in segmented	20.9 kg

Sectioning FA	1250 mm	49.21 in	47.5 kg
	2050 mm	80.71 in	80.0 kg
	2550 mm	100.39 in	96.9 kg
	3050 mm	120.08 in	116.0 kg
	4050 mm	159.45 in	154.0 kg

Sectioning FB	1250 mm	49.21 in	47.5 kg
	2050 mm	80.71 in	80.0 kg
	2550 mm	100.39 in	96.9 kg
	3050 mm	120.08 in	116.0 kg
	4050 mm	159.45 in	154.0 kg



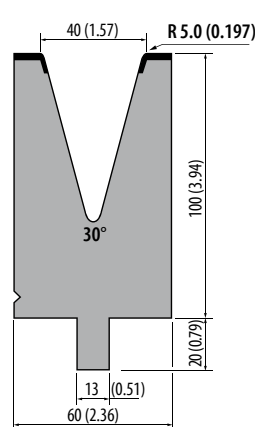
42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR100.40.30

900 kN/m max.

NEW



	500 mm	19.68 in	18.5 kg
FW	250 mm segmented	9.84 in segmented	9.3 kg
FC	550 mm segmented	21.65 in segmented	20.4 kg

Sectioning FA	1250 mm	49.21 in	46.3 kg
	2050 mm	80.71 in	75.9 kg
	2550 mm	100.39 in	94.4 kg
	3050 mm	120.08 in	112.9 kg
	4050 mm	159.45 in	149.9 kg

Sectioning FB	1250 mm	49.21 in	46.3 kg
	2050 mm	80.71 in	75.9 kg
	2550 mm	100.39 in	94.4 kg
	3050 mm	120.08 in	112.9 kg
	4050 mm	159.45 in	149.9 kg



42Cr: 900-1150 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

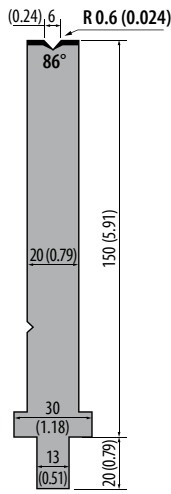
R2 ROLLER TYPE R2

Dies 86°, H=150 (5.91)

TMR150.06.86

400 kN/m max.

NEW



FW FC	500 mm	19.68 in	13.0 kg
	250 mm segmented	9.84 in segmented	6.5 kg
	550 mm segmented	21.65 in segmented	14.3 kg
Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg

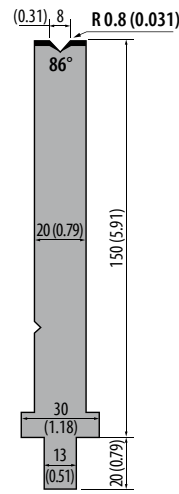
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.08.86

400 kN/m max.

NEW



FW FC	500 mm	19.68 in	13.1 kg
	250 mm segmented	9.84 in segmented	6.6 kg
	550 mm segmented	21.65 in segmented	14.4 kg
Sectioning FA	1250 mm	49.21 in	32.8 kg
	2050 mm	80.71 in	53.7 kg
	2550 mm	100.39 in	66.8 kg
	3050 mm	120.08 in	79.9 kg
	4050 mm	159.45 in	106.1 kg
Sectioning FB	1250 mm	49.21 in	32.8 kg
	2050 mm	80.71 in	53.7 kg
	2550 mm	100.39 in	66.8 kg
	3050 mm	120.08 in	79.9 kg
	4050 mm	159.45 in	106.1 kg

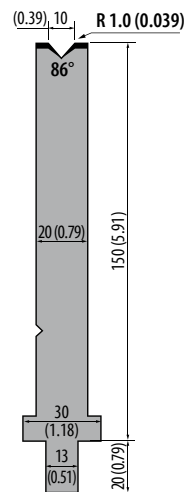
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.10.86

500 kN/m max.

NEW



FW FC	500 mm	19.68 in	13.0 kg
	250 mm segmented	9.84 in segmented	6.5 kg
	550 mm segmented	21.65 in segmented	14.3 kg
Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg

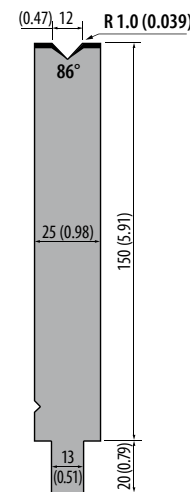
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.12.86

500 kN/m max.

NEW



FW FC	500 mm	19.68 in	15.5 kg
	250 mm segmented	9.84 in segmented	7.8 kg
	550 mm segmented	21.65 in segmented	17.0 kg
Sectioning FA	1250 mm	49.21 in	38.8 kg
	2050 mm	80.71 in	63.6 kg
	2550 mm	100.39 in	79.1 kg
	3050 mm	120.08 in	94.6 kg
	4050 mm	159.45 in	125.6 kg
Sectioning FB	1250 mm	49.21 in	38.8 kg
	2050 mm	80.71 in	63.6 kg
	2550 mm	100.39 in	79.1 kg
	3050 mm	120.08 in	94.6 kg
	4050 mm	159.45 in	125.6 kg

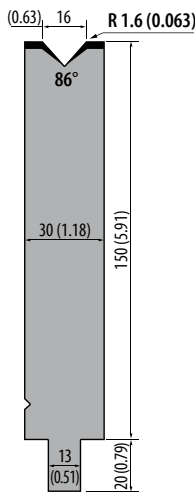
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.16.86

700 kN/m max.

NEW



FW FC	500 mm	19.68 in	18.0 kg
	250 mm segmented	9.84 in segmented	9.0 kg
	550 mm segmented	21.65 in segmented	19.8 kg
Sectioning FA	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	73.8 kg
	2550 mm	100.39 in	91.8 kg
	3050 mm	120.08 in	109.8 kg
	4050 mm	159.45 in	145.8 kg
Sectioning FB	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	73.8 kg
	2550 mm	100.39 in	91.8 kg
	3050 mm	120.08 in	109.8 kg
	4050 mm	159.45 in	145.8 kg

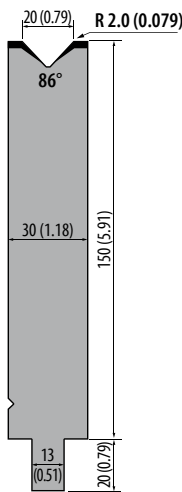
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.20.86

700 kN/m max.

NEW



FW FC	500 mm	19.68 in	18.2 kg
	250 mm segmented	9.84 in segmented	9.1 kg
	550 mm segmented	21.65 in segmented	20.0 kg
Sectioning FA	1250 mm	49.21 in	45.5 kg
	2050 mm	80.71 in	74.6 kg
	2550 mm	100.39 in	92.8 kg
	3050 mm	120.08 in	111.0 kg
	4050 mm	159.45 in	147.4 kg
Sectioning FB	1250 mm	49.21 in	45.5 kg
	2050 mm	80.71 in	74.6 kg
	2550 mm	100.39 in	92.8 kg
	3050 mm	120.08 in	111.0 kg
	4050 mm	159.45 in	147.4 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

R2 ROLLERI TYPE R2

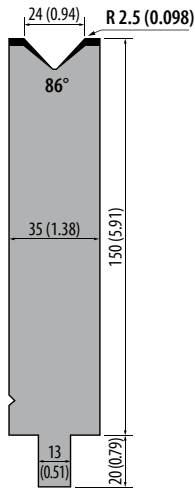
Dies 86°, H=150 (5.91)



TMR150.24.86

700 kN/m max.

NEW



42Cr: 900-1150 N/mm²

FC	500 mm	19.68 in	20.8 kg
	250 mm segmented	9.84 in segmented	10.4 kg
	550 mm segmented	21.65 in segmented	22.9 kg
Sectioning FA	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg
Sectioning FB	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!



4
R2



Rolleri Videos

find updated and helpful videos at:
www.rolleritools.com/videos/overview

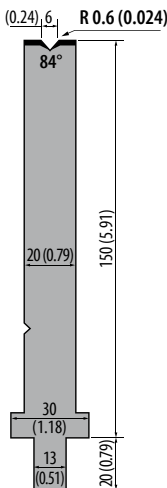


Dies 84°, H=150 (5.91)

TMR150.06.84

400 kN/m max.

NEW



42Cr: 900-1150 N/mm²

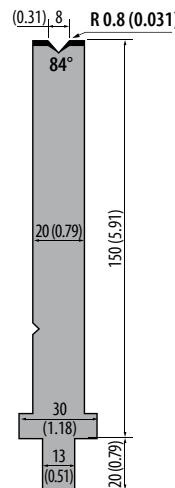
FC	500 mm	19.68 in	13.0 kg
	250 mm segmented	9.84 in segmented	6.5 kg
	550 mm segmented	21.65 in segmented	14.3 kg
Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.08.84

400 kN/m max.

NEW



42Cr: 900-1150 N/mm²

FC	500 mm	19.68 in	13.0 kg
	250 mm segmented	9.84 in segmented	6.5 kg
	550 mm segmented	21.65 in segmented	14.3 kg
Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

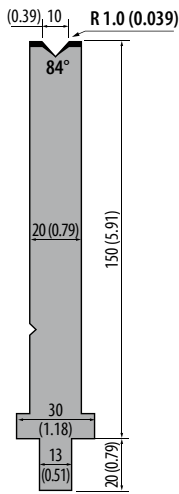
R2 ROLLER TYPE R2

Dies 84°, H=150 (5.91)

TMR150.10.84

500 kN/m max.

NEW



42Cr-900-1150 N/mm²

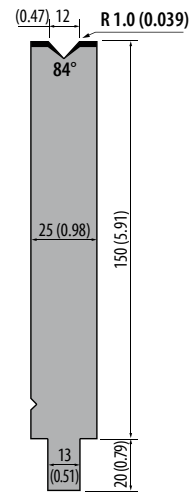
FW FC	500 mm	19.68 in	13.0 kg
	250 mm segmented	9.84 in segmented	6.5 kg
	550 mm segmented	21.65 in segmented	14.3 kg
Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.12.84

500 kN/m max.

NEW



42Cr-900-1150 N/mm²

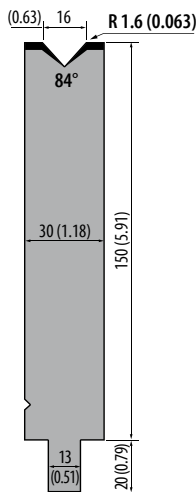
FW FC	500 mm	19.68 in	15.5 kg
	250 mm segmented	9.84 in segmented	7.8 kg
	550 mm segmented	21.65 in segmented	17.0 kg
Sectioning FA	1250 mm	49.21 in	38.8 kg
	2050 mm	80.71 in	63.6 kg
	2550 mm	100.39 in	79.1 kg
	3050 mm	120.08 in	94.6 kg
	4050 mm	159.45 in	125.6 kg
Sectioning FB	1250 mm	49.21 in	38.8 kg
	2050 mm	80.71 in	63.6 kg
	2550 mm	100.39 in	79.1 kg
	3050 mm	120.08 in	94.6 kg
	4050 mm	159.45 in	125.6 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.16.84

700 kN/m max.

NEW



42Cr-900-1150 N/mm²

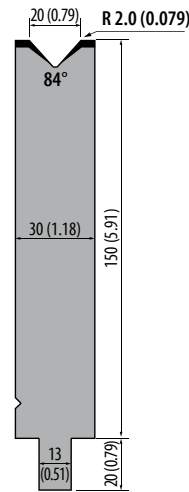
FW FC	500 mm	19.68 in	18.0 kg
	250 mm segmented	9.84 in segmented	9.0 kg
	550 mm segmented	21.65 in segmented	19.8 kg
Sectioning FA	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	73.8 kg
	2550 mm	100.39 in	91.8 kg
	3050 mm	120.08 in	109.8 kg
	4050 mm	159.45 in	145.8 kg
Sectioning FB	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	73.8 kg
	2550 mm	100.39 in	91.8 kg
	3050 mm	120.08 in	109.8 kg
	4050 mm	159.45 in	145.8 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.20.84

700 kN/m max.

NEW



42Cr-900-1150 N/mm²

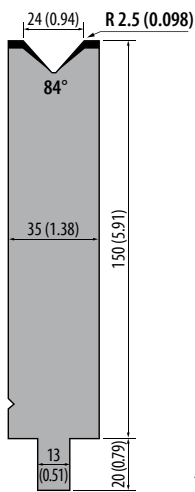
FW FC	500 mm	19.68 in	18.2 kg
	250 mm segmented	9.84 in segmented	9.1 kg
	550 mm segmented	21.65 in segmented	20.0 kg
Sectioning FA	1250 mm	49.21 in	45.5 kg
	2050 mm	80.71 in	74.6 kg
	2550 mm	100.39 in	92.8 kg
	3050 mm	120.08 in	111.0 kg
	4050 mm	159.45 in	147.4 kg
Sectioning FB	1250 mm	49.21 in	45.5 kg
	2050 mm	80.71 in	74.6 kg
	2550 mm	100.39 in	92.8 kg
	3050 mm	120.08 in	111.0 kg
	4050 mm	159.45 in	147.4 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.24.84

700 kN/m max.

NEW



42Cr-900-1150 N/mm²

FW FC	500 mm	19.68 in	20.8 kg
	250 mm segmented	9.84 in segmented	10.4 kg
	550 mm segmented	21.65 in segmented	22.9 kg
Sectioning FA	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg
Sectioning FB	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

R2 ROLLER TYPE R2

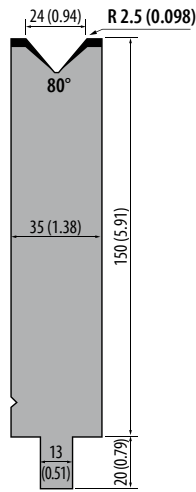
Dies 80°, H=150 (5.91)



TMR150.24.80

700 kN/m max.

NEW



	500 mm	19.68 in	20.8 kg
FW FC	250 mm segmented	9.84 in segmented	10.4 kg
	550 mm segmented	21.65 in segmented	22.9 kg
Sectioning FA	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg
Sectioning FB	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg

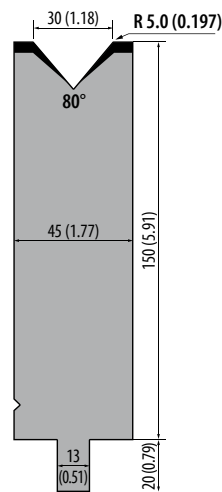
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.30.80

900 kN/m max.

NEW



	500 mm	19.68 in	26.0 kg
FW FC	250 mm segmented	9.84 in segmented	13.0 kg
	550 mm segmented	21.65 in segmented	28.6 kg
Sectioning FA	1250 mm	49.21 in	65.0 kg
	2050 mm	80.71 in	106.6 kg
	2550 mm	100.39 in	132.6 kg
	3050 mm	120.08 in	158.6 kg
	4050 mm	159.45 in	210.6 kg
Sectioning FB	1250 mm	49.21 in	65.0 kg
	2050 mm	80.71 in	106.6 kg
	2550 mm	100.39 in	132.6 kg
	3050 mm	120.08 in	158.6 kg
	4050 mm	159.45 in	210.6 kg

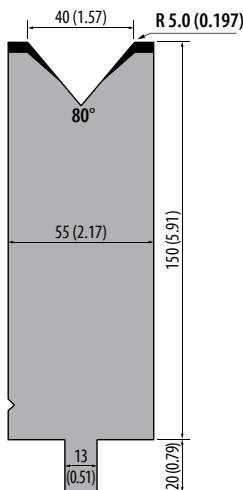
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.40.80

1200 kN/m max.

NEW



	500 mm	19.68 in	31.0 kg
FW FC	250 mm segmented	9.84 in segmented	15.5 kg
	550 mm segmented	21.65 in segmented	34.1 kg
Sectioning FA	1250 mm	49.21 in	77.5 kg
	2050 mm	80.71 in	127.1 kg
	2550 mm	100.39 in	158.1 kg
	3050 mm	120.08 in	189.1 kg
	4050 mm	159.45 in	251.1 kg
Sectioning FB	1250 mm	49.21 in	77.5 kg
	2050 mm	80.71 in	127.1 kg
	2550 mm	100.39 in	158.1 kg
	3050 mm	120.08 in	189.1 kg
	4050 mm	159.45 in	251.1 kg

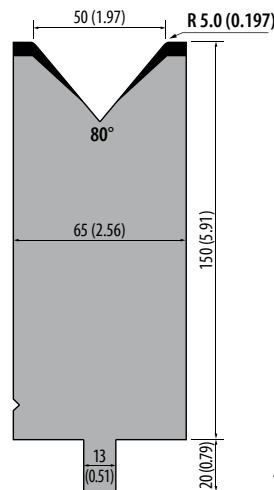
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

TMR150.50.80

1500 kN/m max.

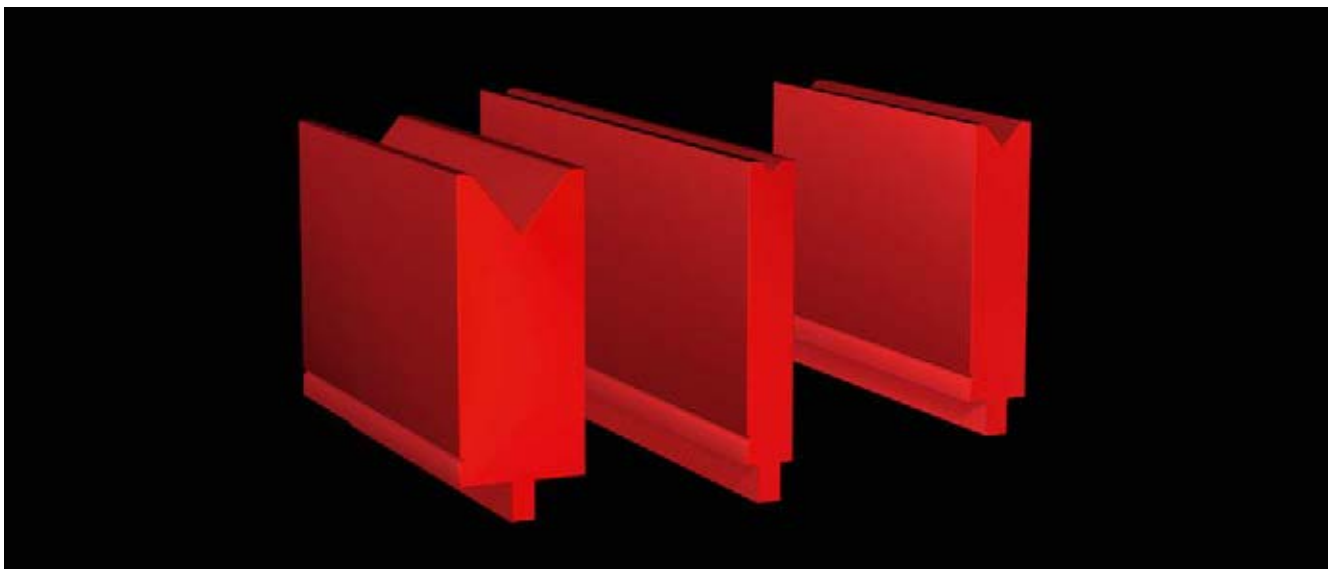
NEW



	500 mm	19.68 in	36.0 kg
FW FC	250 mm segmented	9.84 in segmented	18.0 kg
	550 mm segmented	21.65 in segmented	39.6 kg
Sectioning FA	1250 mm	49.21 in	90.0 kg
	2050 mm	80.71 in	147.6 kg
	2550 mm	100.39 in	183.6 kg
	3050 mm	120.08 in	219.6 kg
	4050 mm	159.45 in	291.6 kg
Sectioning FB	1250 mm	49.21 in	90.0 kg
	2050 mm	80.71 in	147.6 kg
	2550 mm	100.39 in	183.6 kg
	3050 mm	120.08 in	219.6 kg
	4050 mm	159.45 in	291.6 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²



4
R2



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

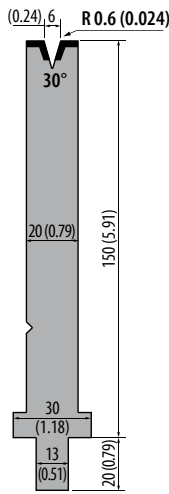
R2 ROLLER TYPE R2

Dies 30°, H=150 (5.91)

TMR150.06.30

400 kN/m max.

NEW



42Cr-900-1150 N/mm²

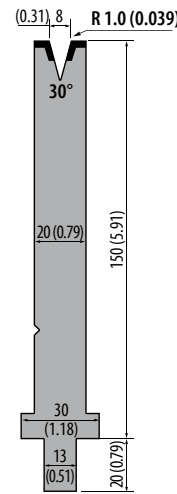
FW FC	500 mm	19.68 in	12.8 kg
	250 mm segmented	9.84 in segmented	6.4 kg
	550 mm segmented	21.65 in segmented	14.0 kg
Sectioning FA	1250 mm	49.21 in	32.0 kg
	2050 mm	80.71 in	52.5 kg
	2550 mm	100.39 in	65.3 kg
	3050 mm	120.08 in	78.1 kg
	4050 mm	159.45 in	103.7 kg
Sectioning FB	1250 mm	49.21 in	32.0 kg
	2050 mm	80.71 in	52.5 kg
	2550 mm	100.39 in	65.3 kg
	3050 mm	120.08 in	78.1 kg
	4050 mm	159.45 in	103.7 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.08.30

400 kN/m max.

NEW



42Cr-900-1150 N/mm²

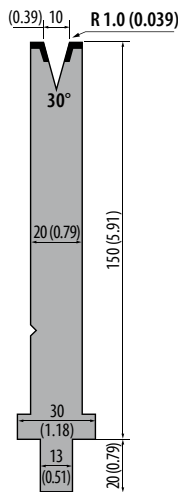
FW FC	500 mm	19.68 in	12.7 kg
	250 mm segmented	9.84 in segmented	6.4 kg
	550 mm segmented	21.65 in segmented	13.9 kg
Sectioning FA	1250 mm	49.21 in	31.8 kg
	2050 mm	80.71 in	52.1 kg
	2550 mm	100.39 in	64.8 kg
	3050 mm	120.08 in	77.5 kg
	4050 mm	159.45 in	102.9 kg
Sectioning FB	1250 mm	49.21 in	31.8 kg
	2050 mm	80.71 in	52.1 kg
	2550 mm	100.39 in	64.8 kg
	3050 mm	120.08 in	77.5 kg
	4050 mm	159.45 in	102.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.10.30

400 kN/m max.

NEW



42Cr-900-1150 N/mm²

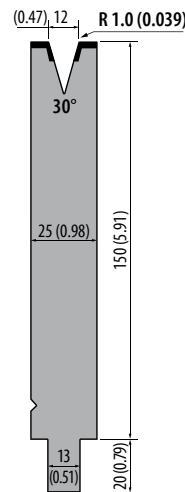
FW FC	500 mm	19.68 in	12.6 kg
	250 mm segmented	9.84 in segmented	6.3 kg
	550 mm segmented	21.65 in segmented	13.9 kg
Sectioning FA	1250 mm	49.21 in	31.5 kg
	2050 mm	80.71 in	51.7 kg
	2550 mm	100.39 in	64.3 kg
	3050 mm	120.08 in	76.9 kg
	4050 mm	159.45 in	102.1 kg
Sectioning FB	1250 mm	49.21 in	31.5 kg
	2050 mm	80.71 in	51.7 kg
	2550 mm	100.39 in	64.3 kg
	3050 mm	120.08 in	76.9 kg
	4050 mm	159.45 in	102.1 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.12.30

400 kN/m max.

NEW



42Cr-900-1150 N/mm²

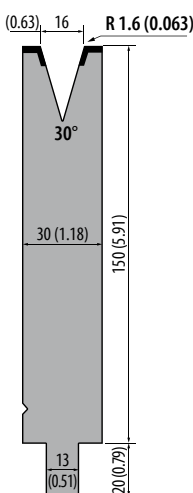
FW FC	500 mm	19.68 in	15.2 kg
	250 mm segmented	9.84 in segmented	7.6 kg
	550 mm segmented	21.65 in segmented	16.7 kg
Sectioning FA	1250 mm	49.21 in	38.0 kg
	2050 mm	80.71 in	62.3 kg
	2550 mm	100.39 in	77.5 kg
	3050 mm	120.08 in	92.7 kg
	4050 mm	159.45 in	123.1 kg
Sectioning FB	1250 mm	49.21 in	38.0 kg
	2050 mm	80.71 in	62.3 kg
	2550 mm	100.39 in	77.5 kg
	3050 mm	120.08 in	92.7 kg
	4050 mm	159.45 in	123.1 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.16.30

500 kN/m max.

NEW



42Cr-900-1150 N/mm²

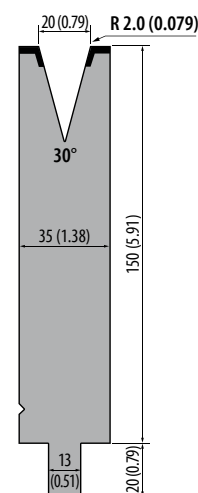
FW FC	500 mm	19.68 in	17.7 kg
	250 mm segmented	9.84 in segmented	8.9 kg
	550 mm segmented	21.65 in segmented	19.5 kg
Sectioning FA	1250 mm	49.21 in	44.3 kg
	2050 mm	80.71 in	72.6 kg
	2550 mm	100.39 in	90.3 kg
	3050 mm	120.08 in	108.0 kg
	4050 mm	159.45 in	143.4 kg
Sectioning FB	1250 mm	49.21 in	44.3 kg
	2050 mm	80.71 in	72.6 kg
	2550 mm	100.39 in	90.3 kg
	3050 mm	120.08 in	108.0 kg
	4050 mm	159.45 in	143.4 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.20.30

600 kN/m max.

NEW



42Cr-900-1150 N/mm²

FW FC	500 mm	19.68 in	20.0 kg
	250 mm segmented	9.84 in segmented	10.0 kg
	550 mm segmented	21.65 in segmented	22.0 kg
Sectioning FA	1250 mm	49.21 in	50.0 kg
	2050 mm	80.71 in	82.0 kg
	2550 mm	100.39 in	102.0 kg
	3050 mm	120.08 in	122.0 kg
	4050 mm	159.45 in	162.0 kg
Sectioning FB	1250 mm	49.21 in	50.0 kg
	2050 mm	80.71 in	82.0 kg
	2550 mm	100.39 in	102.0 kg
	3050 mm	120.08 in	122.0 kg
	4050 mm	159.45 in	162.0 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

R2 ROLLER TYPE R2

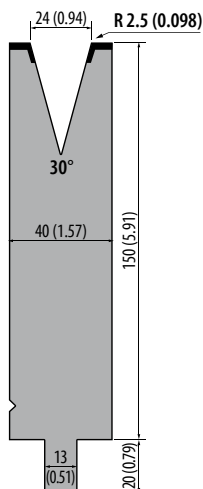
Dies 30°, H=150 (5.91)



TMR150.24.30

650 kN/m max.

NEW



42Cr: 900-1150 N/mm²

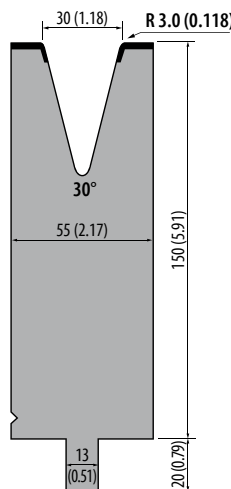
	500 mm	19.68 in	24.6 kg
FW FC	250 mm segmented	9.84 in segmented	12.3 kg
	550 mm segmented	21.65 in segmented	27.0 kg
Sectioning FA	1250 mm	49.21 in	61.5 kg
	2050 mm	80.71 in	100.9 kg
	2550 mm	100.39 in	125.5 kg
	3050 mm	120.08 in	150.1 kg
	4050 mm	159.45 in	199.3 kg
Sectioning FB	1250 mm	49.21 in	61.5 kg
	2050 mm	80.71 in	100.9 kg
	2550 mm	100.39 in	125.5 kg
	3050 mm	120.08 in	150.1 kg
	4050 mm	159.45 in	199.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.30.30

900 kN/m max.

NEW



42Cr: 900-1150 N/mm²

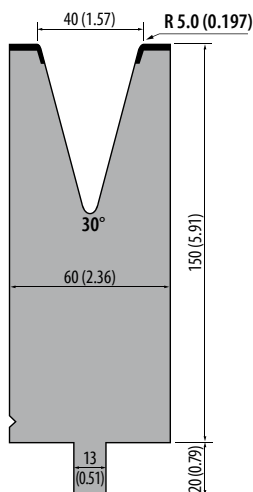
	500 mm	19.68 in	24.6 kg
FW FC	250 mm segmented	9.84 in segmented	12.3 kg
	550 mm segmented	21.65 in segmented	27.0 kg
Sectioning FA	1250 mm	49.21 in	61.5 kg
	2050 mm	80.71 in	100.9 kg
	2550 mm	100.39 in	125.5 kg
	3050 mm	120.08 in	150.1 kg
	4050 mm	159.45 in	199.3 kg
Sectioning FB	1250 mm	49.21 in	61.5 kg
	2050 mm	80.71 in	100.9 kg
	2550 mm	100.39 in	125.5 kg
	3050 mm	120.08 in	150.1 kg
	4050 mm	159.45 in	199.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

TMR150.40.30

900 kN/m max.

NEW



42Cr: 900-1150 N/mm²

	500 mm	19.68 in	25.3 kg
FW FC	250 mm segmented	9.84 in segmented	12.7 kg
	550 mm segmented	21.65 in segmented	27.8 kg
Sectioning FA	1250 mm	49.21 in	63.3 kg
	2050 mm	80.71 in	103.7 kg
	2550 mm	100.39 in	129.0 kg
	3050 mm	120.08 in	154.3 kg
	4050 mm	159.45 in	204.9 kg
Sectioning FB	1250 mm	49.21 in	63.3 kg
	2050 mm	80.71 in	103.7 kg
	2550 mm	100.39 in	129.0 kg
	3050 mm	120.08 in	154.3 kg
	4050 mm	159.45 in	204.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

Please ask for delivery times.
It is usually faster than you think!

4 R2

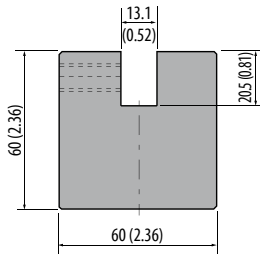
R2 ROLLERI TYPE R2

Die adapters

AD5

1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

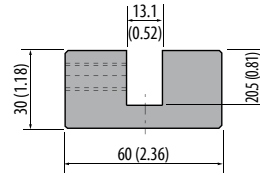
C45: 560-710 N/mm²



AD6

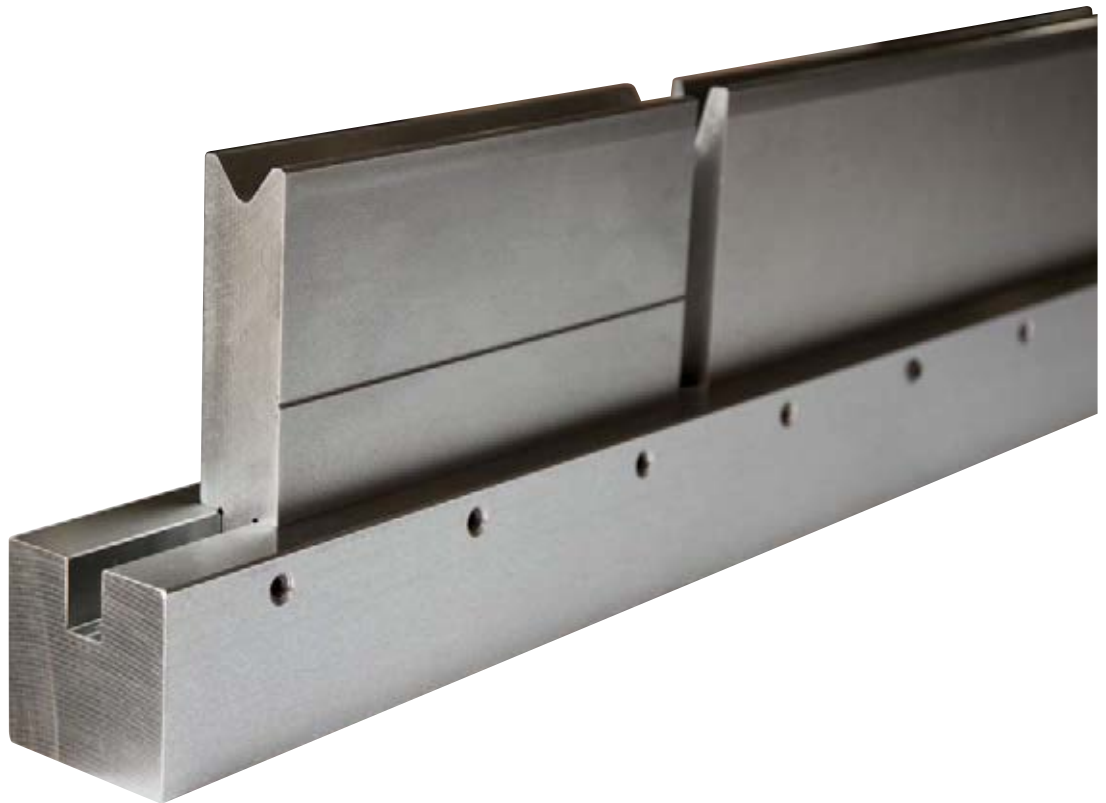
1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

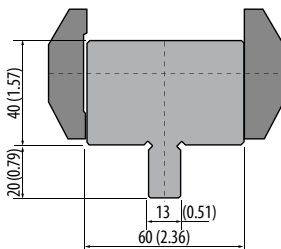
C45: 560-710 N/mm²



AD7

1000 kN/m max.

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



Rolleri Type R2/R3
→ Rolleri Type R1

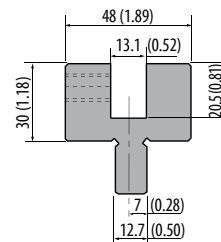
C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.

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



Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



R2 ROLLERI TYPE R2

Synthetic dies, H=100 (3.94)

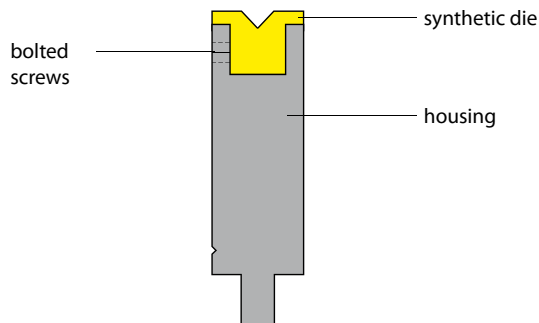


Our Advantages – Your Convenience

- easy handling
- faster and easier exchange
- preventing bending marks
- decrease of post-processing of bended profiles
- higher product quality

Mounting example

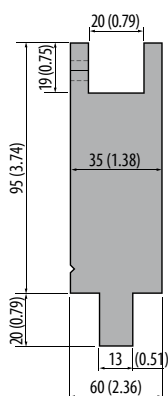
Synthetic dies will be adjusted into the housing and secured with bolted screws.



4
R2

TMN95.20

1000 kN/m max.



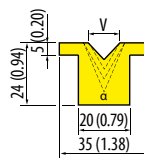
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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



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

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

More mark-free bending available see pages 230-237



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

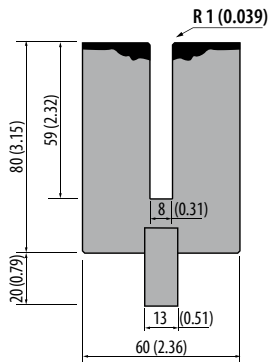


Articles on stock – Please note that delivery time depends on your location.

R2 ROLLER TYPE R2

Hemming Dies

TPR.SM.195.28.8 / TPR.SM.195.24.8

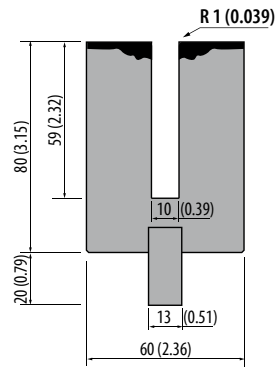


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



TPR.SM.195.24.10

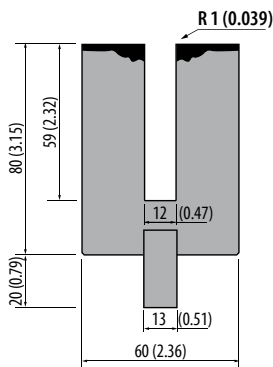


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²



TPR.SM.195.24.12



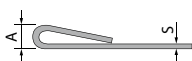
525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

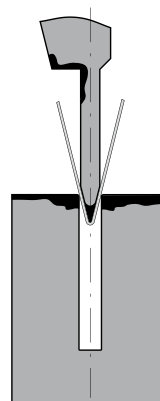


Only for thin material!
Hemming punches see page 91

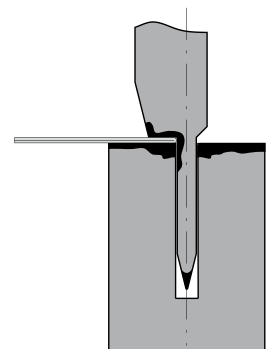
Example of application



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



500 kN/m max.



1000 kN/m max.

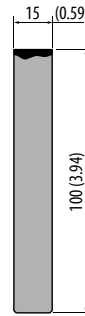
Application

- movable table necessary
- used flexibly
- easy mounting

Hemming punches see page 91

TMI100

1300 kN/m max.



FW	FC	500 mm	19.68 in	5.0 kg
	250 mm segmented	9.84 in segmented	2.5 kg	
Sectioning FA	FW	550 mm segmented	21.65 in segmented	5.5 kg
	1250 mm	49.21 in	12.5 kg	
Sectioning FB	2050 mm	80.71 in	20.5 kg	
	2550 mm	100.39 in	25.5 kg	
	3050 mm	120.08 in	30.5 kg	
	4050 mm	159.45 in	40.5 kg	
	1250 mm	49.21 in	12.5 kg	
Sectioning FB	2050 mm	80.71 in	20.5 kg	
	2550 mm	100.39 in	25.5 kg	
	3050 mm	120.08 in	30.5 kg	
	4050 mm	159.45 in	40.5 kg	
	1250 mm	49.21 in	12.5 kg	



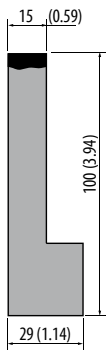
C45: 560-710 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

4 R2

TML100

1200 kN/m max.



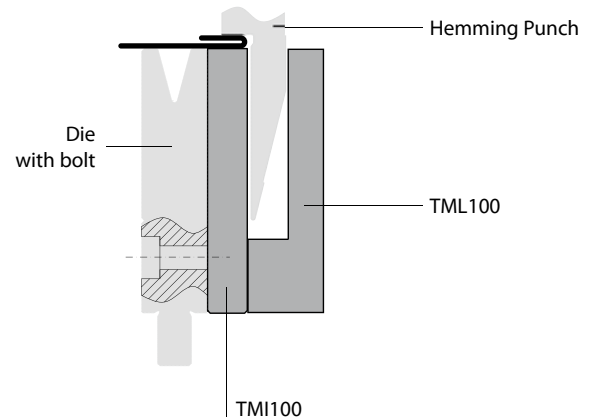
FW	FC	500 mm	19.68 in	5.0 kg
	250 mm segmented	9.84 in segmented	2.5 kg	
Sectioning FA	FW	550 mm segmented	21.65 in segmented	5.5 kg
	1250 mm	49.21 in	12.5 kg	
Sectioning FB	2050 mm	80.71 in	20.5 kg	
	2550 mm	100.39 in	25.5 kg	
	3050 mm	120.08 in	30.5 kg	
	4050 mm	159.45 in	40.5 kg	
	1250 mm	49.21 in	12.5 kg	
Sectioning FB	2050 mm	80.71 in	20.5 kg	
	2550 mm	100.39 in	25.5 kg	
	3050 mm	120.08 in	30.5 kg	
	4050 mm	159.45 in	40.5 kg	
	1250 mm	49.21 in	12.5 kg	



C45: 560-710 N/mm²

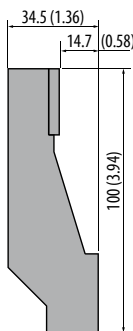
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

Example of application TMI100 + TML100



TMS100

1300 kN/m max.



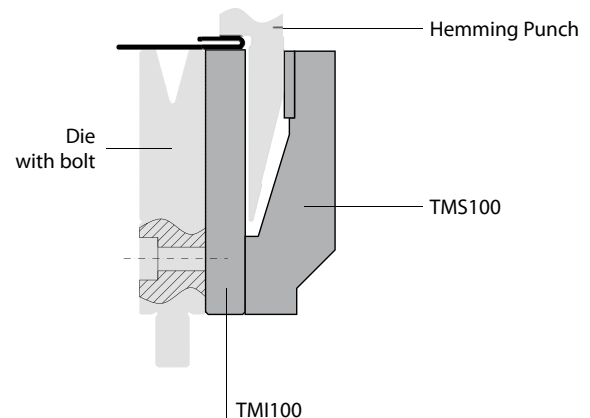
FW	FC	500 mm	19.68 in	5.0 kg
	250 mm segmented	9.84 in segmented	2.5 kg	
Sectioning FA	FW	550 mm segmented	21.65 in segmented	5.5 kg
	1250 mm	49.21 in	12.5 kg	
Sectioning FB	2050 mm	80.71 in	20.5 kg	
	2550 mm	100.39 in	25.5 kg	
	3050 mm	120.08 in	30.5 kg	
	4050 mm	159.45 in	40.5 kg	
	1250 mm	49.21 in	12.5 kg	
Sectioning FB	2050 mm	80.71 in	20.5 kg	
	2550 mm	100.39 in	25.5 kg	
	3050 mm	120.08 in	30.5 kg	
	4050 mm	159.45 in	40.5 kg	
	1250 mm	49.21 in	12.5 kg	



C45: 560-710 N/mm²

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

Example of application TMI100 + TMS100



PUNCHES ROLLERI TYPE R3

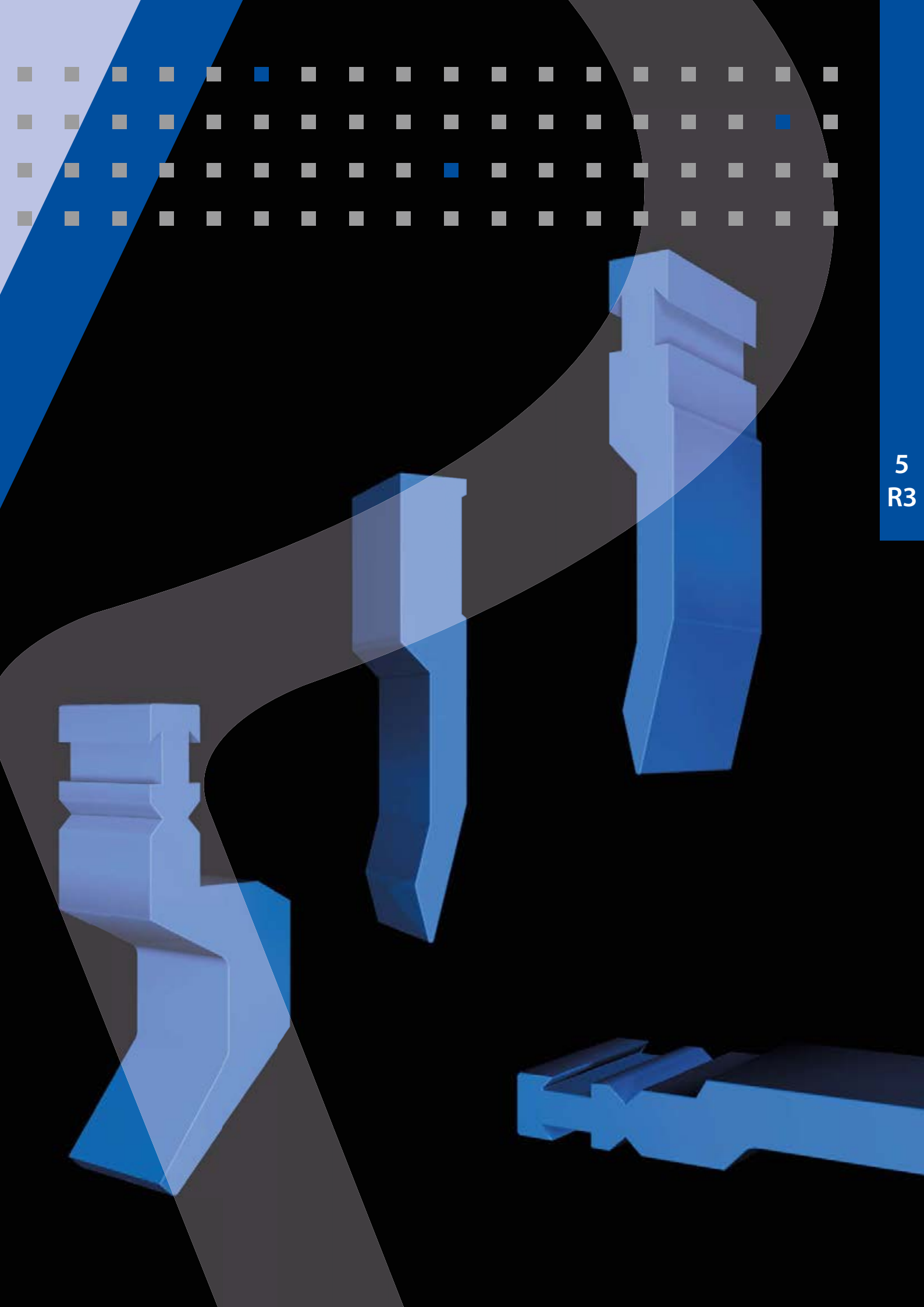
Content Explanation	122 - 123
Punches Bystronic-Beyeler RFA	124 - 125
Punches Bystronic-Beyeler RF	125
Hemming Punches Bystronic-Beyeler RFA	126
Punches Bystronic-Beyeler R	127
Punches Bystronic-Beyeler S	128
Punch adapters	129
Z-Profile Tools	130 - 131
Radius Tools	132 - 133

■ Compatibility

Punches Roller Type R3 are **compatible** with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

With Adapter-Systems the punches Roller Type R3 are also applicable on all other press brake machines.



Compatibility

Punches Rolleri Type R3 are:

- compatible with press brake machines from:
 - Bystronic-Beyeler RFA
 - Bystronic-Beyeler RF
 - Bystronic-Beyeler R
 - Bystronic-Beyeler S

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 256-257)
- very large stock availability

Material

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

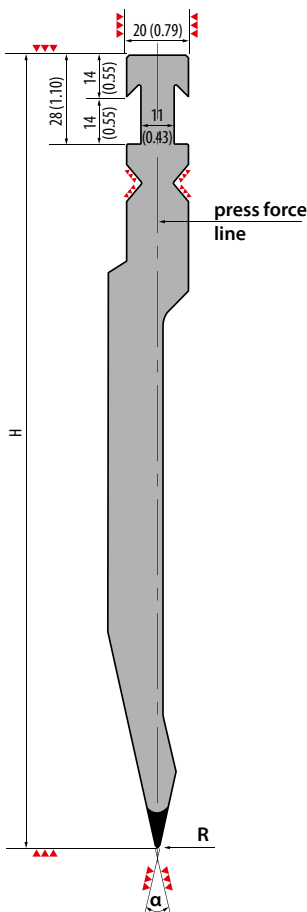
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29,1 - 36,9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15,5 HRC	54 - 60 HRC

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

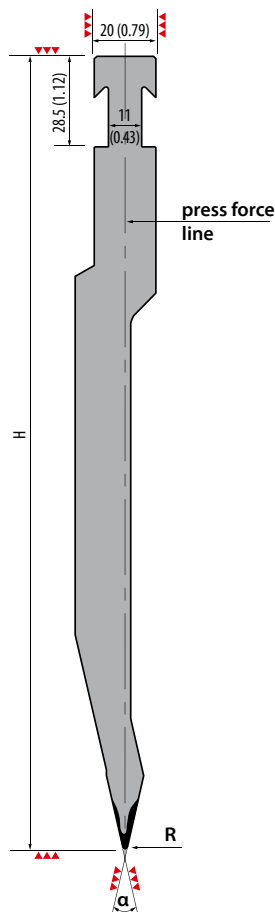
Tang

Punches Rolleri Type R3 have the following tangs:

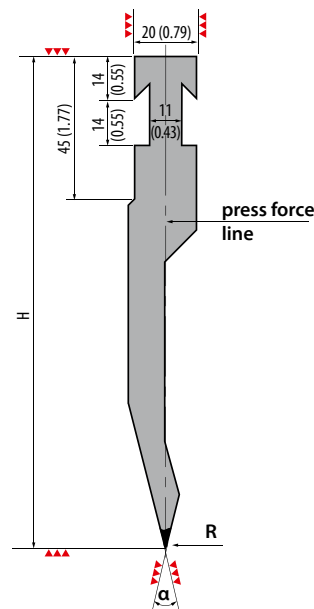
Bystronic-Beyeler RFA



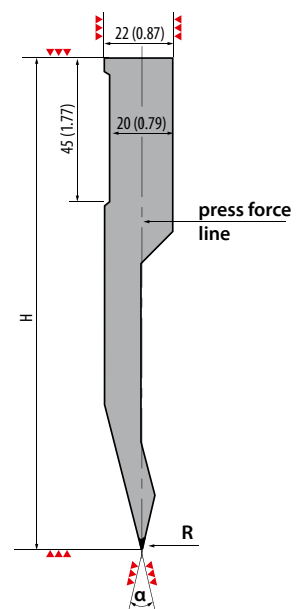
Bystronic-Beyeler RF



Bystronic-Beyeler R



Bystronic-Beyeler S



Indications of precision ground surfaces:

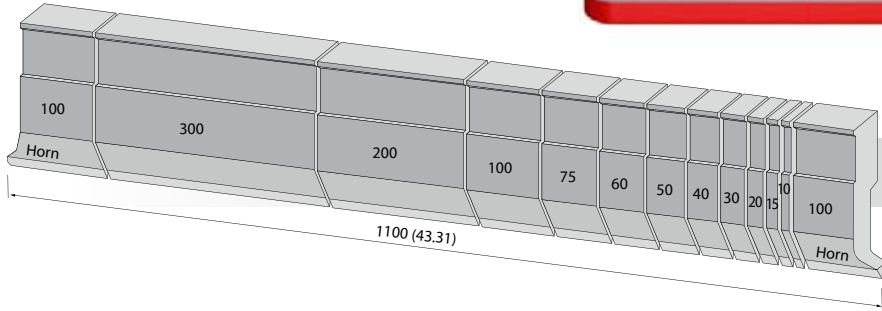


Tool lengths and sectioning

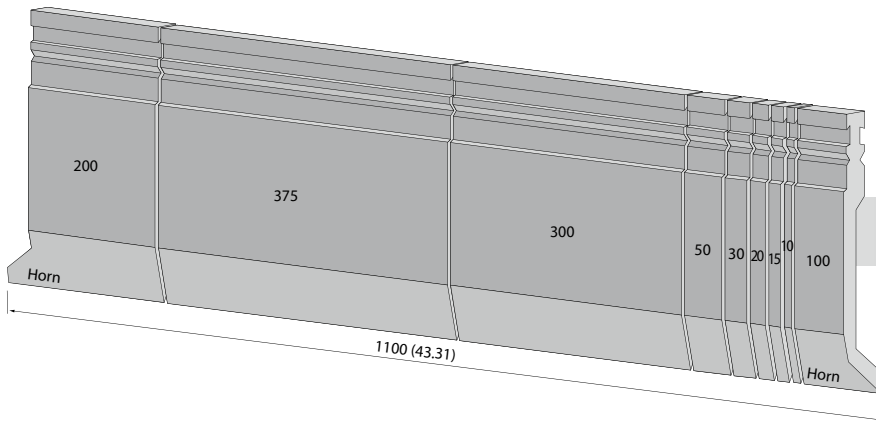
Standard

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

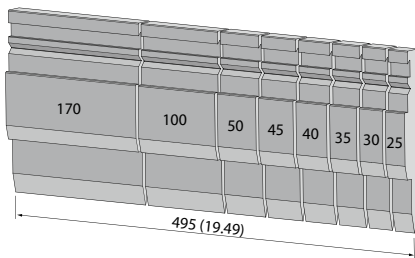
- 1000 mm (39.36 in)
- 500 mm (19.68 in)
- 508 mm (20.00 in)
- 525 mm (20.67 in)



1100 mm (43.30 in) segmented BP (13 segments)

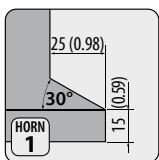


1100 mm (43.30 in) segmented BPR (9 segments)

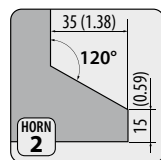


495 mm (19.48 in) segmented (8 segments)

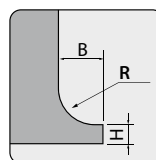
Horn Types



Horn 1
Standard BP
for all segm.
Punches BP
Rolleri Type R3



Horn 2
Standard BPR
for all segm.
Punches BPR
Rolleri Type R3

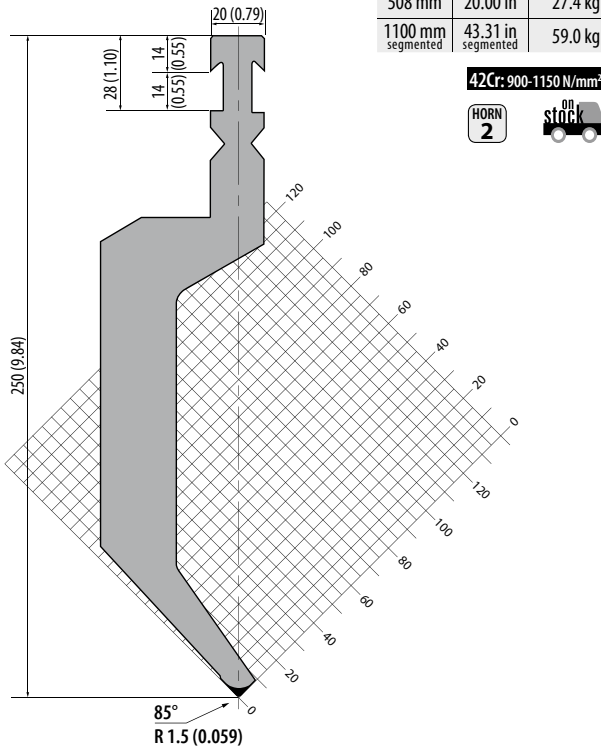


Individual Horn
production
according
to your
specifications

5
R3

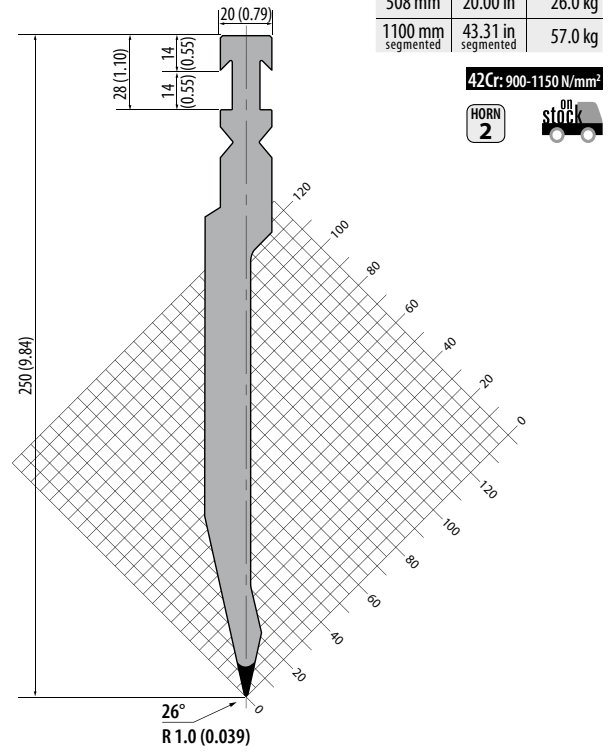
BPR250.P4-RFA

900 kN/m max.



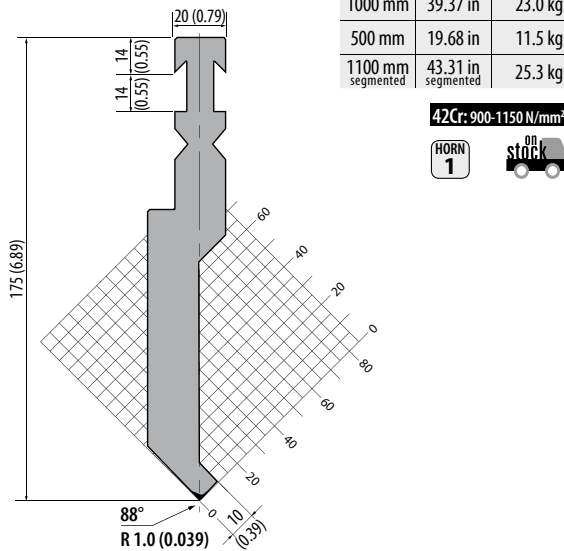
BPR250.P5-RFA

1000 kN/m max.



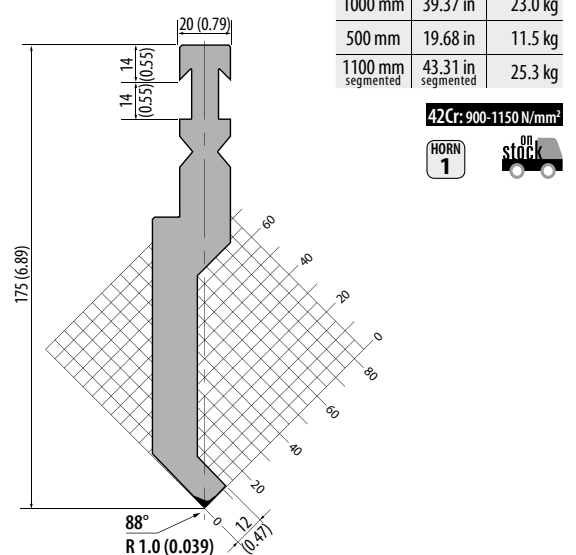
BP175.88.R1-A-RFA

1000 kN/m max.



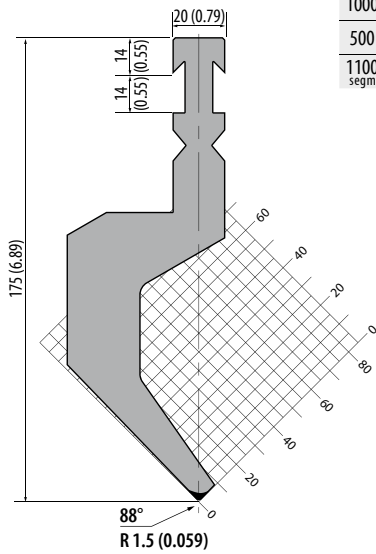
BP175.88.R1-B-RFA

1000 kN/m max.



BP175.88.R15-RFA

500 kN/m max.



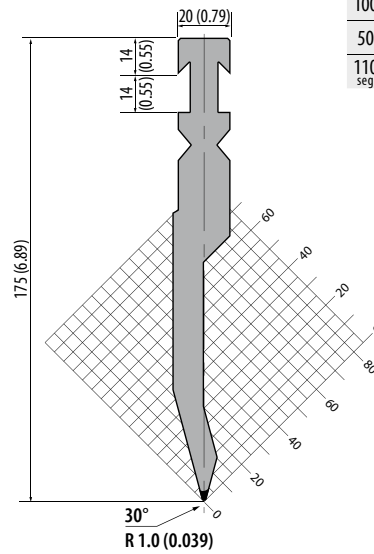
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	23.0 kg

42Cr: 900-1150 N/mm²



BP175.30.R1-RFA

800 kN/m max.



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

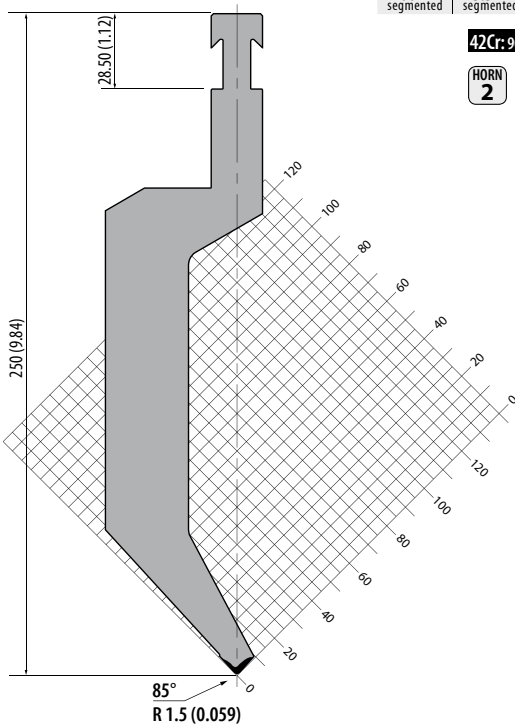
42Cr: 900-1150 N/mm²



Punches Bystronic-Beyeler RF

BPR250.P4-RF

1000 kN/m max.



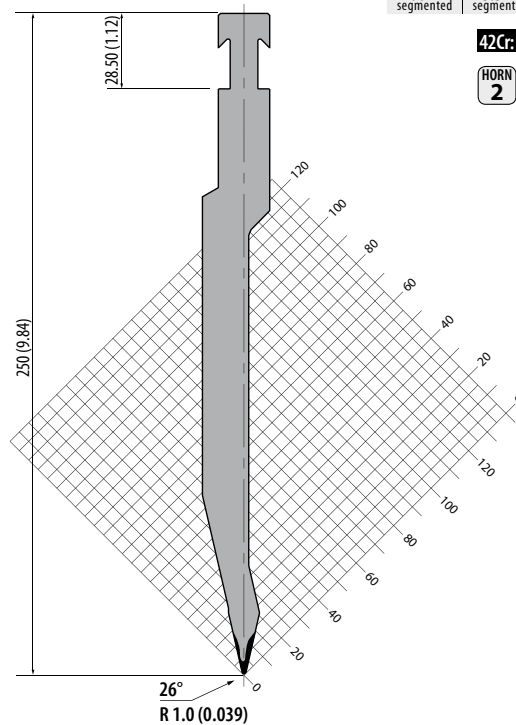
508 mm	20.00 in	27.6 kg
1100 mm segmented	43.31 in segmented	51.0 kg

42Cr: 900-1150 N/mm²



BPR250.P5-RF

900 kN/m max.



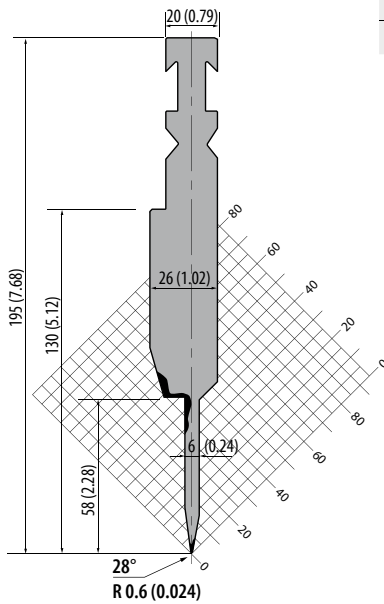
508 mm	20.00 in	16.0 kg
1100 mm segmented	43.31 in segmented	35.0 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.28.6

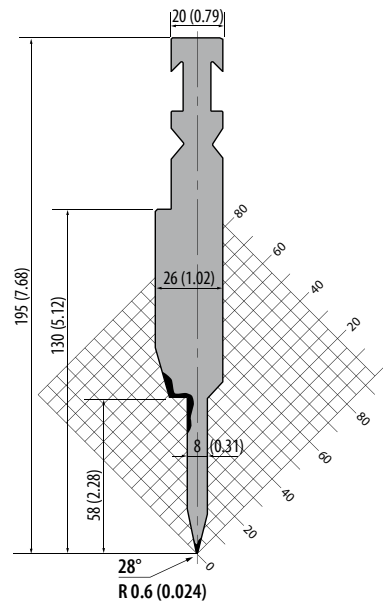
500 kN/m max.



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

42Cr: 900-1150 N/mm²

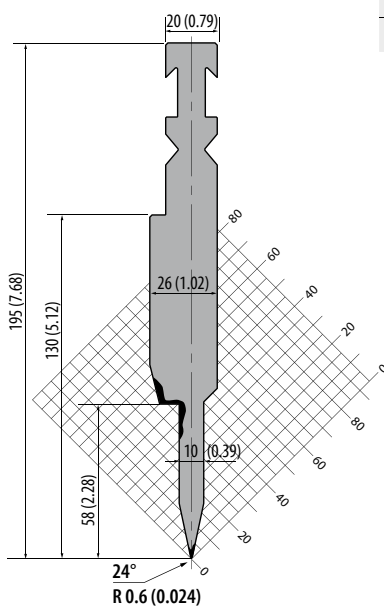
BPR.SP-195.28.8



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

42Cr: 900-1150 N/mm²

BPR.SP-195.24.10

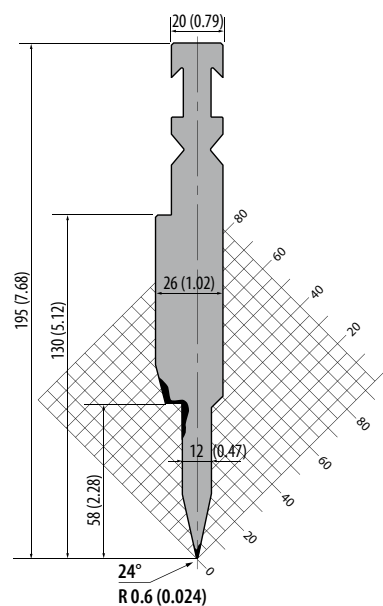


525 mm	20.67 in	8.9 kg
495 mm segmented	19.49 in segmented	8.4 kg

42Cr: 900-1150 N/mm²

Compatible Hemming Dies on page 148

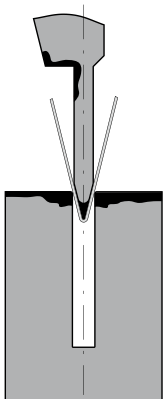
BPR.SP-195.24.12



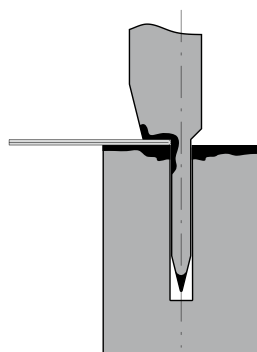
525 mm	20.67 in	9.2 kg
495 mm segmented	19.49 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

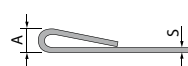
Example of Application



800 kN/m max.



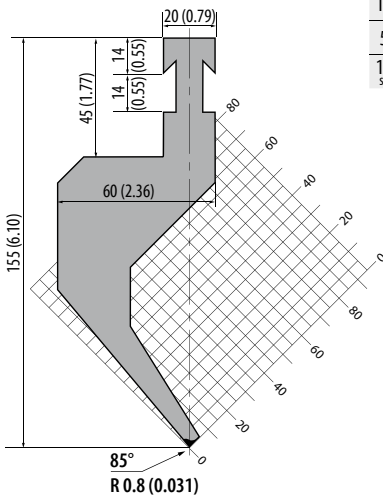
1000 kN/m max.



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

BP155.85.R08-R

500 kN/m max.



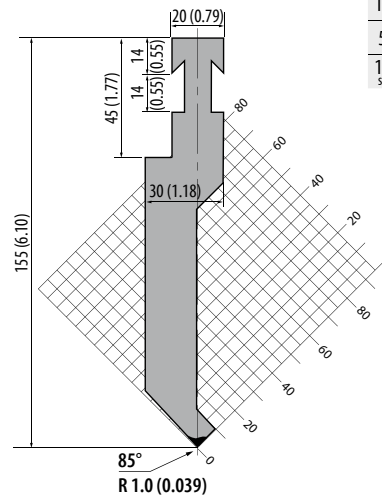
1000 mm	39.37 in	30.5 kg
500 mm	19.68 in	15.0 kg
1100 mm segmented	43.31 in segmented	32.5 kg

42Cr: 900-1150 N/mm²



BP155.85.R1-R

1000 kN/m max.



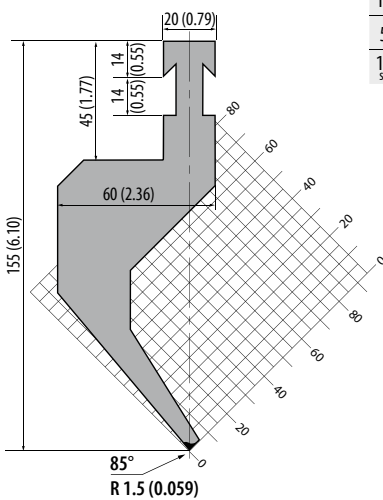
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	23.0 kg

42Cr: 900-1150 N/mm²



BP155.85.R15-R

500 kN/m max.



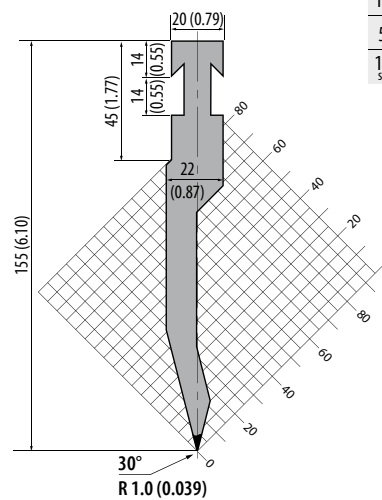
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	32.0 kg

42Cr: 900-1150 N/mm²



BP155.30.R1-R

800 kN/m max.



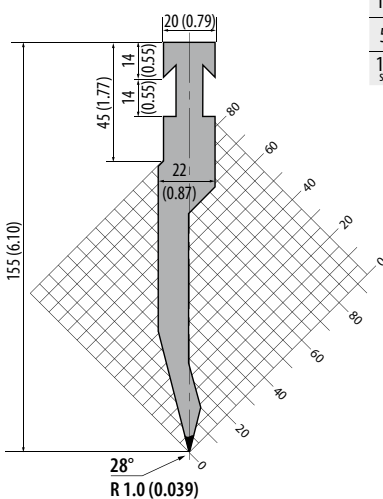
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



BP155.28.R1-R

800 kN/m max.



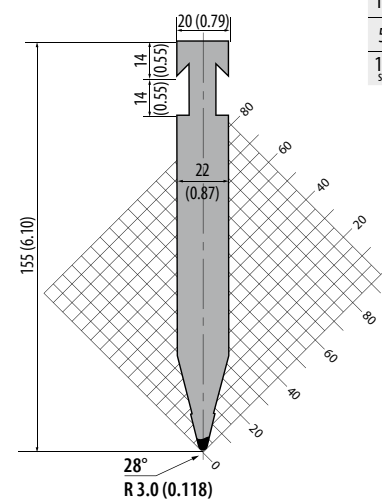
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²



BP155.28.R3-R

1000 kN/m max.



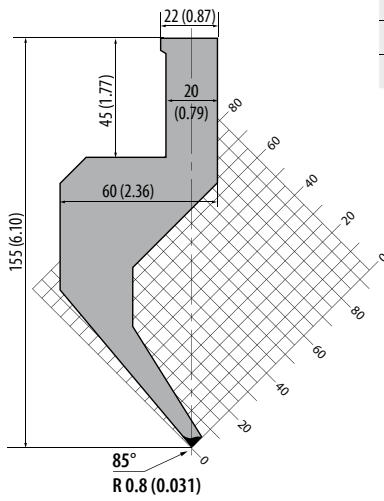
1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	11.0 kg
1100 mm segmented	43.31 in segmented	23.5 kg

C45: 560-710 N/mm²



BP155.85.R08-S

500 kN/m max.

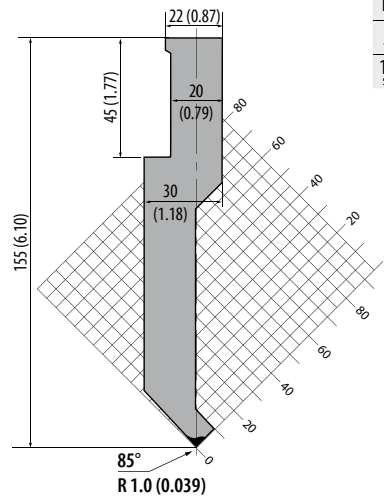


1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	34.0 kg

42Cr: 900-1150 N/mm²
 HORN 1

BP155.85.R1-S

1000 kN/m max.

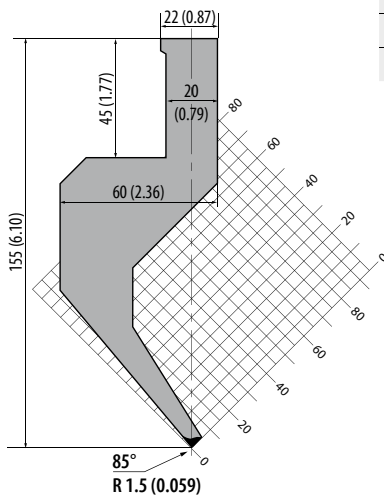


1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	35.2 kg

42Cr: 900-1150 N/mm²
 HORN 1

BP155.85.R15-S

500 kN/m max.

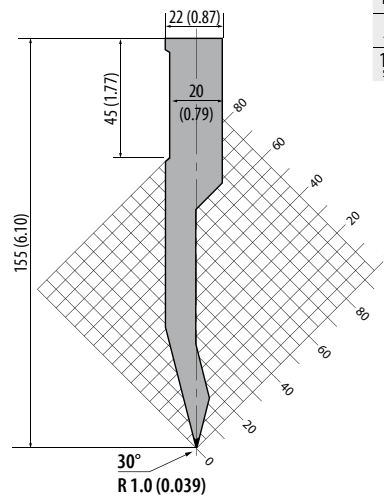


1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.5 kg
1100 mm segmented	43.31 in segmented	32.0 kg

42Cr: 900-1150 N/mm²
 HORN 1

BP155.30.R1-S

800 kN/m max.

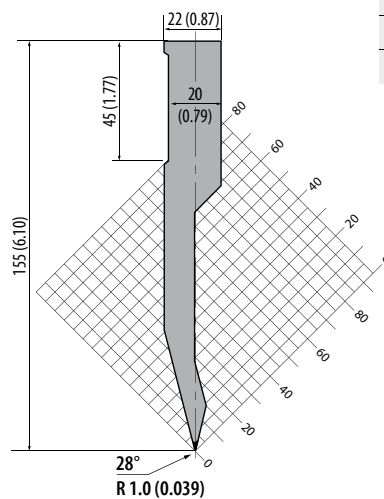


1000 mm	39.37 in	17.5 kg
500 mm	19.68 in	9.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²
 HORN 1

BP155.28.R1-S

800 kN/m max.

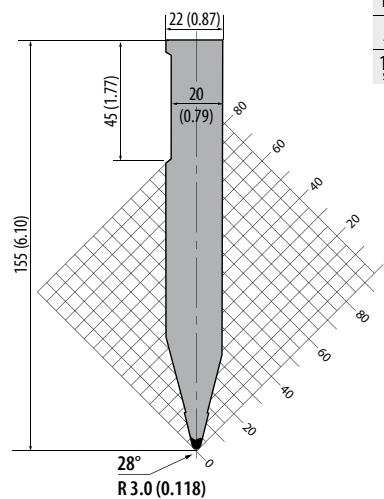


1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²
 HORN 1

BP155.28.R3-S

1000 kN/m max.



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

45: 560-710 N/mm²
 HORN 1

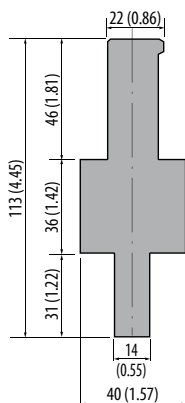
AD3

1000 kN/m max.

150 mm	5.90 in	3.3 kg
--------	---------	--------

Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



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

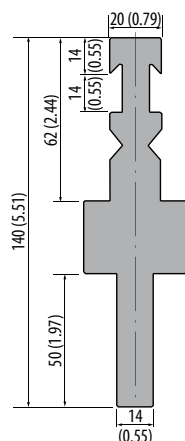
AD10

1000 kN/m max.

150 mm	5.90 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler RFA → Rolleri Type R1

C45: 560-710 N/mm²



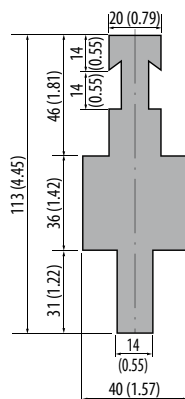
AD22

1000 kN/m max.

150 mm	5.90 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler R
→ Rolleri Type R1

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



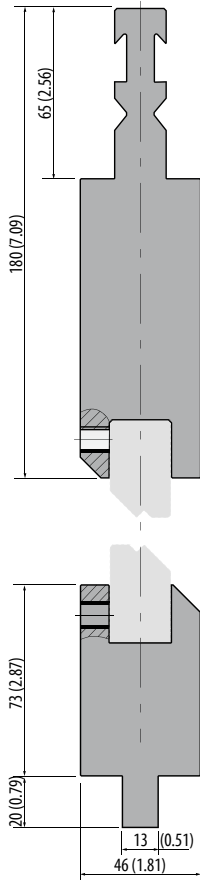
Articles on stock – Please note that delivery time depends on your location.

BPZ-RFA

1000 kN/m max.

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

C45: 560-710 N/mm²



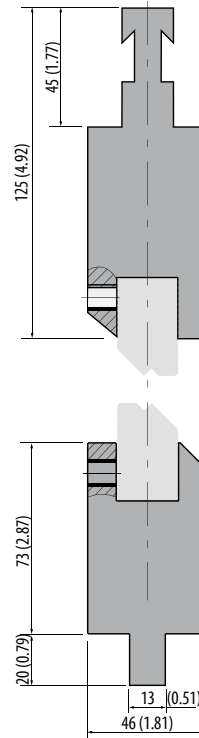
BPZ-R

1000 kN/m max.

NEW

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

C45: 560-710 N/mm²



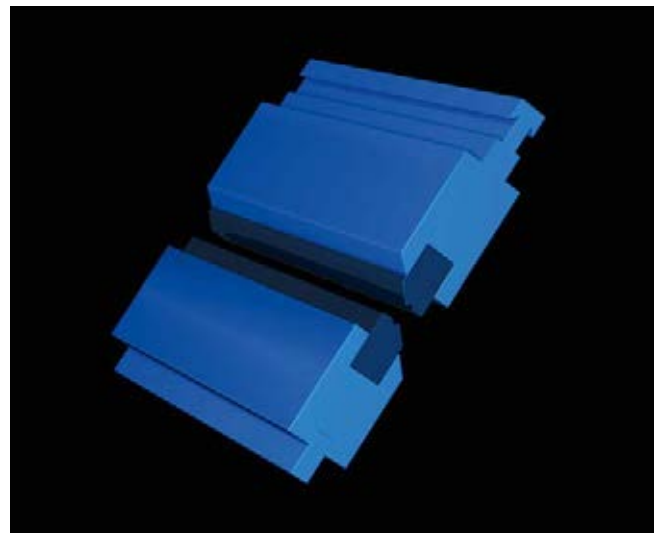
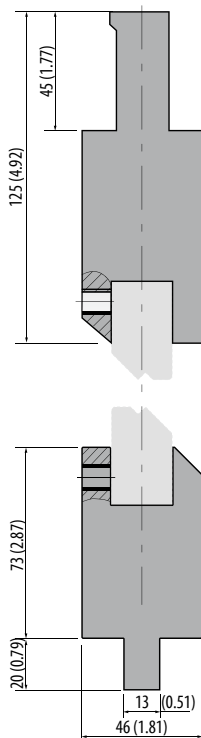
BPZ-S

1000 kN/m max.

NEW

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

C45: 560-710 N/mm²



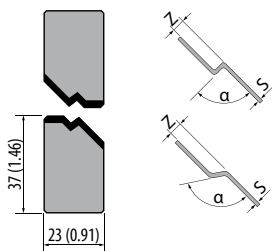
Rolleri Videos

find updated and helpful videos at:
[www.rolleritools.com/
 videos/overview](http://www.rolleritools.com/videos/overview)



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

1000 kN/m max.



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

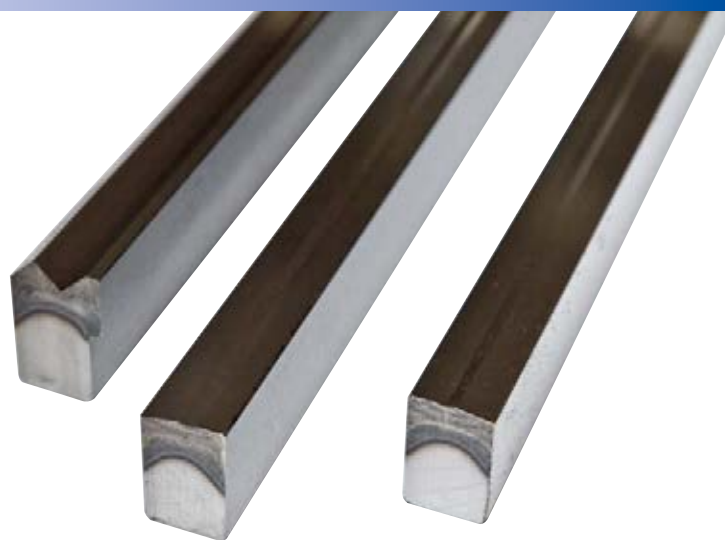
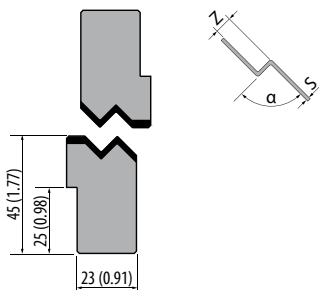
C45: C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

5
R3

Z-Profile Inserts 90°

1000 kN/m max.



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



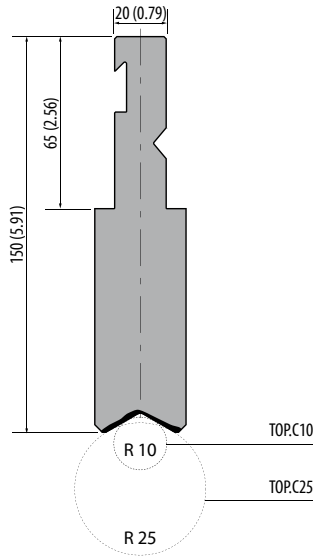
C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²



BPR150.P10.10-RFA

1000 kN/m max.



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

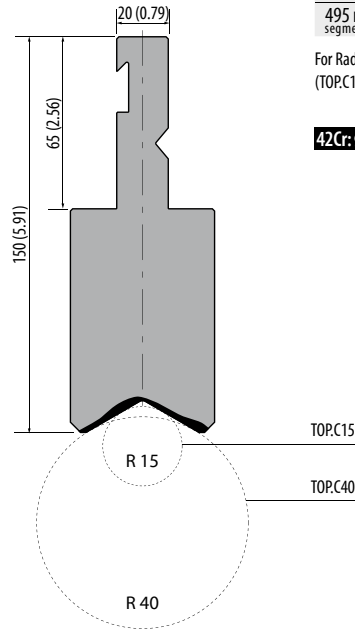
For Radius tools with R10-R25 (TOP.C10-TOP.C25) see below

42Cr: 900-1150 N/mm²



BPR150.P10.15-RFA

1000 kN/m max.



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

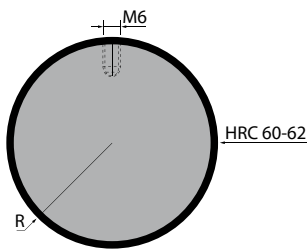
For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm²



Radius Tools: R10-40

1000 kN/m max.



Material: C53
induction hard-
ened 60-62 HRC

C53: 610-760 N/mm²

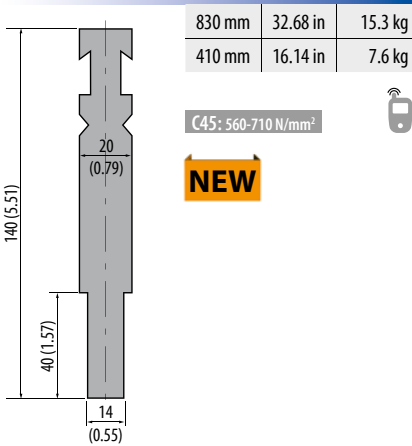


Model	R mm	R in	525 mm / 20.67 in	Weight	495 mm / 16.34 in segmented	Weight
TOP.C10	10	0.39		1.3 kg		2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg		
TOP.C15	15	0.59	3.0 kg	3.8 kg		
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg		
TOP.C20	20	0.79	5.2 kg	6.6 kg		
TOP.C25	25	0.98	8.1 kg	7.5 kg		
TOP.C30	30	1.18	11.7 kg	11.3 kg		
TOP.C35	35	1.38	16.0 kg	15.1 kg		
TOP.C40	40	1.57	20.7 kg	19.5 kg		

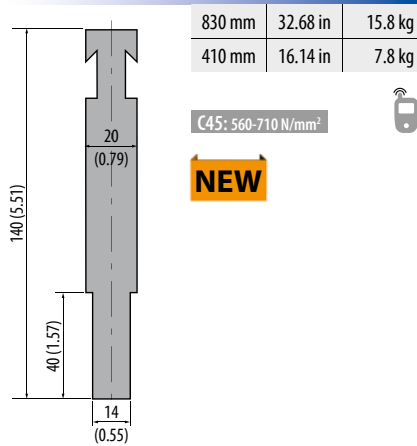
Articles on stock – Please note that delivery time varies according to your location.



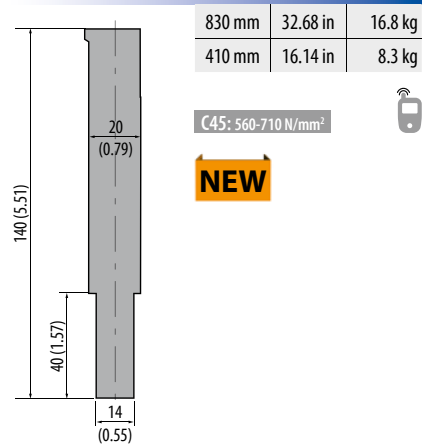
BPU-RFA 800 kN/m max.



BPU-R 800 kN/m max.

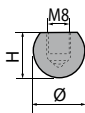


BPU-S 800 kN/m max.



Radius Tool: Ø 16-20 mm (0.63-0.79 in)

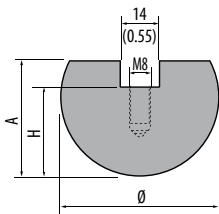
800 kN/m max.



Model	Ø mm	Ø in	H mm	H in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight
C13.08	16	0.63	13	0.51	835 mm / 32.87 in	2.00 kg	415 mm / 16.34 in	1.00 kg
C13.09	18	0.71	16	0.63		2.00 kg		1.00 kg
C16.10	20	0.79	16	0.63		2.00 kg		1.00 kg

Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.

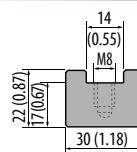


Model	Ø mm	Ø in	H mm	H in	A mm	A in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight
C17.12	25	0.98	17	0.67	22	0.87	835 mm / 32.87 in	2.5 kg	415 mm / 16.34 in	1.2 kg
C20.15	30	1.18	20	0.79	27	1.06		3.7 kg		1.8 kg
C22.17	35	1.38	22	0.87	32	1.26		5.0 kg		2.4 kg
C24.20	40	1.57	24	0.94	34	1.34		7.0 kg		3.5 kg
C29.25	50	1.97	29	1.14	39	1.54		10.0 kg		4.7 kg
C34.30	60	2.36	34	1.34	44	1.73		13.5 kg		6.7 kg
C45.35	70	2.76	45	1.77	55	2.17		20.3 kg		10.0 kg
C45.40	80	3.15	45	1.77	55	2.17		23.0 kg		11.5 kg
C60.45	90	3.54	60	2.36	70	2.76		34.0 kg		17.0 kg
C70.50	100	3.94	70	2.76	80	3.15		43.5 kg		21.7 kg



E30.22

800 kN/m max.



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

C45: 560-710 N/mm²

DIES ROLLERI TYPE R3

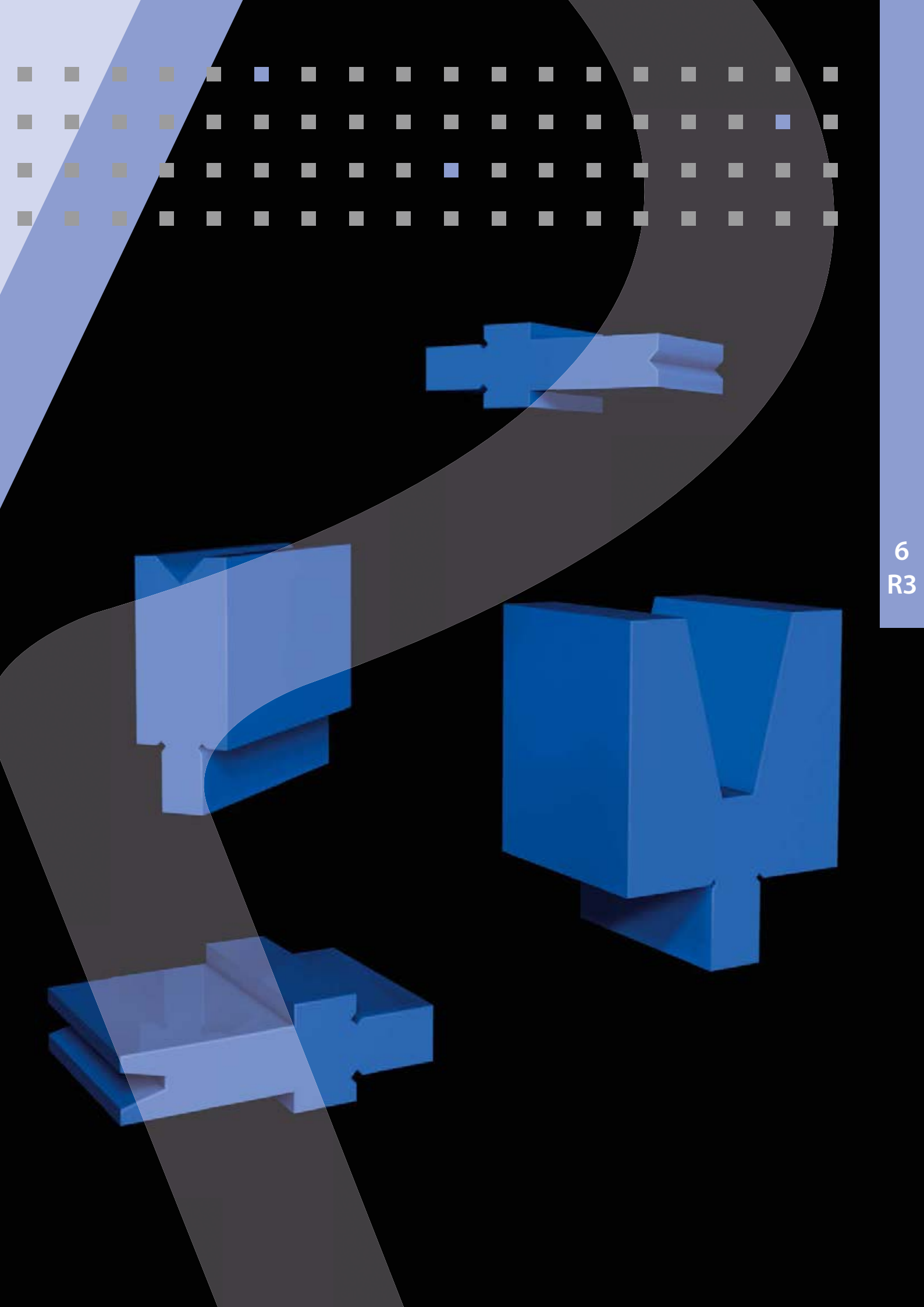
Content Explanation	136 - 137
Dies 90°, H=55 (2.17)	138
Dies 88°, H=55 (2.17)	138 - 139
Dies 85°, H=55 (2.17)	139 - 140
Dies 80°, H=55 (2.17)	141 - 142
Dies 80°, H=65 (2.56) / H=85 (3.35)	142
Dies 60°, H=55 (2.17) / H=65 (2.56)	142
Dies 30°, H=55 (2.17) / H=60 (2.36)	143
Dies 30°, H=70 (2.76)	144
Dies, H=100 (3.94) / H=120 (4.72) / H=150 (5.91)	145 - 147
Hemming Dies	148
Synthetic Dies, H=100 (3.94)	149
Die Adapters	149

■ Compatibility

Dies Rolleri Type R3 are **compatible** with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

With Adapter-Systems the dies Rolleri Type R3 are also applicable on all other press brake machines.



Compatibility

Dies Rolleri Type R3 are:

- **compatible** with press brake machines with a table groove for pins 13 x 20 mm (0.51 x 0.79 in): Bystronic-Beyeler, Bystronic-Hämmerle, Safan, SMD, Trumpf
- also applicable on all other press brake machines **with Adapter-Systems and Adapter Rails** (see pages 226-229).

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 258-261)
- very large stock availability

Material

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

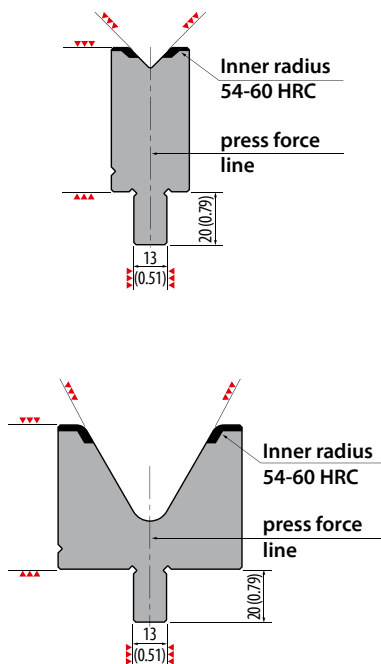
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

All dies Rolleri Type R3 are by default equipped with a **13 x 20 mm (0.51 x 0.79 in) tail**.

Indications of precision ground surfaces:

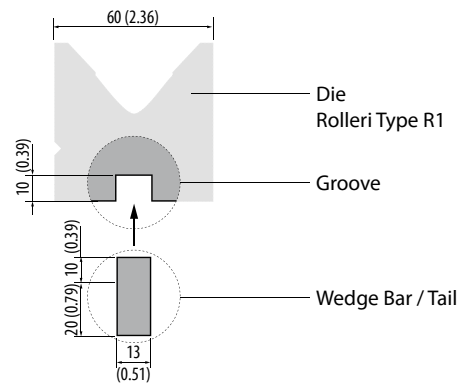


Modification: Wedge Bar / Tail

In order to also use Rolleri Type R1 Dies, a 10 mm (0.39 in) groove is milled and a precise grounded wedge bar / tail in 13 x 30 mm (0.51 x 1.18 in) is inserted.

For more specific information and prices go to page 260 in the Service Chapter.

Example of Application



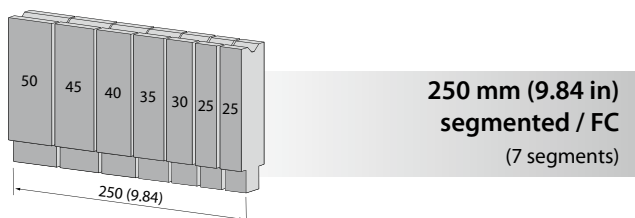
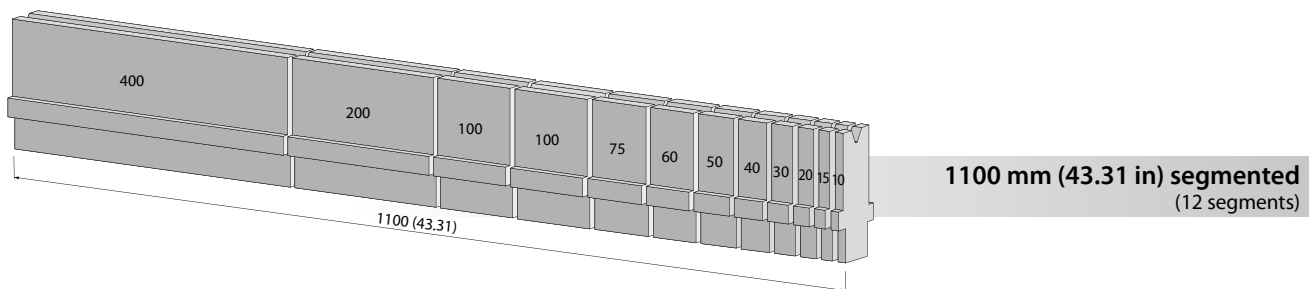
Tool lengths and sectioning

Standard

1000 mm (39.37 in)

500 mm (19.68 in)

525 mm (20.67 in)



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

6
R3



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



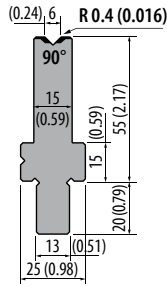
Articles on stock – Please note that delivery time depends on your location.

R3 ROLLERI TYPE R3

Dies 90°, H=55 (2.17)

BMR55.06.90

1150 kN/m max.



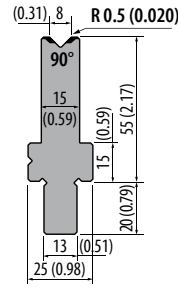
1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.08.90

1100 kN/m max.



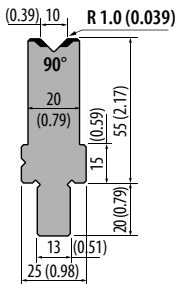
1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.10.90

1100 kN/m max.



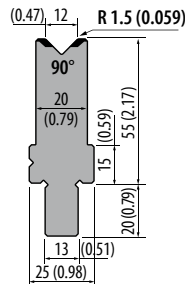
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.90

1200 kN/m max.



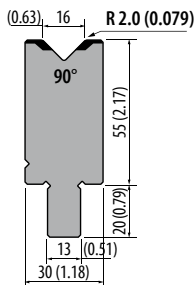
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.90

1200 kN/m max.



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

42Cr: 900-1150 N/mm²

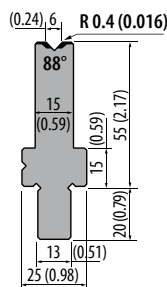


Dies 88°, H=55 (2.17)

BMR55.06.88

1150 kN/m max.

NEW



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

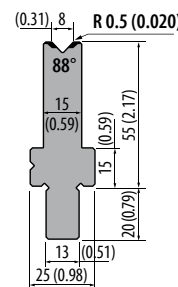
42Cr: 900-1150 N/mm²



BMR55.08.88

1100 kN/m max.

NEW



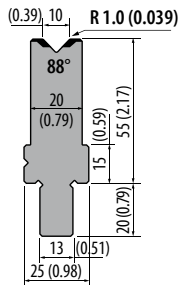
1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.10.88

1100 kN/m max.



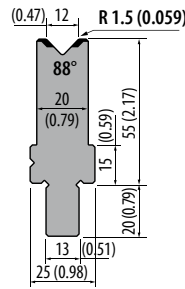
1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	12.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.88

1200 kN/m max.



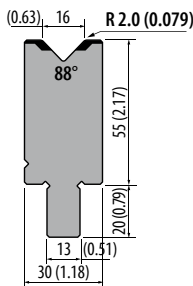
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.88

1200 kN/m max.



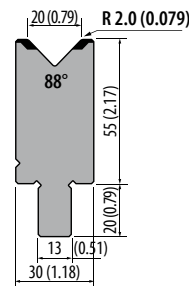
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR55.20.88

1100 kN/m max.



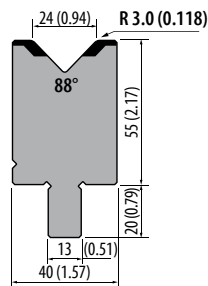
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



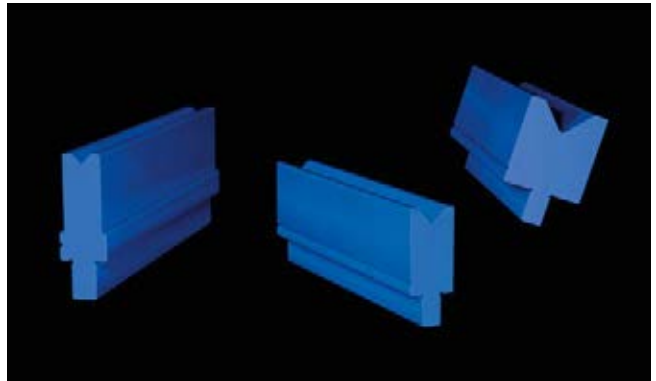
BMR55.24.88

1200 kN/m max.



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

42Cr: 900-1150 N/mm²

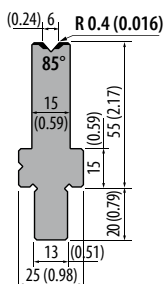


Dies 85°, H=55 (2.17)

BMR55.06.85

1150 kN/m max.

NEW



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

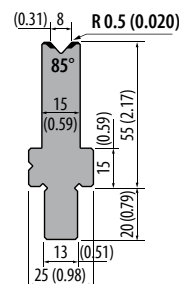
42Cr: 900-1150 N/mm²



BMR55.08.85

1100 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²



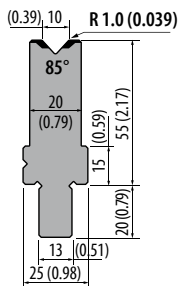
R3 ROLLER TYPE R3

Dies 85°, H=55 mm

BMR55.10.85

1100 kN/m max.

NEW



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

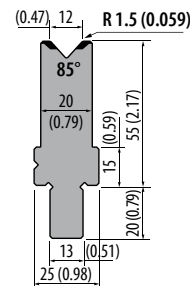
42Cr: 900-1150 N/mm²



BMR55.12.85

1200 kN/m max.

NEW



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

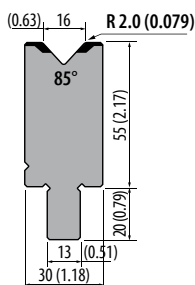
42Cr: 900-1150 N/mm²



BMR55.16.85

1200 kN/m max.

NEW



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

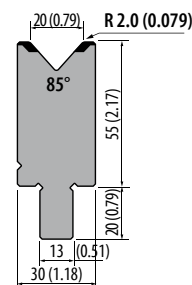
42Cr: 900-1150 N/mm²



BMR55.20.85

1100 kN/m max.

NEW



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

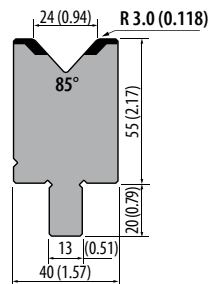
42Cr: 900-1150 N/mm²



BMR55.24.85

1200 kN/m max.

NEW



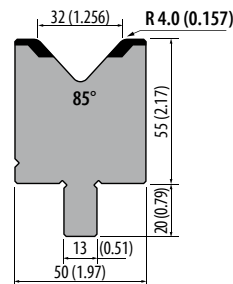
1000 mm	39.37 in	18.5 kg
500 mm	19.68 in	9.2 kg
1100 mm segmented	43.31 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



BMR55.32.85

1200 kN/m max.



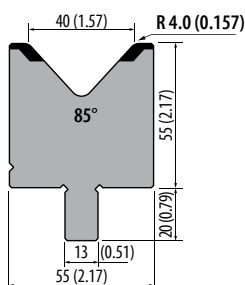
1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	20.5 kg

42Cr: 900-1150 N/mm²



BMR55.40.85

1200 kN/m max.



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

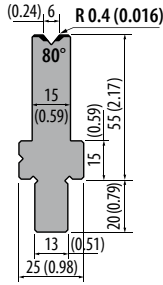
42Cr: 900-1150 N/mm²



BMR55.06.80

1150 kN/m max.

NEW



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

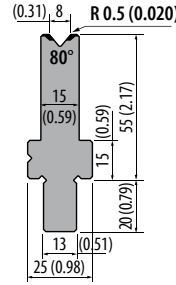
42Cr: 900-1150 N/mm²



BMR55.08.80

1100 kN/m max.

NEW



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

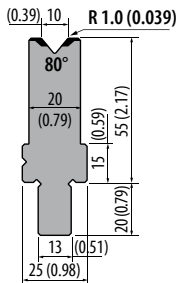
42Cr: 900-1150 N/mm²



BMR55.10.80

1100 kN/m max.

NEW



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

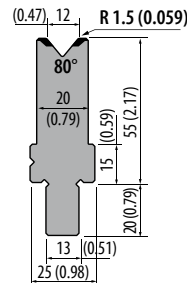
42Cr: 900-1150 N/mm²



BMR55.12.80

1200 kN/m max.

NEW



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

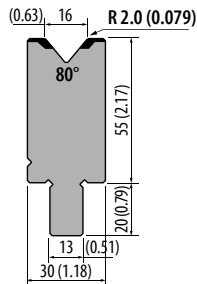
42Cr: 900-1150 N/mm²



BMR55.16.80

1200 kN/m max.

NEW



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

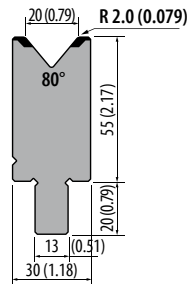
42Cr: 900-1150 N/mm²



BMR55.20.80

1100 kN/m max.

NEW



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

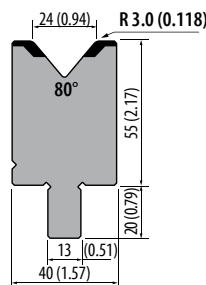
42Cr: 900-1150 N/mm²



BMR55.24.80

1200 kN/m max.

NEW



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

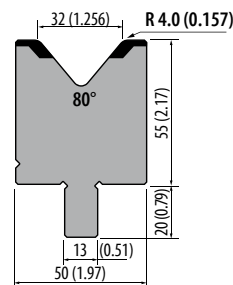
42Cr: 900-1150 N/mm²



BMR55.32.80

1200 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²



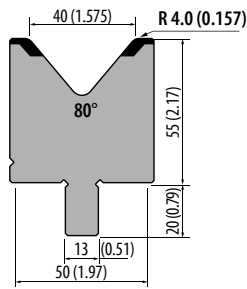
R3 ROLLER TYPE R3

Dies 80°, H=55 (2.17), H=65 (2.56) / H=85 (3.35)

BMR55.40.80

1200 kN/m max.

NEW



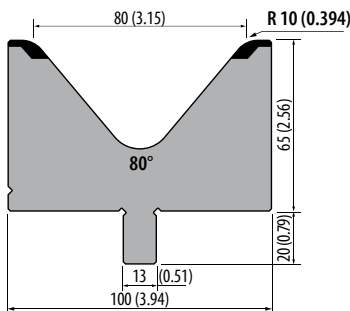
1000 mm	39.37 in	21.5 kg
500 mm	19.68 in	10.7 kg
1100 mm segmented	43.31 in segmented	25.0 kg

42Cr: 900-1150 N/mm²



BMR65.80.80

1700 kN/m max.



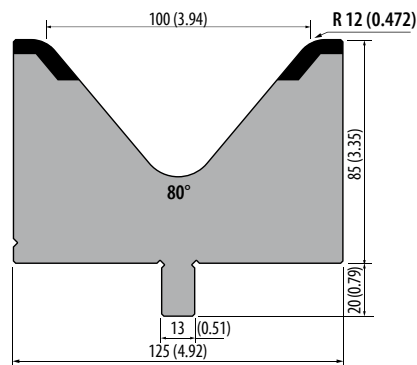
1000 mm	39.37 in	39.0 kg
500 mm	19.68 in	20.0 kg
1100 mm segmented	43.31 in segmented	43.0 kg

42Cr: 900-1150 N/mm²



BMR85.100.80

2300 kN/m max.



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

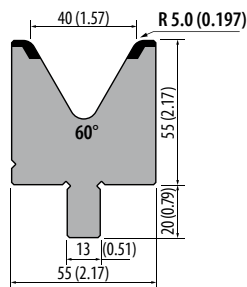
42Cr: 900-1150 N/mm²



Dies 60°, H=55 (2.17), H=65 (2.56)

BMR55.40.60

1300 kN/m max.



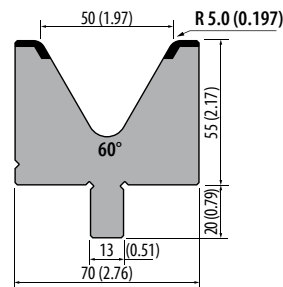
1000 mm	39.37 in	20.3 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	22.3 kg

42Cr: 900-1150 N/mm²



BMR55.50.60

1200 kN/m max.



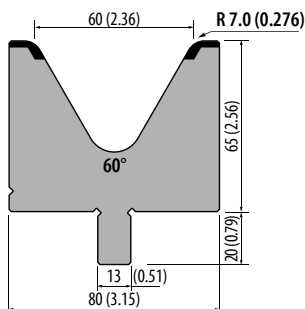
1000 mm	39.37 in	25.0 kg
500 mm	19.68 in	12.0 kg
1100 mm segmented	43.31 in segmented	21.0 kg

42Cr: 900-1150 N/mm²



BMR65.60.60

1100 kN/m max.



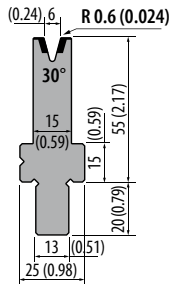
1000 mm	39.37 in	31.0 kg
500 mm	19.68 in	15.5 kg
1100 mm segmented	43.31 in segmented	34.1 kg

42Cr: 900-1150 N/mm²



BMR55.06.30

350 kN/m max.



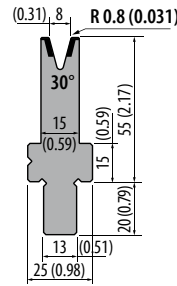
1000 mm	39.37 in	8.0 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	9.0 kg

42Cr: 900-1150 N/mm²



BMR55.08.30

200 kN/m max.



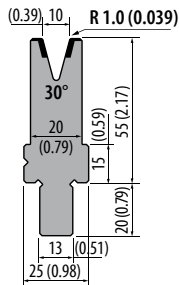
1000 mm	39.37 in	9.2 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	10.1 kg

42Cr: 900-1150 N/mm²



BMR55.10.30

350 kN/m max.



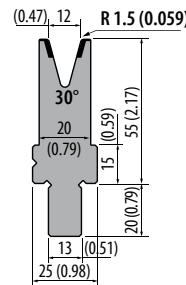
1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.30

300 kN/m max.



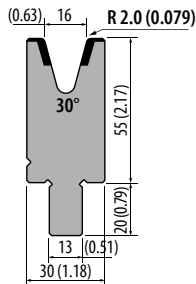
1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.30

450 kN/m max.



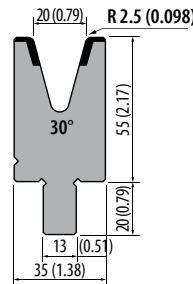
1000 mm	39.37 in	13.5 kg
500 mm	19.68 in	6.7 kg
1100 mm segmented	43.31 in segmented	14.9 kg

42Cr: 900-1150 N/mm²



BMR55.20.30

500 kN/m max.



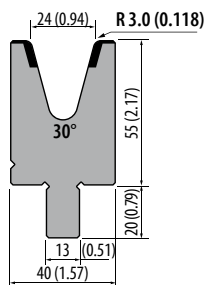
1000 mm	39.37 in	14.0 kg
500 mm	19.68 in	7.0 kg
1100 mm segmented	43.31 in segmented	13.5 kg

42Cr: 900-1150 N/mm²



BMR55.24.30

550 kN/m max.



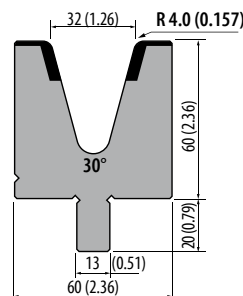
1000 mm	39.37 in	15.5 kg
500 mm	19.68 in	7.8 kg
1100 mm segmented	43.31 in segmented	17.0 kg

42Cr: 900-1150 N/mm²



BMR60.32.30

650 kN/m max.



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

42Cr: 900-1150 N/mm²

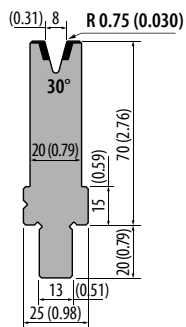


R3 ROLLER TYPE R3

Dies 30°, H=70 (2.76)

BMR70.08.30

200 kN/m max.



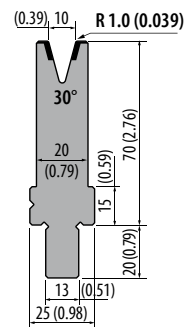
1000 mm	39.37 in	13.1 kg
500 mm	19.68 in	6.5 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR70.10.30

350 kN/m max.



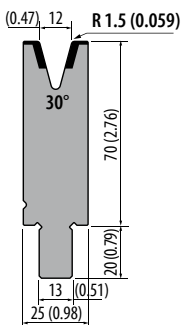
1000 mm	39.37 in	12.8 kg
500 mm	19.68 in	6.4 kg
1100 mm segmented	43.31 in segmented	12.4 kg

42Cr: 900-1150 N/mm²



BMR70.12.30

300 kN/m max.



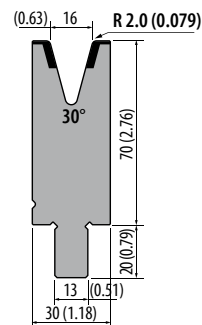
1000 mm	39.37 in	14.7 kg
500 mm	19.68 in	7.3 kg
1100 mm segmented	43.31 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



BMR70.16.30

450 kN/m max.

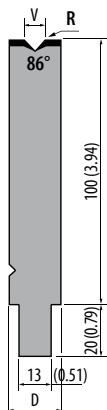


1000 mm	39.37 in	16.7 kg
500 mm	19.68 in	8.3 kg
1100 mm segmented	43.31 in segmented	16.2 kg

42Cr: 900-1150 N/mm²



86° Dies, H=100 (3.94)



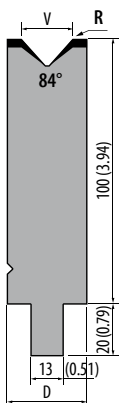
Individual drawings,
available lengths
see pages 101-103

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



42Cr: 900-1150 N/mm²

84° Dies, H=100 (3.94)



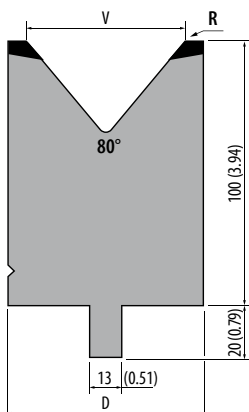
Individual drawings,
available lengths
see pages 103-104

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

42Cr: 900-1150 N/mm²



80° Dies, H=100 (3.94) / H=120 (4.72)



Individual drawings,
available lengths
see page 105

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

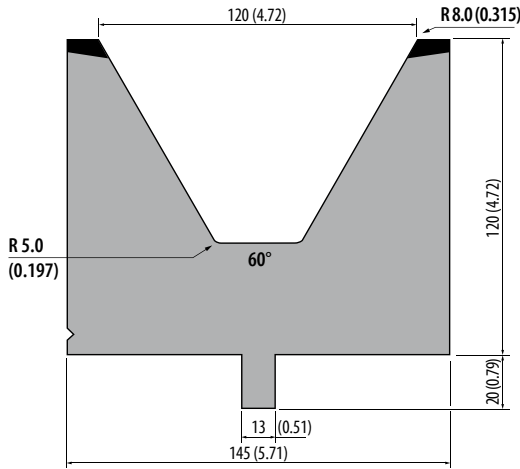
42Cr: 900-1150 N/mm²



R3 ROLLER TYPE R3

Dies, H=100 (3.94) / H=120 (4.72) / H=150 (5.91)

60° Die, H=120 (4.72)



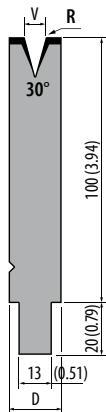
Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR120.120.60	120	4.72	8.0	0.31	145	5.71	1000

42Cr: 900-1150 N/mm²



Individual drawings,
available lengths
see page 106

30° Dies, H=100 (3.94)



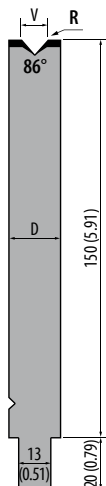
Individual drawings,
available lengths
see pages 106-108

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

42Cr: 900-1150 N/mm²



86° Dies, H=150 (5.91)



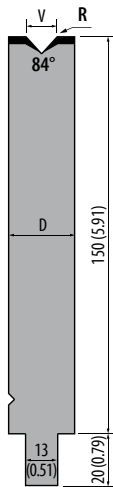
Individual drawings,
available lengths
see pages 109-110

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

42Cr: 900-1150 N/mm²



84° Dies, H=150 (5.91)

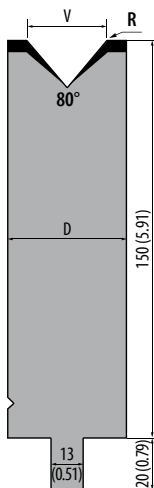


Individual drawings,
available lengths
see pages 110-111

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

42Cr: 900-1150 N/mm²

80° Dies, H=150 (5.91)

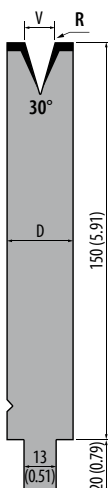


Individual drawings,
available lengths
see page 112

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

42Cr: 900-1150 N/mm²

30° Dies, H=150 (5.91)



Individual drawings,
available lengths
see pages 113-114

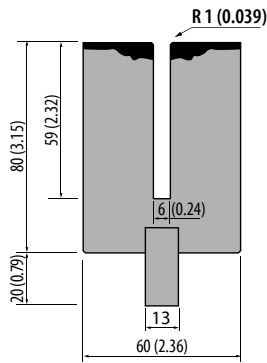
Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.30	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.30	8	0.31	1.0	0.04	20	0.79	400
TMR150.10.30	10	0.39	1.0	0.04	20	0.79	400
TMR150.12.30	12	0.47	1.0	0.04	25	0.98	400
TMR150.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR150.20.30	20	0.79	2.0	0.08	35	1.38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

42Cr: 900-1150 N/mm²

R3 ROLLER TYPE R3

Hemming Dies

BPR.SM.195.28.6



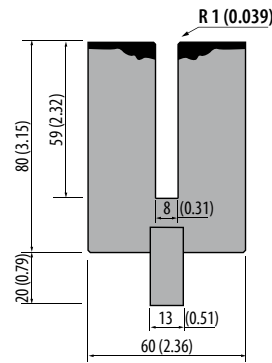
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



Only for thin material!
Hemming punches see page 126

BPR.SM.195.28.8

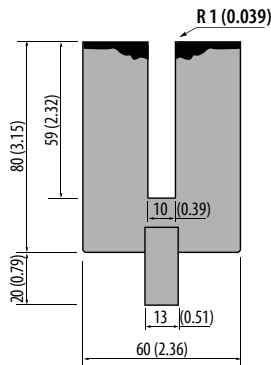


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.10

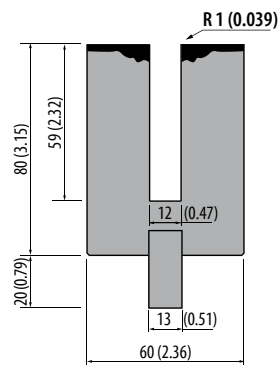


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.12

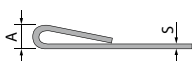


525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	10.8 kg

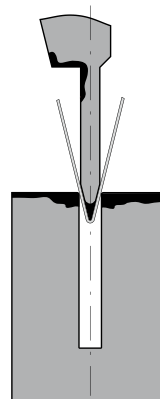
42Cr: 900-1150 N/mm²



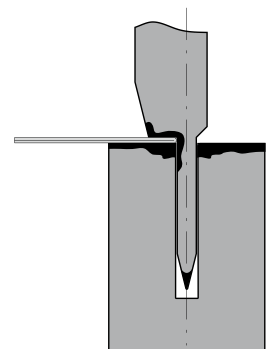
Example of Application



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



500 kN/m max.



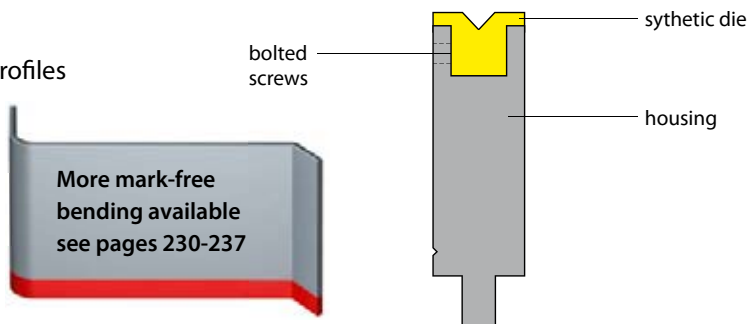
1000 kN/m max.

Our Advantages – Your Convenience

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

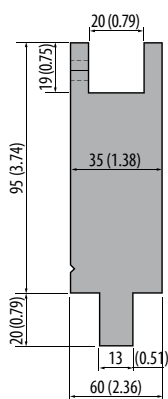
Mounting example

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



TMN95.20

1000 kN/m max.



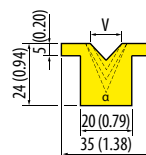
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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



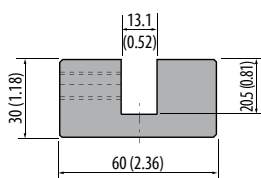
Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

Die Adapters

AD6

1000 kN/m max.



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

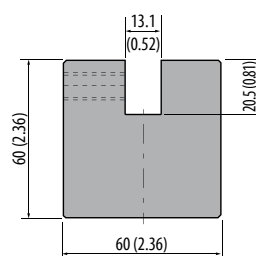
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD5

1000 kN/m max.



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

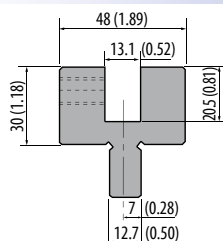
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.



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

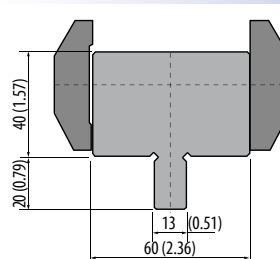
Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD7

1000 kN/m max.



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

Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²



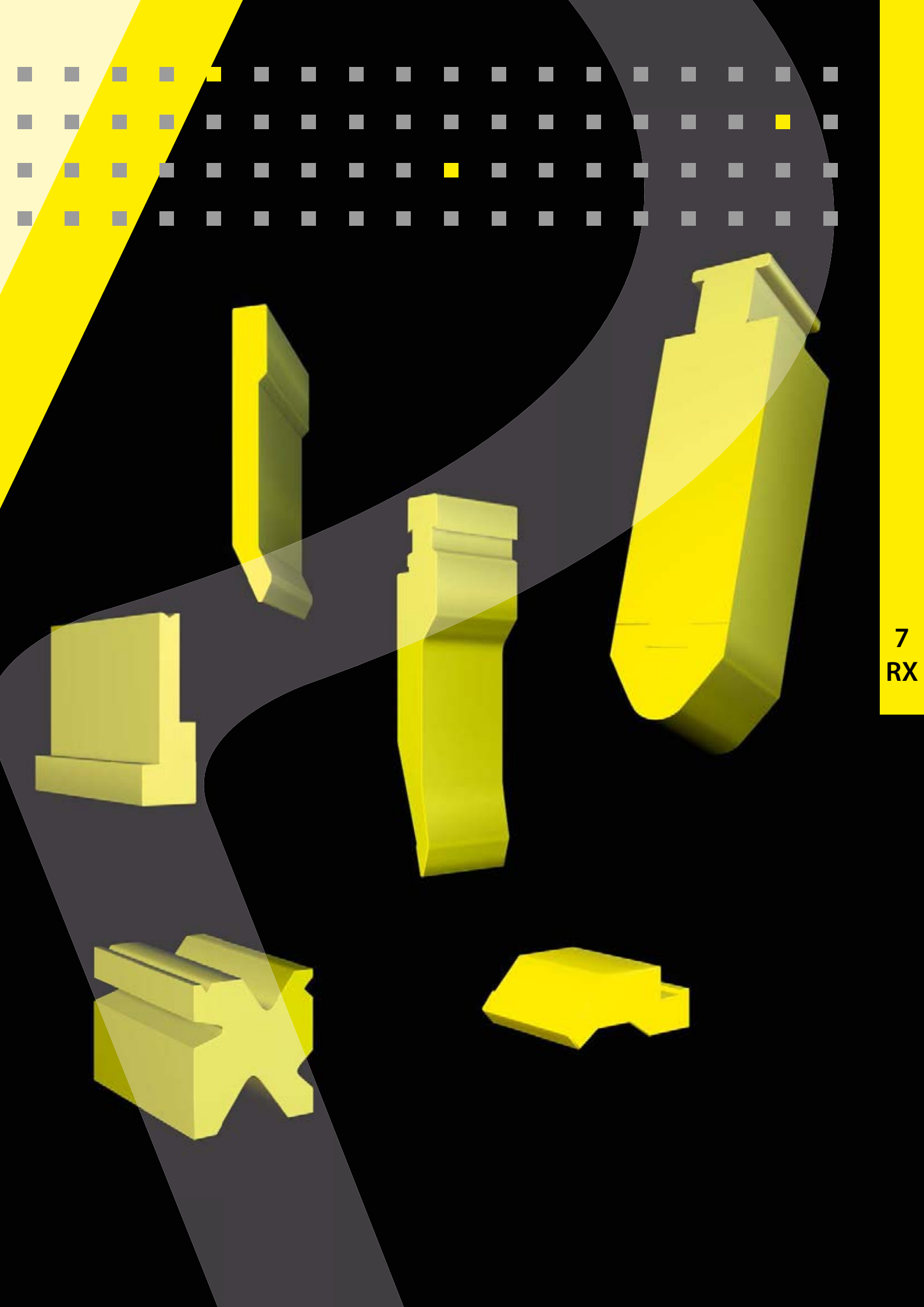
TOOLS ROLLERI TYPE RX

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Weinbrenner: Explanation	153
American: Explanation	154
American: Punches and Dies	154 - 157
Gasparini: Explanation	158
Gasparini: Radius Tools and Punches	158 - 160
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Compatibility

Tools Rolleri Type RX are **compatible** with press brake machines from: EHT, Weinbrenner, American, Gasparini, Ajial-Axial, Colgar, LVD, Colly, Hämmerle-Bystronic, etc.

With Adapter-Systems the tools Rolleri Type RX are also applicable on all other press brake machines.



Compatibility

Tools Rolleri Type RX are:

- **compatible** with press brake machines from: EHT, Weinbrenner, American, Gasparini, Ajial-Axial, Colgar, LVD, Colly, Hämmerle-Bystronic, etc.
- **with Adapter-Systems** (see pages 218-229) also applicable on all other press brake machines.

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modification possible (see pages 256-261)
- very large stock availability

Material

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

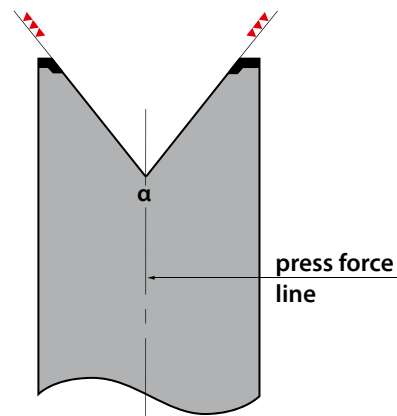
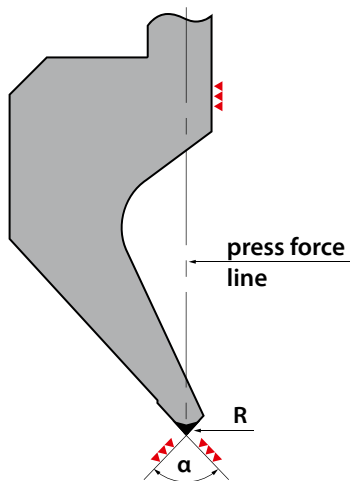
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

Punches Rolleri R Type have various tangs.

Indications of precision ground areas:

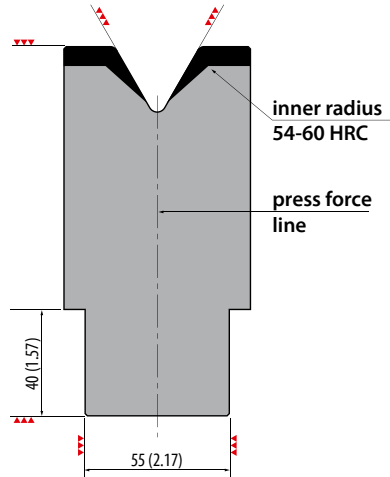
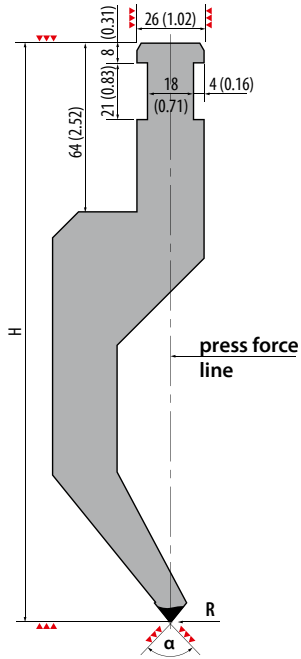


Tool lengths, sectionings and horn types

- tools Rolleri type RX are available in any length
- customized sectioning available upon your measurements
- customized horn pieces available upon request

Explanation

We produce for you the Tools Rolleri Type RX EHT in a vast variety – custom, fast, economic and with precision.

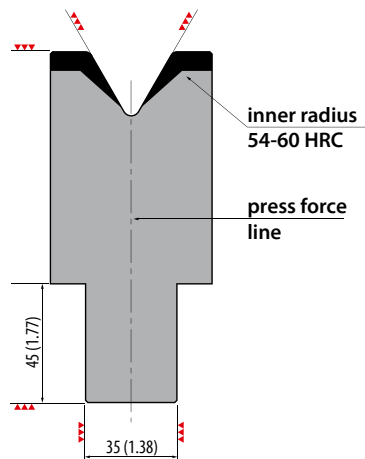
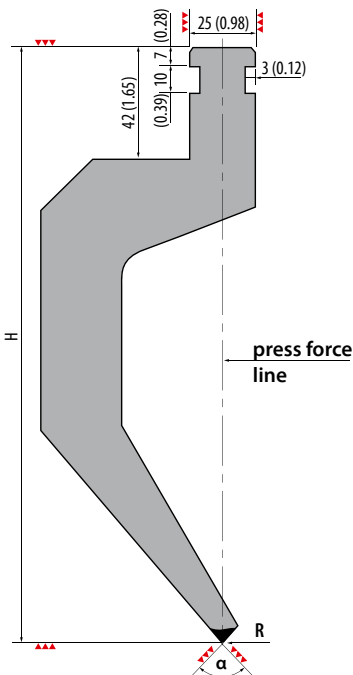


Adapters for Rolleri
Type RX EHT
see pages 221-228

Weinbrenner

Explanation

We produce for you the Tools Rolleri Type RX Weinbrenner in a vast variety – custom, fast, economic and with precision.



Adapters for Rolleri
Type RX Weinbrenner
see pages 221-229

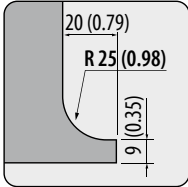
Tool lengths, sectionings and horn types

Punches:

- 838 mm (33 in)
- 415 mm (16.34 in)
- 805 mm (31.69 in) segmented
9 segments (100 Horn left, 100, 50, 40, 20, 15, 10, 370, 100 Horn right)

Dies:

- 838 mm (33 in)
- 415 mm (16.34 in)
- 805 mm (31.69 in) segmented
8 segments (200, 50, 40, 20, 15, 10, 370, 100)

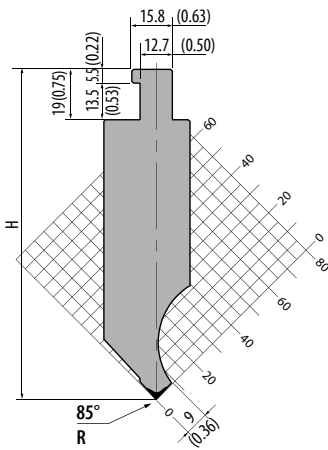


Standard-Horn Type
for all segmented
Punches Roller
Type RX American

Punches American

ASP-135

900 kN/m max.



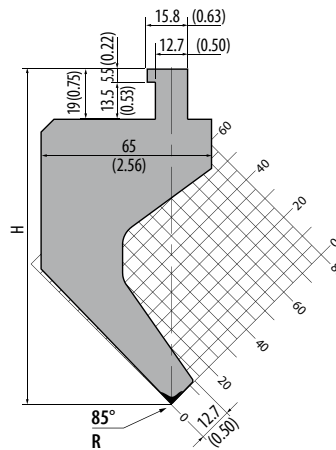
C45: 560-710 N/mm²



ASP-135-16	H=125 (4.92) / R=0.4 (0.016)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-31	H=125 (4.92) / R=0.8 (0.031)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-62	H=124.5 (4.90) / R=1.6 (0.062)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-125	H=123.8 (4.87) / R=3.2 (0.125)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg

ASP-24

700 kN/m max.



42Cr: 900-1150 N/mm²

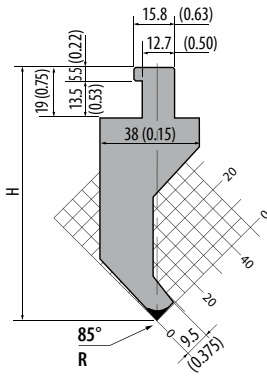


ASP-24-16	H=127 (5.00) / R=0.4 (0.016)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
ASP-24-31	H=127 (5.00) / R=0.8 (0.031)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
ASP-24-62	H=126.5 (4.98) / R=1.6 (0.062)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
ASP-24-125	H=125.9 (4.96) / R=3.2 (0.125)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg

Please find the
Punch Adapters in
the adapter chapter
on page 223

ASP-9

660 kN/m max.

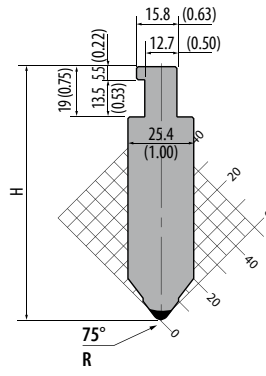


42Cr: 900-1150 N/mm²

ASP-9-16		H=96 (3.78) / R=0.4 (0.016)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	
ASP-9-31		H=96 (3.78) / R=0.8 (0.031)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	
ASP-9-63		H=95.5 (3.76) / R=1.6 (0.062)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	
ASP-9-125		H=94.8 (3.73) / R=3.2 (0.125)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	

ASP-15

1000 kN/m max.

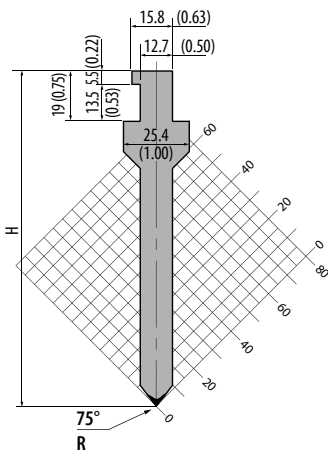


42Cr: 900-1150 N/mm²

ASP-15-16		H=95.9 (3.78) / R=0.4 (0.016)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-31		H=95.9 (3.78) / R=0.8 (0.031)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-63		H=95.9 (3.78) / R=1.6 (0.063)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-98		H=95.9 (3.78) / R=2.5 (0.098)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-125		H=96 (3.78) / R=3.2 (0.125)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	

ASP-14

1000 kN/m max.

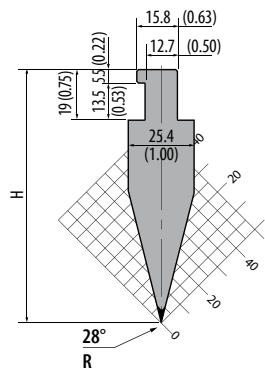


42Cr: 900-1150 N/mm²

ASP-14-16		H=127 (5.00) / R=0.4 (0.016)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-14-31		H=127 (5.00) / R=0.8 (0.031)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-14-62		H=126.5 (4.98) / R=1.6 (0.062)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-14-125		H=126 (4.96) / R=3.2 (0.125)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	

ASP-18

1000 kN/m max.

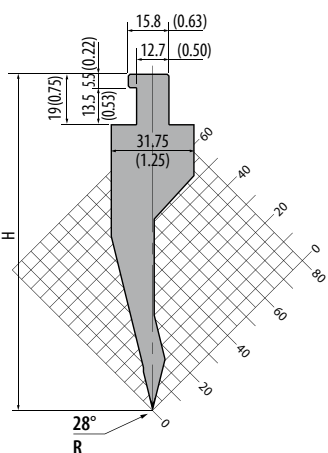


42Cr: 900-1150 N/mm²

ASP-18-31		H=96 (3.78) / R=0.8 (0.031)	
838 mm	33.00 in	10.9 kg	
415 mm	16.34 in	5.4 kg	
805 mm segmented	31.69 in segmented	10.5 kg	
ASP-18-62		H=93.4 (3.68) / R=1.6 (0.062)	
838 mm	33.00 in	10.9 kg	
415 mm	16.34 in	5.4 kg	
805 mm segmented	31.69 in segmented	10.5 kg	
ASP-18-125		H=87.5 (3.44) / R=3.2 (0.125)	
838 mm	33.00 in	10.9 kg	
415 mm	16.34 in	5.4 kg	
805 mm segmented	31.69 in segmented	10.5 kg	

ASP-19

860 kN/m max.

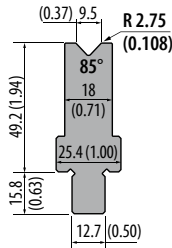


ASP-19-31		H=127 (5.00) / R=0.8 (0.031)	
838 mm	33.00 in	13.8 kg	
415 mm	16.34 in	6.8 kg	
805 mm segmented	31.69 in segmented	13.3 kg	
ASP-19-62		H=124.5 (4.90) / R=1.6 (0.062)	
838 mm	33.00 in	13.8 kg	
415 mm	16.34 in	6.8 kg	
805 mm segmented	31.69 in segmented	13.3 kg	
ASP-19-125		H=118.5 (4.67) / R=3.2 (0.125)	
838 mm	33.00 in	13.8 kg	
415 mm	16.34 in	6.8 kg	
805 mm segmented	31.69 in segmented	13.3 kg	

42Cr: 900-1150 N/mm²

ASD-85-375

1000 kN/m max.



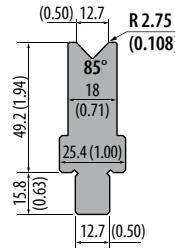
838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm²



ASD-85-500

1000 kN/m max.



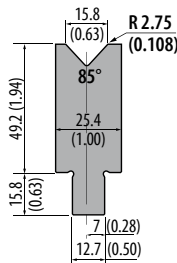
838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm²



ASD-85-625

1000 kN/m max.



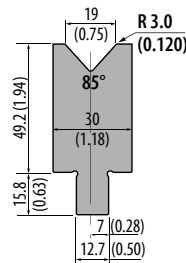
838 mm	33.00 in	9.2 kg
415 mm	16.34 in	4.6 kg
805 mm segmented	31.69 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



ASD-85-750

1080 kN/m max.



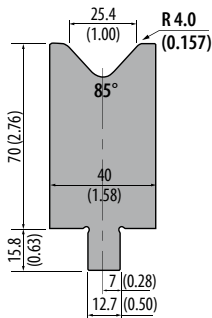
838 mm	33.00 in	10.5 kg
415 mm	16.34 in	5.2 kg
805 mm segmented	31.69 in segmented	10.1 kg

42Cr: 900-1150 N/mm²



ASD-85-100

950 kN/m max.



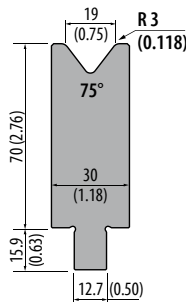
838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	19.9 kg

42Cr: 900-1150 N/mm²



ASD-75-750

1000 kN/m max.



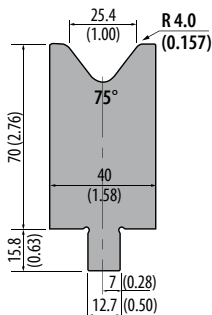
838 mm	33.00 in	14.7 kg
415 mm	16.34 in	7.3 kg
805 mm segmented	31.69 in segmented	14.1 kg

C45: 560-710 N/mm²



ASD-75-100

950 kN/m max.



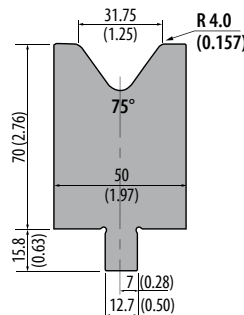
838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

C45: 560-710 N/mm²



ASD-75-125

1000 kN/m max.



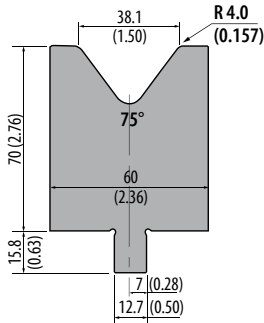
838 mm	33.00 in	22.2 kg
415 mm	16.34 in	11.0 kg
805 mm segmented	31.69 in segmented	21.3 kg

C45: 560-710 N/mm²



ASD-75-150

1000 kN/m max.



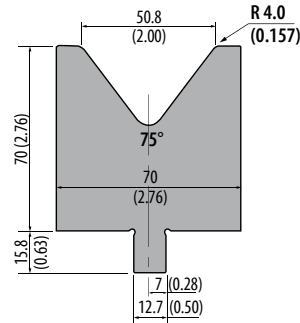
838 mm	33.00 in	25.6 kg
415 mm	16.34 in	12.7 kg
805 mm segmented	31.69 in segmented	24.6 kg

C45: 560-710 N/mm²



ASD-75-200

1000 kN/m max.



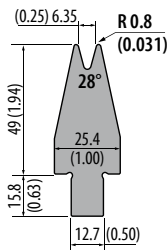
838 mm	33.00 in	27.7 kg
415 mm	16.34 in	13.7 kg
805 mm segmented	31.69 in segmented	25.6 kg

C45: 560-710 N/mm²



ASD-28-250

450 kN/m max.



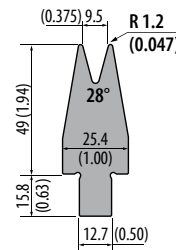
838 mm	33.00 in	7.2 kg
415 mm	16.34 in	3.6 kg
805 mm segmented	31.69 in segmented	6.9 kg

42Cr: 900-1150 N/mm²



ASD-28-375

600 kN/m max.



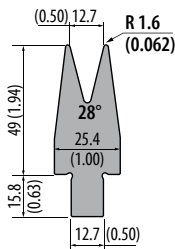
838 mm	33.00 in	7.8 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.5 kg

42Cr: 900-1150 N/mm²



ASD-28-500

860 kN/m max.



838 mm	33.00 in	8.4 kg
415 mm	16.34 in	4.2 kg
805 mm segmented	31.69 in segmented	8.1 kg

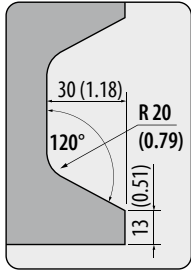
42Cr: 900-1150 N/mm²



Tool lengths, sectionings and horn types

Punches:

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 500 mm (19.68 in) segmented
3 segments (100 Horn left, 300, 100 Horn right)



Standard-Horn Type
for all segmented
Punches Roller
Type RX Gasparini

Radius Tools Holder:

- 522 mm (20.55 in)
- 563 mm (22.17 in) segmented
9 segments (42, 47, 52, 57, 62, 67, 72, 77, 87)
- 491 mm (19.33 in) segmented
3 segments (97, 297, 97)

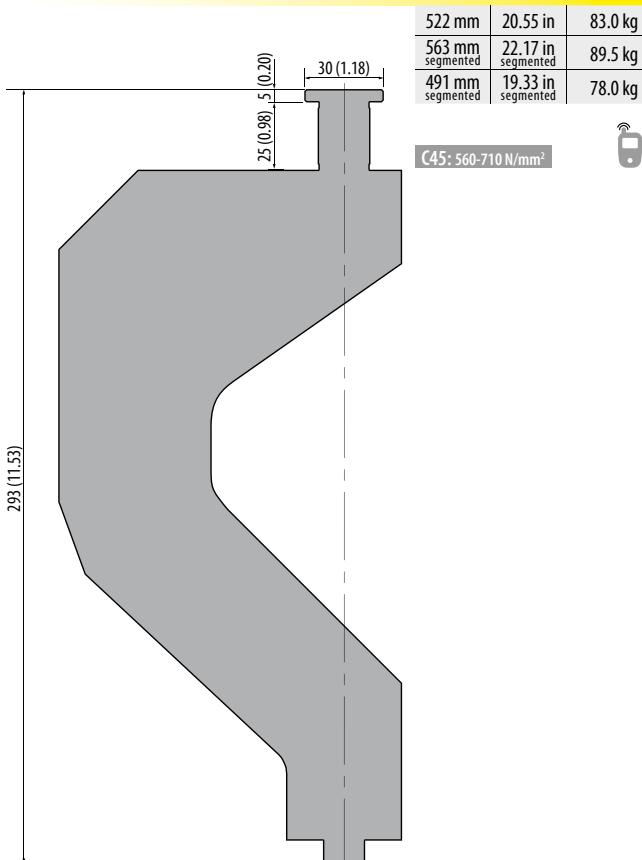
Radius Tools:

- 525 mm (20.67 in)
- 590 mm (23.23 in) segmented
9 segments (45, 50, 55, 60, 65, 70, 75, 80, 90)
- 500 mm (19.68 in) segmented
3 segments (100, 300, 100)

Radius Tools Gasparini

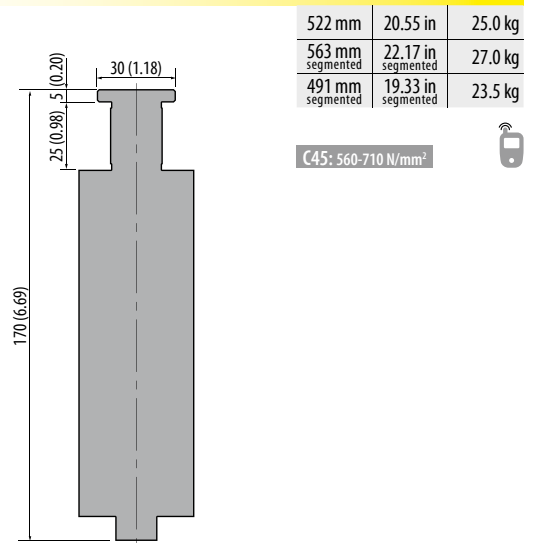
GASP293-16

1000 kN/m max.



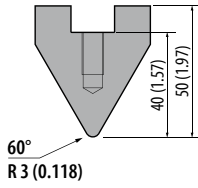
GASP170-16

1800 kN/m max.



GASP40.60.03

1000 kN/m max.



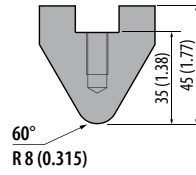
525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²



GASP35.60.08

1000 kN/m max.



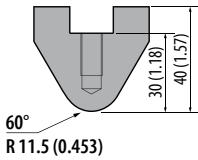
525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²



GASP30.60.11.5

1000 kN/m max.



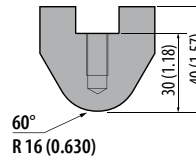
525 mm	20.67 in	4.2 kg
590 mm segmented	23.23 in segmented	4.7 kg
500 mm segmented	19.68 in segmented	4.0 kg

C45: 560-710 N/mm²



GASP30.60.16

1000 kN/m max.



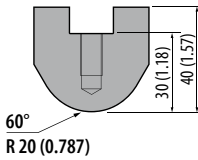
525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²



GASP30.60.20

1000 kN/m max.



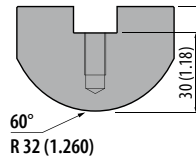
525 mm	20.67 in	5.0 kg
590 mm segmented	23.23 in segmented	5.6 kg
500 mm segmented	19.68 in segmented	4.3 kg

C45: 560-710 N/mm²



GASP30.60.32

1000 kN/m max.



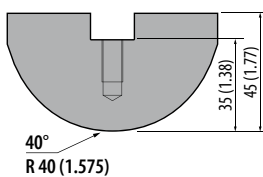
525 mm	20.67 in	7.0 kg
590 mm segmented	23.23 in segmented	7.8 kg
500 mm segmented	19.68 in segmented	6.7 kg

C45: 560-710 N/mm²



GASP35.40.40

1500 kN/m max.



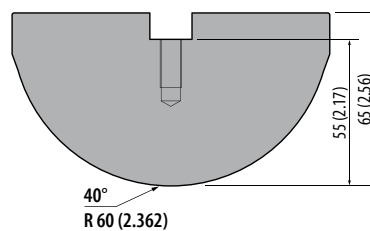
525 mm	20.67 in	10.5 kg
590 mm segmented	23.23 in segmented	11.8 kg
500 mm segmented	19.68 in segmented	10.0 kg

C45: 560-710 N/mm²



GASP55.40.60

1800 kN/m max.



525 mm	20.67 in	24.4 kg
590 mm segmented	23.23 in segmented	27.4 kg
500 mm segmented	19.68 in segmented	23.2 kg

C45: 560-710 N/mm²



7
RX



Article on stock



Please ask for delivery time!

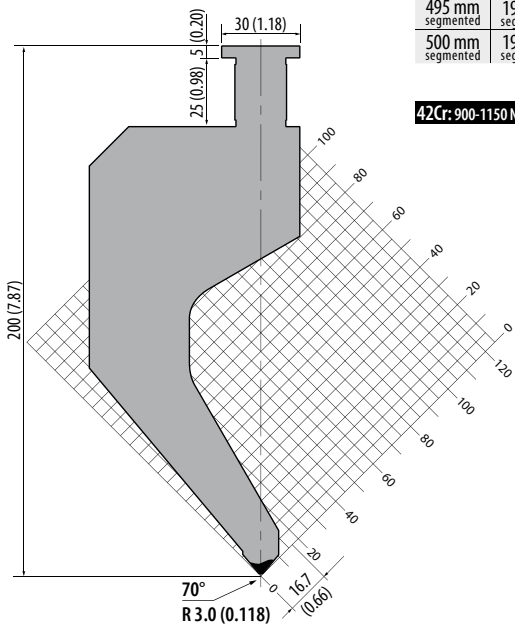
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

GASP200.70.R3-30

1000 kN/m max.



525 mm	20.67 in	31.8 kg
495 mm segmented	19.49 in segmented	30.0 kg
500 mm segmented	19.68 in segmented	30.3 kg

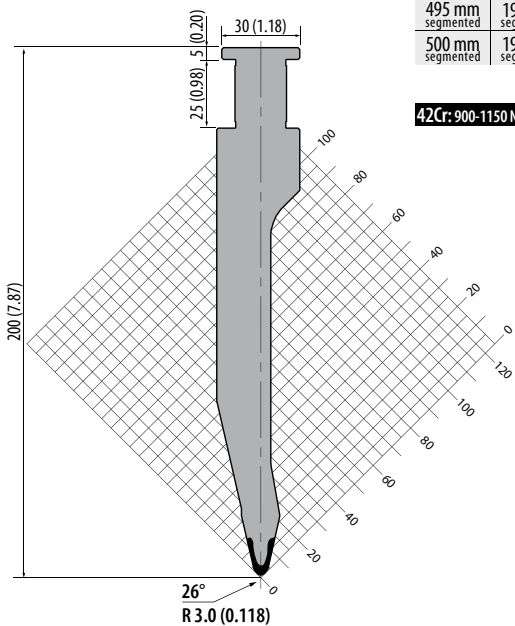
42Cr: 900-1150 N/mm²



Many more tools available for Heavy Duty on pages 242-243

GASP200.26.R3-30

1300 kN/m max.



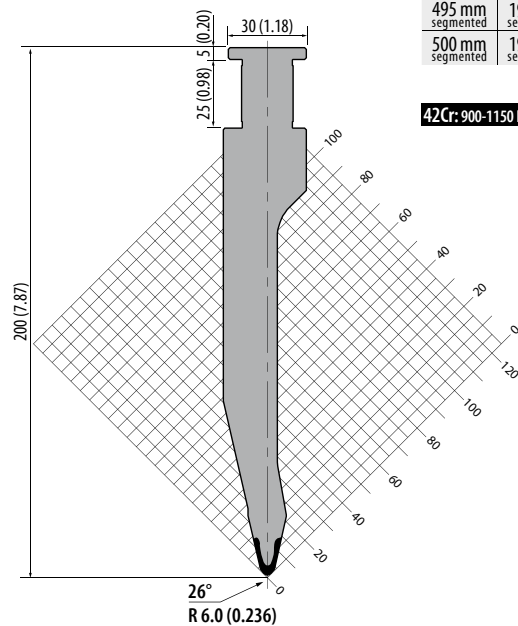
525 mm	20.67 in	16.9 kg
495 mm segmented	19.49 in segmented	10.6 kg
500 mm segmented	19.68 in segmented	10.7 kg

42Cr: 900-1150 N/mm²



GASP200.26.R6-30

1300 kN/m max.



525 mm	20.67 in	16.9 kg
495 mm segmented	19.49 in segmented	10.6 kg
500 mm segmented	19.68 in segmented	10.7 kg

42Cr: 900-1150 N/mm²

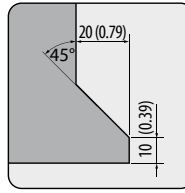


Many more tools available upon request.
Compatible adapters see pages 221 and 225

Tool lengths, sectionings and horn types

Punches:

- 1020 mm (40.16 in)
- 990 mm (38.98 in) segmented
9 segments (100 Horn left, 500, 100, 50, 45, 40, 35, 20, 100 Horn right)

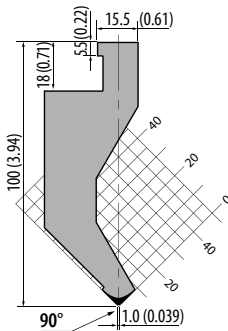


Standard-Horn Type
for all segmented
Punches Roller
Type RX Ajial-Axial

Punches Ajial-Axial

AXP.100.90.1

1000 kN/m max.



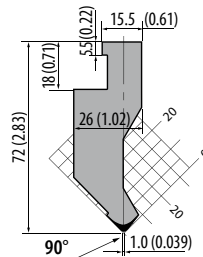
1020 mm	40.16 in	16.3 kg
990 mm segmented	38.98 in segmented	15.8 kg

C45: 560-710 N/mm²



AXP.72.90.1

1000 kN/m max.



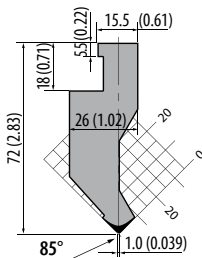
1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm²



AXP.72.85.1

1000 kN/m max.



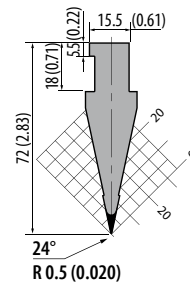
1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm²



AXP.72.24.R05

1000 kN/m max.



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

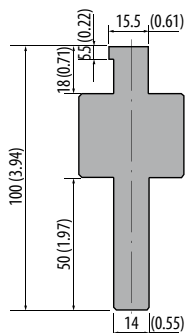
C45: 560-710 N/mm²



Adapters Ajial-Axial

AD15

1000 kN/m max.



150 mm	5.91 in	4.0 kg
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Rolleri Type RX Ajial-Axial
→ **Rolleri Type R1**

C45: 560-710 N/mm²

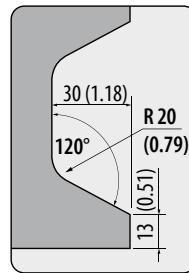


More Punches and Dies
available upon request.
Compatible Adapter
see pages 225

Tool lengths, sectionings and horn types

Punches:

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 500 mm (19.68 in) segmented
3 segments (100 Horn left, 300, 100 Horn right)

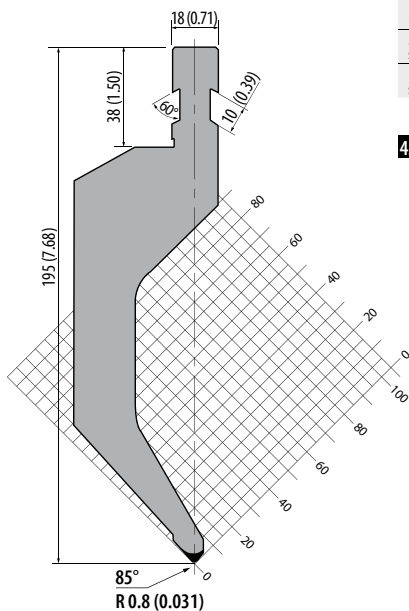


Standard-Horn Type
for all segmented
Punches Roller
Type RX Colgar

Punches and Radius Tools Colgar

PAC195.85.R08

1000 kN/m max.



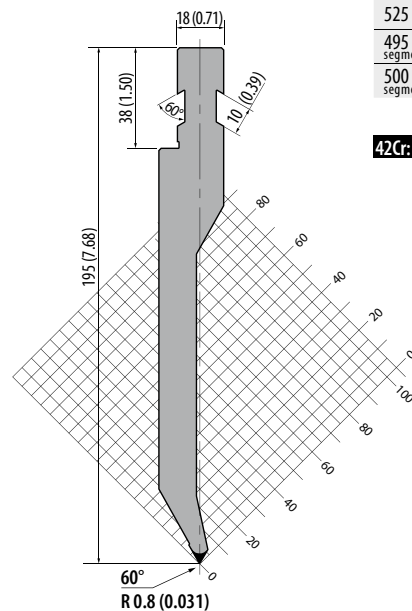
525 mm	20.67 in	20.6 kg
495 mm segmented	19.49 in segmented	19.4 kg
500 mm segmented	19.68 in segmented	19.6 kg

42Cr: 900-1150 N/mm²



PAC195.60.R08

1000 kN/m max.



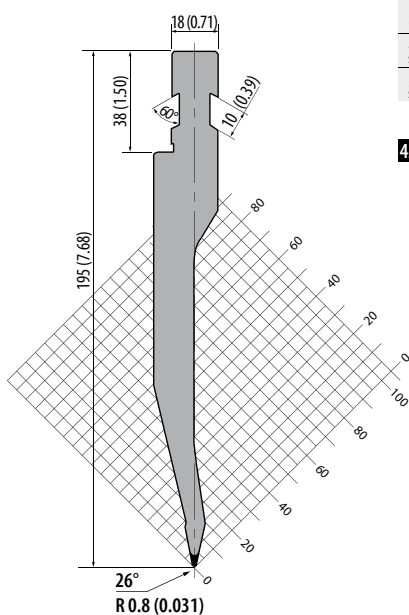
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



PAC195.26.R08

1000 kN/m max.



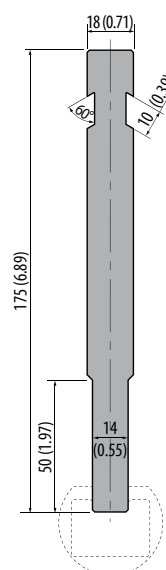
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



PAC175.14

1000 kN/m max.



830 mm	32.68 in	18.0 kg
412 mm	16.22 in	9.0 kg

C45: 560-710 N/mm²



Compatible
Radius holders
see page 33

More Punches and Dies
available upon request.
Compatible adapter
see pages 221, 224

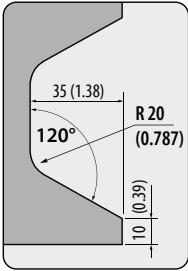
Tool lengths, sectionings and horn types

Punches:

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented
9 segments
(100 Horn left, 25, 30, 35, 40, 45, 50, 125, 100 Horn right)
- 2x 250 mm (9.84 in) segmented

Dies:

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented
9 segments (25, 25, 30, 35, 40, 45, 50, 100, 200)
- 2x 250 mm (9.84 in) segmented



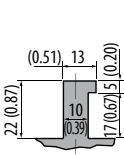
Standard-Horn Type
for all segmented
Punches Roller
Type RX LVD

Hemming Tools:

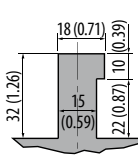
- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 2x 250 mm (9.84 in) segmented

Punch Tangs

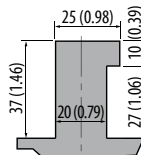
Punches LVD have the following
5 different tangs



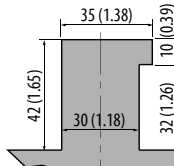
Tang A



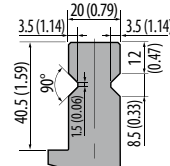
Tang B



Tang C

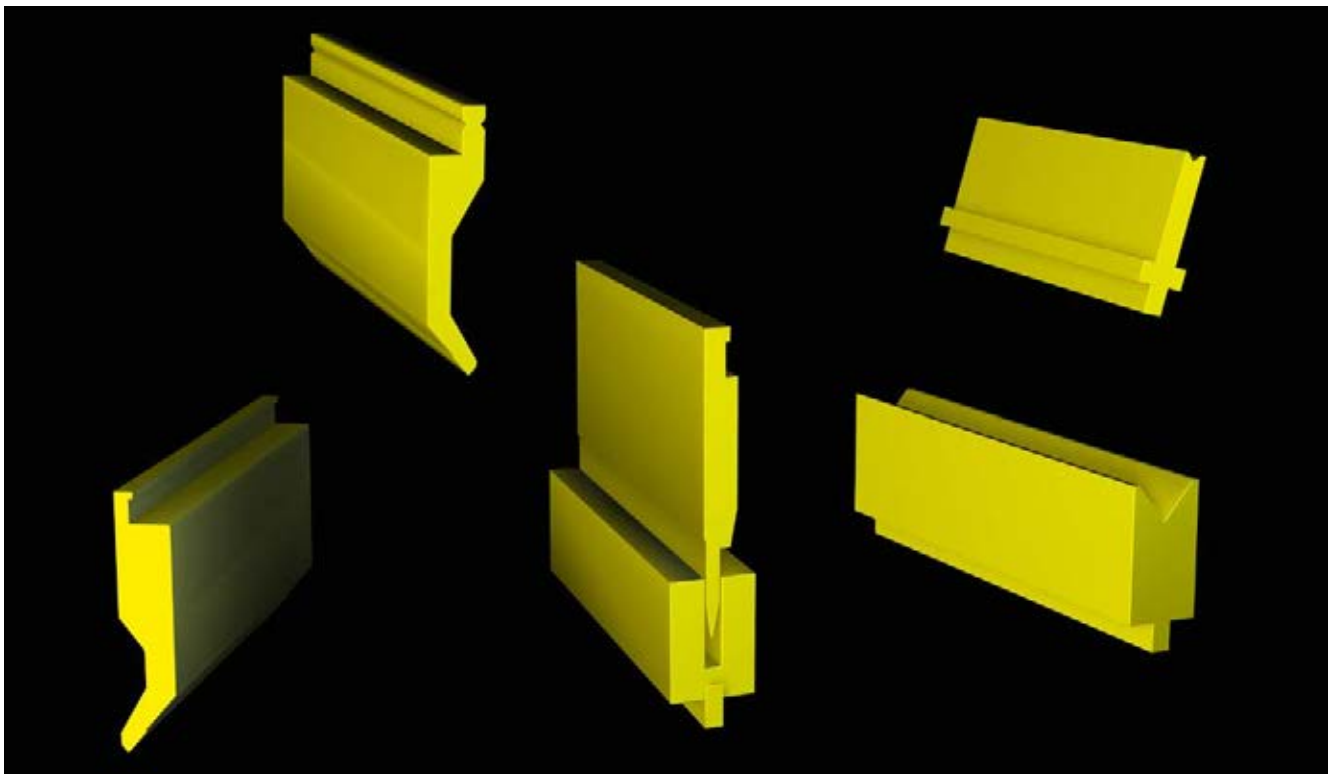


Tang D



Tang W

7
RX



Article on stock



Please ask for delivery time!

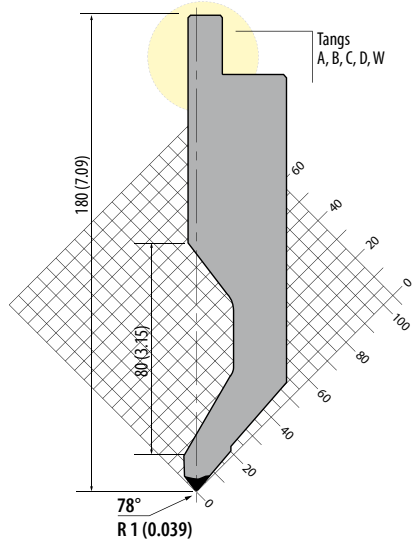
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

LP180.78.R1-A

700 kN/m max.



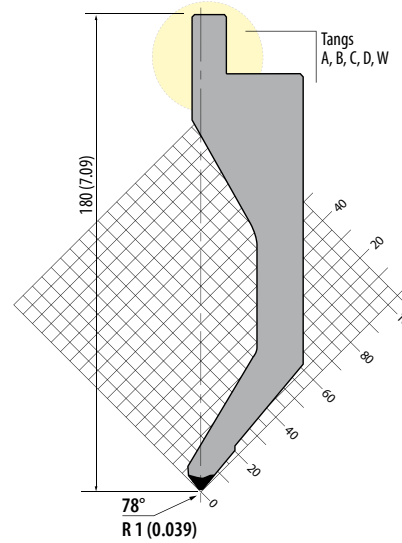
Tang A: LPA180.78.R1-A		
Tang B: LPB180.78.R1-A		
Tang C: LPC180.78.R1-A		
Tang D: LPD180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg
Tang W: LPW196.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg

42Cr: 900-1150 N/mm²



LP180.78.R1-B

450 kN/m max.



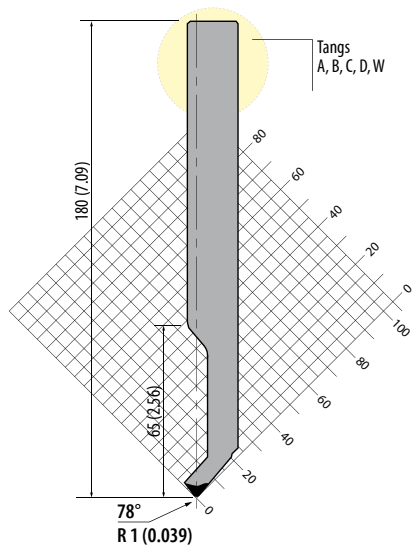
Tang A: LPA180.78.R1-B		
Tang B: LPB180.78.R1-B		
Tang C: LPC180.78.R1-B		
Tang D: LPD180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg
Tang W: LPW196.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg

42Cr: 900-1150 N/mm²



LP180.78.R1-C

500 kN/m max.



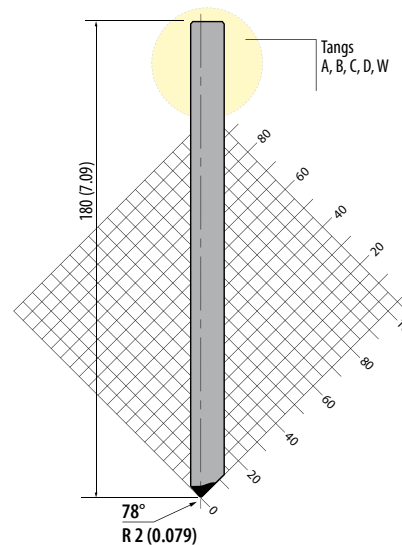
Tang A: LPA180.78.R1-C		
Tang B: LPB180.78.R1-C		
Tang C: LPC180.78.R1-C		
Tang D: LPD180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg
2x250 mm segmented	2x9.84 in segmented	10.9 kg
Tang W: LPW196.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg
2x250 mm segmented	2x9.84 in segmented	10.9 kg

42Cr: 900-1150 N/mm²



LP180.78-R2

1000 kN/m max.



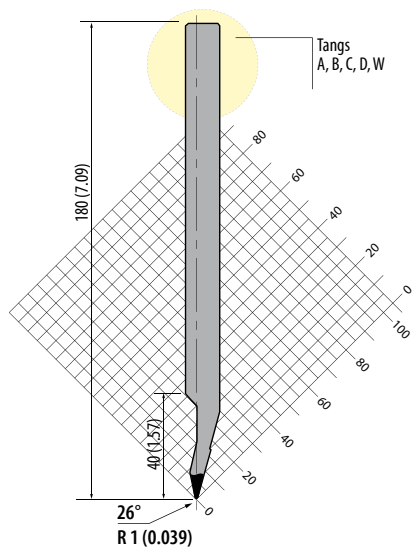
Tang A: LPA180.78-R2		
Tang B: LPB180.78-R2		
Tang C: LPC180.78-R2		
Tang D: LPD180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg
Tang W: LPW196.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



LP180.26-R1

500 kN/m max.



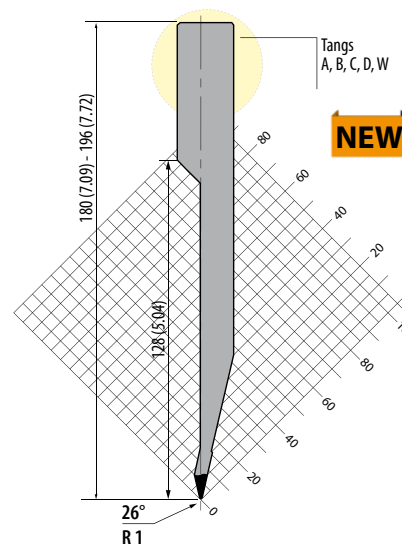
Tang A: LPA180.26-R1		
Tang B: LPB180.26-R1		
Tang C: LPC180.26-R1		
Tang D: LPD180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg
Tang W: LPW196.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



LP180.26-R1-A

400 kN/m max.



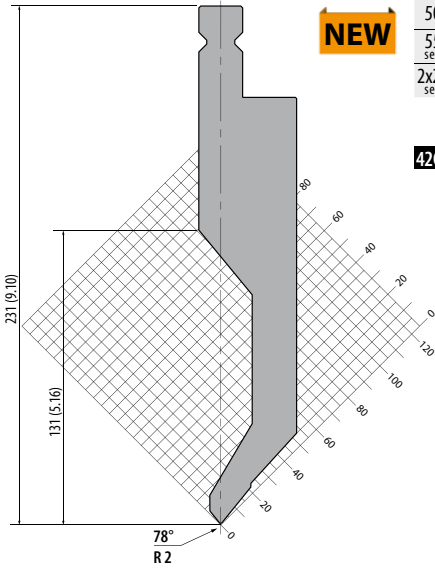
Tang A: LPA180.26-R1-A		
Tang B: LPB180.26-R1-A		
Tang C: LPC180.26-R1-A		
Tang D: LPD180.26-R1-A		
508 mm	20.00 in	12.5 kg
550 mm segmented	21.65 in segmented	13.5 kg
2x250 mm segmented	2x9.84 in segmented	12.3 kg
Tang W: LPW196.26-R1-A		
508 mm	20.00 in	12.5 kg
550 mm segmented	21.65 in segmented	13.5 kg
2x250 mm segmented	2x9.84 in segmented	12.3 kg

42Cr: 900-1150 N/mm²



LPW231.78.R2-A

800 kN/m max.



NEW

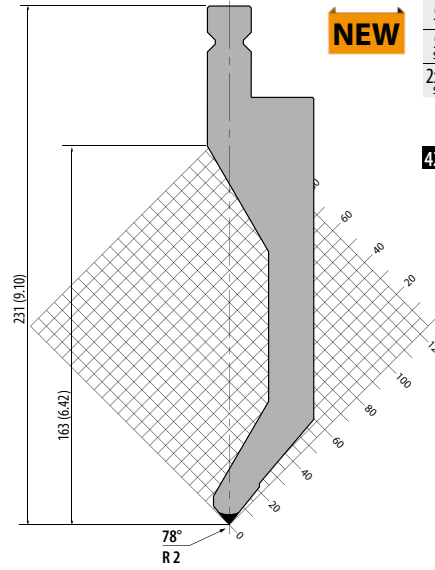
508 mm	20.00 in	27.6 kg
550 mm segmented	21.65 in segmented	29.9 kg
2x250 mm segmented	2x9.84 in segmented	27.2 kg

42Cr: 900-1150 N/mm²



LPW231.78.R2-B

750 kN/m max.



NEW

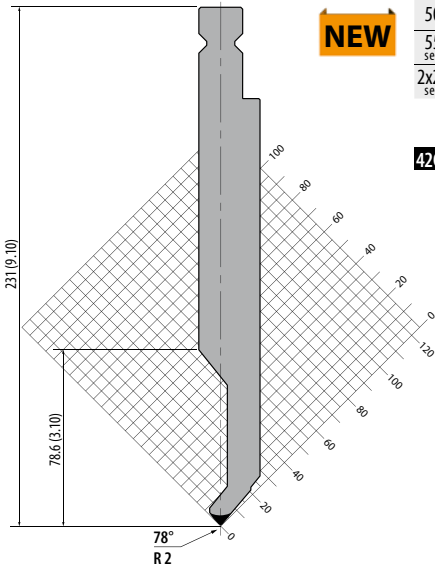
508 mm	20.00 in	23.4 kg
550 mm segmented	21.65 in segmented	25.4 kg
2x250 mm segmented	2x9.84 in segmented	23.1 kg

42Cr: 900-1150 N/mm²



LPW231.78.R2-C

500 kN/m max.



NEW

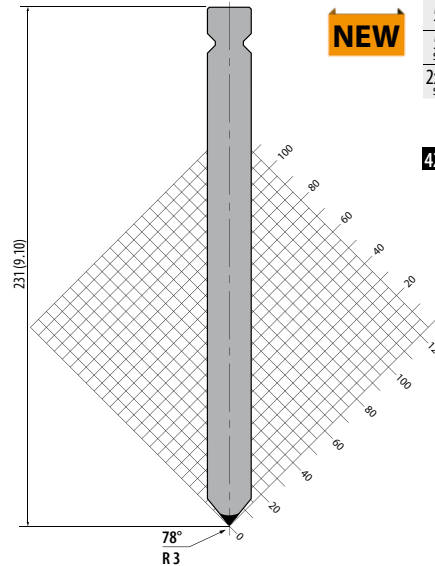
508 mm	20.00 in	19.1 kg
550 mm segmented	21.65 in segmented	20.7 kg
2x250 mm segmented	2x9.84 in segmented	18.8 kg

42Cr: 900-1150 N/mm²



LPW231.78-R3

1200 kN/m max.



NEW

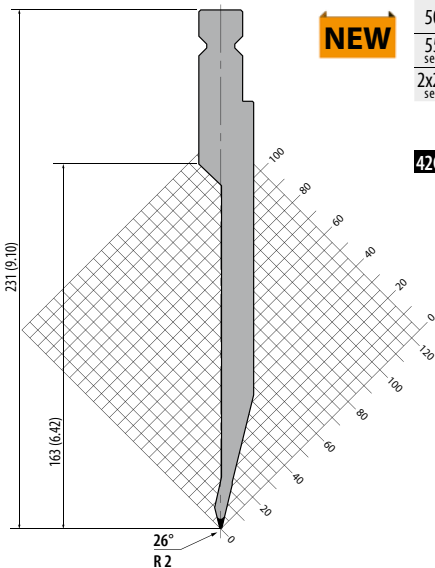
508 mm	20.00 in	18.3 kg
550 mm segmented	21.65 in segmented	19.8 kg
2x250 mm segmented	2x9.84 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



LPW231.26.R2-A

500 kN/m max.



NEW

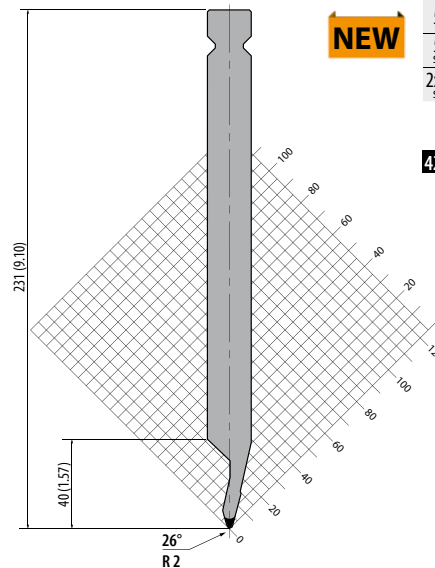
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



LPW231.26.R2

500 kN/m max.



NEW

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

42Cr: 900-1150 N/mm²



7
RX



Article on stock



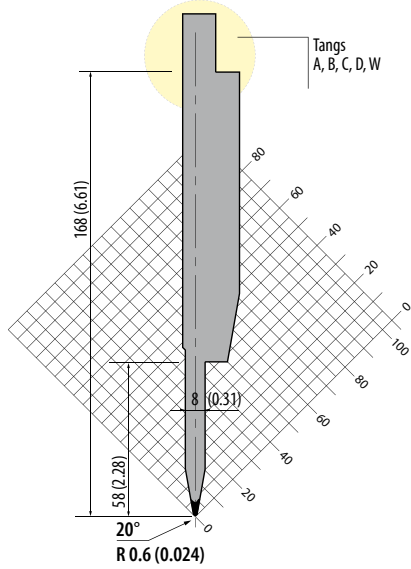
Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

LP.SP-190.20.8

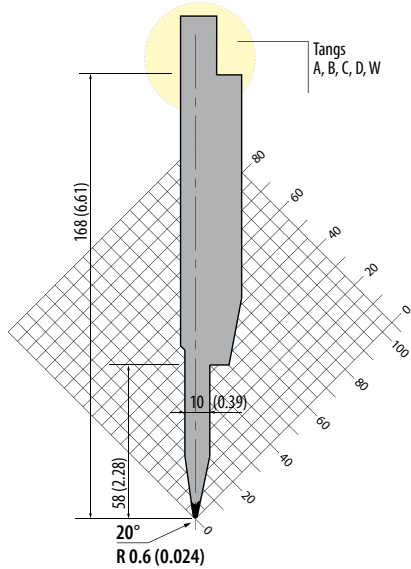


Tang A: LPA.SP-190.20.8		
Tang B: LPB.SP-190.20.8		
Tang C: LPC.SP-190.20.8		
Tang D: LPD.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg
Tang W: LPW.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg

42Cr: 900-1150 N/mm²



LP.SP-190.20.10

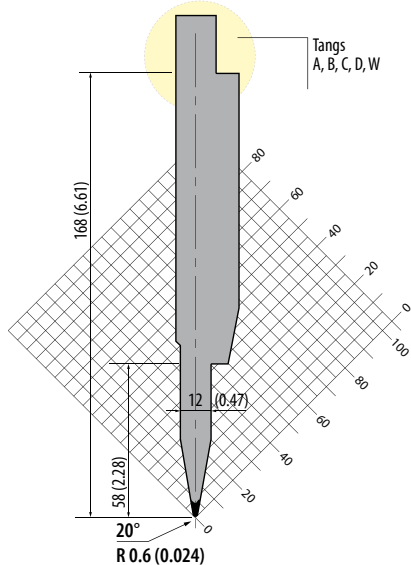


Tang A: LPA.SP-190.20.10		
Tang B: LPB.SP-190.20.10		
Tang C: LPC.SP-190.20.10		
Tang D: LPD.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg
2x250 mm segmented	2x9.84 in segmented	12.5 kg
Tang W: LPW.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg
2x250 mm segmented	2x9.84 in segmented	12.5 kg

42Cr: 900-1150 N/mm²



LP.SP-190.20.12

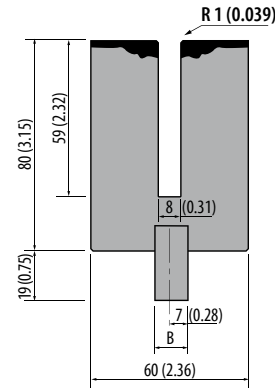


Tang A: LPA.SP-190.20.12		
Tang B: LPB.SP-190.20.12		
Tang C: LPC.SP-190.20.12		
Tang D: LPD.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg
2x250 mm segmented	2x9.84 in segmented	13.0 kg
Tang W: LPW.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg
2x250 mm segmented	2x9.84 in segmented	13.0 kg

42Cr: 900-1150 N/mm²



LP.SM-190.20.8-12.7 / -12

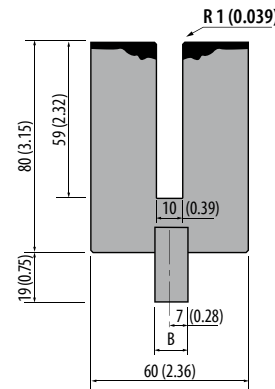


B=12.7 mm		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg
2x250 mm segmented	2x9.84 in segmented	17.8 kg
B=12 mm		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg
2x250 mm segmented	2x9.84 in segmented	17.8 kg

42Cr: 900-1150 N/mm²



LP.SM-190.20.10-12.7 / -12

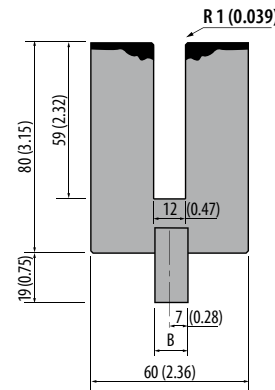


B=12.7 mm		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg
2x250 mm segmented	2x9.84 in segmented	17.4 kg
B=12 mm		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg
2x250 mm segmented	2x9.84 in segmented	17.4 kg

42Cr: 900-1150 N/mm²



LP.SM-190.20.12-12.7 / -12

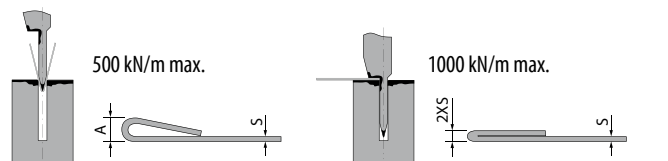


B=12.7 mm		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg
2x250 mm segmented	2x9.84 in segmented	16.9 kg
B=12 mm		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg
2x250 mm segmented	2x9.84 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



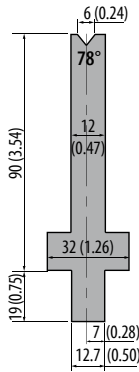
Example of Application



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

LM90.06.78

400 kN/m max.



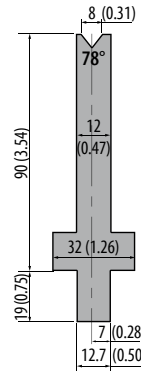
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.08.78

400 kN/m max.



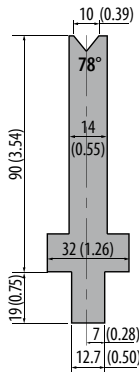
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.10.78

500 kN/m max.



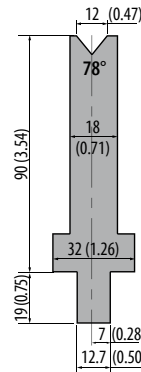
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.5 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.12.78

600 kN/m max.



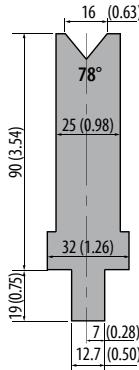
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.7 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.16.78

800 kN/m max.



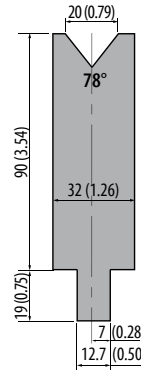
508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg
2x250 mm segmented	2x9.84 in segmented	9.9 kg

42Cr: 900-1150 N/mm²



LM90.20.78

1000 kN/m max.



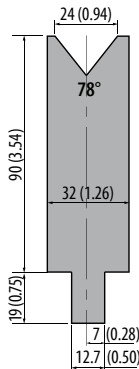
508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.8 kg
2x250 mm segmented	2x9.84 in segmented	11.8 kg

42Cr: 900-1150 N/mm²



LM90.24.78

1000 kN/m max.



508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg
2x250 mm segmented	2x9.84 in segmented	9.9 kg

42Cr: 900-1150 N/mm²



LM90.30.78

1100 kN/m max.



508 mm	20.00 in	12.0 kg
550 mm segmented	21.65 in segmented	13.0 kg
2x250 mm segmented	2x9.84 in segmented	11.8 kg

42Cr: 900-1150 N/mm²



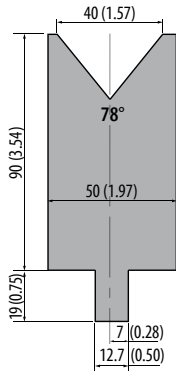
7
RX

RX ROLLER TYPE RX

Dies 78° LVD, H=90 mm

LM90.40.78

1300 kN/m max.



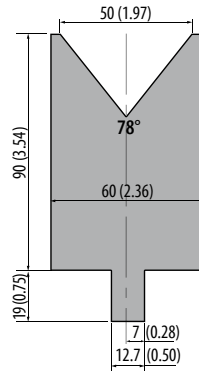
508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg

42Cr: 900-1150 N/mm²



LM90.50.78

1500 kN/m max.



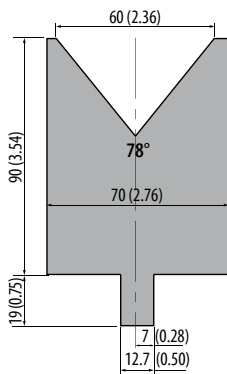
508 mm	20.00 in	19.5 kg
550 mm segmented	21.65 in segmented	21.0 kg
2x250 mm segmented	2x9.84 in segmented	19.2 kg

42Cr: 900-1150 N/mm²



LM90.60.78

1500 kN/m max.



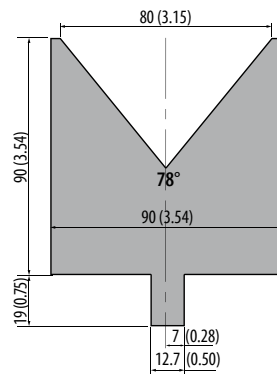
508 mm	20.00 in	23.0 kg
550 mm segmented	21.65 in segmented	24.9 kg
2x250 mm segmented	2x9.84 in segmented	22.7 kg

42Cr: 900-1150 N/mm²



LM90.80.78

1500 kN/m max.



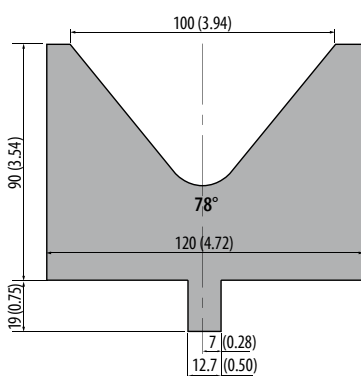
508 mm	20.00 in	25.5 kg
550 mm segmented	21.65 in segmented	27.6 kg
2x250 mm segmented	2x9.84 in segmented	25.1 kg

42Cr: 900-1150 N/mm²



LM90.100.78

1200 kN/m max.



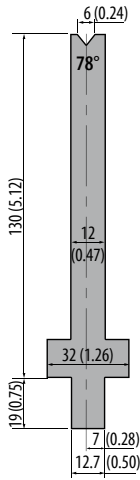
508 mm	20.00 in	31.0 kg
550 mm segmented	21.65 in segmented	33.5 kg
2x250 mm segmented	2x9.84 in segmented	30.6 kg

42Cr: 900-1150 N/mm²



LM130.06.78

400 kN/m max.



508 mm	20.00 in	8.3 kg
550 mm segmented	21.65 in segmented	9.0 kg
2x250 mm segmented	2x9.84 in segmented	8.2 kg

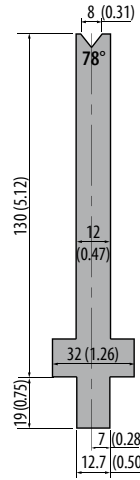
42Cr: 900-1150 N/mm²

NEW



LM130.08.78

400 kN/m max.



508 mm	20.00 in	8.4 kg
550 mm segmented	21.65 in segmented	9.1 kg
2x250 mm segmented	2x9.84 in segmented	8.3 kg

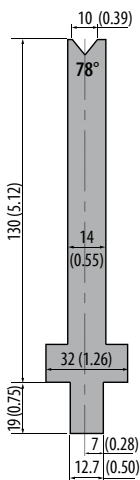
42Cr: 900-1150 N/mm²

NEW



LM130.10.78

500 kN/m max.



508 mm	20.00 in	10.1 kg
550 mm segmented	21.65 in segmented	11.0 kg
2x250 mm segmented	2x9.84 in segmented	10.0 kg

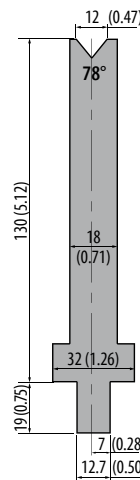
42Cr: 900-1150 N/mm²

NEW



LM130.12.78

600 kN/m max.



508 mm	20.00 in	11.1 kg
550 mm segmented	21.65 in segmented	12.0 kg
2x250 mm segmented	2x9.84 in segmented	10.9 kg

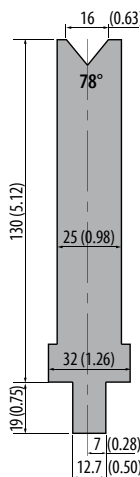
42Cr: 900-1150 N/mm²

NEW



LM130.16.78

800 kN/m max.



508 mm	20.00 in	14.3 kg
550 mm segmented	21.65 in segmented	15.5 kg
2x250 mm segmented	2x9.84 in segmented	14.1 kg

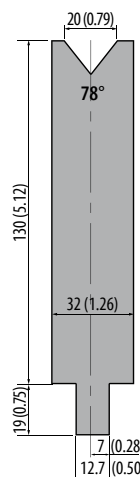
42Cr: 900-1150 N/mm²

NEW



LM130.20.78

1000 kN/m max.



508 mm	20.00 in	17.5 kg
550 mm segmented	21.65 in segmented	19.0 kg
2x250 mm segmented	2x9.84 in segmented	17.2 kg

42Cr: 900-1150 N/mm²

NEW



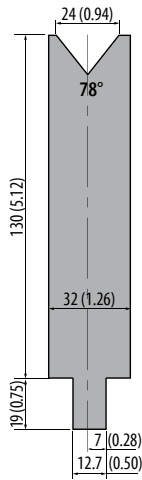
**7
RX**

RX ROLLER TYPE RX

Dies 78° LVD, H=130 mm

LM130.24.78

1000 kN/m max.



508 mm	20.00 in	17.0 kg
550 mm segmented	21.65 in segmented	18.5 kg
2x250 mm segmented	2x9.84 in segmented	16.8 kg

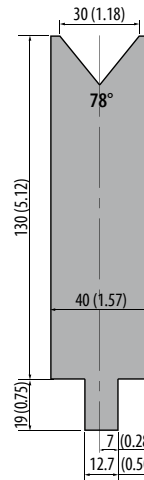
42Cr: 900-1150 N/mm²

NEW



LM130.30.78

1100 kN/m max.



508 mm	20.00 in	20.7 kg
550 mm segmented	21.65 in segmented	22.4 kg
2x250 mm segmented	2x9.84 in segmented	20.4 kg

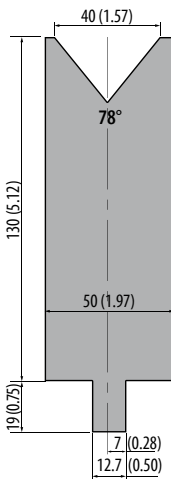
42Cr: 900-1150 N/mm²

NEW



LM130.40.78

1300 kN/m max.



508 mm	20.00 in	26.6 kg
550 mm segmented	21.65 in segmented	28.9 kg
2x250 mm segmented	2x9.84 in segmented	26.2 kg

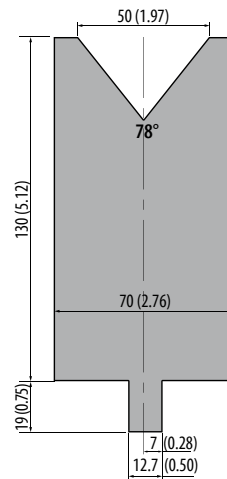
42Cr: 900-1150 N/mm²

NEW



LM130.50.78

1500 kN/m max.



508 mm	20.00 in	34.2 kg
550 mm segmented	21.65 in segmented	37.0 kg
2x250 mm segmented	2x9.84 in segmented	33.6 kg

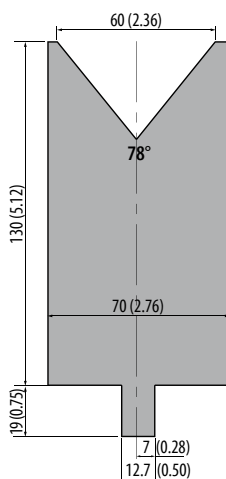
42Cr: 900-1150 N/mm²

NEW



LM130.60.78

1500 kN/m max.



508 mm	20.00 in	34.2 kg
550 mm segmented	21.65 in segmented	37.0 kg
2x250 mm segmented	2x9.84 in segmented	33.6 kg

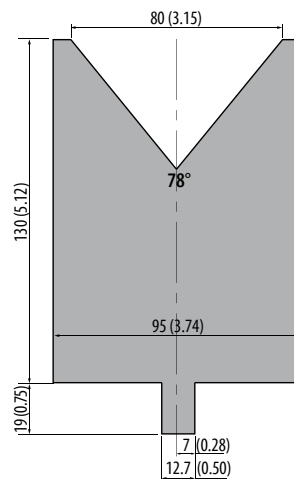
42Cr: 900-1150 N/mm²

NEW



LM130.80.78

1500 kN/m max.



508 mm	20.00 in	42.3 kg
550 mm segmented	21.65 in segmented	45.8 kg
2x250 mm segmented	2x9.84 in segmented	41.6 kg

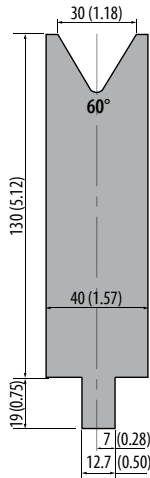
42Cr: 900-1150 N/mm²

NEW



LM130.30.60

500 kN/m max.



508 mm	20.00 in	20.4 kg
550 mm segmented	21.65 in segmented	22.1 kg
2x250 mm segmented	2x9.84 in segmented	20.1 kg

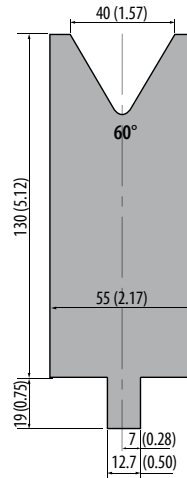
42Cr: 900-1150 N/mm²

NEW



LM130.40.60

660 kN/m max.



508 mm	20.00 in	26.8 kg
550 mm segmented	21.65 in segmented	29.1 kg
2x250 mm segmented	2x9.84 in segmented	26.4 kg

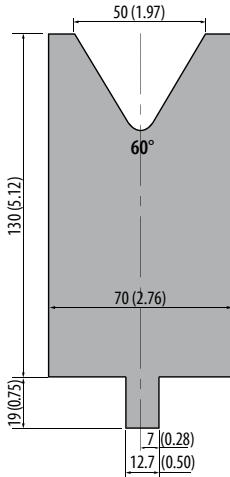
42Cr: 900-1150 N/mm²

NEW



LM130.50.60

1050 kN/m max.



508 mm	20.00 in	33.0 kg
550 mm segmented	21.65 in segmented	35.7 kg
2x250 mm segmented	2x9.84 in segmented	32.5 kg

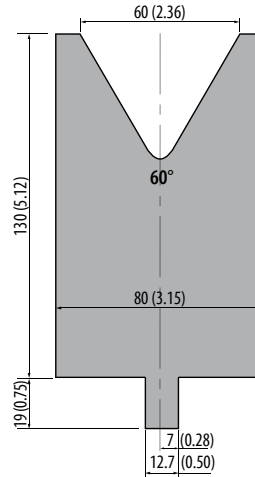
42Cr: 900-1150 N/mm²

NEW



LM130.60.60

1200 kN/m max.



508 mm	20.00 in	36.5 kg
550 mm segmented	21.65 in segmented	39.6 kg
2x250 mm segmented	2x9.84 in segmented	36.0 kg

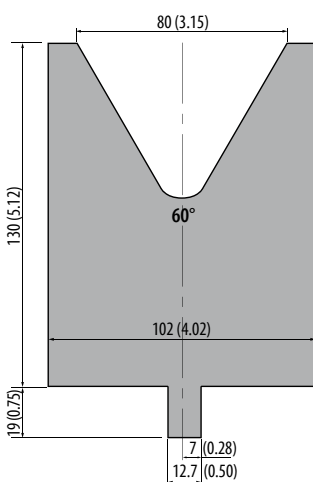
42Cr: 900-1150 N/mm²

NEW



LM130.80.60

1750 kN/m max.



508 mm	20.00 in	43.0 kg
550 mm segmented	21.65 in segmented	46.6 kg
2x250 mm segmented	2x9.84 in segmented	42.4 kg

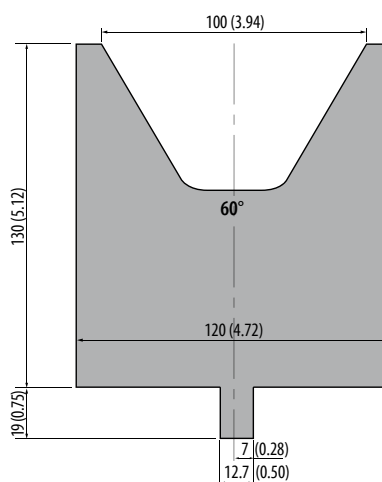
42Cr: 900-1150 N/mm²

NEW



LM130.100.60

1600 kN/m max.



508 mm	20.00 in	47.6 kg
550 mm segmented	21.65 in segmented	51.5 kg
2x250 mm segmented	2x9.84 in segmented	46.8 kg

42Cr: 900-1150 N/mm²

NEW



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

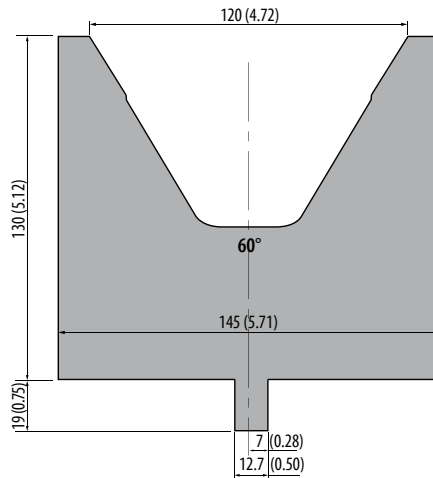
7
RX

RX ROLLER TYPE RX

Dies 60° LVD, H=130 mm

LM130.120.60

1300 kN/m max.



508 mm	20.00 in	51.0 kg
550 mm segmented	21.65 in segmented	55.2 kg
2x250 mm segmented	2x9.84 in segmented	50.2 kg

42Cr: 900-1150 N/mm²

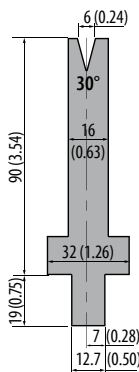
NEW



Dies 30° LVD, H=90 mm

LM90.06.30

200 kN/m max.



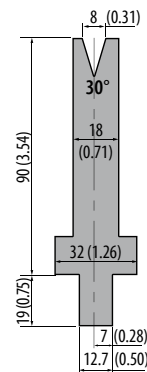
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.08.30

220 kN/m max.



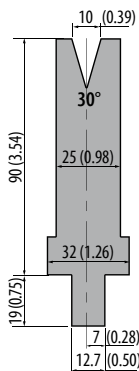
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.10.30

300 kN/m max.



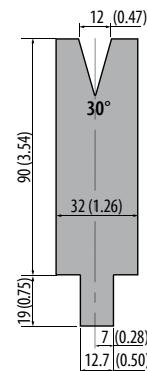
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.12.30

380 kN/m max.



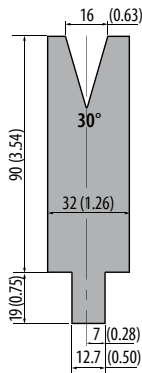
508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.6 kg
2x250 mm segmented	2x9.84 in segmented	11.8 kg

42Cr: 900-1150 N/mm²



LM90.16.30

380 kN/m max.



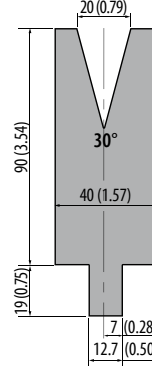
508 mm	20.00 in	11.5 kg
550 mm segmented	21.65 in segmented	12.4 kg
2x250 mm segmented	2x9.84 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



LM90.20.30

380 kN/m max.



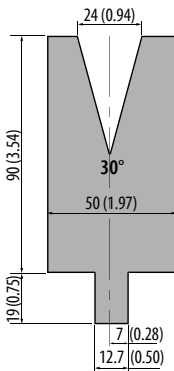
508 mm	20.00 in	13.8 kg
550 mm segmented	21.65 in segmented	15.0 kg
2x250 mm segmented	2x9.84 in segmented	13.6 kg

42Cr: 900-1150 N/mm²



LM90.24.30

550 kN/m max.



508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg

42Cr: 900-1150 N/mm²

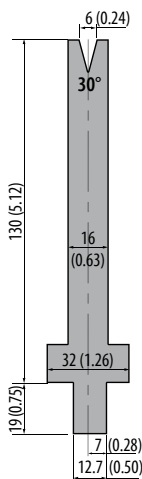


7
RX

Dies 30° LVD, H=130 mm

LM130.06.30

200 kN/m max.



508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg
2x250 mm segmented	2x9.84 in segmented	9.8 kg

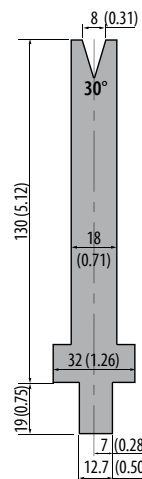
42Cr: 900-1150 N/mm²

NEW



LM130.08.30

220 kN/m max.



508 mm	20.00 in	10.9 kg
550 mm segmented	21.65 in segmented	11.8 kg
2x250 mm segmented	2x9.84 in segmented	10.7 kg

42Cr: 900-1150 N/mm²

NEW



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



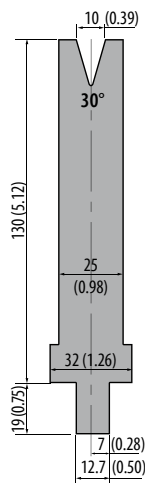
Articles on stock – Please note that delivery time depends on your location.

RX ROLLER TYPE RX

Dies 30° LVD, H=130 mm

LM130.10.30

300 kN/m max.



508 mm	20.00 in	14.0 kg
550 mm segmented	21.65 in segmented	15.1 kg
2x250 mm segmented	2x9.84 in segmented	13.8 kg

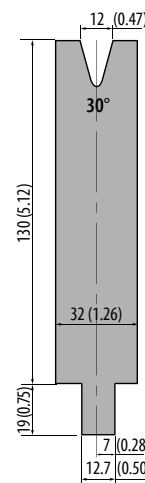
42Cr: 900-1150 N/mm²



NEW

LM130.12.30

380 kN/m max.



508 mm	20.00 in	17.1 kg
550 mm segmented	21.65 in segmented	18.5 kg
2x250 mm segmented	2x9.84 in segmented	16.9 kg

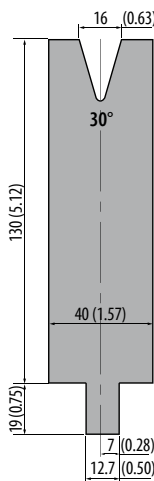
42Cr: 900-1150 N/mm²



NEW

LM130.16.30

380 kN/m max.



508 mm	20.00 in	20.8 kg
550 mm segmented	21.65 in segmented	22.6 kg
2x250 mm segmented	2x9.84 in segmented	20.5 kg

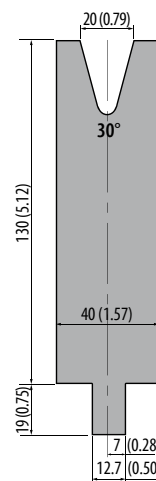
42Cr: 900-1150 N/mm²



NEW

LM130.20.30

380 kN/m max.



508 mm	20.00 in	20.3 kg
550 mm segmented	21.65 in segmented	22.0 kg
2x250 mm segmented	2x9.84 in segmented	20.0 kg

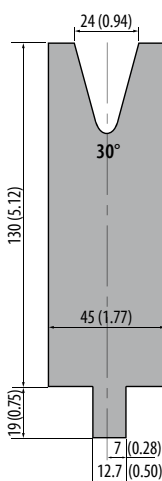
42Cr: 900-1150 N/mm²



NEW

LM130.24.30

550 kN/m max.



508 mm	20.00 in	24.4 kg
550 mm segmented	21.65 in segmented	26.4 kg
2x250 mm segmented	2x9.84 in segmented	24.0 kg

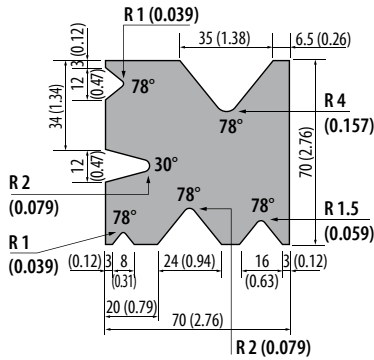
42Cr: 900-1150 N/mm²



NEW

LM70

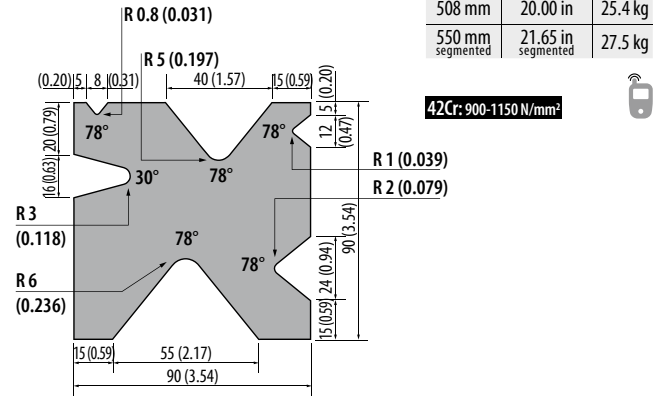
508 mm	20.00 in	16.8 kg
550 mm segmented	21.65 in segmented	18.2 kg



	V1	V2	V3	V4	V5	V6
V mm (in)	12 (0.47)	12 (0.47)	35 (1.38)	24 (0.94)	16 (0.63)	8 (0.31)
Angle	30°	78°	78°	78°	78°	78°
kN/m max.	1300	600	1300	1200	950	500

LM90

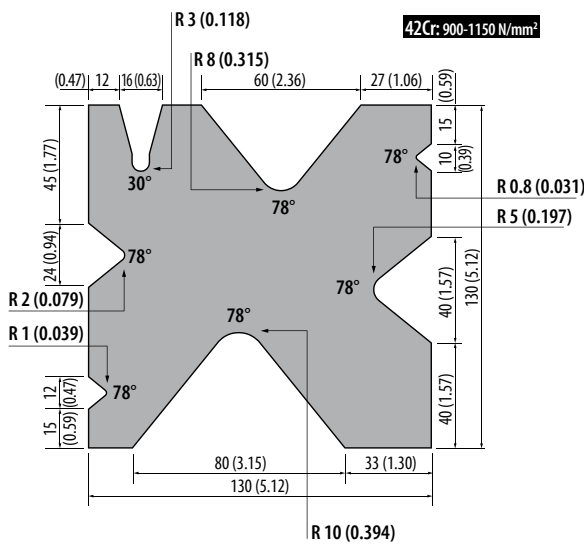
508 mm	20.00 in	25.4 kg
550 mm segmented	21.65 in segmented	27.5 kg



	V1	V2	V3	V4	V5	V6
V mm (in)	8 (0.31)	40 (1.57)	12 (0.47)	24 (0.94)	55 (2.17)	16 (0.63)
Angle	78°	78°	78°	78°	78°	30°
kN/m max.	550	1400	550	650	1000	1000

LM130

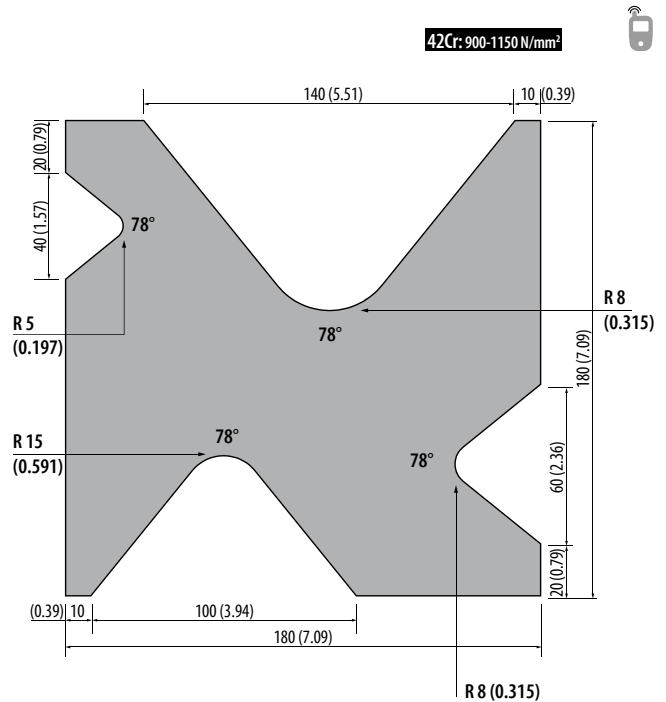
508 mm	20.00 in	51.8 kg
550 mm segmented	21.65 in segmented	56.1 kg



	V1	V2	V3	V4	V5	V6	V7
V mm (in)	16 (0.63)	60 (2.36)	10 (0.39)	80 (3.15)	40 (1.57)	12 (0.47)	24 (0.94)
Angle	30°	78°	78°	78°	78°	78°	78°
kN/m max.	650	1500	650	1250	1500	480	1500

LM180

508 mm	20.00 in	87.9 kg
550 mm segmented	21.65 in segmented	95.2 kg

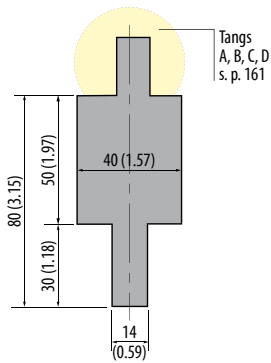


	V1	V2	V3	V4
V mm (in)	140 (5.51)	60 (2.36)	100 (3.94)	40 (1.57)
Angle	78°	78°	78°	78°
kN/m max.	550	650	700	320

7
RX

AD1

1000 kN/m max.



Tang A: AD1-A		
150 mm	5.91 in	3.1 kg
Tang B: AD1-B		
150 mm	5.91 in	3.1 kg
Tang C: AD1-C		
150 mm	5.91 in	3.1 kg
Tang D: AD1-D		
150 mm	5.91 in	3.1 kg

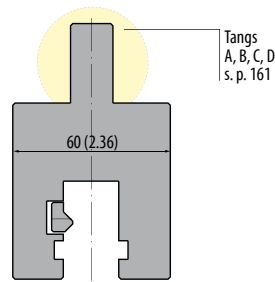
Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



AD20 LVD

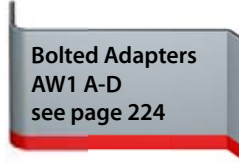
1000 kN/m max.



Tang A: AD20 LVD-A		
150 mm	5.91 in	3.6 kg
Tang B: AD20 LVD-B		
150 mm	5.91 in	3.8 kg
Tang C: AD20 LVD-C		
150 mm	5.91 in	4.0 kg
Tang D: AD20 LVD-D		
150 mm	5.91 in	4.0 kg

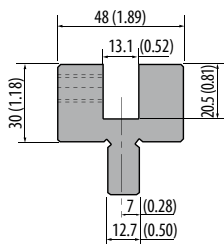
Rolleri Type RX LVD
→ Rolleri Type R2

C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.



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

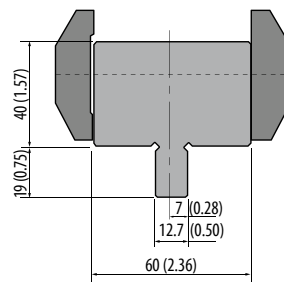
Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD9-12.7

1000 kN/m max.



835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.5 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²

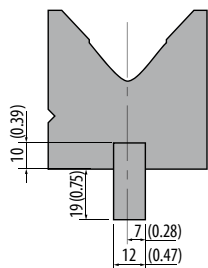


Modification: Wedge Bar / Tail

To use Dies Rolleri Type R1, a 10 mm (0.39 in) groove is milled and polished in order to fit a wedge bar / tail of the required measurement.

A31

Wedge Bar / Tail:
12 x 29 mm (0.47 x 1.14) for
• Rolleri Type RX LVD

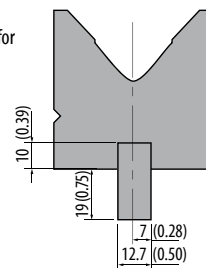


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A32

Wedge Bar / Tail:
12.7 x 29 mm (0.50 x 1.14) for
• Rolleri Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



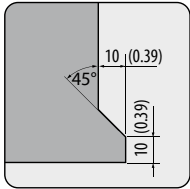
Tool lengths, sectionings and horn types

Punches:

- 1020 mm (40.16 in)
- 1250 mm (49.21 in) segmented
15 segments (100 Horn left, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 100, 100 Horn right)

Dies:

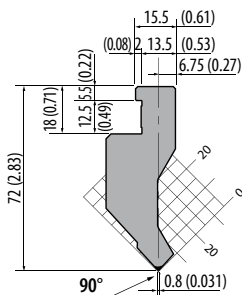
- 1020 mm (40.16 in)
- 1250 mm (49.21 in) segmented
14 segments (100, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 200)



Standard-Horn Type
for all segmented
Punches Roller
Type RX Colly

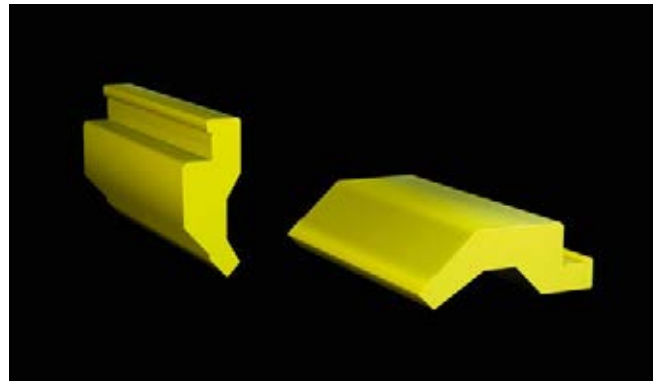
Punches Colly

CP72.90.08



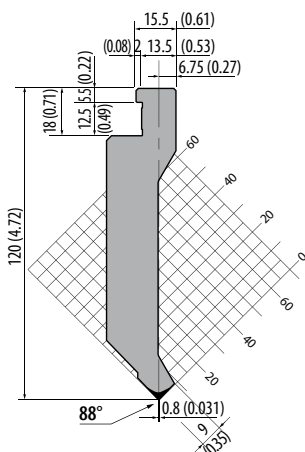
1020 mm	40.16 in	10.2 kg
1250 mm segmented	49.21 in segmented	12.5 kg

C45: 560-710 N/mm²



7
RX

CP120.88.08

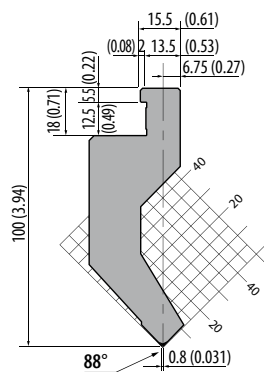


1020 mm	40.16 in	18.5 kg
1250 mm segmented	49.21 in segmented	22.6 kg

C45: 560-710 N/mm²



CP100.88.08-A



1020 mm	40.16 in	16.7 kg
1250 mm segmented	49.21 in segmented	20.4 kg

C45: 560-710 N/mm²



Article on stock



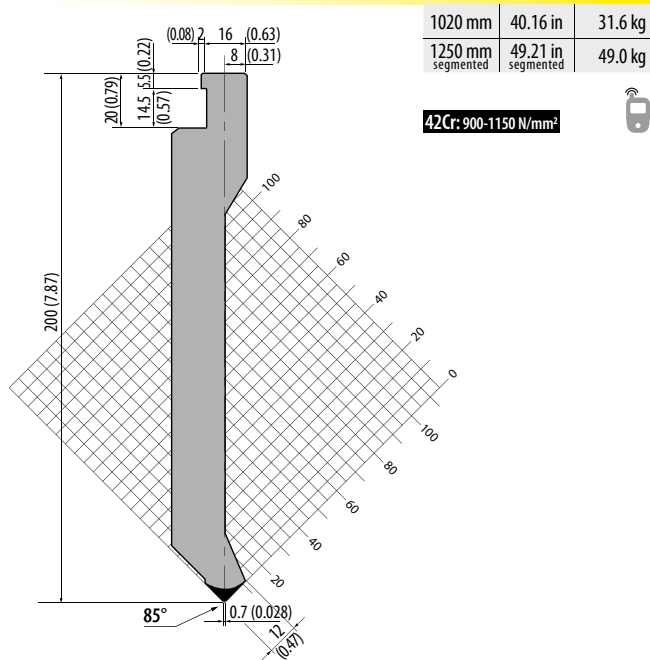
Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

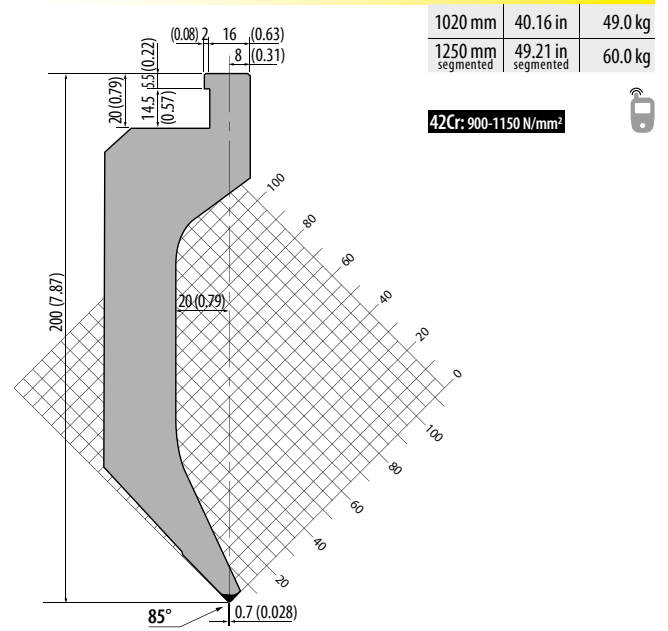


Articles on stock – Please note that delivery time depends on your location.

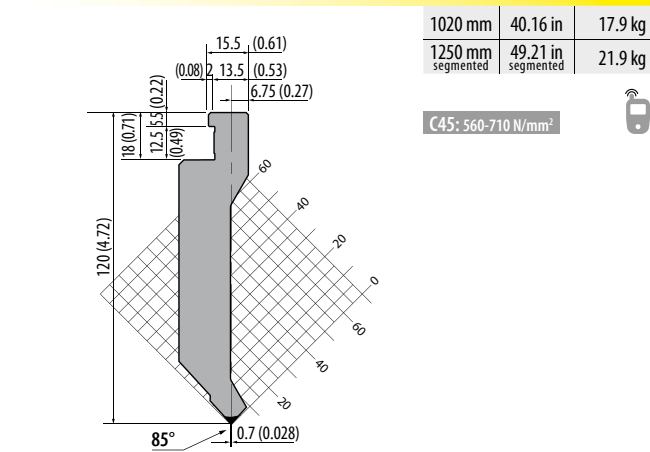
CP200.85.07



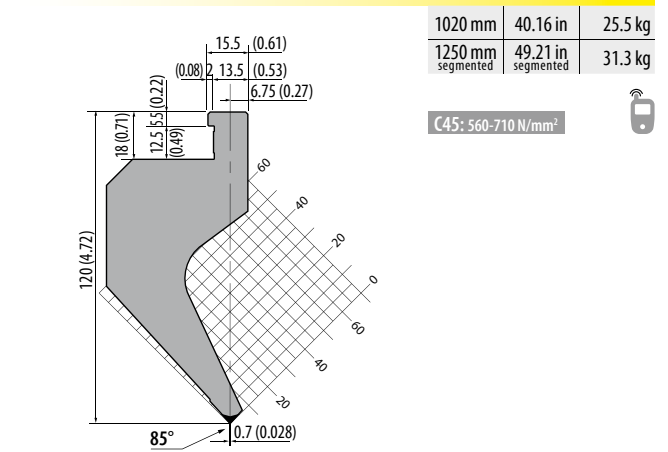
CP200.85.07-A



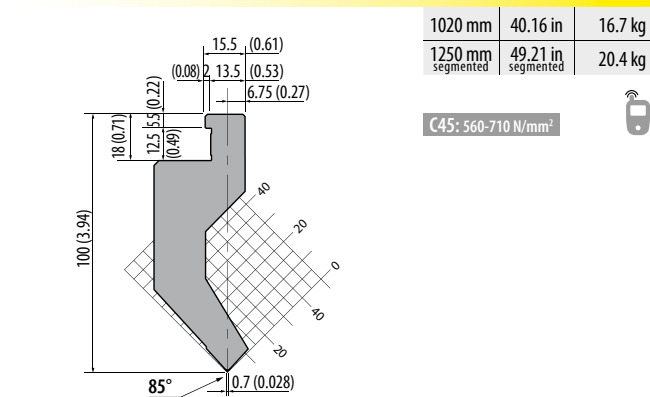
CP120.85.07



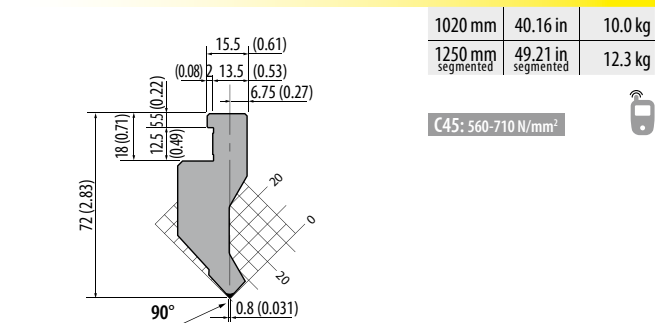
CP120.85.07-A



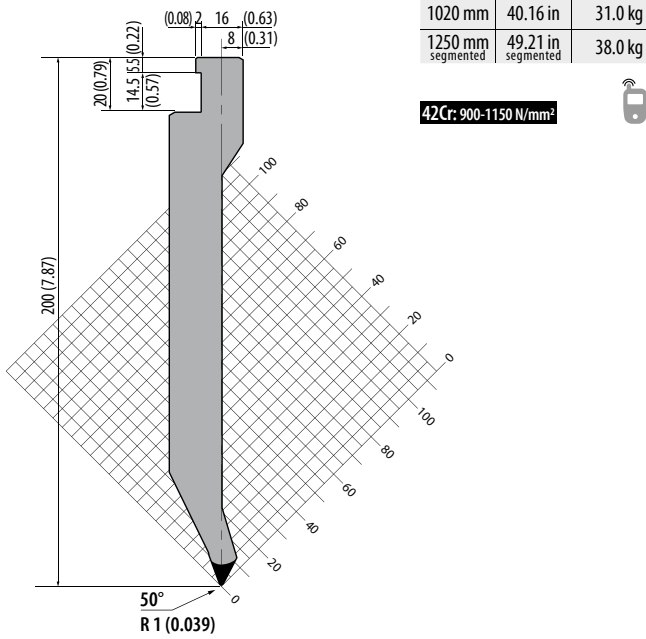
CP100.85.07-A



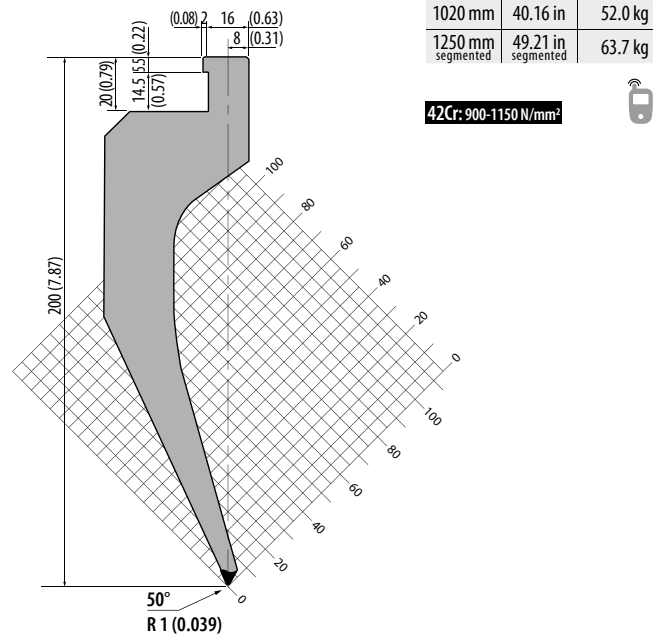
CP72.85.07



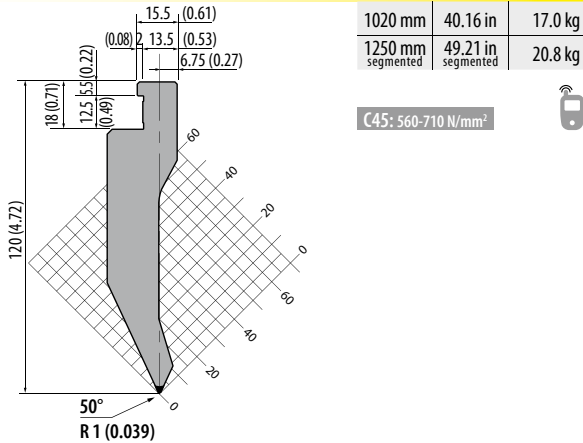
CP200.50.R1



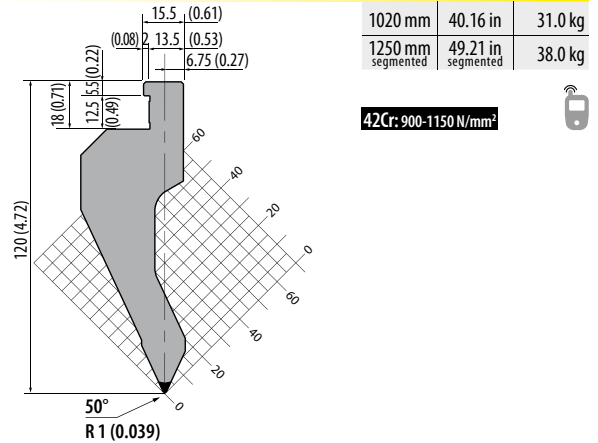
CP200.50.R1-A



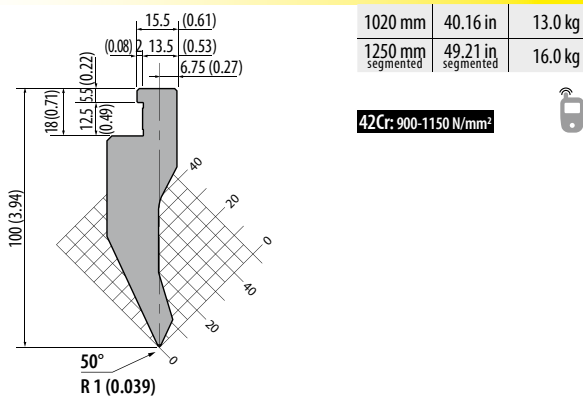
CP120.50.R1



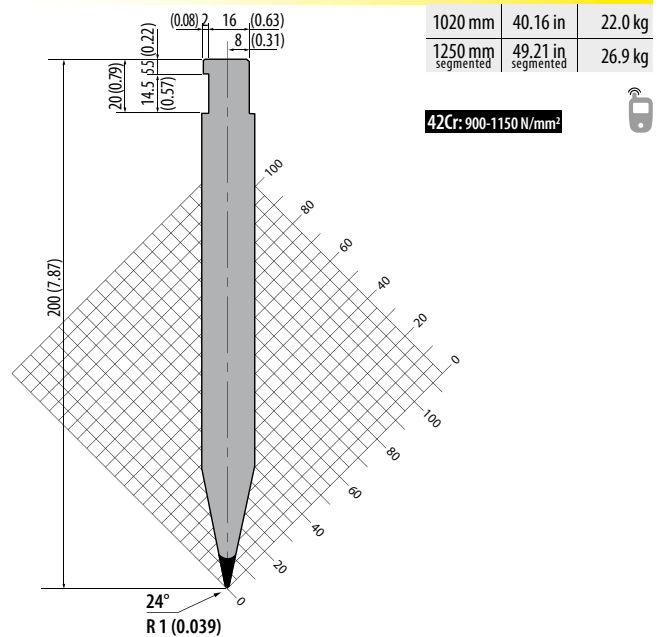
CP120.50.R1-A



CP100.50.R1



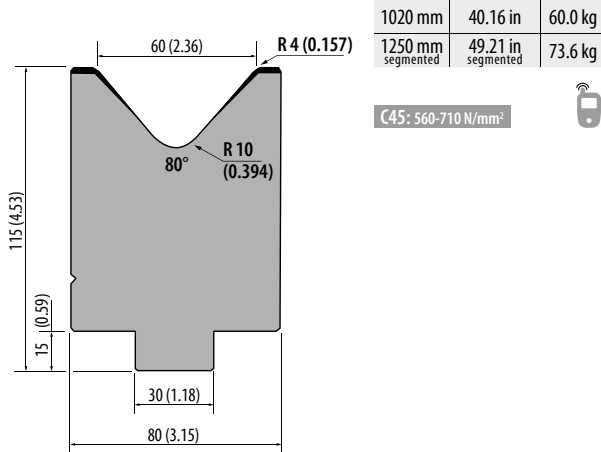
CP200.24.R1



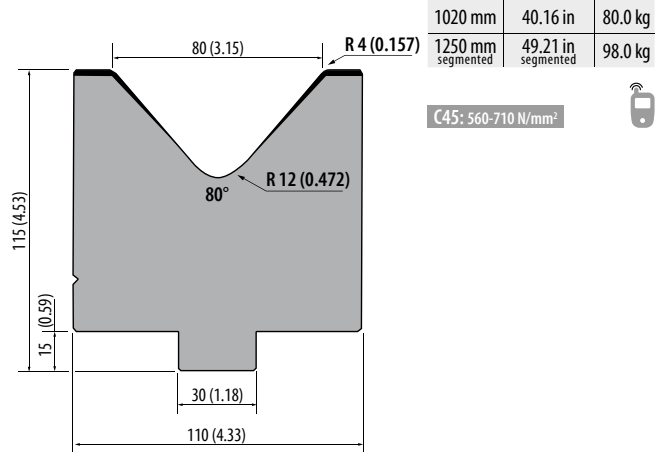
Bolted Adapters
see page 225

7
RX

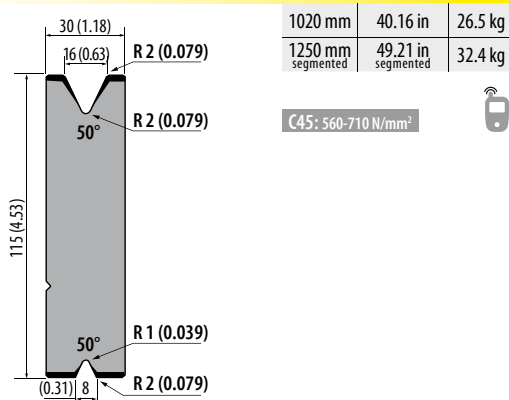
M115.80.60



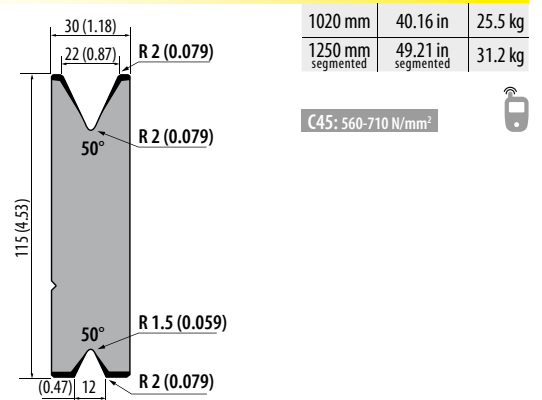
M115.80.80



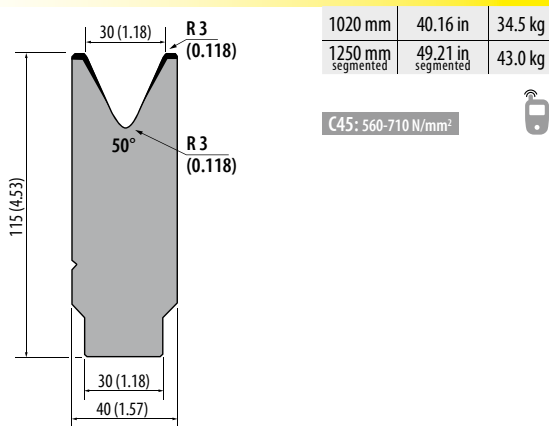
M115.50.16



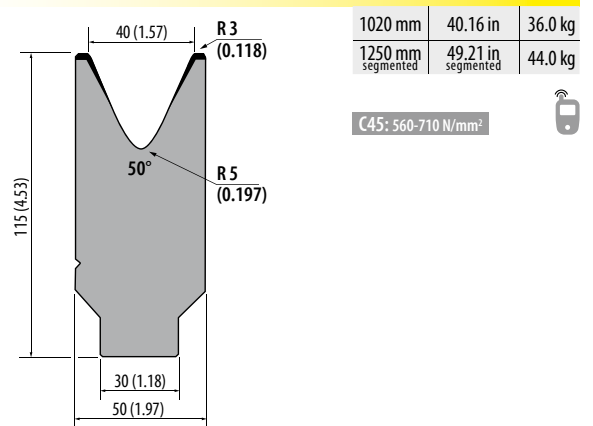
M115.50.22



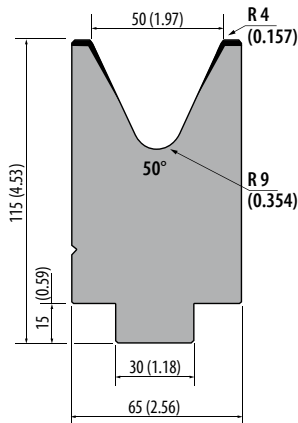
M115.50.30



M115.50.40



M115.50.50

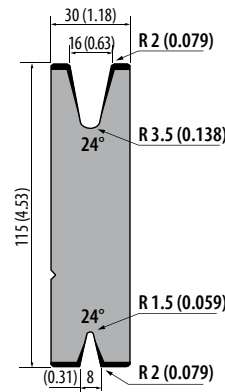


1020 mm	40.16 in	45.5 kg
1250 mm segmented	49.21 in segmented	55.7 kg

C45: 560-710 N/mm²



M115.24.16

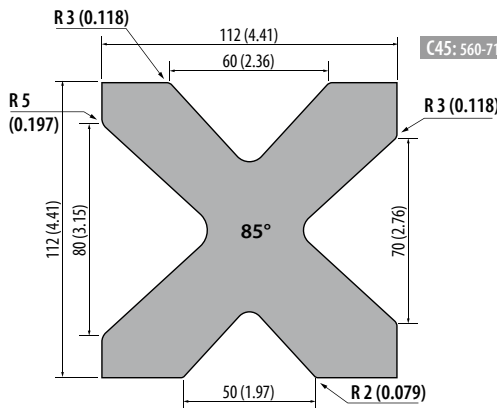


1020 mm	40.16 in	24.9 kg
1250 mm segmented	49.21 in segmented	31.0 kg

C45: 560-710 N/mm²



MC112.3050

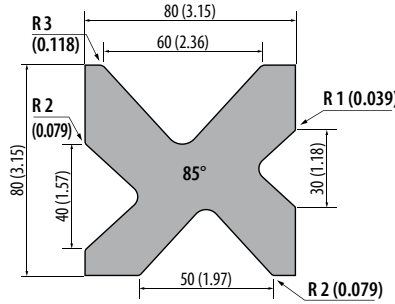


3050 mm	120.08 in	188.0 kg
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C45: 560-710 N/mm²



MC80.2050 / MC80.3050

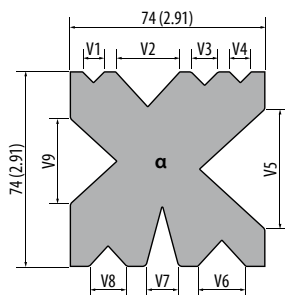


2050 mm	80.71 in	66.0 kg
3050 mm	120.08 in	98.0 kg

C45: 560-710 N/mm²



MC74.2050 / MC74.3050

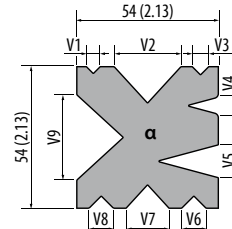


2050 mm	80.71 in	67.0 kg
3050 mm	120.08 in	101.0 kg

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

C45: 560-710 N/mm²

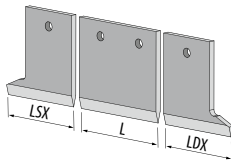


	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm (in)	8 (0.31)	24 (0.94)	10 (0.39)	8 (0.31)	45 (1.77)	18 (0.71)	12 (0.47)	14 (0.55)	32 (1.26)
Angle	90°	85°	90°	90°	85°	85°	30°	85°	85°
R mm (in)	0.8 (0.031)	0.8 (0.031)	2.0 (0.079)	0.8 (0.031)	2.0 (0.079)	1.0 (0.039)	2.0 (0.079)	2.0 (0.079)	2.0 (0.079)

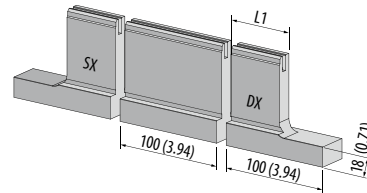
	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm (in)	6 (0.24)	25 (0.98)	6 (0.24)	6 (0.24)	12 (0.47)	9 (0.35)	16 (0.63)	9 (0.35)	32 (1.26)
Angle	90°	85°	90°	30°	30°	90°	85°	90°	85°
R mm (in)	0.5 (0.020)	1.0 (0.039)	0.5 (0.020)	2.0 (0.079)	0.5 (0.020)	1.0 (0.039)	0.5 (0.020)	1.5 (0.059)	1.0 (0.039)

Tool lengths, sectionings and horn types

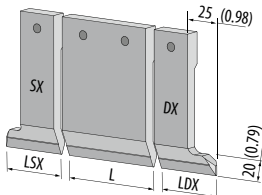
Punches H11:



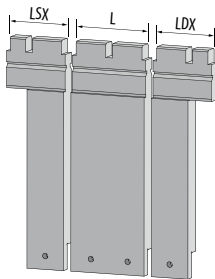
Dies H31, H41:



Punches H12:



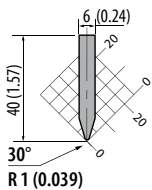
Punches H21:



Punches Hämmerle-Bystronic

H11.010.0

600 kN/m max.

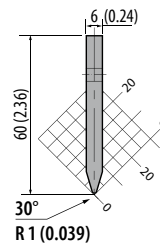


Model	Length	Weight
H11.010.01.01	100 3.94	0.17 kg
H11.010.02.01	50 1.97	0.09 kg
H11.010.02.02	55 2.17	0.09 kg
H11.010.02.03	60 2.36	0.10 kg
H11.010.02.04	65 2.56	0.11 kg
H11.010.02.05	70 2.76	0.12 kg
H11.010.02.06	75 2.95	0.13 kg
H11.010.02.07	80 3.15	0.14 kg
H11.010.02.08	85 3.35	0.14 kg
H11.010.02.09	90 3.54	0.15 kg
H11.010.02.10	95 3.74	0.16 kg
H11.010.04.01	75 DX 2.95 DX	0.12 kg
H11.010.04.02	85 DX 3.35 DX	0.14 kg
H11.010.04.03	95 DX 3.74 DX	0.15 kg
H11.010.04.04	105 DX 4.13 DX	0.17 kg
H11.010.04.05	115 DX 4.53 DX	0.19 kg
H11.010.04.06	80 SX 3.15 SX	0.13 kg
H11.010.05.01	75 SX 2.95 SX	0.12 kg
H11.010.05.02	85 SX 3.35 SX	0.14 kg
H11.010.05.03	95 SX 3.74 SX	0.15 kg
H11.010.05.04	105 SX 4.13 SX	0.17 kg
H11.010.05.05	115 SX 4.53 SX	0.19 kg
H11.010.05.06	80 DX 3.15 DX	0.13 kg

HRC 58-60

H11.007.0

1000 kN/m max.

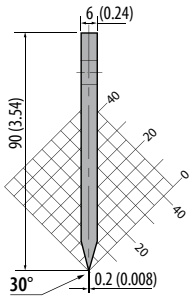


Model	Length	Weight
H11.007.01.01	100 3.94	0.26 kg
H11.007.02.01	50 1.97	0.13 kg
H11.007.02.02	55 2.17	0.14 kg
H11.007.02.03	60 2.36	0.16 kg
H11.007.02.04	65 2.56	0.17 kg
H11.007.02.05	70 2.76	0.18 kg
H11.007.02.06	75 2.95	0.20 kg
H11.007.02.07	80 3.15	0.21 kg
H11.007.02.08	85 3.35	0.22 kg
H11.007.02.09	90 3.54	0.23 kg
H11.007.02.10	95 3.74	0.25 kg
H11.007.04.01	75 DX 2.95 DX	0.18 kg
H11.007.04.02	85 DX 3.35 DX	0.21 kg
H11.007.04.03	95 DX 3.74 DX	0.23 kg
H11.007.04.04	105 DX 4.13 DX	0.25 kg
H11.007.04.05	115 DX 4.53 DX	0.29 kg
H11.007.04.06	80 SX 3.15 SX	0.20 kg
H11.007.05.01	75 SX 2.95 SX	0.18 kg
H11.007.05.02	85 SX 3.35 SX	0.21 kg
H11.007.05.03	95 SX 3.74 SX	0.23 kg
H11.007.05.04	105 SX 4.13 SX	0.25 kg
H11.007.05.05	115 SX 4.53 SX	0.29 kg
H11.007.05.06	80 DX 3.15 DX	0.20 kg

HRC 58-60

H11.002.0

1000 kN/m max.

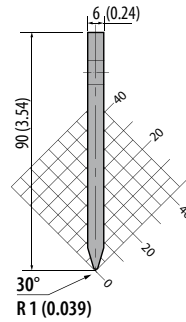


Model	Length	Weight
H11.002.01.01	100	3.94
H11.002.02.01	50	1.97
H11.002.02.02	55	2.17
H11.002.02.03	60	2.36
H11.002.02.04	65	2.56
H11.002.02.05	70	2.76
H11.002.02.06	75	2.95
H11.002.02.07	80	3.15
H11.002.02.08	85	3.35
H11.002.02.09	90	3.54
H11.002.02.10	95	3.74
H11.002.04.01	75 DX	2.95 DX
H11.002.04.02	85 DX	3.35 DX
H11.002.04.03	95 DX	3.74 DX
H11.002.04.04	105 DX	4.13 DX
H11.002.04.05	115 DX	4.53 DX
H11.002.04.06	80 SX	3.15 SX
H11.002.05.01	75 SX	2.95 SX
H11.002.05.02	85 SX	3.35 SX
H11.002.05.03	95 SX	3.74 SX
H11.002.05.04	105 SX	4.13 SX
H11.002.05.05	115 SX	4.53 SX
H11.002.05.06	80 DX	3.15 DX

HRc 58-60

H11.001.0

1000 kN/m max.

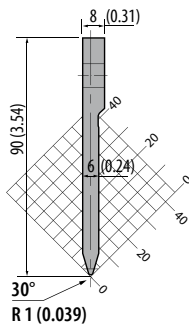


Model	Length	Weight
H11.001.01.01	100	3.94
H11.001.02.01	50	1.97
H11.001.02.02	55	2.17
H11.001.02.03	60	2.36
H11.001.02.04	65	2.56
H11.001.02.05	70	2.76
H11.001.02.06	75	2.95
H11.001.02.07	80	3.15
H11.001.02.08	85	3.35
H11.001.02.09	90	3.54
H11.001.02.10	95	3.74
H11.001.04.01	75 DX	2.95 DX
H11.001.04.02	85 DX	3.35 DX
H11.001.04.03	95 DX	3.74 DX
H11.001.04.04	105 DX	4.13 DX
H11.001.04.05	115 DX	4.53 DX
H11.001.04.06	80 SX	3.15 SX
H11.001.05.01	75 SX	2.95 SX
H11.001.05.02	85 SX	3.35 SX
H11.001.05.03	95 SX	3.74 SX
H11.001.05.04	105 SX	4.13 SX
H11.001.05.05	115 SX	4.53 SX
H11.001.05.06	80 DX	3.15 DX

HRc 58-60

H11.008.0

1000 kN/m max.

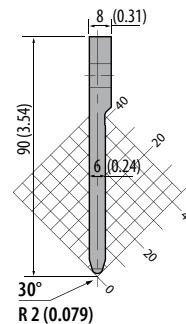


Model	Length	Weight
H11.008.01.01	100	3.94
H11.008.02.01	50	1.97
H11.008.02.02	55	2.17
H11.008.02.03	60	2.36
H11.008.02.04	65	2.56
H11.008.02.05	70	2.76
H11.008.02.06	75	2.95
H11.008.02.07	80	3.15
H11.008.02.08	85	3.35
H11.008.02.09	90	3.54
H11.008.02.10	95	3.74
H11.008.04.01	75 DX	2.95 DX
H11.008.04.02	85 DX	3.35 DX
H11.008.04.03	95 DX	3.74 DX
H11.008.04.04	105 DX	4.13 DX
H11.008.04.05	115 DX	4.53 DX
H11.008.04.06	80 SX	3.15 SX
H11.008.05.01	75 SX	2.95 SX
H11.008.05.02	85 SX	3.35 SX
H11.008.05.03	95 SX	3.74 SX
H11.008.05.04	105 SX	4.13 SX
H11.008.05.05	115 SX	4.53 SX
H11.008.05.06	80 DX	3.15 DX

HRc 58-60

H11.006.0

1000 kN/m max.

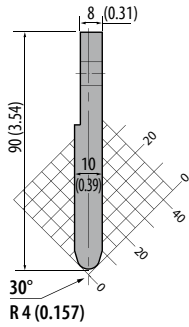


Model	Length	Weight
H11.006.01.01	100	3.94
H11.006.02.01	50	1.97
H11.006.02.02	55	2.17
H11.006.02.03	60	2.36
H11.006.02.04	65	2.56
H11.006.02.05	70	2.76
H11.006.02.06	75	2.95
H11.006.02.07	80	3.15
H11.006.02.08	85	3.35
H11.006.02.09	90	3.54
H11.006.02.10	95	3.74
H11.006.04.01	75 DX	2.95 DX
H11.006.04.02	85 DX	3.35 DX
H11.006.04.03	95 DX	3.74 DX
H11.006.04.04	105 DX	4.13 DX
H11.006.04.05	115 DX	4.53 DX
H11.006.04.06	80 SX	3.15 SX
H11.006.05.01	75 SX	2.95 SX
H11.006.05.02	85 SX	3.35 SX
H11.006.05.03	95 SX	3.74 SX
H11.006.05.04	105 SX	4.13 SX
H11.006.05.05	115 SX	4.53 SX
H11.006.05.06	80 DX	3.15 DX

HRc 58-60

H11.034.0

1000 kN/m max.

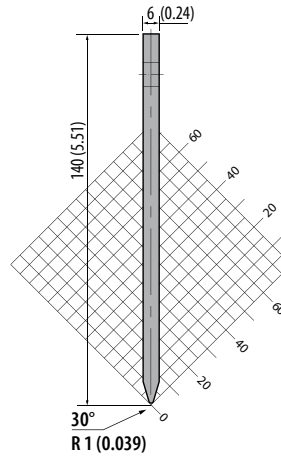


Model	Length	Weight
H11.034.01.01	100	3.94
H11.034.02.01	50	1.97
H11.034.02.02	55	2.17
H11.034.02.03	60	2.36
H11.034.02.04	65	2.56
H11.034.02.05	70	2.76
H11.034.02.06	75	2.95
H11.034.02.07	80	3.15
H11.034.02.08	85	3.35
H11.034.02.09	90	3.54
H11.034.02.10	95	3.74
H11.034.04.01	75 DX	2.95 DX
H11.034.04.02	85 DX	3.35 DX
H11.034.04.03	95 DX	3.74 DX
H11.034.04.04	105 DX	4.13 DX
H11.034.04.05	115 DX	4.53 DX
H11.034.04.06	80 SX	3.15 SX
H11.034.05.01	75 SX	2.95 SX
H11.034.05.02	85 SX	3.35 SX
H11.034.05.03	95 SX	3.74 SX
H11.034.05.04	105 SX	4.13 SX
H11.034.05.05	115 SX	4.53 SX
H11.034.05.06	80 DX	3.15 DX

HRC 58-60

H11.003.0

1000 kN/m max.

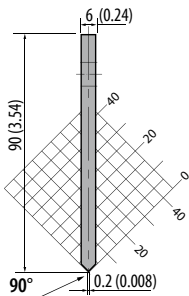


Model	Length	Weight
H11.003.01.01	100	3.94
H11.003.02.01	50	1.97
H11.003.02.02	55	2.17
H11.003.02.03	60	2.36
H11.003.02.04	65	2.56
H11.003.02.05	70	2.76
H11.003.02.06	75	2.95
H11.003.02.07	80	3.15
H11.003.02.08	85	3.35
H11.003.02.09	90	3.54
H11.003.02.10	95	3.74
H11.003.04.01	75 DX	2.95 DX
H11.003.04.02	85 DX	3.35 DX
H11.003.04.03	95 DX	3.74 DX
H11.003.04.04	105 DX	4.13 DX
H11.003.04.05	115 DX	4.53 DX
H11.003.04.06	80 SX	3.15 SX
H11.003.05.01	75 SX	2.95 SX
H11.003.05.02	85 SX	3.35 SX
H11.003.05.03	95 SX	3.74 SX
H11.003.05.04	105 SX	4.13 SX
H11.003.05.05	115 SX	4.53 SX
H11.003.05.06	80 DX	3.15 DX

HRC 58-60

H11.005.0

1000 kN/m max.

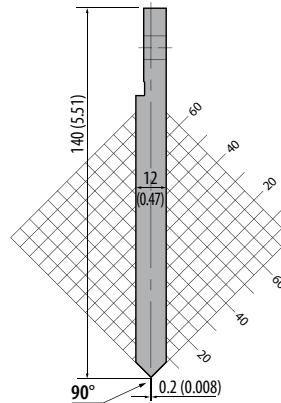


Model	Length	Weight
H11.005.01.01	100	3.94
H11.005.02.01	50	1.97
H11.005.02.02	55	2.17
H11.005.02.03	60	2.36
H11.005.02.04	65	2.56
H11.005.02.05	70	2.76
H11.005.02.06	75	2.95
H11.005.02.07	80	3.15
H11.005.02.08	85	3.35
H11.005.02.09	90	3.54
H11.005.02.10	95	3.74
H11.005.04.01	75 DX	2.95 DX
H11.005.04.02	85 DX	3.35 DX
H11.005.04.03	95 DX	3.74 DX
H11.005.04.04	105 DX	4.13 DX
H11.005.04.05	115 DX	4.53 DX
H11.005.04.06	80 SX	3.15 SX
H11.005.05.01	75 SX	2.95 SX
H11.005.05.02	85 SX	3.35 SX
H11.005.05.03	95 SX	3.74 SX
H11.005.05.04	105 SX	4.13 SX
H11.005.05.05	115 SX	4.53 SX
H11.005.05.06	80 DX	3.15 DX

HRC 58-60

H11.009.1

1000 kN/m max.

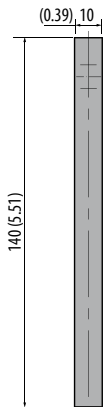


Model	Length	Weight
H11.009.10.01	100	3.94
H11.009.12.01	50	1.97
H11.009.12.02	55	2.17
H11.009.12.03	60	2.36
H11.009.12.04	65	2.56
H11.009.12.05	70	2.76
H11.009.12.06	75	2.95
H11.009.12.07	80	3.15
H11.009.12.08	85	3.35
H11.009.12.09	90	3.54
H11.009.12.10	95	3.74
H11.009.14.01	75 DX	2.95 DX
H11.009.14.02	85 DX	3.35 DX
H11.009.14.03	95 DX	3.74 DX
H11.009.14.04	105 DX	4.13 DX
H11.009.14.05	115 DX	4.53 DX
H11.009.14.06	80 SX	3.15 SX
H11.009.15.01	75 SX	2.95 SX
H11.009.15.02	85 SX	3.35 SX
H11.009.15.03	95 SX	3.74 SX
H11.009.15.04	105 SX	4.13 SX
H11.009.15.05	115 SX	4.53 SX
H11.009.15.06	80 DX	3.15 DX

HRC 58-60

H14.021.0

1000 kN/m max.



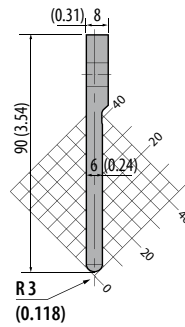
Model	Length	Weight
H14.021.01.01	100	3.94
H14.021.02.01	50	1.97
H14.021.02.02	55	2.17
H14.021.02.03	60	2.36
H14.021.02.04	65	2.56
H14.021.02.05	70	2.76
H14.021.02.06	75	2.95
H14.021.02.07	80	3.15
H14.021.02.08	85	3.35
H14.021.02.09	90	3.54
H14.021.02.10	95	3.74

HRc 58-60



H11.033.1

1000 kN/m max.



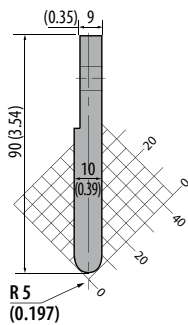
Model	Length	Weight
H11.033.11.01	100	3.94
H11.033.12.01	50	1.97
H11.033.12.02	55	2.17
H11.033.12.03	60	2.36
H11.033.12.04	65	2.56
H11.033.12.05	70	2.76
H11.033.12.06	75	2.95
H11.033.12.07	80	3.15
H11.033.12.08	85	3.35
H11.033.12.09	90	3.54
H11.033.12.10	95	3.74
H11.033.14.01	75 DX	2.95 DX
H11.033.14.02	85 DX	3.35 DX
H11.033.14.03	95 DX	3.74 DX
H11.033.14.04	105 DX	4.13 DX
H11.033.14.05	115 DX	4.53 DX
H11.033.14.06	80 SX	3.15 SX
H11.033.15.01	75 SX	2.95 SX
H11.033.15.02	85 SX	3.35 SX
H11.033.15.03	95 SX	3.74 SX
H11.033.15.04	105 SX	4.13 SX
H11.033.15.05	115 SX	4.53 SX
H11.033.15.06	80 DX	3.15 DX

HRc 58-60



H11.035.0

1000 kN/m max.



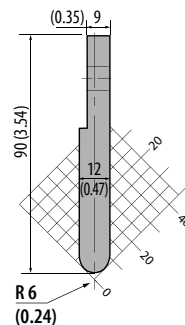
Model	Length	Weight
H11.035.01.01	100	3.94
H11.035.02.01	50	1.97
H11.035.02.02	55	2.17
H11.035.02.03	60	2.36
H11.035.02.04	65	2.56
H11.035.02.05	70	2.76
H11.035.02.06	75	2.95
H11.035.02.07	80	3.15
H11.035.02.08	85	3.35
H11.035.02.09	90	3.54
H11.035.02.10	95	3.74
H11.035.04.01	75 DX	2.95 DX
H11.035.04.02	85 DX	3.35 DX
H11.035.04.03	95 DX	3.74 DX
H11.035.04.04	105 DX	4.13 DX
H11.035.04.05	115 DX	4.53 DX
H11.035.04.06	80 SX	3.15 SX
H11.035.05.01	75 SX	2.95 SX
H11.035.05.02	85 SX	3.35 SX
H11.035.05.03	95 SX	3.74 SX
H11.035.05.04	105 SX	4.13 SX
H11.035.05.05	115 SX	4.53 SX
H11.035.05.06	80 DX	3.15 DX

HRc 58-60



H11.036.0

1000 kN/m max.



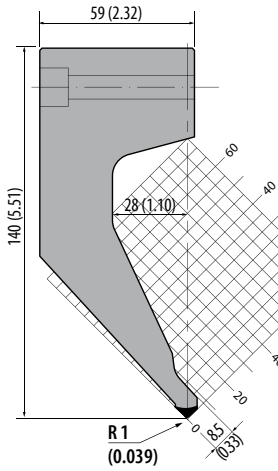
Model	Length	Weight
H11.036.01.01	100	3.94
H11.036.02.01	50	1.97
H11.036.02.02	55	2.17
H11.036.02.03	60	2.36
H11.036.02.04	65	2.56
H11.036.02.05	70	2.76
H11.036.02.06	75	2.95
H11.036.02.07	80	3.15
H11.036.02.08	85	3.35
H11.036.02.09	90	3.54
H11.036.02.10	95	3.74
H11.036.04.01	75 DX	2.95 DX
H11.036.04.02	85 DX	3.35 DX
H11.036.04.03	95 DX	3.74 DX
H11.036.04.04	105 DX	4.13 DX
H11.036.04.05	115 DX	4.53 DX
H11.036.04.06	80 SX	3.15 SX
H11.036.05.01	75 SX	2.95 SX
H11.036.05.02	85 SX	3.35 SX
H11.036.05.03	95 SX	3.74 SX
H11.036.05.04	105 SX	4.13 SX
H11.036.05.05	115 SX	4.53 SX
H11.036.05.06	80 DX	3.15 DX

HRc 58-60



H12.014.0

975 kN/m max.

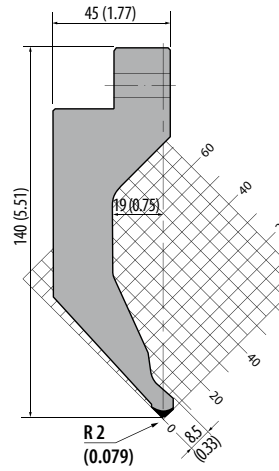


Model	Length	Weight
H12.014.01.01	100	3.94
H12.014.02.01	50	1.97
H12.014.02.02	55	2.17
H12.014.02.03	60	2.36
H12.014.02.04	65	2.56
H12.014.02.05	70	2.76
H12.014.02.06	75	2.95
H12.014.02.07	80	3.15
H12.014.02.08	85	3.35
H12.014.02.09	90	3.54
H12.014.02.10	95	3.74
H12.014.04.01	75 DX	2.95 DX
H12.014.04.02	85 DX	3.35 DX
H12.014.04.03	95 DX	3.74 DX
H12.014.04.04	105 DX	4.13 DX
H12.014.04.05	115 DX	4.53 DX
H12.014.04.06	80 SX	3.15 SX
H12.014.05.01	75 SX	2.95 SX
H12.014.05.02	85 SX	3.35 SX
H12.014.05.03	95 SX	3.74 SX
H12.014.05.04	105 SX	4.13 SX
H12.014.05.05	115 SX	4.53 SX
H12.014.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.052.0

975 kN/m max.

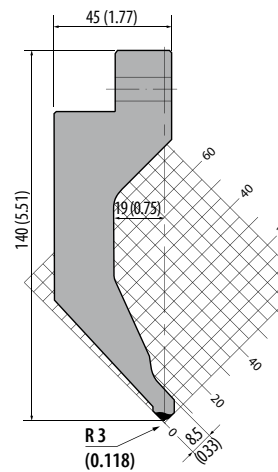


Model	Length	Weight
H12.052.01.01	100	3.94
H12.052.02.01	50	1.97
H12.052.02.02	55	2.17
H12.052.02.03	60	2.36
H12.052.02.04	65	2.56
H12.052.02.05	70	2.76
H12.052.02.06	75	2.95
H12.052.02.07	80	3.15
H12.052.02.08	85	3.35
H12.052.02.09	90	3.54
H12.052.02.10	95	3.74
H12.052.04.01	75 DX	2.95 DX
H12.052.04.02	85 DX	3.35 DX
H12.052.04.03	95 DX	3.74 DX
H12.052.04.04	105 DX	4.13 DX
H12.052.04.05	115 DX	4.53 DX
H12.052.04.06	80 SX	3.15 SX
H12.052.05.01	75 SX	2.95 SX
H12.052.05.02	85 SX	3.35 SX
H12.052.05.03	95 SX	3.74 SX
H12.052.05.04	105 SX	4.13 SX
H12.052.05.05	115 SX	4.53 SX
H12.052.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.053.0

975 kN/m max.

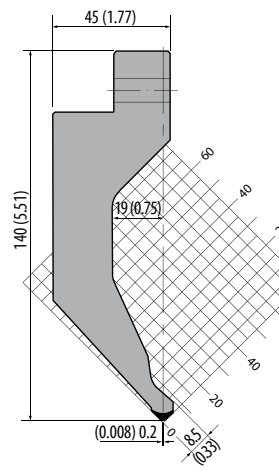


Model	Length	Weight
H12.053.01.01	100	3.94
H12.053.02.01	50	1.97
H12.053.02.02	55	2.17
H12.053.02.03	60	2.36
H12.053.02.04	65	2.56
H12.053.02.05	70	2.76
H12.053.02.06	75	2.95
H12.053.02.07	80	3.15
H12.053.02.08	85	3.35
H12.053.02.09	90	3.54
H12.053.02.10	95	3.74
H12.053.04.01	75 DX	2.95 DX
H12.053.04.02	85 DX	3.35 DX
H12.053.04.03	95 DX	3.74 DX
H12.053.04.04	105 DX	4.13 DX
H12.053.04.05	115 DX	4.53 DX
H12.053.04.06	80 SX	3.15 SX
H12.053.05.01	75 SX	2.95 SX
H12.053.05.02	85 SX	3.35 SX
H12.053.05.03	95 SX	3.74 SX
H12.053.05.04	105 SX	4.13 SX
H12.053.05.05	115 SX	4.53 SX
H12.053.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.019.0

975 kN/m max.

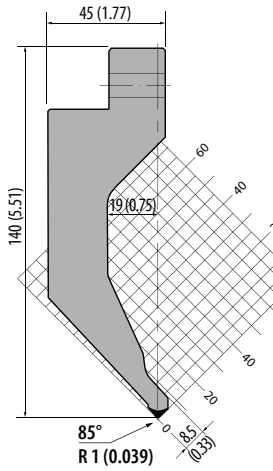


Model	Length	Weight
H12.019.01.01	100	3.94
H12.019.02.01	50	1.97
H12.019.02.02	55	2.17
H12.019.02.03	60	2.36
H12.019.02.04	65	2.56
H12.019.02.05	70	2.76
H12.019.02.06	75	2.95
H12.019.02.07	80	3.15
H12.019.02.08	85	3.35
H12.019.02.09	90	3.54
H12.019.02.10	95	3.74
H12.019.04.01	75 DX	2.95 DX
H12.019.04.02	85 DX	3.35 DX
H12.019.04.03	95 DX	3.74 DX
H12.019.04.04	105 DX	4.13 DX
H12.019.04.05	115 DX	4.53 DX
H12.019.04.06	80 SX	3.15 SX
H12.019.05.01	75 SX	2.95 SX
H12.019.05.02	85 SX	3.35 SX
H12.019.05.03	95 SX	3.74 SX
H12.019.05.04	105 SX	4.13 SX
H12.019.05.05	115 SX	4.53 SX
H12.019.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.015.0

975 kN/m max.

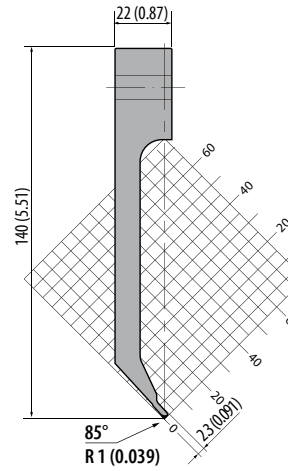


Model	Length	Weight
H12.015.01.01	100	3.94
H12.015.02.01	50	1.97
H12.015.02.02	55	2.17
H12.015.02.03	60	2.36
H12.015.02.04	65	2.56
H12.015.02.05	70	2.76
H12.015.02.06	75	2.95
H12.015.02.07	80	3.15
H12.015.02.08	85	3.35
H12.015.02.09	90	3.54
H12.015.02.10	95	3.74
H12.015.04.01	75 DX	2.95 DX
H12.015.04.02	85 DX	3.35 DX
H12.015.04.03	95 DX	3.74 DX
H12.015.04.04	105 DX	4.13 DX
H12.015.04.05	115 DX	4.53 DX
H12.015.04.06	80 SX	3.15 SX
H12.015.05.01	75 SX	2.95 SX
H12.015.05.02	85 SX	3.35 SX
H12.015.05.03	95 SX	3.74 SX
H12.015.05.04	105 SX	4.13 SX
H12.015.05.05	115 SX	4.53 SX
H12.015.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.025.0

250 kN/m max.

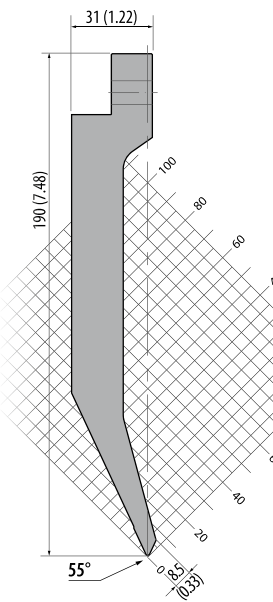


Model	Length	Weight
H12.025.01.01	100	3.94
H12.025.02.01	50	1.97
H12.025.02.02	55	2.17
H12.025.02.03	60	2.36
H12.025.02.04	65	2.56
H12.025.02.05	70	2.76
H12.025.02.06	75	2.95
H12.025.02.07	80	3.15
H12.025.02.08	85	3.35
H12.025.02.09	90	3.54
H12.025.02.10	95	3.74
H12.025.04.01	75 DX	2.95 DX
H12.025.04.02	85 DX	3.35 DX
H12.025.04.03	95 DX	3.74 DX
H12.025.04.04	105 DX	4.13 DX
H12.025.04.05	115 DX	4.53 DX
H12.025.04.06	80 SX	3.15 SX
H12.025.05.01	75 SX	2.95 SX
H12.025.05.02	85 SX	3.35 SX
H12.025.05.03	95 SX	3.74 SX
H12.025.05.04	105 SX	4.13 SX
H12.025.05.05	115 SX	4.53 SX
H12.025.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.017.0

750 kN/m max.

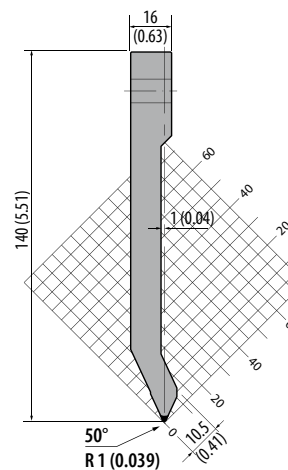


Model	Length	Weight
H12.017.01.01	100	3.94
H12.017.02.01	50	1.97
H12.017.02.02	55	2.17
H12.017.02.03	60	2.36
H12.017.02.04	65	2.56
H12.017.02.05	70	2.76
H12.017.02.06	75	2.95
H12.017.02.07	80	3.15
H12.017.02.08	85	3.35
H12.017.02.09	90	3.54
H12.017.02.10	95	3.74
H12.017.04.01	75 DX	2.95 DX
H12.017.04.02	85 DX	3.35 DX
H12.017.04.03	95 DX	3.74 DX
H12.017.04.04	105 DX	4.13 DX
H12.017.04.05	115 DX	4.53 DX
H12.017.04.06	80 SX	3.15 SX
H12.017.05.01	75 SX	2.95 SX
H12.017.05.02	85 SX	3.35 SX
H12.017.05.03	95 SX	3.74 SX
H12.017.05.04	105 SX	4.13 SX
H12.017.05.05	115 SX	4.53 SX
H12.017.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.065.0

1000 kN/m max.



Model	Length	Weight
H12.065.01.01	100	3.94
H12.065.02.01	50	1.97
H12.065.02.02	55	2.17
H12.065.02.03	60	2.36
H12.065.02.04	65	2.56
H12.065.02.05	70	2.76
H12.065.02.06	75	2.95
H12.065.02.07	80	3.15
H12.065.02.08	85	3.35
H12.065.02.09	90	3.54
H12.065.02.10	95	3.74
H12.065.04.01	75 DX	2.95 DX
H12.065.04.02	85 DX	3.35 DX
H12.065.04.03	95 DX	3.74 DX
H12.065.04.04	105 DX	4.13 DX
H12.065.04.05	115 DX	4.53 DX
H12.065.04.06	80 SX	3.15 SX
H12.065.05.01	75 SX	2.95 SX
H12.065.05.02	85 SX	3.35 SX
H12.065.05.03	95 SX	3.74 SX
H12.065.05.04	105 SX	4.13 SX
H12.065.05.05	115 SX	4.53 SX
H12.065.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

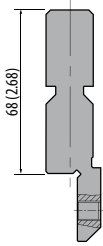
7
RX

RX ROLLERI TYPE RX

Punch holders Hämmerle-Bystronic

H21.003.0

1000 kN/m max.



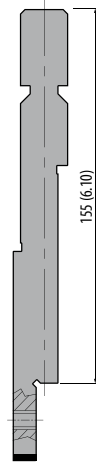
Model	Length	Weight
H21.003.01.01	100	3.94
H21.003.01.03	200	7.87
H21.003.02.01	50	1.97
H21.003.02.02	55	2.17
H21.003.02.03	60	2.36
H21.003.02.04	65	2.56
H21.003.02.05	70	2.76
H21.003.02.06	75	2.95
H21.003.02.07	80	3.15
H21.003.02.08	85	3.35
H21.003.02.09	90	3.54
H21.003.02.10	95	3.74
H21.003.04.01	75 DX	2.95 DX
H21.003.04.02	85 DX	3.35 DX
H21.003.04.03	95 DX	3.74 DX
H21.003.04.04	105 DX	4.13 DX
H21.003.04.05	115 DX	4.53 DX
H21.003.04.06	80 SX	3.15 SX
H21.003.05.01	75 SX	2.95 SX
H21.003.05.02	85 SX	3.35 SX
H21.003.05.03	95 SX	3.74 SX
H21.003.05.04	105 SX	4.13 SX
H21.003.05.05	115 SX	4.53 SX
H21.003.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



H21.002.0

1000 kN/m max.



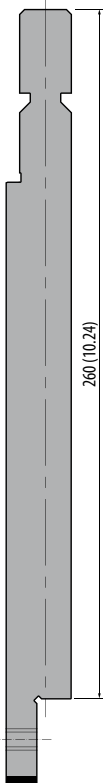
Model	Length	Weight
H21.002.01.01	100	3.94
H21.002.01.03	200	7.87
H21.002.02.01	50	1.97
H21.002.02.02	55	2.17
H21.002.02.03	60	2.36
H21.002.02.04	65	2.56
H21.002.02.05	70	2.76
H21.002.02.06	75	2.95
H21.002.02.07	80	3.15
H21.002.02.08	85	3.35
H21.002.02.09	90	3.54
H21.002.02.10	95	3.74
H21.002.04.01	75 DX	2.95 DX
H21.002.04.02	85 DX	3.35 DX
H21.002.04.03	95 DX	3.74 DX
H21.002.04.04	105 DX	4.13 DX
H21.002.04.05	115 DX	4.53 DX
H21.002.04.06	80 SX	3.15 SX
H21.002.05.01	75 SX	2.95 SX
H21.002.05.02	85 SX	3.35 SX
H21.002.05.03	95 SX	3.74 SX
H21.002.05.04	105 SX	4.13 SX
H21.002.05.05	115 SX	4.53 SX
H21.002.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



H21.005.0

1000 kN/m max.



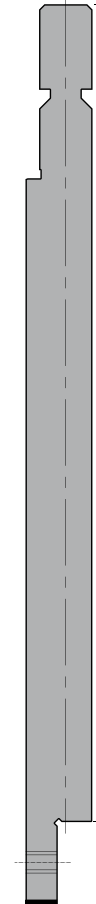
Model	Length	Weight
H21.005.01.01	100	3.94
H21.005.01.03	200	7.87
H21.005.02.01	50	1.97
H21.005.02.02	55	2.17
H21.005.02.03	60	2.36
H21.005.02.04	65	2.56
H21.005.02.05	70	2.76
H21.005.02.06	75	2.95
H21.005.02.07	80	3.15
H21.005.02.08	85	3.35
H21.005.02.09	90	3.54
H21.005.02.10	95	3.74
H21.005.04.01	75 DX	2.95 DX
H21.005.04.02	85 DX	3.35 DX
H21.005.04.03	95 DX	3.74 DX
H21.005.04.04	105 DX	4.13 DX
H21.005.04.05	115 DX	4.53 DX
H21.005.04.06	80 SX	3.15 SX
H21.005.05.01	75 SX	2.95 SX
H21.005.05.02	85 SX	3.35 SX
H21.005.05.03	95 SX	3.74 SX
H21.005.05.04	105 SX	4.13 SX
H21.005.05.05	115 SX	4.53 SX
H21.005.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



H21.010.0

1000 kN/m max.



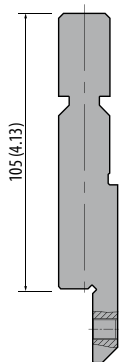
Model	Length	Weight
H21.010.01.01	100	3.94
H21.010.01.03	200	7.87
H21.010.02.01	50	1.97
H21.010.02.02	55	2.17
H21.010.02.03	60	2.36
H21.010.02.04	65	2.56
H21.010.02.05	70	2.76
H21.010.02.06	75	2.95
H21.010.02.07	80	3.15
H21.010.02.08	85	3.35
H21.010.02.09	90	3.54
H21.010.02.10	95	3.74
H21.010.04.01	75 DX	2.95 DX
H21.010.04.02	85 DX	3.35 DX
H21.010.04.03	95 DX	3.74 DX
H21.010.04.04	105 DX	4.13 DX
H21.010.04.05	115 DX	4.53 DX
H21.010.04.06	80 SX	3.15 SX
H21.010.05.01	75 SX	2.95 SX
H21.010.05.02	85 SX	3.35 SX
H21.010.05.03	95 SX	3.74 SX
H21.010.05.04	105 SX	4.13 SX
H21.010.05.05	115 SX	4.53 SX
H21.010.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



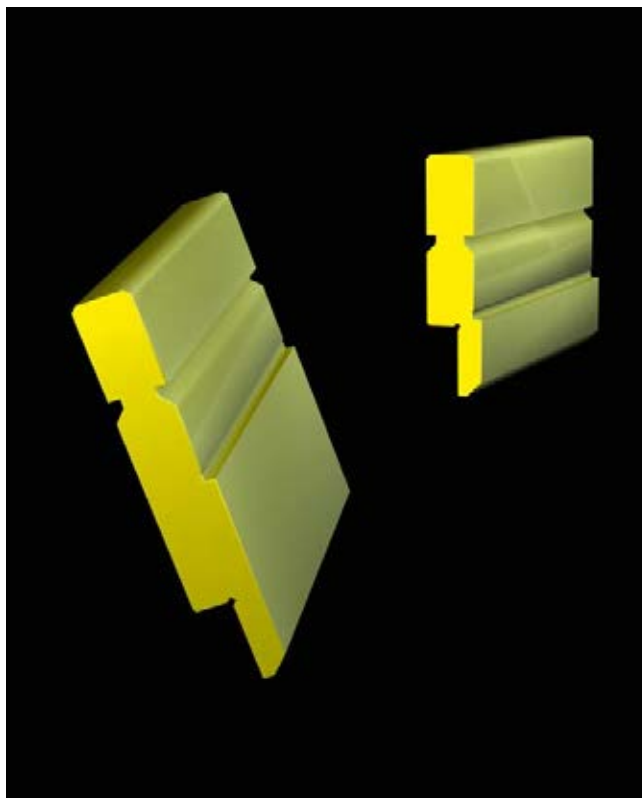
H21.004.0

1000 kN/m max.



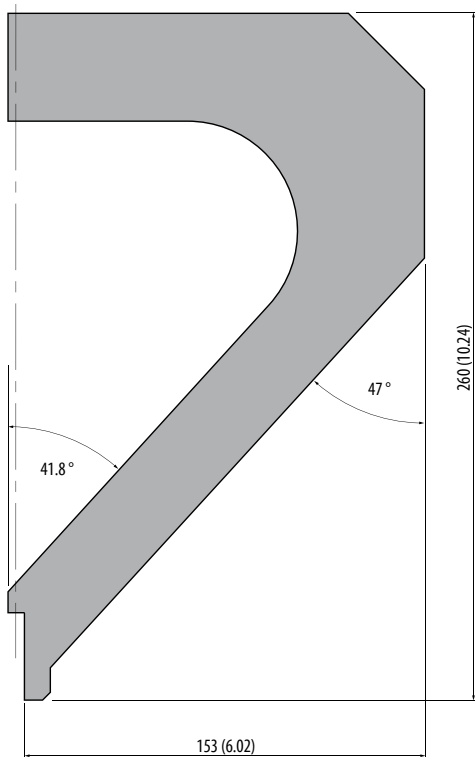
Model	Length	Weight
H21.004.01.01	100	3.94
H21.004.01.03	200	7.87
H21.004.02.01	50	1.97
H21.004.02.02	55	2.17
H21.004.02.03	60	2.36
H21.004.02.04	65	2.56
H21.004.02.05	70	2.76
H21.004.02.06	75	2.95
H21.004.02.07	80	3.15
H21.004.02.08	85	3.35
H21.004.02.09	90	3.54
H21.004.02.10	95	3.74
H21.004.04.01	75 DX	2.95 DX
H21.004.04.02	85 DX	3.35 DX
H21.004.04.03	95 DX	3.74 DX
H21.004.04.04	105 DX	4.13 DX
H21.004.04.05	115 DX	4.53 DX
H21.004.04.06	80 SX	3.15 SX
H21.004.05.01	75 SX	2.95 SX
H21.004.05.02	85 SX	3.35 SX
H21.004.05.03	95 SX	3.74 SX
H21.004.05.04	105 SX	4.13 SX
H21.004.05.05	115 SX	4.53 SX
H21.004.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



H22.006.0

600 kN/m max.



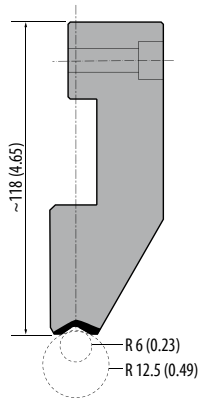
Model	Length	Weight
H22.006.01.01	100	3.94
H22.006.02.01	50	1.97
H22.006.02.02	55	2.17
H22.006.02.03	60	2.36
H22.006.02.04	65	2.56
H22.006.02.05	70	2.76
H22.006.02.06	75	2.95
H22.006.02.07	80	3.15
H22.006.02.08	85	3.35
H22.006.02.09	90	3.54
H22.006.02.10	95	3.74

42Cr: 900-1150 N/mm²

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RX

H22.013.0

1000 kN/m max.



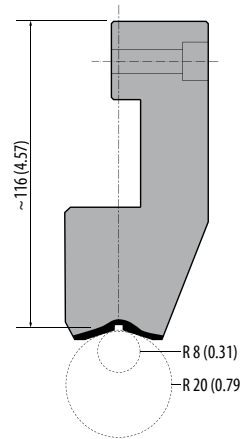
Model	Length	Weight
H22.013.01.01	100	3.94
H22.013.02.01	50	1.97
H22.013.02.02	55	2.17
H22.013.02.03	60	2.36
H22.013.02.04	65	2.56
H22.013.02.05	70	2.76
H22.013.02.06	75	2.95
H22.013.02.07	80	3.15
H22.013.02.08	85	3.35
H22.013.02.09	90	3.54
H22.013.02.10	95	3.74

C45: 560-710 N/mm²



H22.014.0

1000 kN/m max.



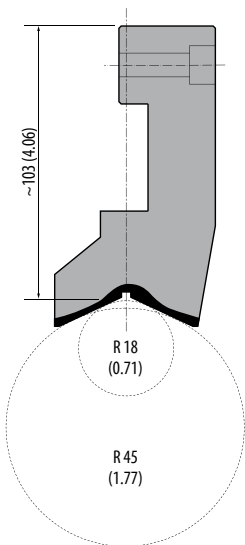
Model	Length	Weight
H22.014.01.01	100	3.94
H22.014.02.01	50	1.97
H22.014.02.02	55	2.17
H22.014.02.03	60	2.36
H22.014.02.04	65	2.56
H22.014.02.05	70	2.76
H22.014.02.06	75	2.95
H22.014.02.07	80	3.15
H22.014.02.08	85	3.35
H22.014.02.09	90	3.54
H22.014.02.10	95	3.74

C45: 560-710 N/mm²



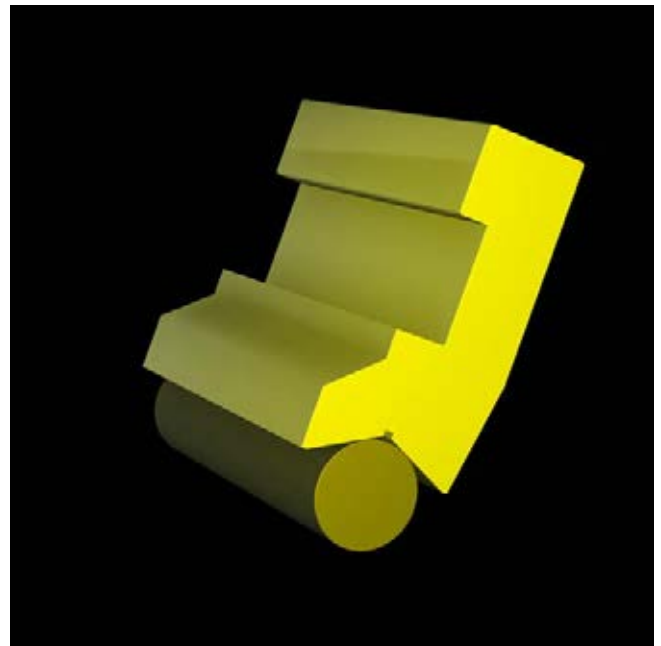
H22.015.0

1000 kN/m max.

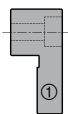


Model	Length	Weight
H22.015.01.01	100	3.94
H22.015.02.01	50	1.97
H22.015.02.02	55	2.17
H22.015.02.03	60	2.36
H22.015.02.04	65	2.56
H22.015.02.05	70	2.76
H22.015.02.06	75	2.95
H22.015.02.07	80	3.15
H22.015.02.08	85	3.35
H22.015.02.09	90	3.54
H22.015.02.10	95	3.74

C45: 560-710 N/mm²



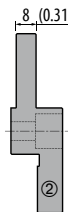
H61.100.01 / H61.500.01



Model	Length	Weight
H61.100.01	100	0.63 kg
H61.500.01	500	3.15 kg

C45: 560-710 N/mm² 

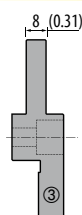
H61.100.02 / H61.500.02



Model	Length	Weight
H61.100.02	100	0.70 kg
H61.500.02	500	3.50 kg

C45: 560-710 N/mm² 

H61.100.03 / H61.500.03



Model	Length	Price	Weight
H61.100.03	100	3.94	0.70 kg
H61.500.03	500	19.68	3.50 kg

C45: 560-710 N/mm² 

H61.100.04 / H61.500.04



Model	Length	Weight
H61.100.04	100	0.63 kg
H61.500.04	500	3.15 kg

C45: 560-710 N/mm² 

H61.100.05 / H61.500.05



Model	Length	Weight
H61.100.05	100	0.30 kg
H61.500.05	500	1.50 kg

C45: 560-710 N/mm² 

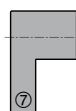
H61.100.06 / H61.500.06



Model	Length	Weight
H61.100.06	100	0.63 kg
H61.500.06	500	3.15 kg

C45: 560-710 N/mm² 

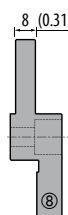
H61.100.07



Model	Length	Weight
H61.100.07	100	0.65 kg

C45: 560-710 N/mm² 

H61.100.08 / H61.500.08



Model	Length	Weight
H61.100.08	100	0.70 kg
H61.500.08	500	3.50 kg

C45: 560-710 N/mm² 

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RX



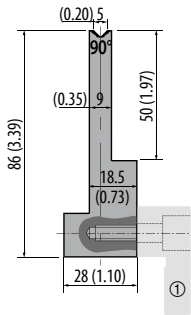
Rolleri Videos

find updated and helpful videos at:
[www.rolleritools.com/
videos/overview](http://www.rolleritools.com/videos/overview)



H41.005.0

1000 kN/m max.

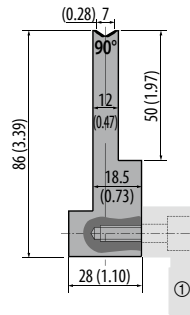


Model	Length	Weight
H41.005.01.01	100	3.94
H41.005.02.01	50 SX	1.97 SX
H41.005.02.02	55 DX	2.17 DX
H41.005.02.03	60 DX	2.36 DX
H41.005.02.04	65 DX	2.56 DX
H41.005.02.05	70 DX	2.76 DX
H41.005.02.06	75 DX	2.95 DX
H41.005.02.07	80 DX	3.15 DX
H41.005.02.08	85 DX	3.35 DX
H41.005.02.09	90 DX	3.54 DX
H41.005.02.10	95 DX	3.74 DX
H41.005.03.01	50 DX	1.97 DX
H41.005.03.02	55 SX	2.17 SX
H41.005.03.03	60 SX	2.36 SX
H41.005.03.04	65 SX	2.56 SX
H41.005.03.05	70 SX	2.76 SX
H41.005.03.06	75 SX	2.95 SX
H41.005.03.07	80 SX	3.15 SX
H41.005.03.08	85 SX	3.35 SX
H41.005.03.09	90 SX	3.54 SX
H41.005.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H41.007.0

1000 kN/m max.

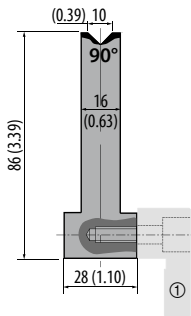


Model	Length	Weight
H41.007.01.01	100	3.94
H41.007.02.01	50 SX	1.97 SX
H41.007.02.02	55 DX	2.17 DX
H41.007.02.03	60 DX	2.36 DX
H41.007.02.04	65 DX	2.56 DX
H41.007.02.05	70 DX	2.76 DX
H41.007.02.06	75 DX	2.95 DX
H41.007.02.07	80 DX	3.15 DX
H41.007.02.08	85 DX	3.35 DX
H41.007.02.09	90 DX	3.54 DX
H41.007.02.10	95 DX	3.74 DX
H41.007.03.01	50 DX	1.97 DX
H41.007.03.02	55 SX	2.17 SX
H41.007.03.03	60 SX	2.36 SX
H41.007.03.04	65 SX	2.56 SX
H41.007.03.05	70 SX	2.76 SX
H41.007.03.06	75 SX	2.95 SX
H41.007.03.07	80 SX	3.15 SX
H41.007.03.08	85 SX	3.35 SX
H41.007.03.09	90 SX	3.54 SX
H41.007.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H41.010.0

1000 kN/m max.

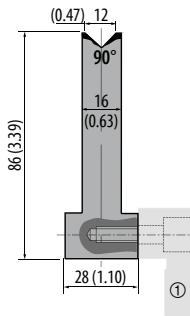


Model	Length	Weight
H41.010.01.01	100	3.94
H41.010.02.01	50 SX	1.97 SX
H41.010.02.02	55 DX	2.17 DX
H41.010.02.03	60 DX	2.36 DX
H41.010.02.04	65 DX	2.56 DX
H41.010.02.05	70 DX	2.76 DX
H41.010.02.06	75 DX	2.95 DX
H41.010.02.07	80 DX	3.15 DX
H41.010.02.08	85 DX	3.35 DX
H41.010.02.09	90 DX	3.54 DX
H41.010.02.10	95 DX	3.74 DX
H41.010.03.01	50 DX	1.97 DX
H41.010.03.02	55 SX	2.17 SX
H41.010.03.03	60 SX	2.36 SX
H41.010.03.04	65 SX	2.56 SX
H41.010.03.05	70 SX	2.76 SX
H41.010.03.06	75 SX	2.95 SX
H41.010.03.07	80 SX	3.15 SX
H41.010.03.08	85 SX	3.35 SX
H41.010.03.09	90 SX	3.54 SX
H41.010.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H41.012.0

1000 kN/m max.

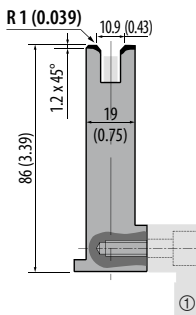


Model	Length	Weight
H41.012.01.01	100	3.94
H41.012.02.01	50 SX	1.97 SX
H41.012.02.02	55 DX	2.17 DX
H41.012.02.03	60 DX	2.36 DX
H41.012.02.04	65 DX	2.56 DX
H41.012.02.05	70 DX	2.76 DX
H41.012.02.06	75 DX	2.95 DX
H41.012.02.07	80 DX	3.15 DX
H41.012.02.08	85 DX	3.35 DX
H41.012.02.09	90 DX	3.54 DX
H41.012.02.10	95 DX	3.74 DX
H41.012.03.01	50 DX	1.97 DX
H41.012.03.02	55 SX	2.17 SX
H41.012.03.03	60 SX	2.36 SX
H41.012.03.04	65 SX	2.56 SX
H41.012.03.05	70 SX	2.76 SX
H41.012.03.06	75 SX	2.95 SX
H41.012.03.07	80 SX	3.15 SX
H41.012.03.08	85 SX	3.35 SX
H41.012.03.09	90 SX	3.54 SX
H41.012.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H31.010.2

550 kN/m max.

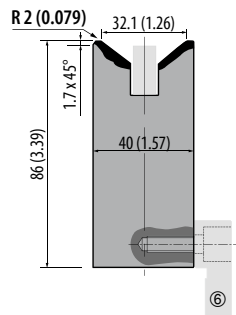


Model	Length	Weight
H31.010.21.01	100	3.94
H31.010.22.01	50 SX	1.97 SX
H31.010.22.02	55 DX	2.17 DX
H31.010.22.03	60 DX	2.36 DX
H31.010.22.04	65 DX	2.56 DX
H31.010.22.05	70 DX	2.76 DX
H31.010.22.06	75 DX	2.95 DX
H31.010.22.07	80 DX	3.15 DX
H31.010.22.08	85 DX	3.35 DX
H31.010.22.09	90 DX	3.54 DX
H31.010.22.10	95 DX	3.74 DX
H31.010.23.01	50 DX	1.97 DX
H31.010.23.02	55 SX	2.17 SX
H31.010.23.03	60 SX	2.36 SX
H31.010.23.04	65 SX	2.56 SX
H31.010.23.05	70 SX	2.76 SX
H31.010.23.06	75 SX	2.95 SX
H31.010.23.07	80 SX	3.15 SX
H31.010.23.08	85 SX	3.35 SX
H31.010.23.09	90 SX	3.54 SX
H31.010.23.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H31.032.1

1200 kN/m max.

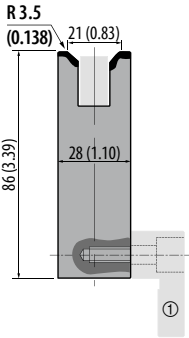


Model	Length	Weight
H31.032.11.01	100	3.94
H31.032.12.01	50 SX	1.97 SX
H31.032.12.02	55 DX	2.17 DX
H31.032.12.03	60 DX	2.36 DX
H31.032.12.04	65 DX	2.56 DX
H31.032.12.05	70 DX	2.76 DX
H31.032.12.06	75 DX	2.95 DX
H31.032.12.07	80 DX	3.15 DX
H31.032.12.08	85 DX	3.35 DX
H31.032.12.09	90 DX	3.54 DX
H31.032.12.10	95 DX	3.74 DX
H31.032.13.01	50 DX	1.97 DX
H31.032.13.02	55 SX	2.17 SX
H31.032.13.03	60 SX	2.36 SX
H31.032.13.04	65 SX	2.56 SX
H31.032.13.05	70 SX	2.76 SX
H31.032.13.06	75 SX	2.95 SX
H31.032.13.07	80 SX	3.15 SX
H31.032.13.08	85 SX	3.35 SX
H31.032.13.09	90 SX	3.54 SX
H31.032.13.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.021.0

500 kN/m max.

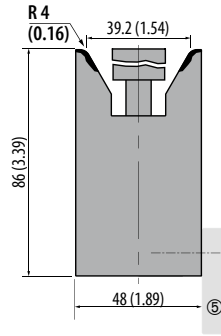


Model	Length	Weight
H31.021.01.01	100	3.94
H31.021.02.01	50 SX	1.97 SX
H31.021.02.02	55 DX	2.17 DX
H31.021.02.03	60 DX	2.36 DX
H31.021.02.04	65 DX	2.56 DX
H31.021.02.05	70 DX	2.76 DX
H31.021.02.06	75 DX	2.95 DX
H31.021.02.07	80 DX	3.15 DX
H31.021.02.08	85 DX	3.35 DX
H31.021.02.09	90 DX	3.54 DX
H31.021.02.10	95 DX	3.74 DX
H31.021.03.01	50 DX	1.97 DX
H31.021.03.02	55 SX	2.17 SX
H31.021.03.03	60 SX	2.36 SX
H31.021.03.04	65 SX	2.56 SX
H31.021.03.05	70 SX	2.76 SX
H31.021.03.06	75 SX	2.95 SX
H31.021.03.07	80 SX	3.15 SX
H31.021.03.08	85 SX	3.35 SX
H31.021.03.09	90 SX	3.54 SX
H31.021.03.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.040.1

750 kN/m max.

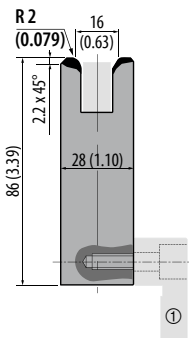


Model	Length	Weight
H31.040.11.01	100	3.94
H31.040.12.01	50 SX	1.97 SX
H31.040.12.02	55 DX	2.17 DX
H31.040.12.03	60 DX	2.36 DX
H31.040.12.04	65 DX	2.56 DX
H31.040.12.05	70 DX	2.76 DX
H31.040.12.06	75 DX	2.95 DX
H31.040.12.07	80 DX	3.15 DX
H31.040.12.08	85 DX	3.35 DX
H31.040.12.09	90 DX	3.54 DX
H31.040.12.10	95 DX	3.74 DX
H31.040.13.01	50 DX	1.97 DX
H31.040.13.02	55 SX	2.17 SX
H31.040.13.03	60 SX	2.36 SX
H31.040.13.04	65 SX	2.56 SX
H31.040.13.05	70 SX	2.76 SX
H31.040.13.06	75 SX	2.95 SX
H31.040.13.07	80 SX	3.15 SX
H31.040.13.08	85 SX	3.35 SX
H31.040.13.09	90 SX	3.54 SX
H31.040.13.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.016.0

500 kN/m max.

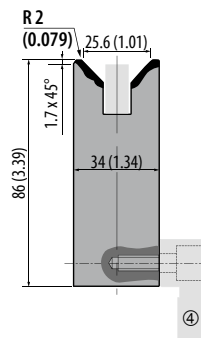


Model	Length	Weight
H31.016.01.01	100	3.94
H31.016.02.01	50 SX	1.97 SX
H31.016.02.02	55 DX	2.17 DX
H31.016.02.03	60 DX	2.36 DX
H31.016.02.04	65 DX	2.56 DX
H31.016.02.05	70 DX	2.76 DX
H31.016.02.06	75 DX	2.95 DX
H31.016.02.07	80 DX	3.15 DX
H31.016.02.08	85 DX	3.35 DX
H31.016.02.09	90 DX	3.54 DX
H31.016.02.10	95 DX	3.74 DX
H31.016.03.01	50 DX	1.97 DX
H31.016.03.02	55 SX	2.17 SX
H31.016.03.03	60 SX	2.36 SX
H31.016.03.04	65 SX	2.56 SX
H31.016.03.05	70 SX	2.76 SX
H31.016.03.06	75 SX	2.95 SX
H31.016.03.07	80 SX	3.15 SX
H31.016.03.08	85 SX	3.35 SX
H31.016.03.09	90 SX	3.54 SX
H31.016.03.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.024.0

750 kN/m max.

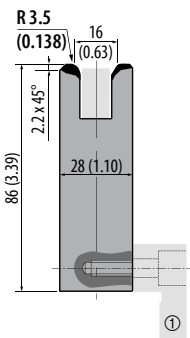


Model	Length	Weight
H31.024.01.01	100	3.94
H31.024.02.01	50 SX	1.97 SX
H31.024.02.02	55 DX	2.17 DX
H31.024.02.03	60 DX	2.36 DX
H31.024.02.04	65 DX	2.56 DX
H31.024.02.05	70 DX	2.76 DX
H31.024.02.06	75 DX	2.95 DX
H31.024.02.07	80 DX	3.15 DX
H31.024.02.08	85 DX	3.35 DX
H31.024.02.09	90 DX	3.54 DX
H31.024.02.10	95 DX	3.74 DX
H31.024.03.01	50 DX	1.97 DX
H31.024.03.02	55 SX	2.17 SX
H31.024.03.03	60 SX	2.36 SX
H31.024.03.04	65 SX	2.56 SX
H31.024.03.05	70 SX	2.76 SX
H31.024.03.06	75 SX	2.95 SX
H31.024.03.07	80 SX	3.15 SX
H31.024.03.08	85 SX	3.35 SX
H31.024.03.09	90 SX	3.54 SX
H31.024.03.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.016.1

500 kN/m max.

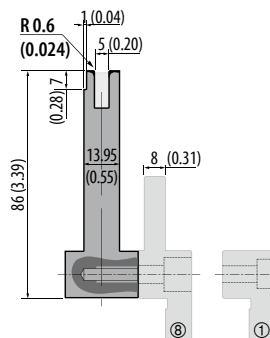


Model	Length	Weight
H31.016.11.01	100	3.94
H31.016.12.01	50 SX	1.97 SX
H31.016.12.02	55 DX	2.17 DX
H31.016.12.03	60 DX	2.36 DX
H31.016.12.04	65 DX	2.56 DX
H31.016.12.05	70 DX	2.76 DX
H31.016.12.06	75 DX	2.95 DX
H31.016.12.07	80 DX	3.15 DX
H31.016.12.08	85 DX	3.35 DX
H31.016.12.09	90 DX	3.54 DX
H31.016.12.10	95 DX	3.74 DX
H31.016.13.01	50 DX	1.97 DX
H31.016.13.02	55 SX	2.17 SX
H31.016.13.03	60 SX	2.36 SX
H31.016.13.04	65 SX	2.56 SX
H31.016.13.05	70 SX	2.76 SX
H31.016.13.06	75 SX	2.95 SX
H31.016.13.07	80 SX	3.15 SX
H31.016.13.08	85 SX	3.35 SX
H31.016.13.09	90 SX	3.54 SX
H31.016.13.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.005.0

250 kN/m max.



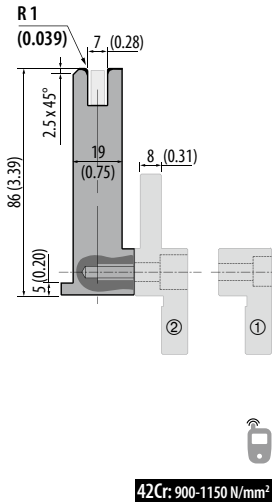
Model	Length	Weight
H31.005.01.01	100	3.94
H31.005.02.01	50 SX	1.97 SX
H31.005.02.02	55 DX	2.17 DX
H31.005.02.03	60 DX	2.36 DX
H31.005.02.04	65 DX	2.56 DX
H31.005.02.05	70 DX	2.76 DX
H31.005.02.06	75 DX	2.95 DX
H31.005.02.07	80 DX	3.15 DX
H31.005.02.08	85 DX	3.35 DX
H31.005.02.09	90 DX	3.54 DX
H31.005.02.10	95 DX	3.74 DX
H31.005.03.01	50 DX	1.97 DX
H31.005.03.02	55 SX	2.17 SX
H31.005.03.03	60 SX	2.36 SX
H31.005.03.04	65 SX	2.56 SX
H31.005.03.05	70 SX	2.76 SX
H31.005.03.06	75 SX	2.95 SX
H31.005.03.07	80 SX	3.15 SX
H31.005.03.08	85 SX	3.35 SX
H31.005.03.09	90 SX	3.54 SX
H31.005.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

7
RX

H31.007.0

500 kN/m max.

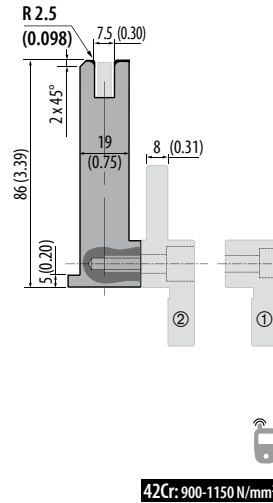


Model	Length	Weight
H31.007.01.01	100	3.94
H31.007.02.01	50 SX	1.97 SX
H31.007.02.02	55 DX	2.17 DX
H31.007.02.03	60 DX	2.36 DX
H31.007.02.04	65 DX	2.56 DX
H31.007.02.05	70 DX	2.76 DX
H31.007.02.06	75 DX	2.95 DX
H31.007.02.07	80 DX	3.15 DX
H31.007.02.08	85 DX	3.35 DX
H31.007.02.09	90 DX	3.54 DX
H31.007.02.10	95 DX	3.74 DX
H31.007.03.01	50 DX	1.97 DX
H31.007.03.02	55 SX	2.17 SX
H31.007.03.03	60 SX	2.36 SX
H31.007.03.04	65 SX	2.56 SX
H31.007.03.05	70 SX	2.76 SX
H31.007.03.06	75 SX	2.95 SX
H31.007.03.07	80 SX	3.15 SX
H31.007.03.08	85 SX	3.35 SX
H31.007.03.09	90 SX	3.54 SX
H31.007.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H31.007.2

500 kN/m max.

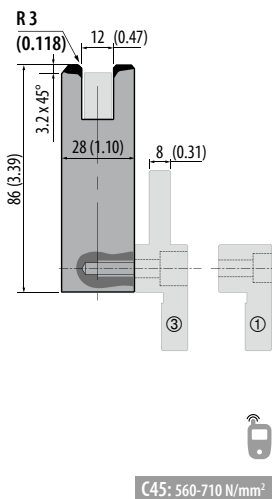


Model	Length	Weight
H31.007.21.01	100	3.94
H31.007.22.01	50 SX	1.97 SX
H31.007.22.02	55 DX	2.17 DX
H31.007.22.03	60 DX	2.36 DX
H31.007.22.04	65 DX	2.56 DX
H31.007.22.05	70 DX	2.76 DX
H31.007.22.06	75 DX	2.95 DX
H31.007.22.07	80 DX	3.15 DX
H31.007.22.08	85 DX	3.35 DX
H31.007.22.09	90 DX	3.54 DX
H31.007.22.10	95 DX	3.74 DX
H31.007.23.01	50 DX	1.97 DX
H31.007.23.02	55 SX	2.17 SX
H31.007.23.03	60 SX	2.36 SX
H31.007.23.04	65 SX	2.56 SX
H31.007.23.05	70 SX	2.76 SX
H31.007.23.06	75 SX	2.95 SX
H31.007.23.07	80 SX	3.15 SX
H31.007.23.08	85 SX	3.35 SX
H31.007.23.09	90 SX	3.54 SX
H31.007.23.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H31.013.0

500 kN/m max.

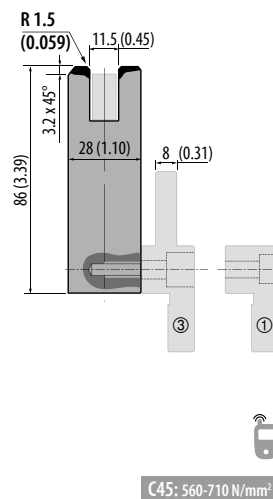


Model	Length	Weight
H31.013.01.01	100	3.94
H31.013.02.01	50 SX	1.97 SX
H31.013.02.02	55 DX	2.17 DX
H31.013.02.03	60 DX	2.36 DX
H31.013.02.04	65 DX	2.56 DX
H31.013.02.05	70 DX	2.76 DX
H31.013.02.06	75 DX	2.95 DX
H31.013.02.07	80 DX	3.15 DX
H31.013.02.08	85 DX	3.35 DX
H31.013.02.09	90 DX	3.54 DX
H31.013.02.10	95 DX	3.74 DX
H31.013.03.01	50 DX	1.97 DX
H31.013.03.02	55 SX	2.17 SX
H31.013.03.03	60 SX	2.36 SX
H31.013.03.04	65 SX	2.56 SX
H31.013.03.05	70 SX	2.76 SX
H31.013.03.06	75 SX	2.95 SX
H31.013.03.07	80 SX	3.15 SX
H31.013.03.08	85 SX	3.35 SX
H31.013.03.09	90 SX	3.54 SX
H31.013.03.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.012.0

500 kN/m max.

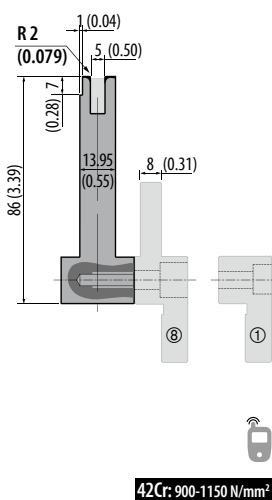


Model	Length	Weight
H31.012.01.01	100	3.94
H31.012.02.01	50 SX	1.97 SX
H31.012.02.02	55 DX	2.17 DX
H31.012.02.03	60 DX	2.36 DX
H31.012.02.04	65 DX	2.56 DX
H31.012.02.05	70 DX	2.76 DX
H31.012.02.06	75 DX	2.95 DX
H31.012.02.07	80 DX	3.15 DX
H31.012.02.08	85 DX	3.35 DX
H31.012.02.09	90 DX	3.54 DX
H31.012.02.10	95 DX	3.74 DX
H31.012.03.01	50 DX	1.97 DX
H31.012.03.02	55 SX	2.17 SX
H31.012.03.03	60 SX	2.36 SX
H31.012.03.04	65 SX	2.56 SX
H31.012.03.05	70 SX	2.76 SX
H31.012.03.06	75 SX	2.95 SX
H31.012.03.07	80 SX	3.15 SX
H31.012.03.08	85 SX	3.35 SX
H31.012.03.09	90 SX	3.54 SX
H31.012.03.10	95 SX	3.74 SX

C45: 560-710 N/mm²

H31.006.0

350 kN/m max.

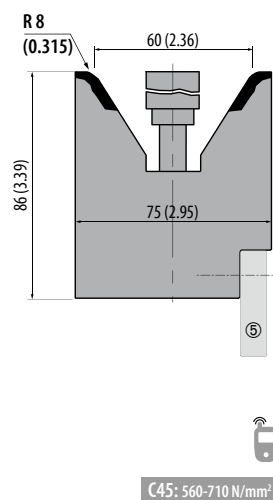


Model	Length	Weight
H31.006.01.01	100	3.94
H31.006.02.01	50 SX	1.97 SX
H31.006.02.02	55 DX	2.17 DX
H31.006.02.03	60 DX	2.36 DX
H31.006.02.04	65 DX	2.56 DX
H31.006.02.05	70 DX	2.76 DX
H31.006.02.06	75 DX	2.95 DX
H31.006.02.07	80 DX	3.15 DX
H31.006.02.08	85 DX	3.35 DX
H31.006.02.09	90 DX	3.54 DX
H31.006.02.10	95 DX	3.74 DX
H31.006.03.01	50 DX	1.97 DX
H31.006.03.02	55 SX	2.17 SX
H31.006.03.03	60 SX	2.36 SX
H31.006.03.04	65 SX	2.56 SX
H31.006.03.05	70 SX	2.76 SX
H31.006.03.06	75 SX	2.95 SX
H31.006.03.07	80 SX	3.15 SX
H31.006.03.08	85 SX	3.35 SX
H31.006.03.09	90 SX	3.54 SX
H31.006.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm²

H31.060.0

1500 kN/m max.



Model	Length	Weight
H31.060.01.01	100	3.94
H31.060.02.01	50 SX	1.97 SX
H31.060.02.02	55 DX	2.17 DX
H31.060.02.03	60 DX	2.36 DX
H31.060.02.04	65 DX	2.56 DX
H31.060.02.05	70 DX	2.76 DX
H31.060.02.06	75 DX	2.95 DX
H31.060.02.07	80 DX	3.15 DX
H31.060.02.08	85 DX	3.35 DX
H31.060.02.09	90 DX	3.54 DX
H31.060.02.10	95 DX	3.74 DX
H31.060.03.01	50 DX	1.97 DX
H31.060.03.02	55 SX	2.17 SX
H31.060.03.03	60 SX	2.36 SX
H31.060.03.04	65 SX	2.56 SX
H31.060.03.05	70 SX	2.76 SX
H31.060.03.06	75 SX	2.95 SX
H31.060.03.07	80 SX	3.15 SX
H31.060.03.08	85 SX	3.35 SX
H31.060.03.09	90 SX	3.54 SX
H31.060.03.10	95 SX	3.74 SX

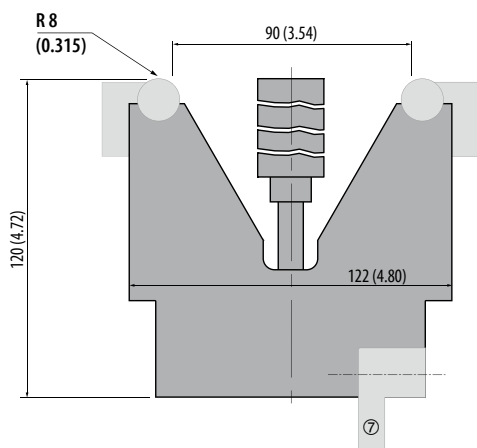
C45: 560-710 N/mm²

H31.090.01.01

1500 kN/m max.

Model	Length	Weight
H31.090.01.01	100	8.15 kg

C45: 560-710 N/mm²

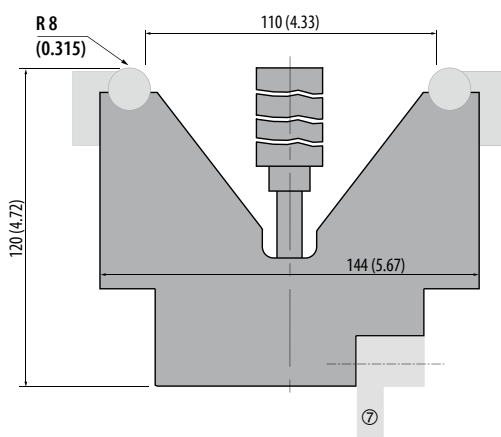


H31.110.01.01

1500 kN/m max.

Model	Length	Weight
H31.110.01.01	100	8.83 kg

C45: 560-710 N/mm²



7
RX



Article on stock



Please ask for delivery time!

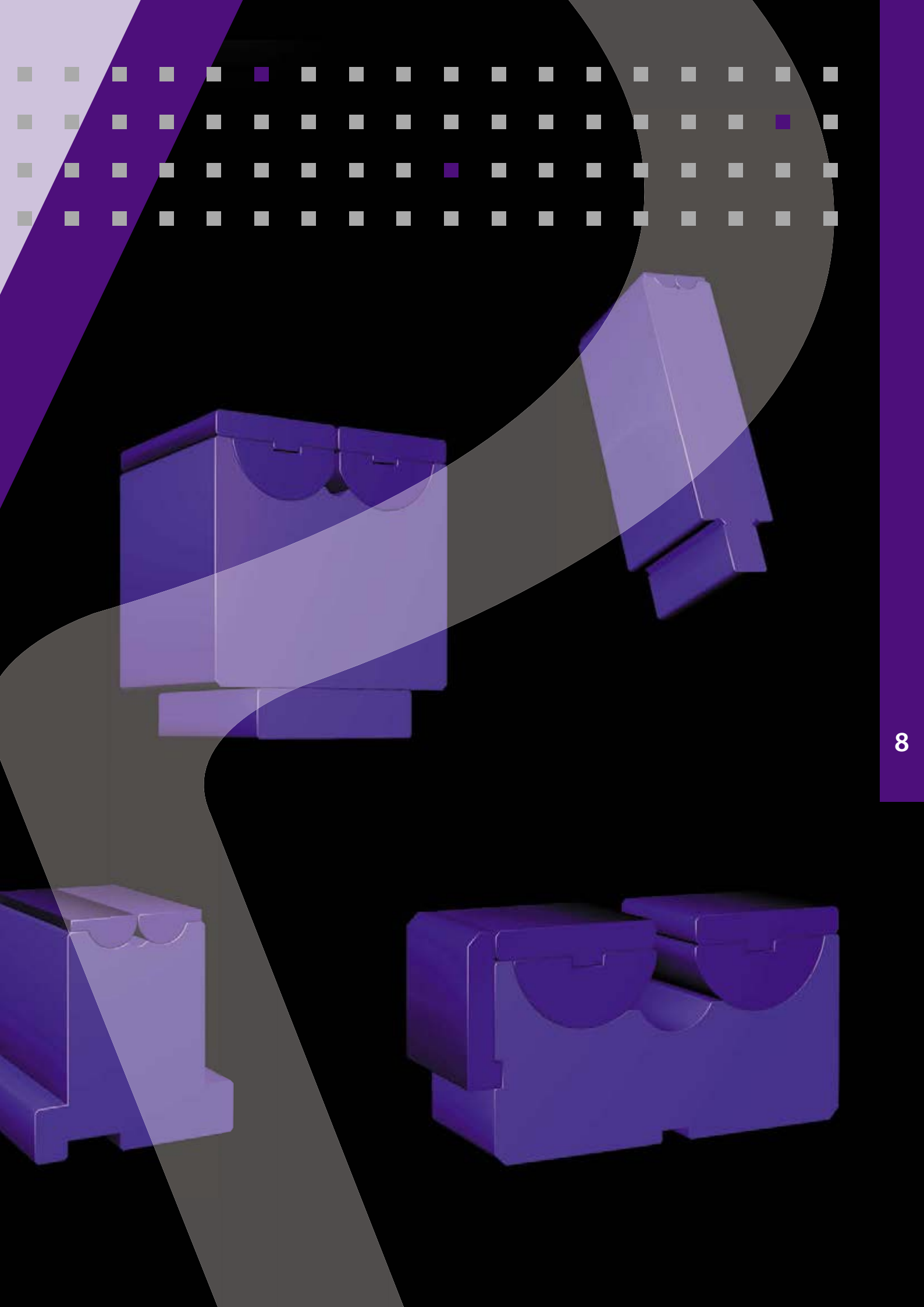
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

ROLLERI DIES ROLLA-V

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Model 1	200
Model 2	201
Model 2.5	201
Model 3	202
Model 4	202
Adjustable Dies	203
Hemming- and Joggle Tools	203



Content Explanation

Compatibility

- **RVP Dies (Models 1, 2, 3)** are compatible with press brake machines (60 mm / 2.36 in die holder) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- **RVS Dies (Models 1, 2, 3)** are compatible with press brake machines (14 mm / 0.55 in pins) from: Amada Single V style
- **RVT Dies (Models 1, 2, 3)** are compatible with press brake machines (12.7 mm / 0.50 in / 13 mm / 0.51 in pins) from: Bystronic, Hämmerle, Beyeler, Edwards, Safan, SMD, Trumpf
- **RVT90 Dies (Models 1, 2, 3)** are compatible with press brakes machines (12.7 mm / 0.50 in pins) from: LVD
- **RVM Dies (Models 2.5, 3, 4)** are compatible with all press brake machines (various die holders)
- all dies are compatible on other press brakes machines with the means of adapter-systems or customized die holders.

Our Advantages – Your Convenience

- highly precision ground
- interchangeability guaranteed
- exact Parallelism
- reducing bending marks on the sheet metals
- minimum borders bending mark free
- no tool contamination throughout the bending of galvanized sheet metal or aluminum
- extremely short flanges
- fewer tool exchange
- ideal for diagonal or tapered edges



Material

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

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4	1100-1200 N/mm ²	55 HRc
Inserts	1 / 2 / 2.5	Toolox 44	1450 N/mm ²	through hardened 44 HRc
Inserts	3 / 4	Toolox 33	1100 N/mm ²	55 HRc

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

	Equivalent V size mm (in)	max. tool load (kN/m)	Material Thickness mm (in)	min. bending angle	needed press force (kN)	min. outside flange mm (in)	max. outside radius mm (in)
Model 1 Max. recommended thickness =1.5 mm (0.06 in) (2.0 mm / 0.08 in possible)	8 (0.31)	1000	0.70 (0.03)	40°	50	3.0 (0.12)	3.0 (0.12)
		1000	1.10 (0.04)	35°	130	3.9 (0.15)	2.6 (0.10)
		1000	1.50 (0.06)	35°	270	4.2 (0.17)	2.2 (0.09)
Model 2 Max. recommended thickness =3.0 mm (0.12 in) (4.0 mm / 0.15 in possible)	15 (0.59)	1500	2.00 (0.08)	59°	210	8.5 (0.33)	6.0 (0.24)
		1500	3.00 (0.12)	47°	550	9.3 (0.37)	5.0 (0.20)
		1500	3.20 (0.13)	47°	650	9.3 (0.37)	4.8 (0.19)
Model 2.5 Max. recommended thickness =5.0 mm (0.20 in) (6.35 mm / 0.24 in possible)	28 (1.10)	2500	2.00 (0.08)	46°	100	18.6 (0.73)	13.2 (0.52)
		2500	4.00 (0.16)	46°	470	18.6 (0.73)	12.0 (0.47)
		2500	6.00 (0.24)	55°	1270	18.6 (0.73)	9.8 (0.39)
Model 3 Max. recommended thickness =6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)	38 (1.50)	2500	2.00 (0.08)	68°	70	22.5 (0.89)	13.9 (0.55)
		2500	4.00 (0.16)	47°	340	22.5 (0.89)	11.9 (0.47)
		2500	6.00 (0.24)	50°	900	22.5 (0.89)	9.9 (0.39)
Model 4 Max. recommended thickness =16.0 mm (0.63 in)	85 (3.35)	3000	6.00 (0.24)	78°	260	56.6 (2.23)	36.4 (1.43)
		3000	8.00 (0.31)	76°	500	56.6 (2.23)	36.4 (1.43)
		3000	12.00 (0.47)	73°	1290	56.6 (2.23)	36.4 (1.43)

Content Explanation

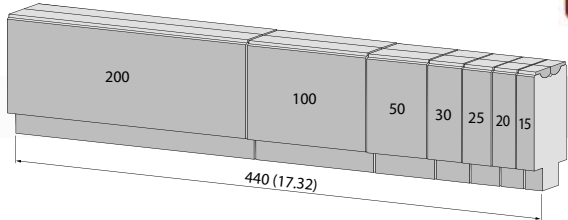
Tool lengths and sectioning

Standard

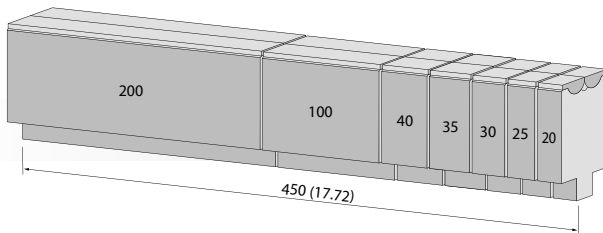
Segmented tools are delivered in complete sets. Single pieces are also available!
More lengths and sectionings are possible upon request.

500 mm (19.68 in)

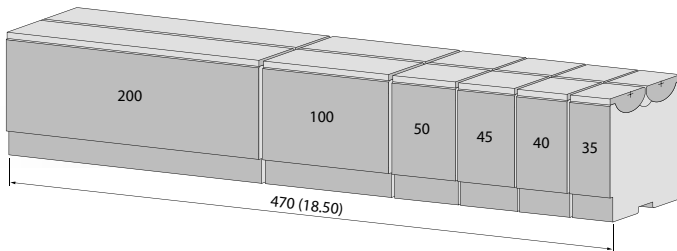
200 mm (7.87 in)



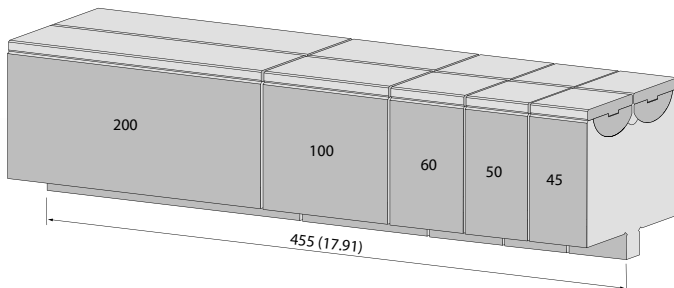
Model 1, 440 mm (17.32 in) segmented
(7 segments)



Model 2, 450 mm (17.72 in) segmented
(7 segments)



Model 2.5, 470 mm (18.50 in) segmented
(6 segments)



Model 3, 455 mm (17.91 in) segmented
(5 segments)



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

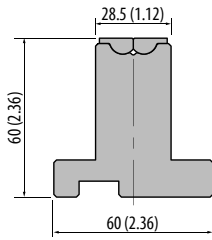
DIES ROLLA-V

Model 1

RVP60-1

1000 kN/m max.

NEW



500 mm	16.68 in	6.9 kg
440 mm segmented	17.32 in segmented	6.1 kg

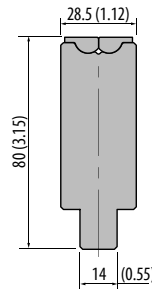
42Cr: 1100-1200 N/mm²



RVS80-1

1000 kN/m max.

NEW



500 mm	16.68 in	6.3 kg
440 mm segmented	17.32 in segmented	5.8 kg

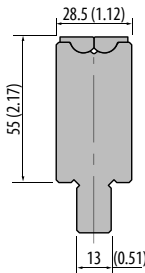
42Cr: 1100-1200 N/mm²



RVT55-1

1000 kN/m max.

NEW



500 mm	16.68 in	5.5 kg
440 mm segmented	17.32 in segmented	5.0 kg

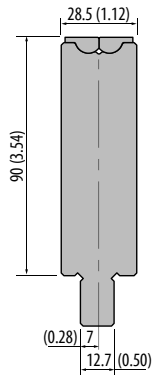
42Cr: 1100-1200 N/mm²



RVT90-1

1000 kN/m max.

NEW



500 mm	16.68 in	8.5 kg
440 mm segmented	17.32 in segmented	7.8 kg

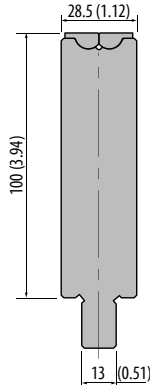
42Cr: 1100-1200 N/mm²



RVT100-1

1000 kN/m max.

NEW



500 mm	16.68 in	9.4 kg
440 mm segmented	17.32 in segmented	8.6 kg

42Cr: 1100-1200 N/mm²



Ideal for thick material!
Making the impossible,
possible ...

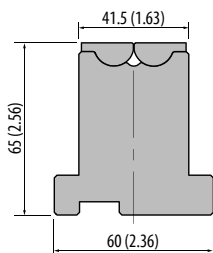


Model 2

RVP65-2

1500 kN/m max.

NEW



500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

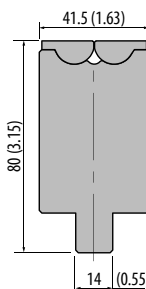
42Cr: 1100-1200 N/mm²



RVS80-2

1500 kN/m max.

NEW



500 mm	16.68 in	8.3 kg
450 mm segmented	17.72 in segmented	7.8 kg

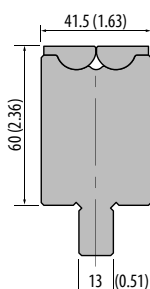
42Cr: 1100-1200 N/mm²



RVT60-2

1500 kN/m max.

NEW



500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

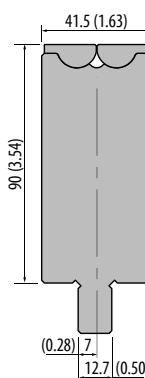
42Cr: 1100-1200 N/mm²



RVT90-2

1500 kN/m max.

NEW



500 mm	16.68 in	11.3 kg
450 mm segmented	17.72 in segmented	10.6 kg

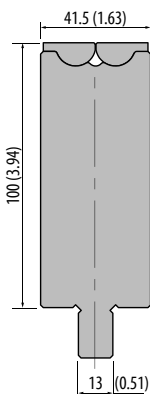
42Cr: 1100-1200 N/mm²



RVT100-2

1500 kN/m max.

NEW



500 mm	16.68 in	12.4 kg
450 mm segmented	17.72 in segmented	11.7 kg

42Cr: 1100-1200 N/mm²

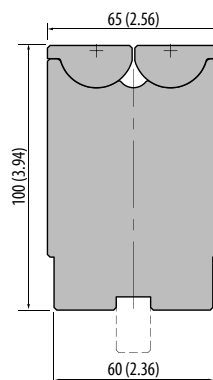


Model 2.5

RVM2.5

2000 kN/m max.

NEW



500 mm	16.68 in	22.0 kg
470 mm segmented	18.50 in segmented	21.0 kg

42Cr: 1100-1200 N/mm²



Rolleri Videos



Use and application of Rolla-V dies
www.rolleritools.com/videos/rolla-v



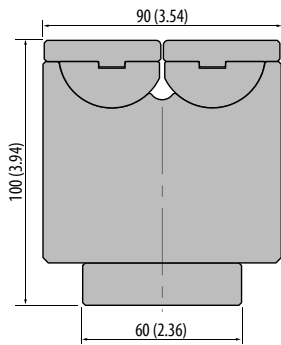
DIES ROLLA-V

Model 3

RVP100-3

2500 kN/m max.

NEW



500 mm	16.68 in	28.8 kg
455 mm segmented	17.91 in segmented	26.2 kg

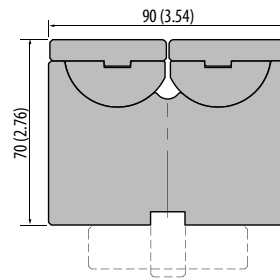
42Cr: 1100-1200 N/mm²



RVM70-3

2500 kN/m max.

NEW



500 mm	16.68 in	20.6 kg
455 mm segmented	17.91 in segmented	18.7 kg

42Cr: 1100-1200 N/mm²



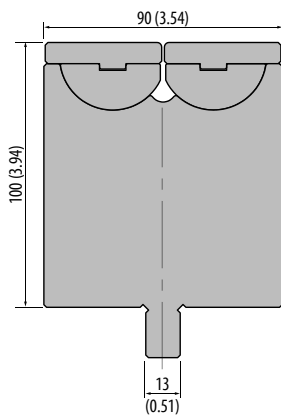
Possible Die Holders:

- 60 mm (2.36 in)
- 13 mm (0.51 in) pin
- 12.7 mm (0.50 in) pin
- 12.8 mm (0.50 in) offset pin

RVT100-3

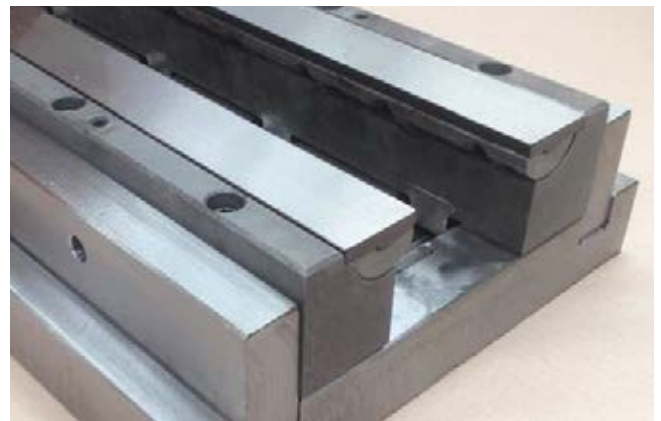
2500 kN/m max.

NEW



500 mm	16.68 in	30.9 kg
455 mm segmented	17.91 in segmented	28.5 kg

42Cr: 1100-1200 N/mm²



Model 4

Our Advantages – Your Convenience

The **model 4 tools** and the **adjustable dies** are for bending thick material and large radii. Material specifications vary greatly, therefore no specific data can be given.

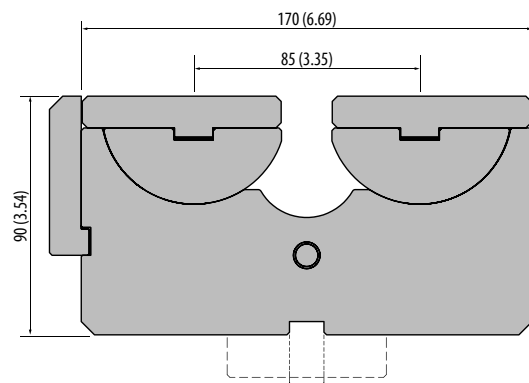
- Minimum borders are highly dependant on the squareness of the component.
- Enlargement and hole distortion will be greatly reduced, however will be influenced depending on the type of material
- Radius bending is strongly influenced by the elastic return of specific material and flange-size.

For advice please contact us!

RVM90-4

3000 kN/m max.

NEW



500 mm	16.68 in	56.6 kg
200 mm	7.87 in	22.7 kg

42Cr: 1100-1200 N/mm²



Possible Die Holders:

- 60 mm (2.36 in)
- 13 mm (0.51 in) pin
- 12.7 mm (0.50 in) pin
- 12.8 mm (0.50 in) offset pin

Our advantages – Your Convenience

- bending possible up to the thickness of 30 mm
- inserts hardened
- no traditional bending marks
- adjustable openings
 RVPV3 = 39-94 mm (1.54-3.70 in)
 RVHD3 = 39-118 mm (1.54-4.65 in)
 RVHD4 = 70-220 mm (2.76-8.66 in)
- bends laser-cut sheet metal without damaging the tool
- exact inner radius

RVPV3

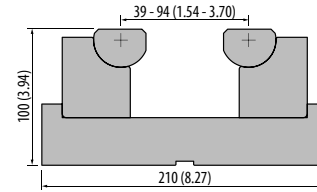
2500 kN/m max.

NEW

42Cr: 1100-1200 N/mm²



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



RVHD3

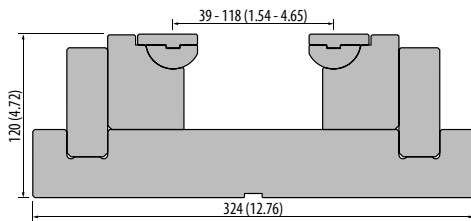
3500 kN/m max.

NEW

42Cr: 1100-1200 N/mm²



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



RVHD4

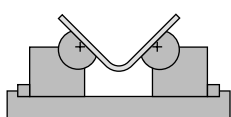
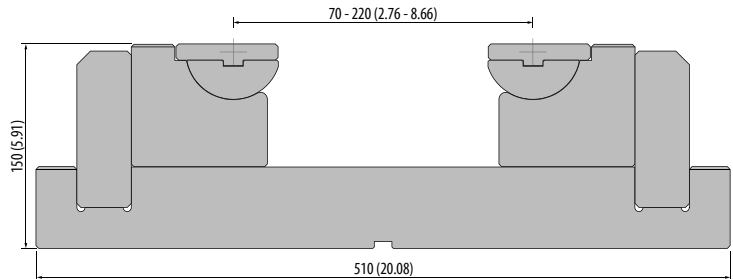
3500 kN/m max.

NEW

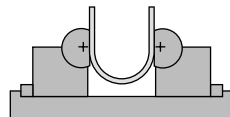
42Cr: 1100-1200 N/mm²



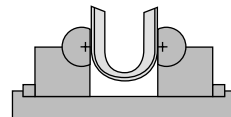
500 mm	16.68 in	200.0 kg
200 mm	7.87 in	80.0 kg



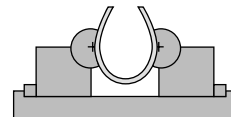
- V-Bending
- flat inserts



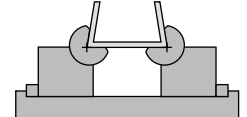
- Radius-Bending
- flat inserts



- Conical Bending
- flat inserts



- Radius-Overbending
- concave inserts

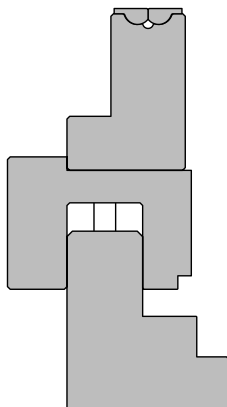


- U-Bending
- V-inserts

Hemming- and Z-Tools

Hemming Tool

NEW



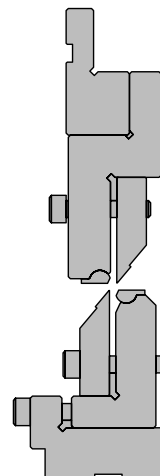
per piece | Price upon request
 Production according to your specifications

42Cr: 1100-1200 N/mm²



Joggle Tool

NEW



per piece | Price upon request
 Production according to your specifications

42Cr: 1100-1200 N/mm²

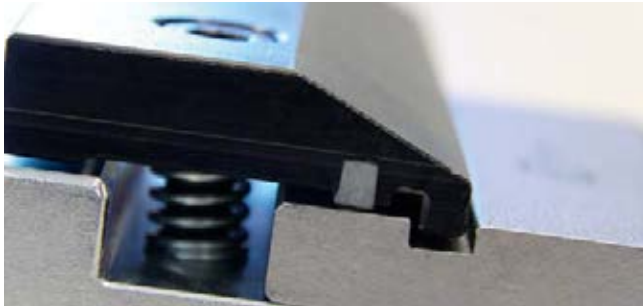


ROLLERI CLAMPING SYSTEMS

Content Explanation	206
Intermediates	207
Clamps	208 - 209
ROL100-System for Punches Roller Type R1	210 - 211
ROL1-System for Punches Roller Type R1	212 - 213
ROL4-System for Punches Roller Type R1	213
W-ROL PN-System for Punches Roller Type R2	214
ROL3-System for Punches Roller Type R3 and RX	215
ROL2-System for Dies Roller Type R1	216 - 217
Movable Die Clamps for Dies Roller Type R1	217



Content Explanation



- All pneumatic clamps work with a pressure of at least 10 bar.

Standard-Clamping

- for PUNCHES Roller Type R1
- made of: Tensioning device + intermediate
- dual sided clamping (KDS-System)
- **horizontal tool exchange**
- see pages 207-209



ROL100 Clamping

- for PUNCHES Roller Type R1
- **vertical tool exchange**
- can be used **without modifying** PUNCHES Roller Type R1
- safety guard
- including selectable intermediates
- manual and pneumatic models available
- see pages 210-211



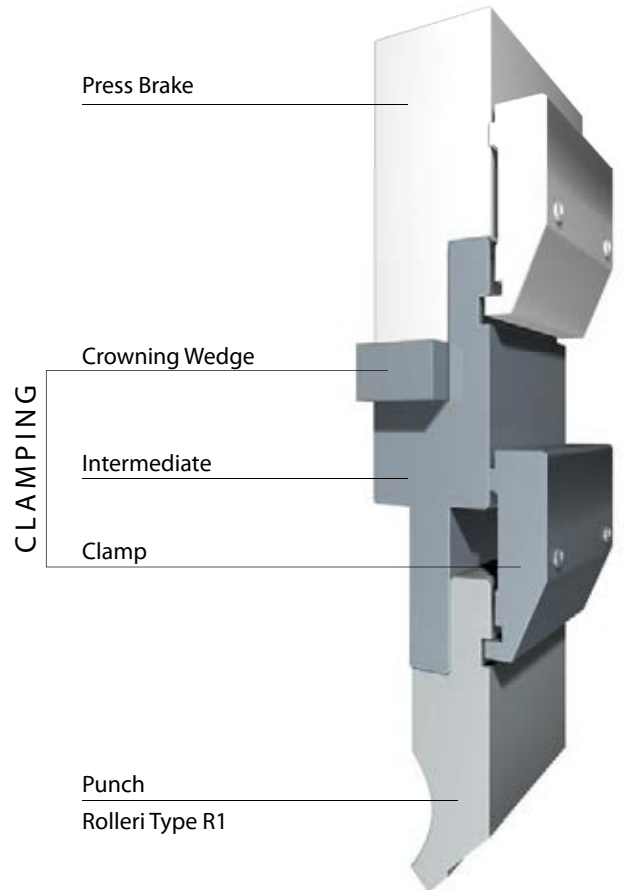
ROL1 Clamping

- for PUNCHES Roller Type R1
- **vertical tool exchange**
- **modification necessary:** PUNCHES Roller Type R1 are equipped with spring-loaded balls
- safety guard
- including selectable intermediates
- manual, pneumatic and hydraulic models available
- dual sided clamping (KDS-System)
- see pages 212-213



ROL4 Clamping

- for PUNCHES Roller Type R1
- **horizontal tool exchange**
- can be used **without modifying** PUNCHES Roller Type R1
- safety guard
- including selectable intermediates
- manual and hydraulic models available
- dual sided clamping integrated
- see page 213



W-ROL PN Clamping

- for PUNCHES Roller Type R2
- **vertical tool exchange** with ROL1-System and QuickLock-System
- PUNCHES with Safety-Pins are inserted **horizontal**
- safety guard
- pneumatic model available only
- see page 214



ROL3 Clamping

- for PUNCHES Roller Type R3/RX
- **vertical or horizontal tool exchange**
- custom manufacturing
- safety guard
- hydraulic model available only
- see page 215



ROL2 Clamping

- for Dies Roller Type R1
- manual, pneumatic and hydraulic models available
- see pages 216-217

Movable Die Clamps

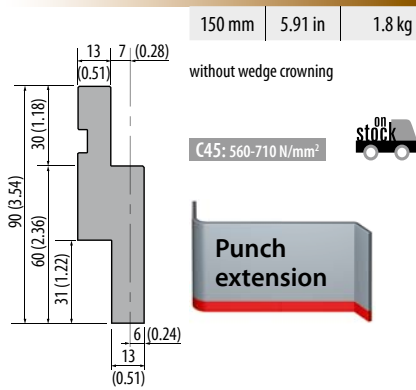
- for Dies Roller Type R1
- manual model available only
- see page 217

R1 ROLLERI CLAMPING SYSTEMS

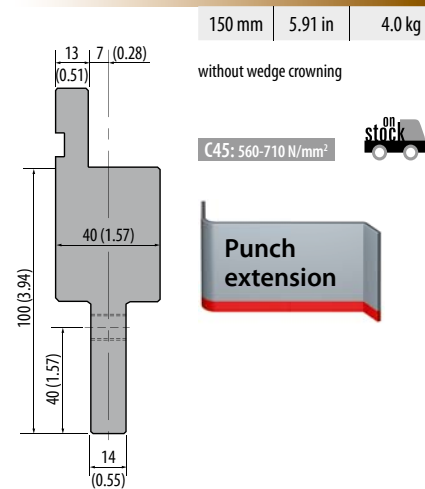
Intermediates



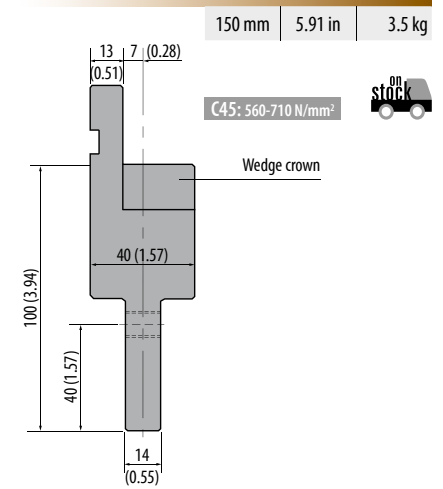
AD4 1000 kN/m max.



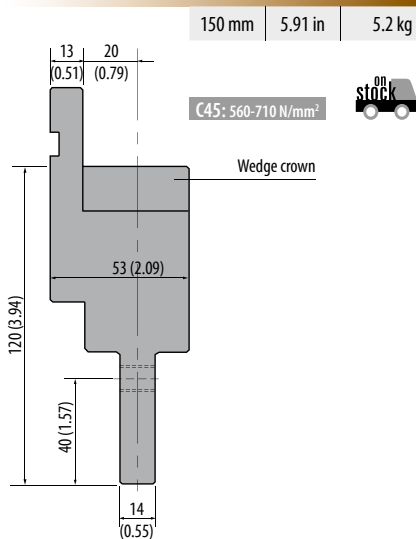
INT100 FISSO 1000 kN/m max.



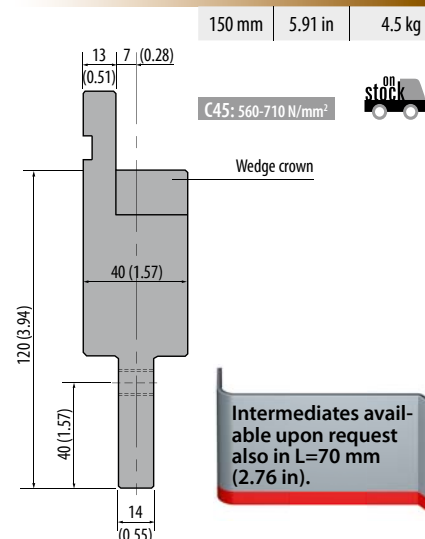
INT100 1000 kN/m max.



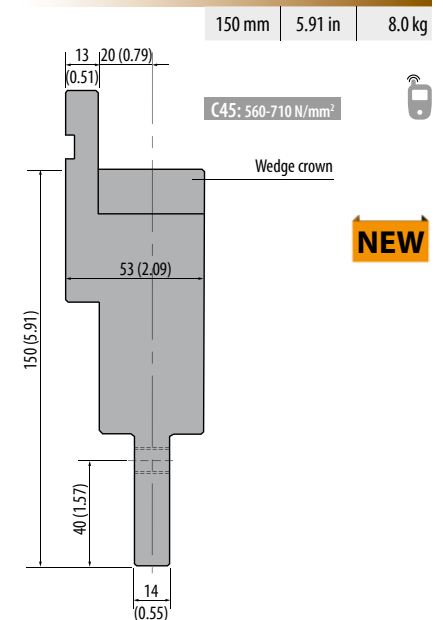
INT120-40 1000 kN/m max.



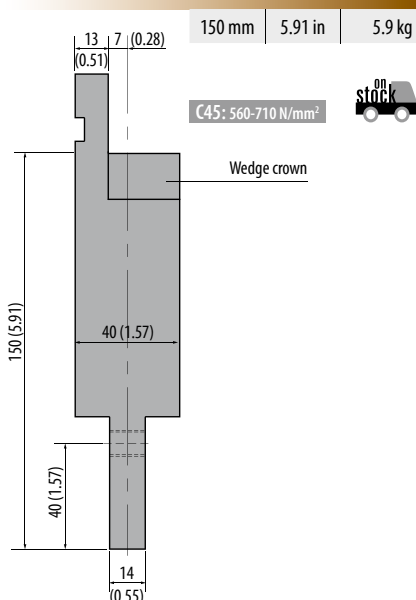
INT120 1000 kN/m max.



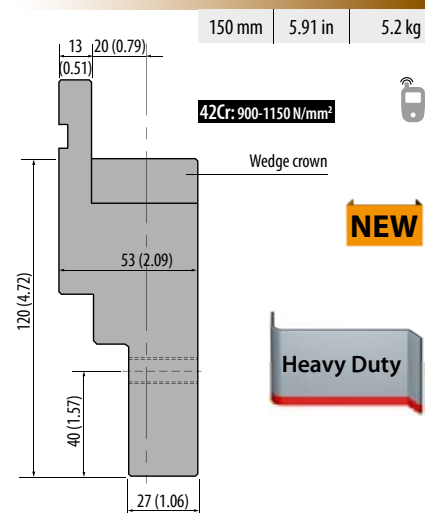
INT150-40 1000 kN/m max.



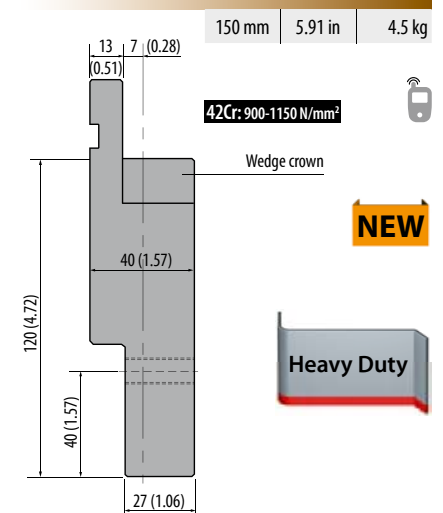
INT150 1000 kN/m max.



INT120-40-HD 1600 kN/m max.



INT120-HD 1600 kN/m max.



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

R1 ROLLER CLAMPING SYSTEMS

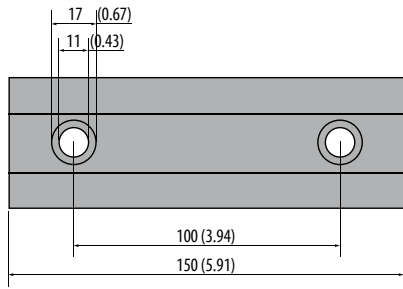
Clamps

Our Advantages – Your Convenience

- **Rapid Clamping Systems** allow a fast horizontal tool exchange
- **Plastic Pressure Strip** improves the clamping especially with short tool pieces.

needed clamps	Length of press brake
4 pieces	835 mm (32.87 in)
6 pieces	1250 mm (49.21 in)
11 pieces	2100 mm (82.68 in)
14 pieces	2600 mm (102.36 in)
16 pieces	3100 mm (122.05 in)
21 pieces	4100 mm (161.42 in)

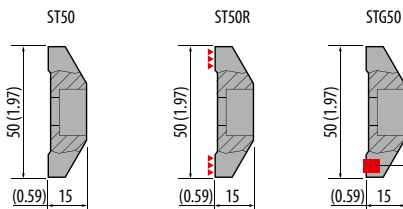
ST50 / ST50R / STG50



ST50	0.70 kg
ST50R	0.50 kg
STG50	0.70 kg

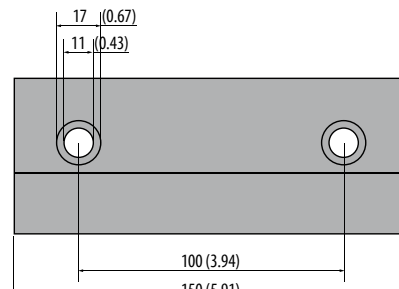
L=150 mm (5.91 in)

Fe37: 370-470 N/mm²



Plastic Pressure Strip

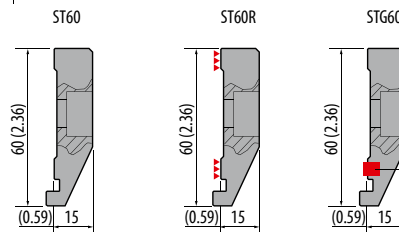
ST60 / ST60R / STG60



ST60	0.80 kg
ST60R	0.85 kg
STG60	0.80 kg

L=150 mm (5.91 in)

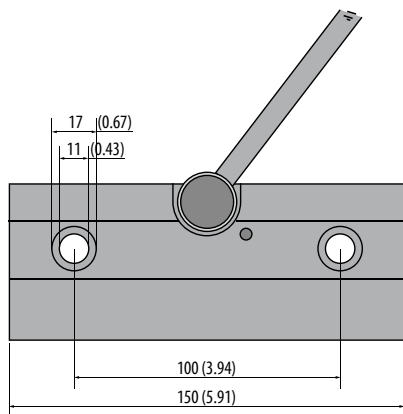
Fe37: 370-470 N/mm²



Plastic Pressure Strip

Compatible Intermediates on page 207

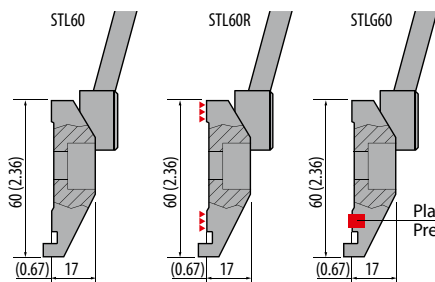
STL60 / STL60R / STL60G



STL60	1.00 kg
STL60R	0.80 kg
STL60G	1.00 kg

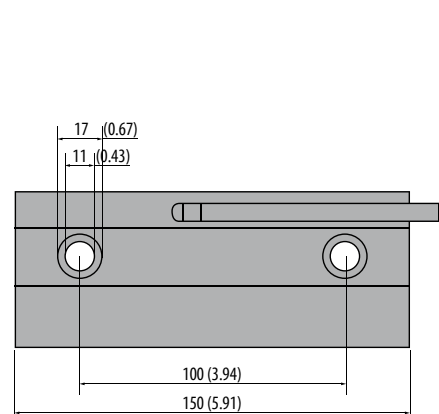
L=150 mm (5.91 in)

Fe37: 370-470 N/mm²



Plastic Pressure Strip

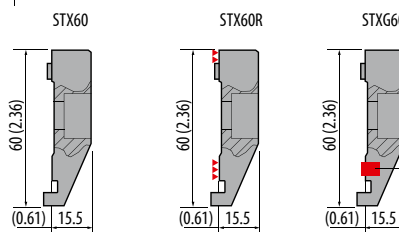
STX60 / STX60R / STX60G



STX60	0.85 kg
STX60R	0.50 kg
STX60G	1.00 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²



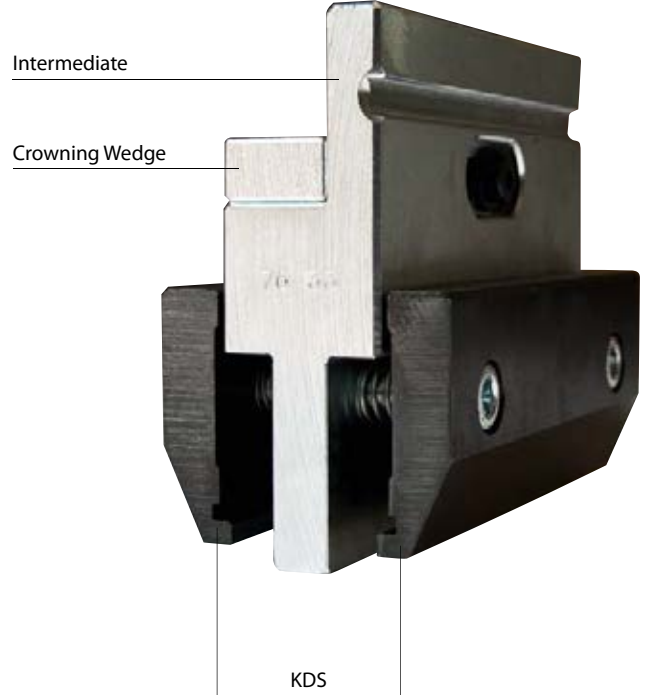
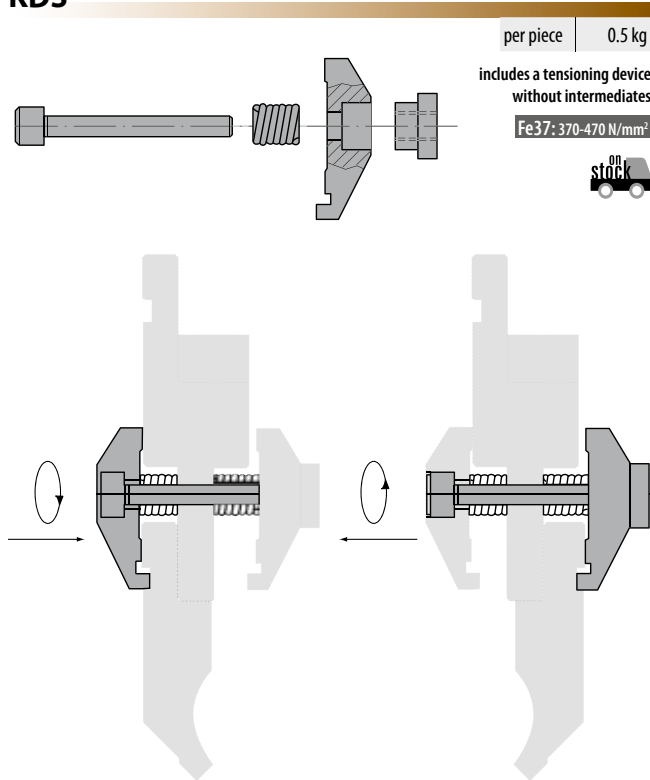
Plastic Pressure Strip

R1 ROLLERI CLAMPING SYSTEMS

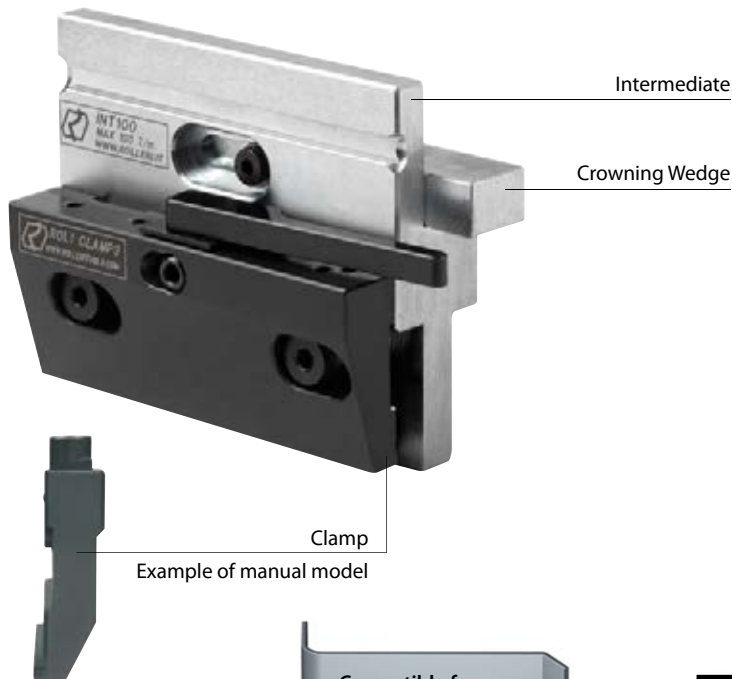
Clamps



KDS



ROL1 CLAMP3 – manual – hydraulic – pneumatic



horizontal

horizontal

horizontal

Model	with Intermediate
ROL1 CLAMP3 manual	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

ROL1 CLAMP3 manual
without Intermediate

Model	with Intermediate
ROL1 CLAMP3 hydraulic	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

Model	with Intermediate
ROL1 CLAMP3 pneumatic	INT120
	INT150

L=150 mm (5.91 in)
horizontal tool exchange
including selectable intermediates

Compatible for
Standard Punches
Rolleri Type R1



Rolleri Videos

Application of Clamping System
ROL1 CLAMP3: [www.rolleritools.com/
videos/rol1-clamp3](http://www.rolleritools.com/videos/rol1-clamp3)

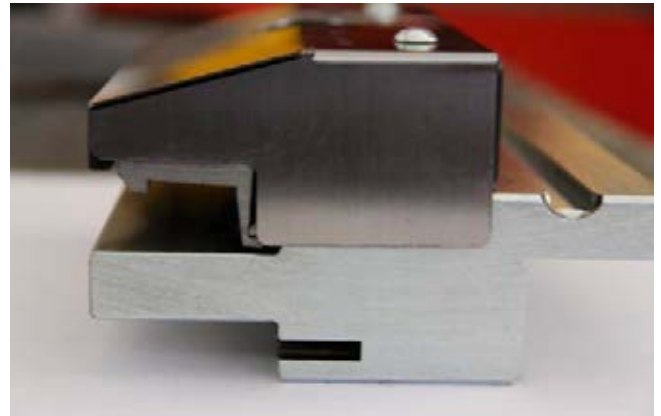


R1 ROLLERI CLAMPING SYSTEMS

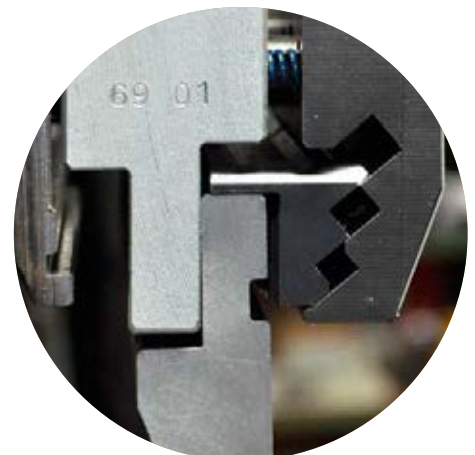
ROL100-System for Punches Roller Type R1

... the newest innovation from our Research and Development Department

- fast **vertical** tool exchange for all Punches Roller Type R1
- can be used without modifying Punches Roller Type R1
- safe and fast tool exchange
- significant savings on your setup costs
- no falling out of tools
- available in manual and pneumatic models
- Mounting:
Simply from the bottom into the housing, tighten – DONE!
- Disassembly:
Untighten, gently lift tool and remove downwards.
- Easy to mount on your press brake.
A conversion of the press brake is not necessary.
- For Press Brake Machines and Punches Roller Type R1:
(ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, JMT, LFK, Metfab, MVD, Newton, Oriance, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.)



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



R1 ROLLERI CLAMPING SYSTEMS

ROL100-System for Punches Roller Type R1



ROL100 – manual

NEW



Model	with Intermediate
ROL100 manual	INT100
	INT120
	INT150
	INT100 FISSO



L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates



The ROL100-System is suited for Standard-Punches. There are no modifications necessary!

ROL100 – pneumatic

NEW



Model	with Intermediate
ROL100 pneumatic	INT100
	INT120
	INT150
	INT100 FISSO



L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates



R1 ROLLERI CLAMPING SYSTEMS

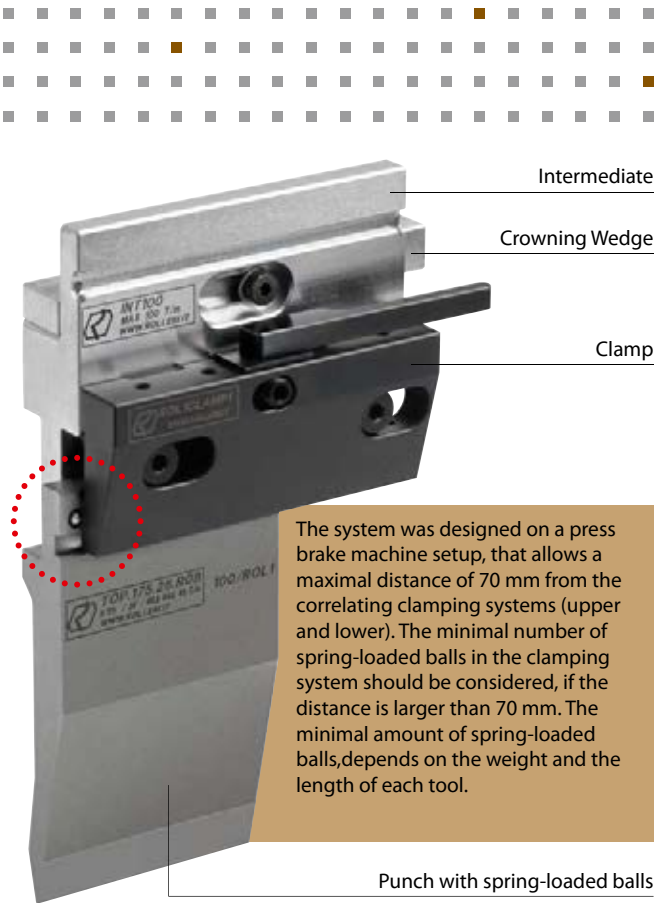
ROL1-System for Punches Roller Type R1

In order to use the ROL1 System, the punches are modified and equipped with spring-loaded balls.

ROL1 can be used on all press brakes with standard tang intermediates of Roller Type R1.

Our Advantages – Your Convenience

- **vertical clamping** of tools is possible on press brakes thanks to a row of **spring-loaded balls** which are also used as **safety guards** to prevent the falling out of tools.
- complete mechanic functioning fast clamping system for press brake machines.
- Productivity and Versatility of the press brake machines will be increased.
- Significant **reduction in the set-up times** when changing tools



Punch with spring-loaded balls

ROL1 CLAMP1 – manual

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 CLAMP1	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



ROL1 CLAMP1
without Intermediate



ROL1 PN CLAMP1 – pneumatic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 PN CLAMP1	INT120	
	INT150	



Mounting example



Rolleri Videos

Application of Clamping Systems
 ROL1 CLAMP1: www.rolleritools.com/videos/rol1-clamp1



R1 ROLLERI CLAMPING SYSTEMS

ROL1-System for Punches Roller Type R1



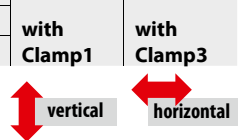
ROL1 HYD CLAMP1 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 HYD CLAMP1	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



ROL1 KDS

Model	with Intermediate	L=150 mm vertical tool exchange including selectable intermediates
ROL1 KDS	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



Detailed information about intermediates on page 207



ROL4-System for Punches Roller Type R1

ROL4 – manual

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates integrated KDS-System
ROL4 manual	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT100 FISSO	



ROL4 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates integrated KDS-System
ROL4 hydraulic	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



The ROL4-System is suitable for Standard-Punches Roller Type R1. There are no modifications necessary!



Rolleri Videos

Application of hydraulic clamping ROL4
www.rolleritools.com/videos/rol4-hydraulic-clamping



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
 100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

R2 ROLLERI CLAMPING SYSTEMS

W-ROL PN for Punches Roller Type R2

W-ROL PN – pneumatic



Our Advantages – Your Convenience

- vertical tool exchange of punches with:
 - ROL1-System
 - QuickLock-System
- Horizontal tool exchange of punches with safety pins
- significantly more efficient bending productivity



R3/RX ROLLER CLAMPING SYSTEMS

ROL3-System for Punches Roller Type R3 and RX



ROL3 HYD – hydraulic

500 mm | 19.68 in



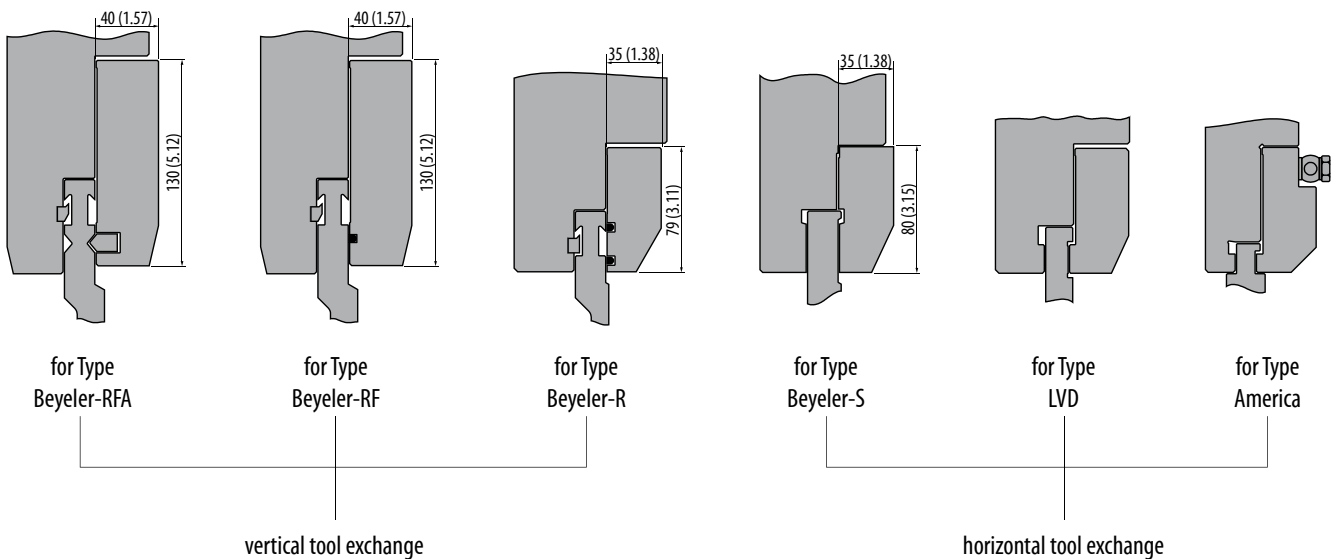
Our Advantages – Your Convenience

- can be used on press brake machines with different tang types
- custom manufacturing possible upon request
- significantly more efficient bending productivity

Equip your press brake with our ROL3 system in order to use the advantages of a hydraulic clamping system!



Examples of ROL3 with various systems



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

R1 ROLLERI CLAMPING SYSTEMS

ROL2-System for Dies Roller Type R1

■ Explanations

The **ROL2 System** is a system which is used to secure the die into place. It is made up of a special bar (known as **ROL2 CLAMP1**, L=500 mm / 19.68 in), which is operated through a centralized lever.

The **ROL2 System** has a built in spring mechanism and the clamp plates **ROL2 CLAMP1** are positioned in the inner lining of the system, which can be opened or tightened for the die to be perfectly secured.

A special rubber insert inside the clamp plates grants the best positioning for the tools. The press force of the clamp plates is evenly distributed along the complete length. Therefore short tools are also securely fastened.

At a press brake of 3 meters (118.11 in), for example; all dies are secured with 6 simple hand movements.

■ Our Advantages – Your Convenience

- fast exchange of tools
- very time saving
- reduced production costs
- significantly increased profitability
- improved competitiveness

■ Application

- **Directly on the die holder with 60 mm / 2.36 in width**
 - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
 - alternatively modifications of the existing threaded holes necessary
 - system is compatible for press brakes with automatic coving tables
- **Directly on the die holder with 90 mm / 3.54 in width**
 - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
 - alternatively modifications of the existing threaded holes necessary
 - for the use of dies Roller Type R1, two 15 mm / 0.59 in wide inserts are mounted and ground (securing with pins)
 - with rubber corners, the use of short tools is possible and are perfectly secured.
- **With Die Holder on the Die Rail**
 - 60 x 55 mm / 2.36 x 2.167 in die holder, ground and induction hardened.



R1 ROLLERI CLAMPING SYSTEMS

ROL2-System for Dies Roller Type R1



ROL2 – manual

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	38.0 kg	table: 60 mm	2.36 in	4.0 kg
table: 90 mm	3.54 in	58.0 kg	table: 90 mm	3.54 in	4.5 kg

L=1075 mm



L=500 mm



ROL2 – hydraulic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

L=1075 mm



L=500 mm



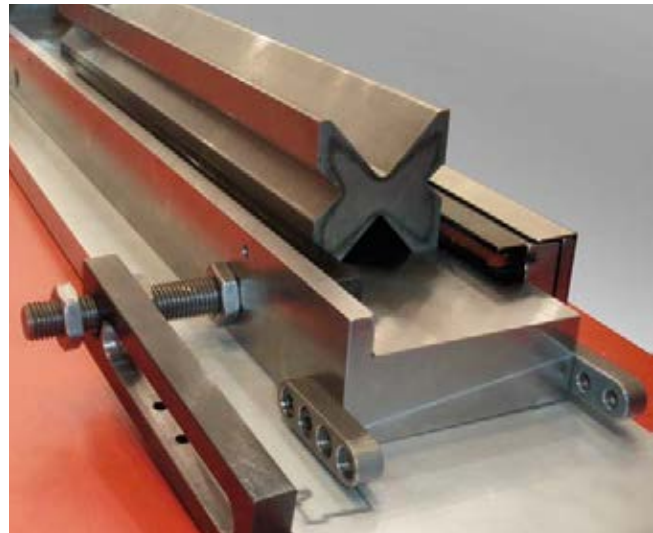
ROL2 – pneumatic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

L=1075 mm



L=500 mm



Movable Die Clamps for Dies Roller Type R1

Our Advantages – Your Convenience

- lowerable clamping plate
- significantly easier exchange of tools, due the possibility of removing the tool by sliding it out and not lifting the tool.



Rolleri Videos

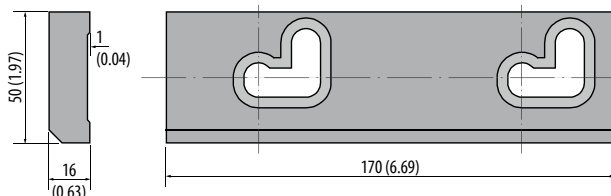
movable die holders ST50-S:
www.rolleritools.com/videos/movable-die-holders



ST50-S

per piece 0.70 kg

Fe37: 370-470 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
 100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

ROLLERI ADAPTERS

Punch Adapters	220 - 223
Bolted Adapters	224 - 225
Die Adapter Rails	226
Die Adapters	227 - 229
Modification: Wedge Bar / Tail	229

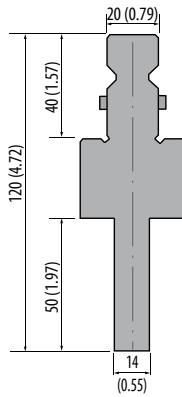


ROLLERI ADAPTERS

Punch Adapters

AD11

1000 kN/m max.



150 mm | 5.91 in | 3.0 kg

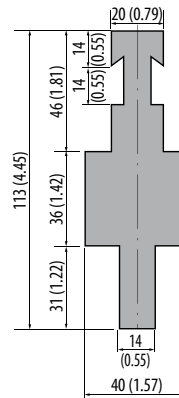
Rolleri Type R2
→ Rolleri Type R1

C45: 560-710 N/mm²



AD22

1000 kN/m max.



150 mm | 5.91 in | 3.4 kg

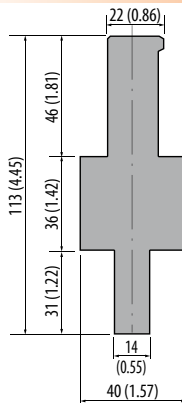
Rolleri Type R3 Beyeler R
→ Rolleri Type R1

C45: 560-710 N/mm²



AD3

1000 kN/m max.



150 mm | 5.91 in | 3.3 kg

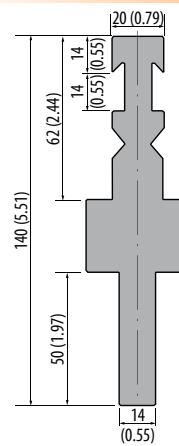
Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



AD10

1000 kN/m max.



150 mm | 5.91 in | 3.4 kg

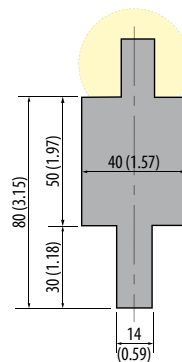
Rolleri Type R3 Beyeler
RFA → Rolleri Type R1

C45: 560-710 N/mm²



AD1

1000 kN/m max.



Tang A: **AD1-A**

150 mm | 5.91 in | 3.1 kg

Tang B: **AD1-B**

150 mm | 5.91 in | 3.1 kg

Tang C: **AD1-C**

150 mm | 5.91 in | 3.1 kg

Tang D: **AD1-D**

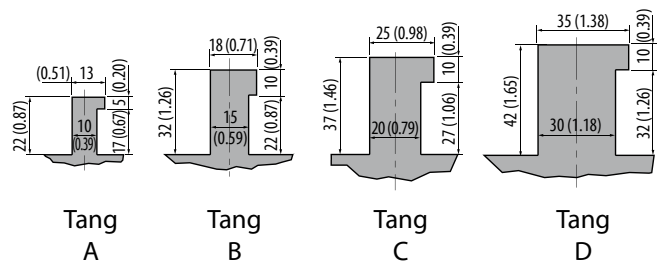
150 mm | 5.91 in | 3.1 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



Tangs LVD



Tang A

Tang B

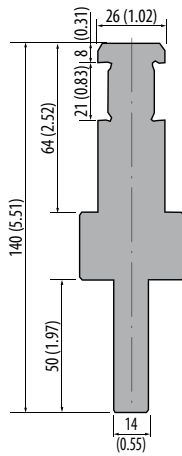
Tang C

Tang D

With adapters you can use the vast amount of Punches Rolleri Type R1!

AD13

1000 kN/m max.



150 mm | 5.91 in | 3.0 kg

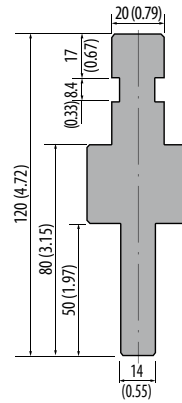
Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²



AD14

1000 kN/m max.



150 mm | 5.91 in | 3.2 kg

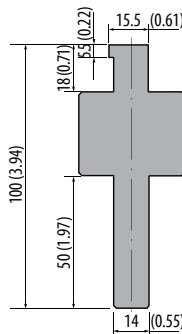
Rolleri Type RX Gas-parini
→ Rolleri Type R1

C45: 560-710 N/mm²



AD15

1000 kN/m max.



150 mm | 5.91 in | 4.0 kg

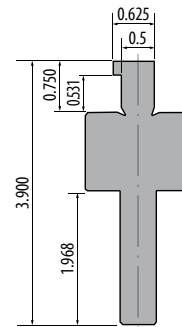
Rolleri Type RX Ajial-Axial
→ Rolleri Type R1

C45: 560-710 N/mm²



AD16

1000 kN/m max.



5.9 inch | 5.91 in | 4.0 kg

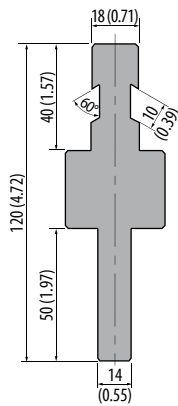
Rolleri Type American
→ Rolleri Type R1

C45: 560-710 N/mm²



AD12

1000 kN/m max.



150 mm | 5.91 in | 1.5 kg

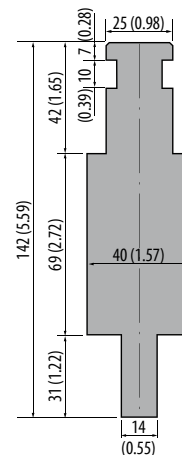
Rolleri Type RX Colgar
→ Rolleri Type R1

C45: 560-710 N/mm²



AD23

1000 kN/m max.



150 mm | 5.91 in | 5.0 kg

Rolleri Type RX Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm²



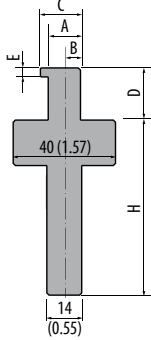
10

ROLLERI ADAPTERS

Punch Adapters

ADX

1000 kN/m max.



150 mm | 5.91 in | 3.5 kg

Type X
→ Rolleri Type R1

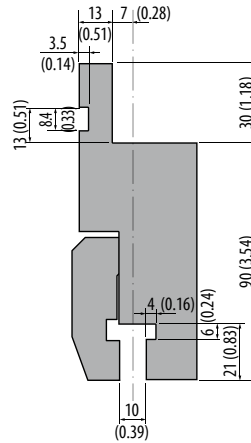
Production according to your specifications

C45: 560-710 N/mm²



AD19-A

1000 kN/m max.



150 mm | 5.91 in | 6.0 kg

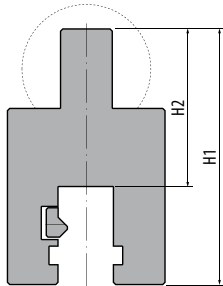
Rolleri Type R1
→ Rolleri Type RX LVD

C45: 560-710 N/mm²



ADX2

NEW



150 mm | 5.91 in | 4.0 kg

Type X
→ Rolleri Type R2

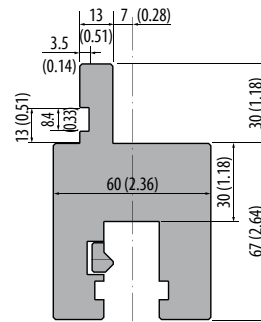
Production according to your specifications

C45: 560-710 N/mm²



AD20

1000 kN/m max.



150 mm | 5.91 in | 4.0 kg

Rolleri Type R1
→ Rolleri Type R2

C45: 560-710 N/mm²

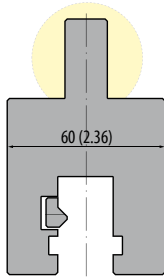


Pneumatic Adapters see page 214

AD20 LVD

1000 kN/m max.

NEW



Tang A: **AD20 LVD-A**

150 mm | 5.91 in | 3.6 kg

Tang B: **AD20 LVD-B**

150 mm | 5.91 in | 3.8 kg

Tang C: **AD20 LVD-C**

150 mm | 5.91 in | 4.0 kg

Tang D: **AD20 LVD-D**

150 mm | 5.91 in | 4.0 kg

Rolleri Type RX LVD
→ Rolleri Type R2

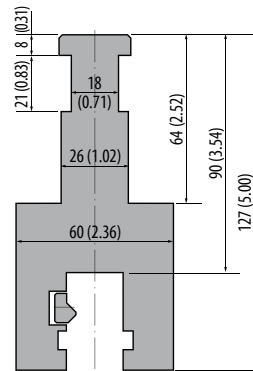
C45: 560-710 N/mm²



AD28

1000 kN/m max.

NEW



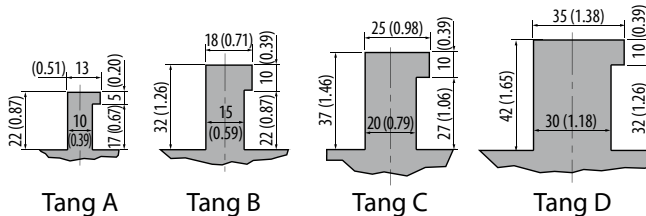
150 mm | 5.91 in | 5.0 kg

Rolleri Type RX EHT
→ Rolleri Type R2

C45: 560-710 N/mm²



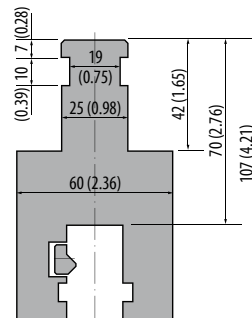
Tangs LVD



AD29

1000 kN/m max.

NEW



150 mm | 5.91 in | 4.5 kg

Rolleri Type RX Weinbrenner
→ Rolleri Type R2

C45: 560-710 N/mm²



Rolleri Videos

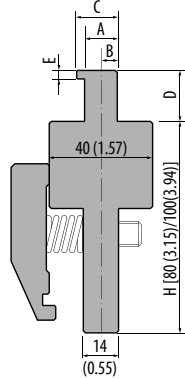
Bolted Adapters AW, P. 216-217
www.rolleritools.com/videos/bolted-adapters



Punch Adapters

INT80-100

1000 kN/m max.



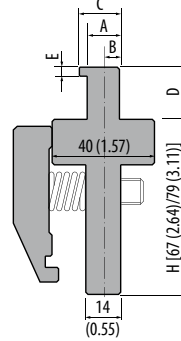
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

C45: 560-710 N/mm²



INT67-79

1000 kN/m max.



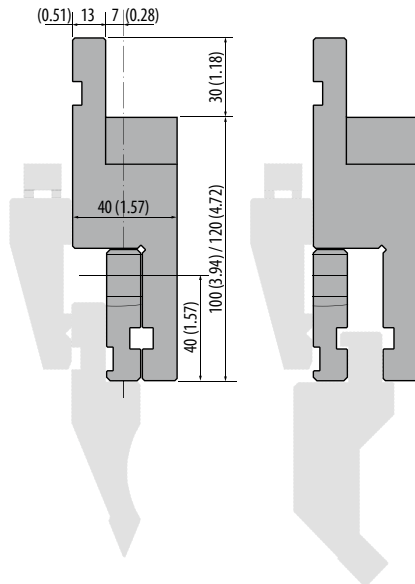
835 mm	32.87 in	20.5 kg
415 mm	16.34 in	10.0 kg

C45: 560-710 N/mm²



INT100-A / INT120-A

1000 kN/m max.



INT100-A		
150 mm	5.91 in	3.5 kg

INT120-A		
150 mm	5.91 in	5.2 kg

C45: 560-710 N/mm²



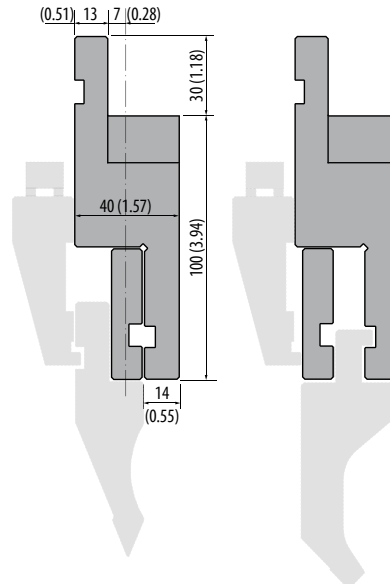
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 208
- Fast Clamping (ROL1 Clamp3), see page 209
- Pneumatic system only on INT120-A (ROL1 Clamp3 PN), see page 209
- Hydraulic system (ROL1 Clamp3 HYD), see page 209



INT100-N (Newton)

1000 kN/m max.



150 mm	5.91 in	3.5 kg
--------	---------	--------

C45: 560-710 N/mm²



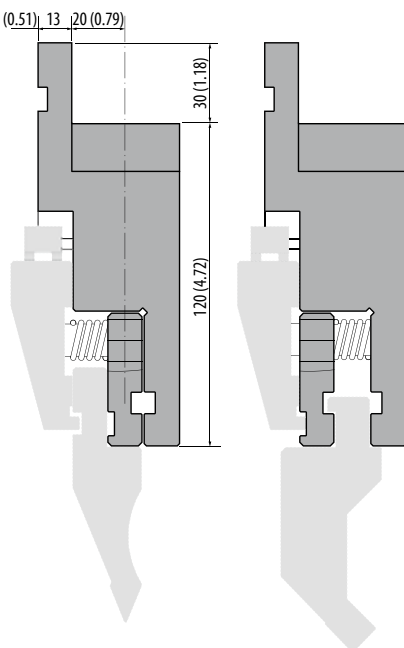
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 208
- Fast Clamping (ROL1 Clamp3), see page 209
- Hydraulic system (ROL1 Clamp3 HYD), see page 209



INT120-40-A

1000 kN/m max.



150 mm	5.91 in	6.0 kg
--------	---------	--------

C45: 560-710 N/mm²



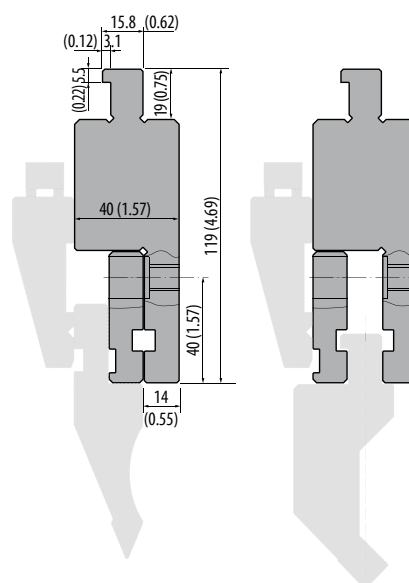
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 208
- Fast Clamping (ROL1 Clamp3), see page 209



INT100-A (American)

1000 kN/m max.



150 mm	5.91 in	3.5 kg
--------	---------	--------

C45: 560-710 N/mm²



suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 208
- Fast Clamping (ROL1 Clamp3), see page 209
- Hydraulic system (ROL1 Clamp3 HYD), see page 209



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



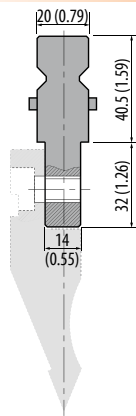
Articles on stock – Please note that delivery time depends on your location.

ROLLERI ADAPTERS

Bolted Adapters

AW11

NEW



1000 kN/m max.

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	2.9 kg

Rolleri Type R2
→ Rolleri Type R1

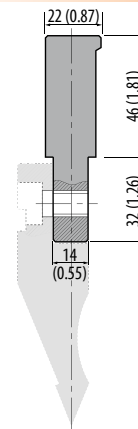
C45: 560-710 N/mm²



Do you prefer our QuickLock or ROL1-System?
Contact us now!

AW3

NEW



1000 kN/m max.

835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
805 mm segmented	31.69 in segmented	8.7 kg

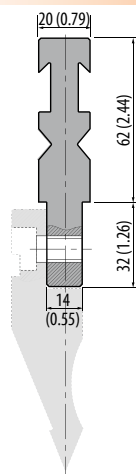
Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



AW10

NEW



1000 kN/m max.

835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
805 mm segmented	31.69 in segmented	9.6 kg

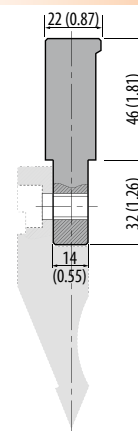
Rolleri Type R3 Beyeler RFA
→ Rolleri Type R1

C45: 560-710 N/mm²



AW12

NEW



1000 kN/m max.

835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.5 kg
805 mm segmented	31.69 in segmented	6.7 kg

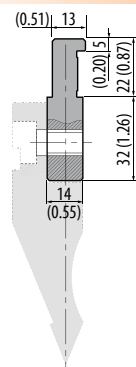
Rolleri Type RX Colgar
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-A

NEW



1000 kN/m max.

835 mm	32.87 in	4.5 kg
415 mm	16.34 in	2.2 kg
805 mm segmented	31.69 in segmented	4.3 kg

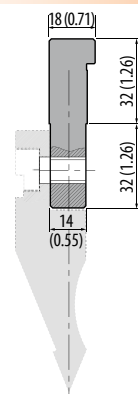
Rolleri Type RX LVD A
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-B

NEW



1000 kN/m max.

835 mm	32.87 in	6.3 kg
415 mm	16.34 in	3.1 kg
805 mm segmented	31.69 in segmented	6.0 kg

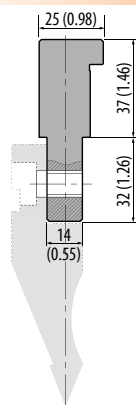
Rolleri Type RX LVD B
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-C

NEW



1000 kN/m max.

835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
805 mm segmented	31.69 in segmented	9.4 kg

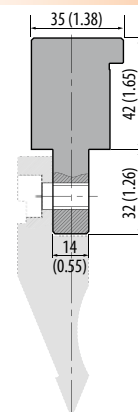
Rolleri Type RX LVD C
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-D

NEW



1000 kN/m max.

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

Rolleri Type RX LVD D
→ Rolleri Type R1

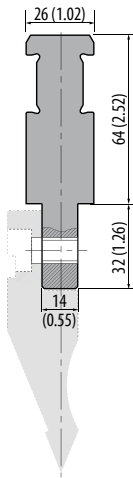
C45: 560-710 N/mm²



AW13

1000 kN/m max.

NEW



835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.3 kg
805 mm segmented	31.69 in segmented	12.1 kg

Rolleri Type RX EHT
→ Rolleri Type R1

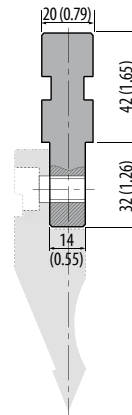
C45: 560-710 N/mm²



AW14

1000 kN/m max.

NEW



835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
805 mm segmented	31.69 in segmented	7.7 kg

Rolleri Type RX Gas-parini → Rolleri Type R1

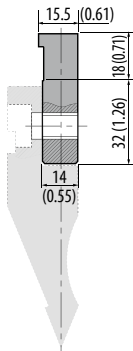
C45: 560-710 N/mm²



AW15

1000 kN/m max.

NEW



835 mm	32.87 in	4.6 kg
415 mm	16.34 in	2.3 kg
805 mm segmented	31.69 in segmented	4.4 kg

Rolleri Type RX Ajial-Axial → Rolleri Type R1

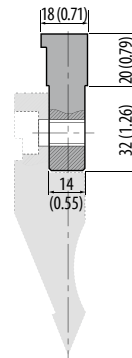
C45: 560-710 N/mm²



AWC16

1000 kN/m max.

NEW



835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

Rolleri Type RX Colly → Rolleri Type R1

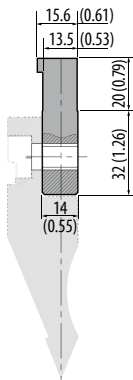
C45: 560-710 N/mm²



AWC13.5

1000 kN/m max.

NEW



835 mm	32.87 in	4.8 kg
415 mm	16.34 in	2.4 kg
805 mm segmented	31.69 in segmented	4.6 kg

Rolleri Type RX Colly → Rolleri Type R1

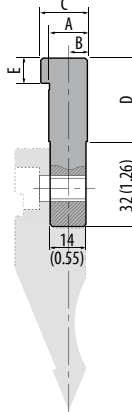
C45: 560-710 N/mm²



AWX

1000 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	3.0 kg

Individual → Rolleri Type R1

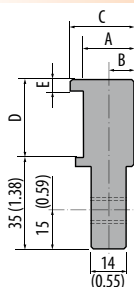
C45: 560-710 N/mm²



INT35

1000 kN/m max.

NEW



835 mm	32.87 in	4.0 kg
525 mm	20.67 in	2.5 kg
805 mm segmented	31.69 in segmented	3.9 kg

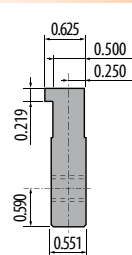
C45: 560-710 N/mm²



INT35-A

1000 kN/m max.

NEW



835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

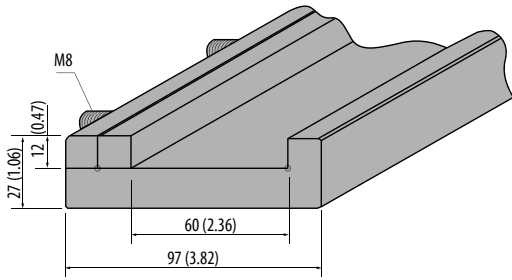


Articles on stock – Please note that delivery time depends on your location.

ROLLERI ADAPTERS

Die Adapter Rails

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



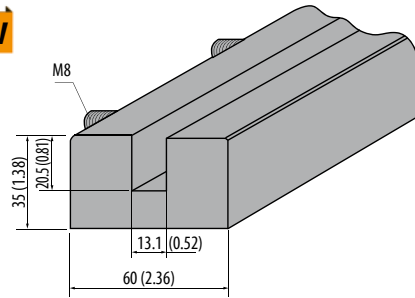
Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm²

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

NEW

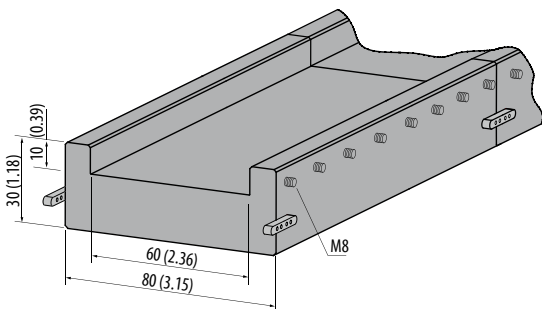


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm²

C 1050/R

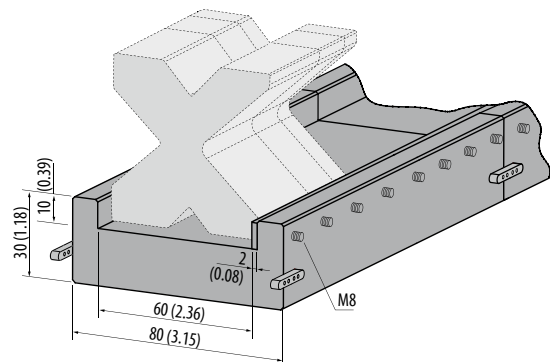


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg



C45: 560-710 N/mm²

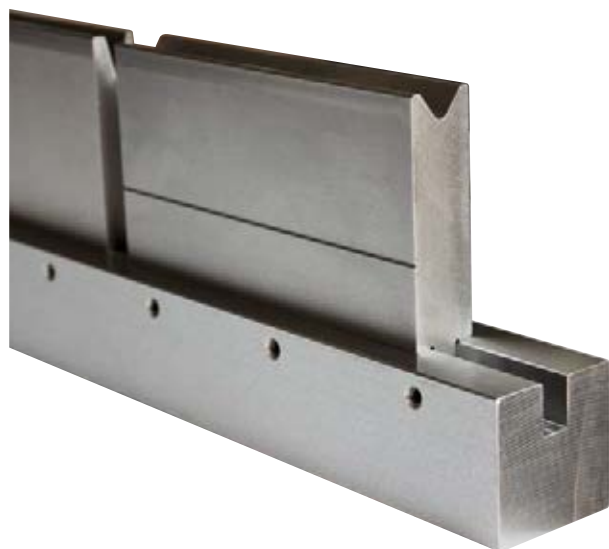
C 1050/RS



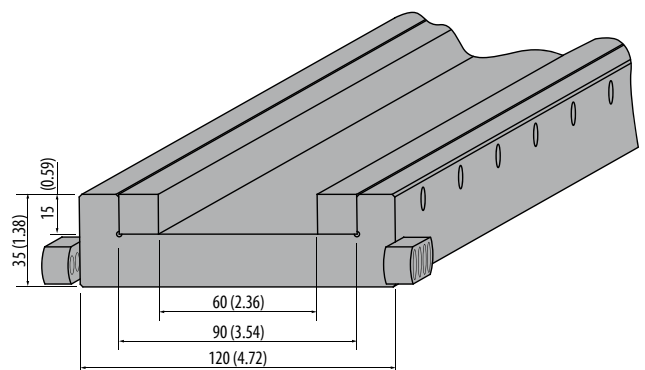
Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



C45: 560-710 N/mm²



C 1050-90



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



C45: 560-710 N/mm²

Die Adapters

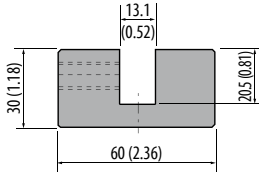
AD6

1000 kN/m max.

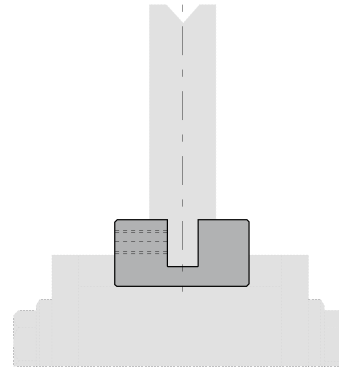
1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD6 Example of Application



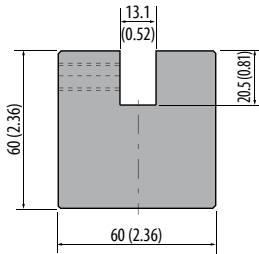
AD5

1000 kN/m max.

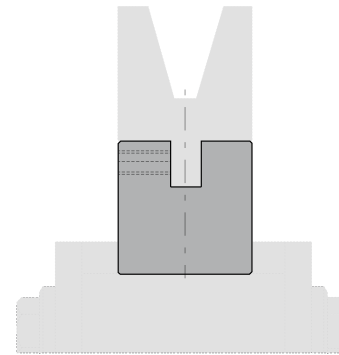
1000 mm	39.37 in	26.1 kg
500 mm	19.68 in	13.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD5 Example of Application



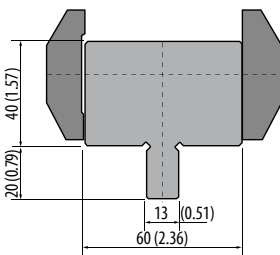
AD7

1000 kN/m max.

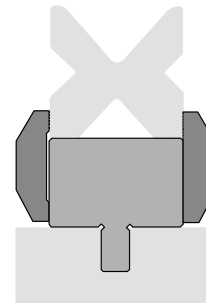
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²



AD7 Example of Application



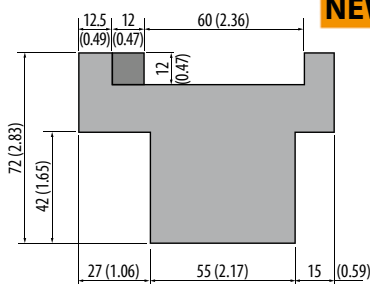
AD24

1000 kN/m max.

835 mm	32.87 in	28.5 kg
415 mm	16.34 in	14.2 kg

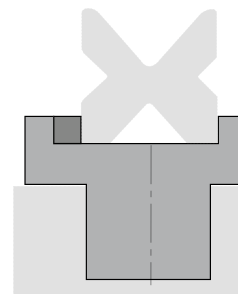
Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²



NEW

AD24 Example of Application



10



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



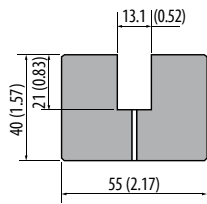
Articles on stock – Please note that delivery time depends on your location.

ROLLERI ADAPTERS

Die Adapters

AD25

NEW



1000 kN/m max.

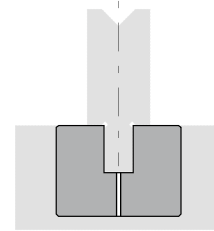
500 mm	19.68 in	7.5 kg
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Rolleri Type RX EHT
→ Rolleri Type R2/R3

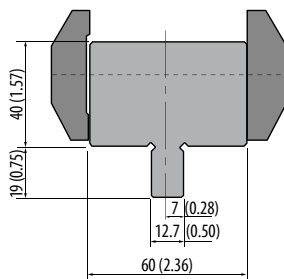
C45: 560-710 N/mm²



AD25 Example of Application



AD9-12.7



1000 kN/m max.

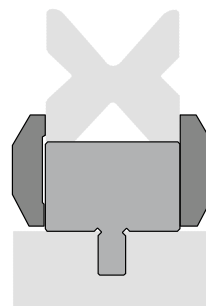
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.5 kg

Rolleri Type RX LVD
→ Rolleri Type R1

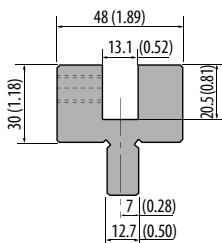
C45: 560-710 N/mm²



AD9-12.7 Example of Application



AD8-12.7



1000 kN/m max.

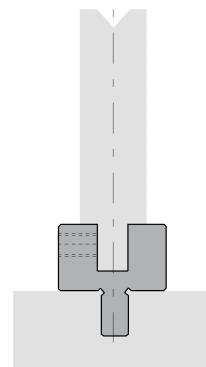
1000 mm	39.37 in	15.0 kg
500 mm	19.68 in	7.5 kg

Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

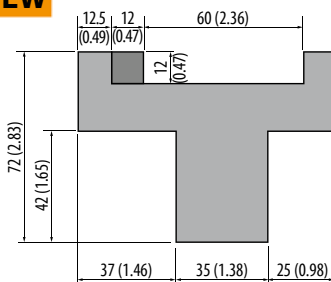


AD8-12.7 Example of Application



AD26

NEW



1000 kN/m max.

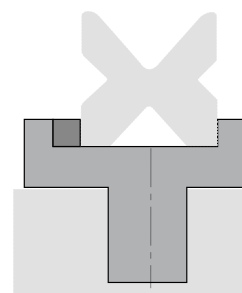
835 mm	32.87 in	23.0 kg
415 mm	16.34 in	11.4 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm²



AD26 Example of Application

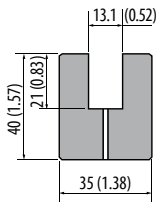


Die Adapters

AD27

1000 kN/m max.

NEW



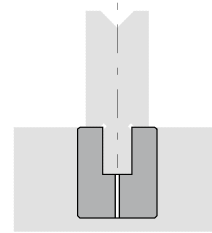
500 mm	19.68 in	4.5 kg
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Rolleri Type RX
Weinbrenner
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

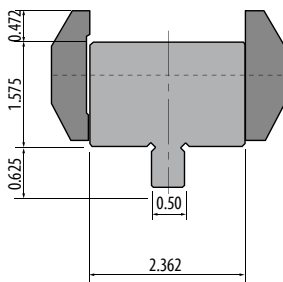


AD27 Example of Application



AD17

1000 kN/m max.



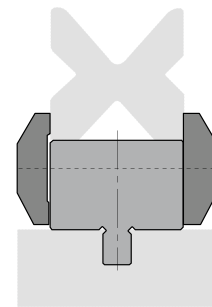
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Type American
→ Rolleri Type R1

C45: 560-710 N/mm²

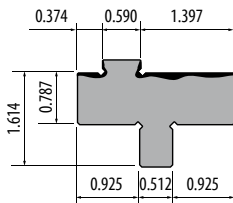


AD17 Example of Application



AD18

1000 kN/m max.



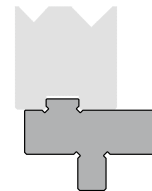
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Type American
→ Rolleri Type R1

C45: 560-710 N/mm²



AD18 Example of Application



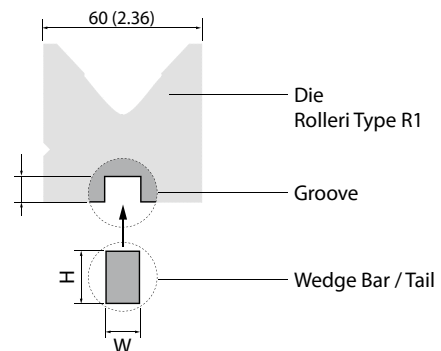
Modification: Wedge Bar / Tail

In order to use the dies Rolleri Type R1 on other press brake machines, a 10 mm (0.39 in) groove is milled to insert a ground wedge bar / tail into the die.

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

Specific information and prizes are found in the Rolleri Service / Modifications Chapter (see page 260)

Mounting example



ROLLERI MARK FREE BENDING

Prevention of Bending Marks	232
Bending Foil Holder/Tensioner	232
Bending Foil	233
PU-Holder and PU-Upholstery	234 - 235
Synthetic Dies	236 - 237



ROLLERI MARK FREE BENDING

Prevention of Bending Marks

One of the challenges of bending is to prevent the profile of having bending marks, such as; scratches and abrasions on the surface areas.

Especially of Profile made of:

- Stainless Steel
- Aluminium
- painted metal panels

It is often the case of a line building from the contact of the sheet metal with the die. This is the cause of friction of sheet metal on small radius.

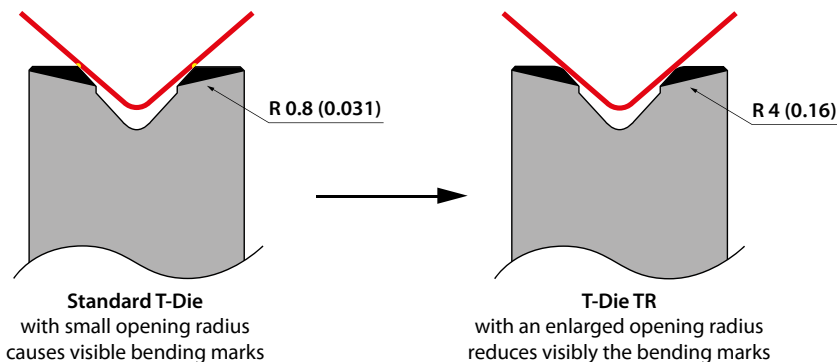
In order to prevent this markings, the following solutions are possible:

- Bending Foil
- PU-Upholstery
- Plastic Dies
- enlarged opening radius on special T-Dies



Our Advantages – Your Convenience

- Prevention of scratches and abrasions on bent sheet metals
- No post-processing necessary, therefore time and cost saving
- No contamination of bended pieces
- increases the product quality
- easy handling



T-Dies (TR) with an enlarged opening radius for the prevention of bending marks see pages 54-55, 60-61

Bending Foil - Holder / Tensioner

CT



per pair | 6.0 kg



Bending Foil

Our Advantages – Your Convenience

- easy handling
- can be used flexibly
- Prevention of Bending Marks
- decrease of post-processing of bent parts
- no contamination of the material
- increased product quality



Bending Foil:
Practical, easy and economic!

ROLFILM



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



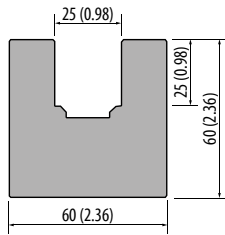
Rolleri Videos
mark free bending:
www.rolleritools.com/videos/mark-free-bending



ROLLERI MARK FREE BENDING

PU-Holders and PU-Upholstery

MPG25

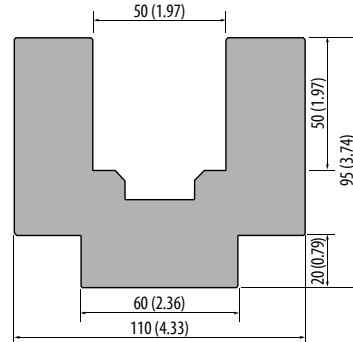


835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg

C45: 560-710 N/mm²



MPG50

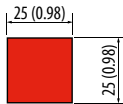


835 mm	32.87 in	44.0 kg
415 mm	16.34 in	22.0 kg

C45: 560-710 N/mm²



GM 25x25

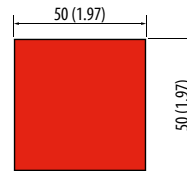


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane



GM 50x50

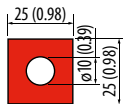


835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

polyurethane



GMF 25x25x10

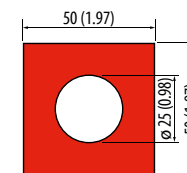


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane



GMF 50x50x25



835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

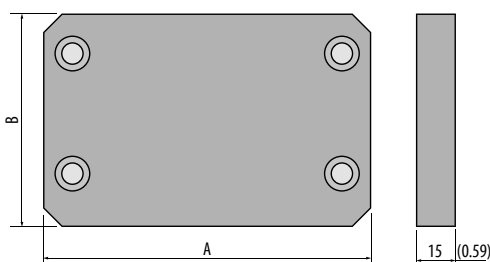
polyurethane



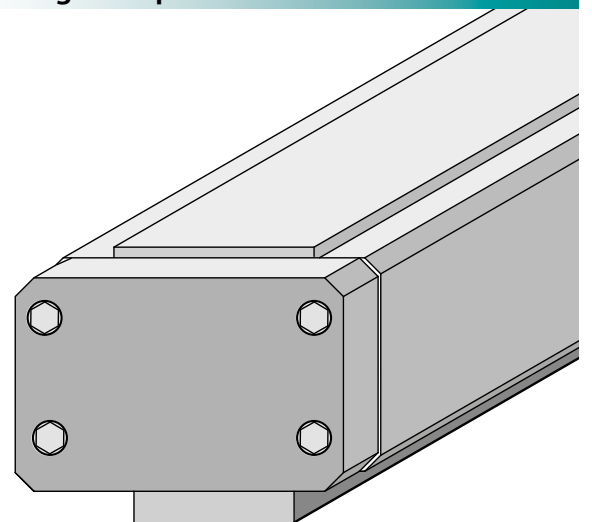
PSTCON

cover plate	Model	A (mm)	A (in)	R (mm)	R (in)	Weight
	PSTCON25	58	2.28	58	2.28	1.2 kg
	PSTCON50	108	4.25	75	2.95	0.6 kg
	PSTCON75	123	4.84	80	3.15	0.8 kg
	PSTCON100	153	6.02	80	3.15	1.0 kg

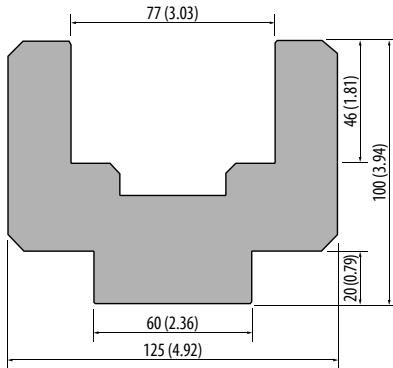
C45: 560-710 N/mm²



Mounting example



MPG75

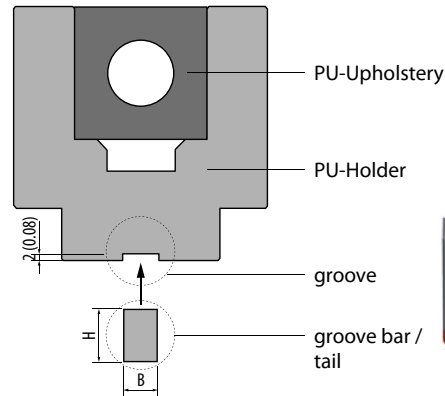


835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg

C45: 560-710 N/mm²

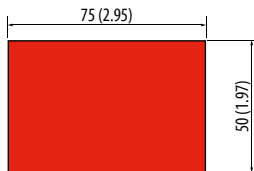


Mounting example



Also mountable on other press brakes!

GM 75x50

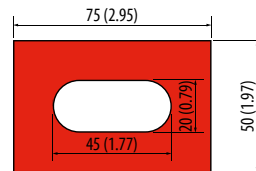


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane



GMF 75x50x20

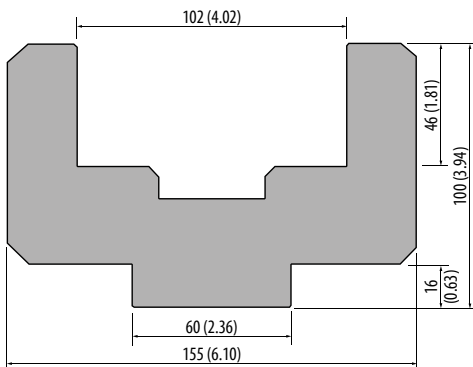


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane



MPG100



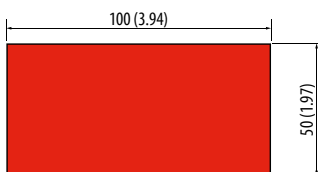
835 mm	32.87 in	55.0 kg
415 mm	16.34 in	27.5 kg

C45: 560-710 N/mm²



PU-Upholstery are suitable for radius- and U-profile bendings, etc.

GM 100x50

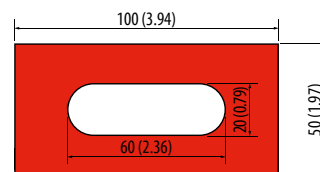


835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg

polyurethane



GMF 100x50x20



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	2.2 kg

polyurethane



ROLLERI MARK FREE BENDING

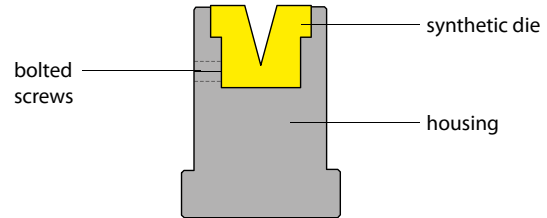
Synthetic Dies

Our Advantages – Your Convenience

- easy handling
- faster and easier exchange of plastic dies
- prevention of bending marks
- decrease of post-processing of bent pieces
- no contamination of the materials
- increased product quality

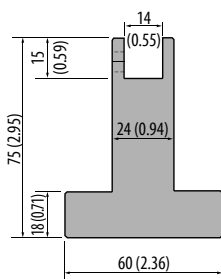
Mounting example

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



TN80.14

1000 kN/m max.



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

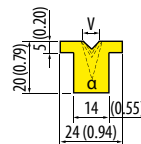
Rolleri Type R1

C45: 560-710 N/mm²



INS14...

200 kN/m max.



835 mm	32.87 in	0.30 kg
415 mm	16.34 in	0.15 kg

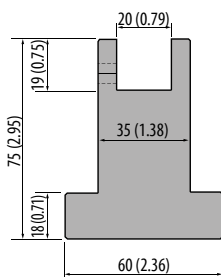


Model	α	V (mm)	V (in)
INS14.06.88	88°	6	0.24
INS14.08.88	88°	8	0.31
INS14.10.88	88°	10	0.39
INS14.06.60	60°	6	0.24
INS14.08.60	60°	8	0.31
INS14.10.60	60°	10	0.39

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

TN80.20

1000 kN/m max.



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

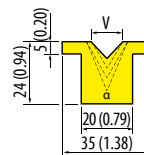
Rolleri Type R1

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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



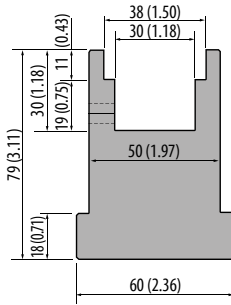
Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

Synthetic Dies

TN80.30

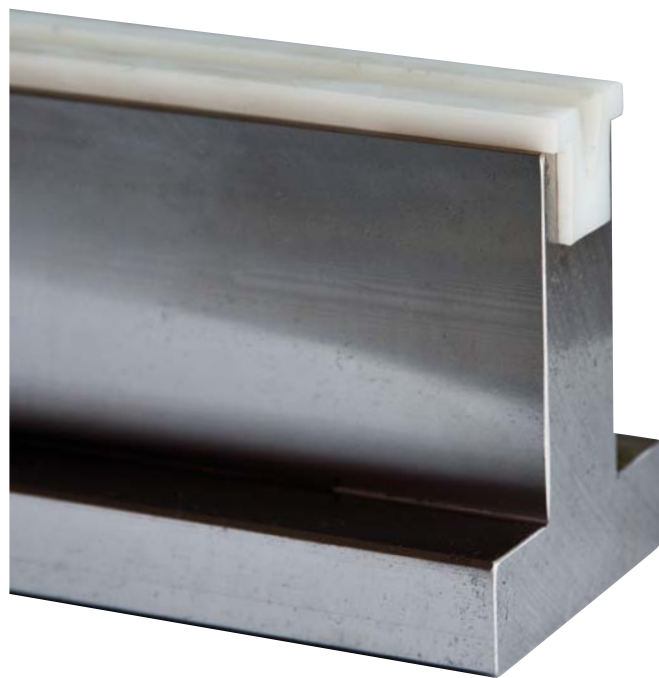
1000 kN/m max.



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

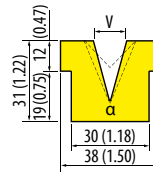
Rolleri Type R1

C45: 560-710 N/mm²



INS30...

200 kN/m max.



835 mm	32.87 in	0.50 kg
415 mm	16.34 in	0.25 kg



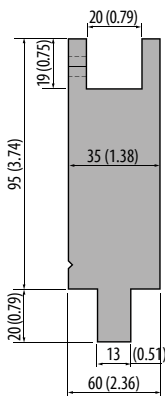
Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.47
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16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

Model	α	V (mm)	V (in)
INS30.06.45	45°	6	0.24
INS30.08.45	45°	8	0.31
INS30.10.45	45°	10	0.39
INS30.12.45	45°	12	0.47
INS30.16.45	45°	16	0.63
INS30.20.45	45°	20	0.79
INS30.06.30	30°	6	0.24
INS30.08.30	30°	8	0.31
INS30.10.30	30°	10	0.39
INS30.12.30	30°	12	0.47
INS30.16.30	30°	16	0.63



TMN95.20

1000 kN/m max.



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

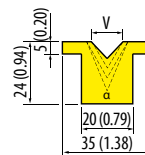
Rolleri Type R2/R3

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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



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

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.16.45	45°	16	0.63
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock - Please note that delivery time depends on your location.

ROLLERI **SPECIAL AND HEAVY DUTY TOOLS**

Explanation of Special Tools	240
Explanation of Heavy Duty Tools	241
Heavy Duty Tools	242 - 243
Examples of Special Tools	244 - 246
Dies with Rollers	247 - 249
ROL6-System	250
Panelling Tools	250
BLACKFIRE	251





ROLLERI SPECIAL AND HEAVY DUTY TOOLS

Special Solutions

Our Advantages – Your Convenience

- in-house construction and production (no reseller or dealer)
- competent consulting
- client specific developments
- tracking of every tool possible, with a unique serial number on every article after the quality control check
- precision grinding (tolerance of +/-0.01mm)
- guaranteed tool reproduction
- exact parallelism
- bending tests upon request

Special Tooling for:

- Z-Profiles
- Hat-Profiles
- Trapezoidal Profiles
- Pressed contours
- Foldings
- Hinges
- Radii
- Beads
- Special Profiles
- etc.



Material

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

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29,1 - 36,9 HRc	54 - 60 HRc
C45	560-710 N/mm ²	12 - 15,5 HRc	54 - 60 HRc
1.2767	830 N/mm ²	22 - 25 HRc	54 - 60 HRc

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





■ Our Advantages – Your Convenience

The bending of materials with extreme high resistance, (Hardox, Weldox, etc.), has developed into an important task.

The Heavy Duty tools of Rolleri are built and finished for these challenges.

Tools that have a press force up to 4000 kN/m, offer you many production possibility.

Our many years of experience in the area of special and heavy duty tooling, along with our own developing department, guarantee you functional and economic solutions in the bending sector.

From the compatible tang to the punch onto the compatible die; we manufacture everything in our own production facilities.

Take advantage of the direct contact to the manufacturer and the benefits which come along with it.



Contact us now!
We are here
to help you!



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



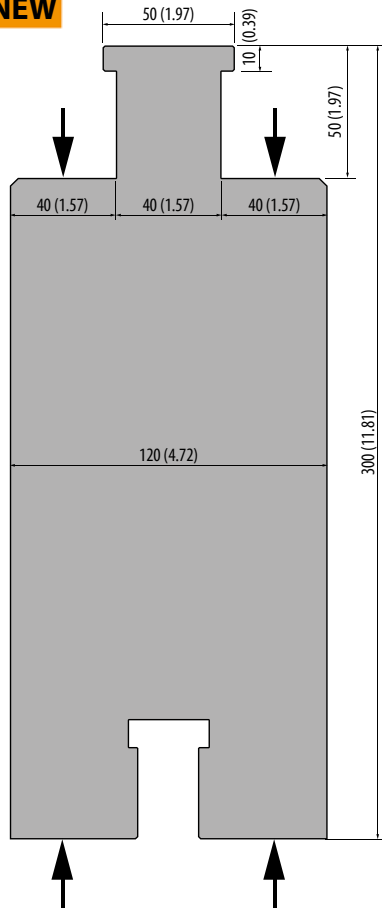
Articles on stock – Please note that delivery time depends on your location.

ROLLERI SPECIAL AND HEAVY DUTY TOOLS

Heavy Duty Tools

RHD.300

NEW



RHD.300-250		
500 mm	19.68 in	122.0 kg

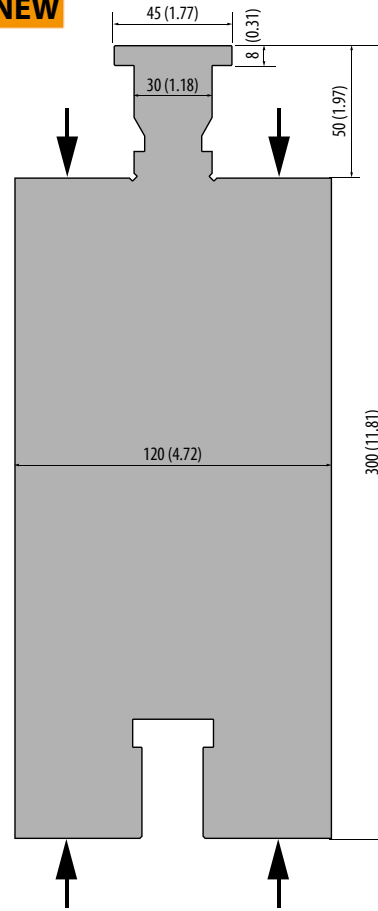
2500 kN/m max.
42Cr: 900-1150 N/mm²

RHD.300-400		
500 mm	19.68 in	122.0 kg

4000 kN/m max.
1.2767: 830 N/mm²

RHD.300 HYD

NEW



RHD.300-250 HYD		
500 mm	19.68 in	120.0 kg

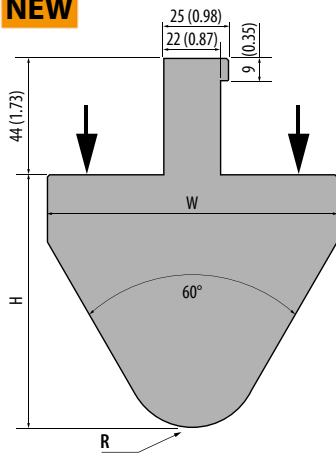
2500 kN/m max.
42Cr: 900-1150 N/mm²

RHD.300-400 HYD		
500 mm	19.68 in	120.0 kg

4000 kN/m max.
1.2767: 830 N/mm²

RHDP.60

NEW



500 mm	19.68 in
--------	----------

Model	2500 kN/m max.						4000 kN/m max.						
	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)	Model	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-250	96	3.78	110	4.33	20	0.79	RHDP.60.20-400	96	3.78	110	4.33	20	0.79
RHDP.60.25-250	96	3.78	110	4.33	25	0.98	RHDP.60.25-400	96	3.78	110	4.33	25	0.98
RHDP.60.30-250	96	3.78	110	4.33	30	1.18	RHDP.60.30-400	96	3.78	110	4.33	30	1.18
RHDP.60.40-250	96	3.78	110	4.33	40	1.57	RHDP.60.40-400	96	3.78	110	4.33	40	1.57
RHDP.60.50-250	96	3.78	110	4.33	50	1.97	RHDP.60.50-400	96	3.78	110	4.33	50	1.97
RHDP.60.60-250	96	3.78	110	4.33	60	2.36	RHDP.60.60-400	96	3.78	110	4.33	60	2.36
RHDP.60.70-250	86	3.39	140	5.51	70	2.76	RHDP.60.70-400	86	3.39	140	5.51	70	2.76
RHDP.60.80-250	86	3.39	150	5.91	80	3.15	RHDP.60.80-400	86	3.39	150	5.91	80	3.15
RHDP.60.90-250	86	3.39	165	6.50	90	3.54	RHDP.60.90-400	86	3.39	165	6.50	90	3.54
RHDP.60.100-250	86	3.39	185	7.28	100	3.94	RHDP.60.100-400	86	3.39	185	7.28	100	3.94

42Cr: 900-1150 N/mm²

1.2767: 830 N/mm²

RHD.500-200

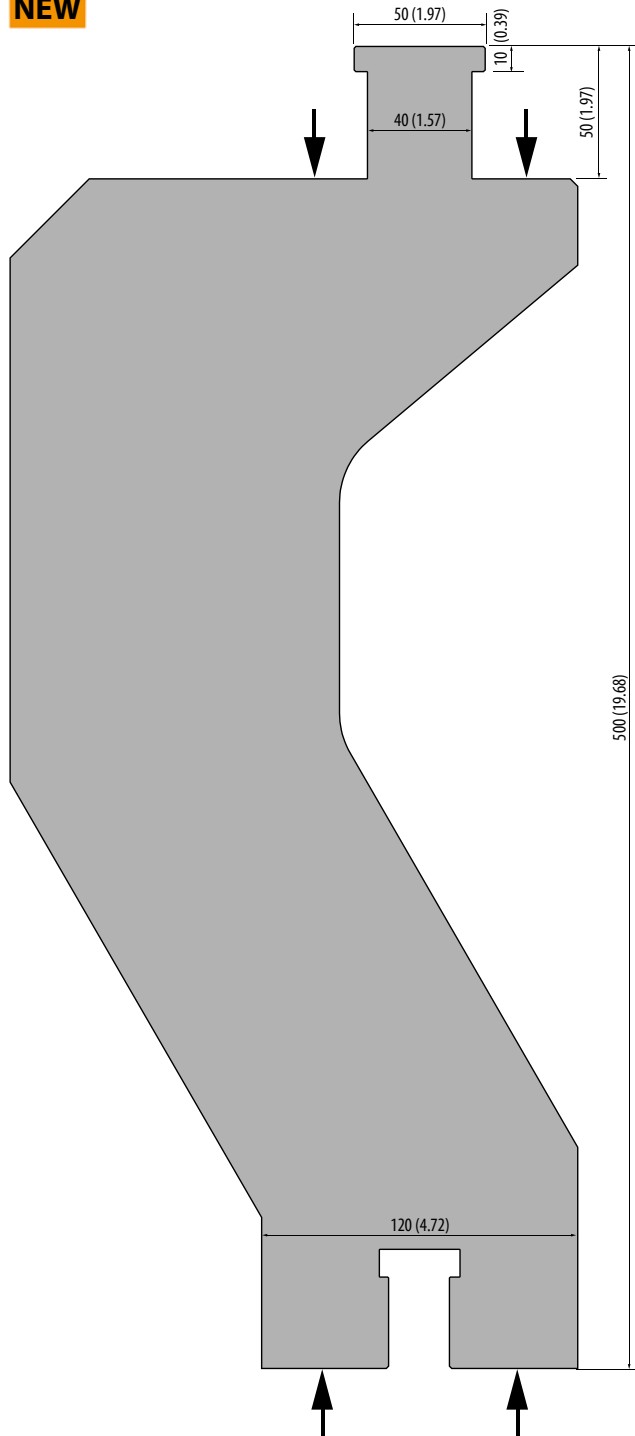
2000 kN/m max.

150 mm | 19.68 in | 253.0 kg

42Cr: 900-1150 N/mm²



NEW



More Tools for Heavy Duty operations can be found on pages 158-160



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

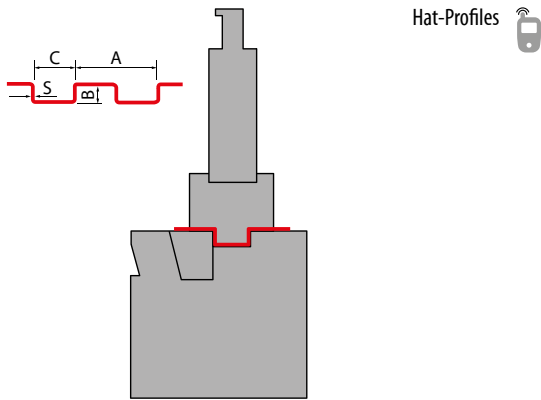


Articles on stock – Please note that delivery time depends on your location.

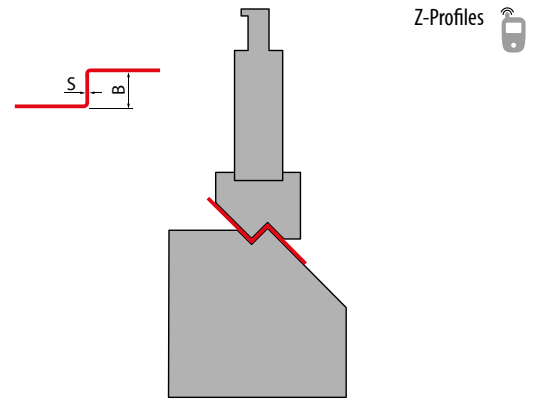
ROLLERI SPECIAL AND HEAVY DUTY TOOLS

Tool examples

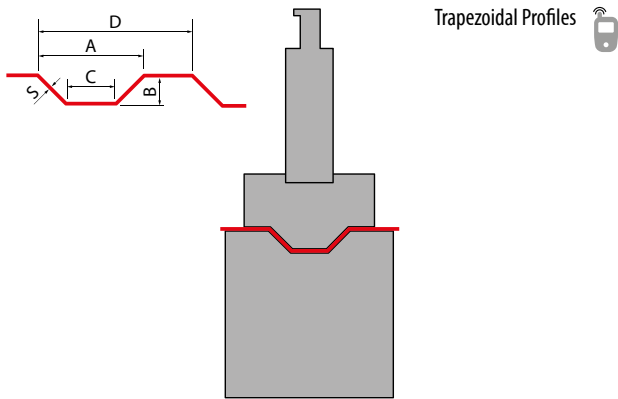
SPE1



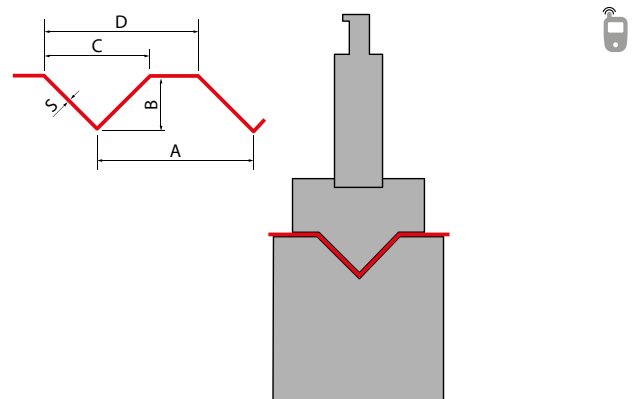
SPE2



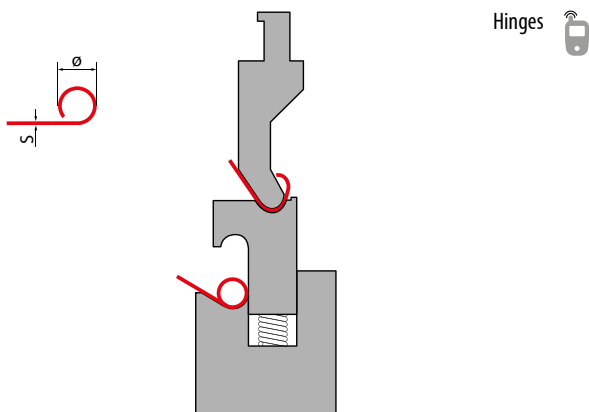
SPE3



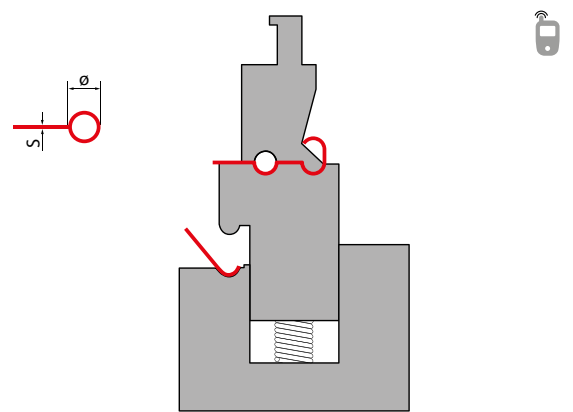
SPE4



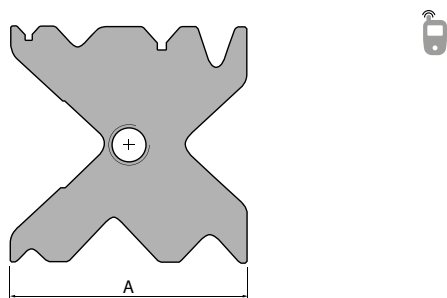
SPE5



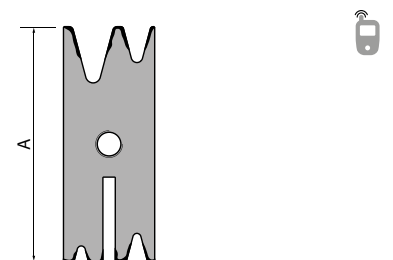
SPE6



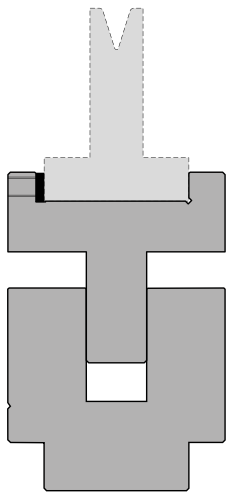
SPE7



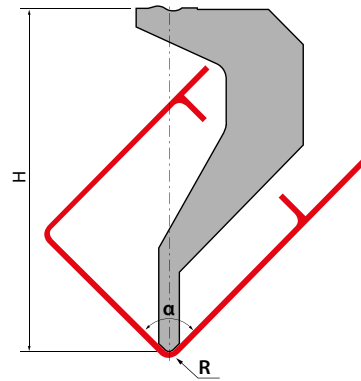
SPE-X



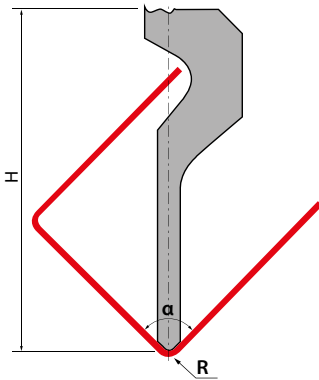
SPE9



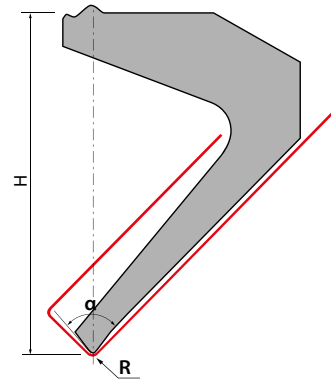
SPE-P1



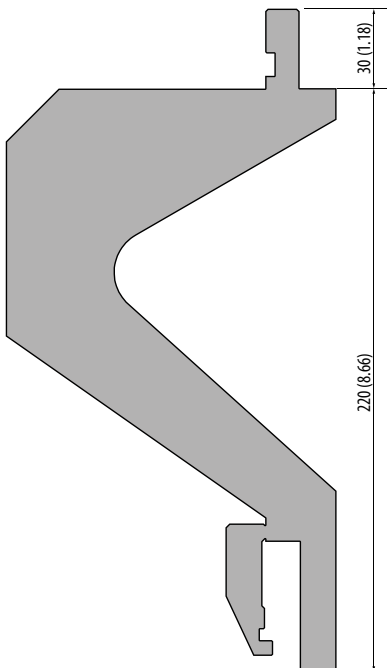
SPE-P2



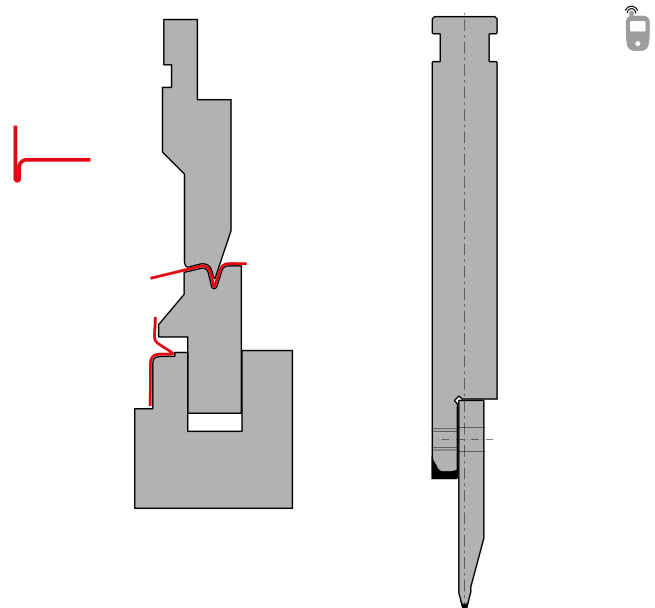
SPE-P3



SPE-P4



Front- and Hemming Tool (Foldings)



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

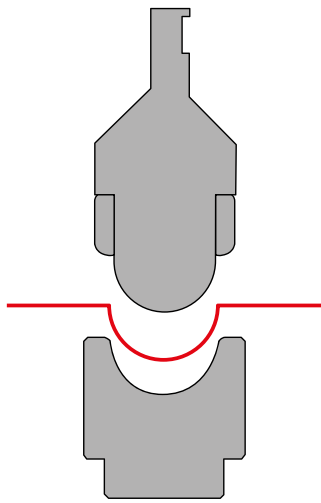


Articles on stock – Please note that delivery time depends on your location.

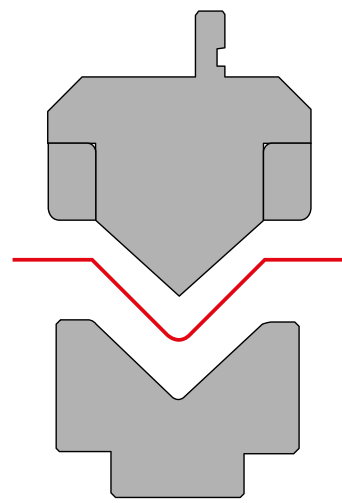
ROLLERI SPECIAL AND HEAVY DUTY TOOLS

Tool examples

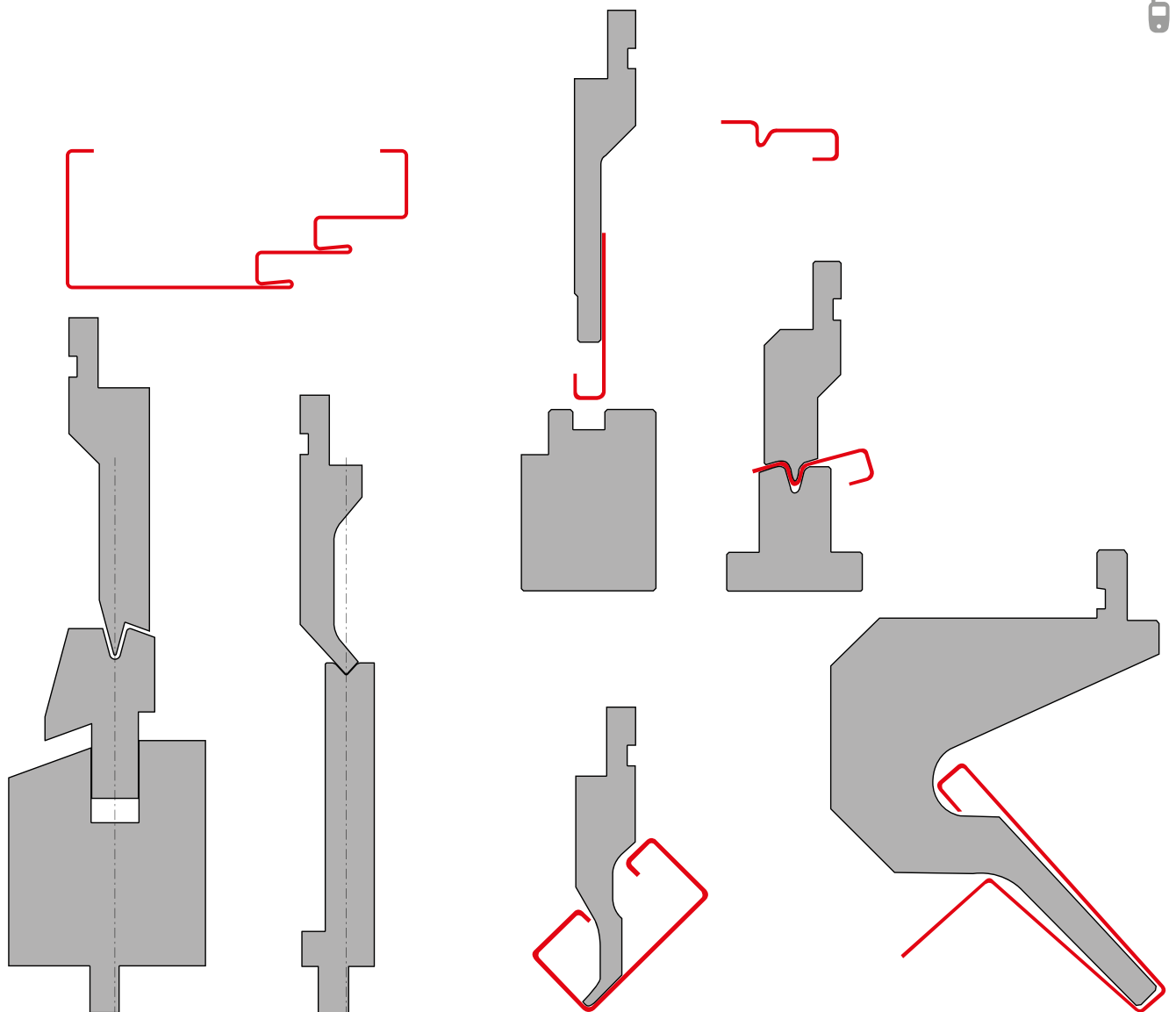
Radii



Pressing

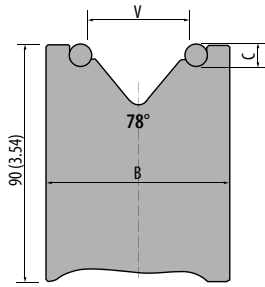


Special Profiles



Dies with Rollers

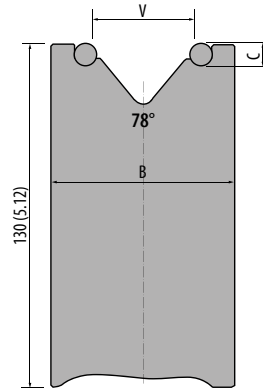
MR90



Rollen: C53.60-62 HRC
42Cr: 900-1150 N/mm²



MR130



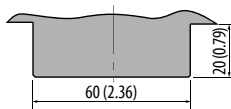
Rollen: C53.60-62 HRC
42Cr: 900-1150 N/mm²



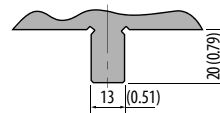
Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
MR90.20.78	20	0.79	45	1.77	6	0.24	835	32.87	15.0
MR90.24.78	24	0.94	49	1.93	6	0.24	835	32.87	17.0
MR90.30.78	30	1.18	60	2.36	8	0.31	835	32.87	21.0
MR90.40.78	40	1.57	70	2.76	8	0.31	835	32.87	24.0
MR90.50.78	50	1.97	84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

Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
MR130.20.78	20	0.79	45	1.77	6	0.24	835	32.87	22.0
MR130.24.78	24	0.94	49	1.93	6	0.24	835	32.87	25.0
MR130.30.78	30	1.18	60	2.36	8	0.31	835	32.87	28.0
MR130.40.78	40	1.57	70	2.76	8	0.31	835	32.87	34.0
MR130.50.78	50	1.97	84	3.31	10	0.39	835	32.87	40.0
MR130.60.78	60	2.36	94	3.70	10	0.39	835	32.87	45.0
MR130.75.78	75	2.95	118	4.65	16	0.63	835	32.87	50.0
MR130.80.78	80	3.15	123	4.84	16	0.63	835	32.87	55.0
MR130.90.78	90	3.54	133	5.24	16	0.63	835	32.87	60.0
MR130.100.78	100	3.94	143	5.63	16	0.63	835	32.87	65.0
MR130.120.78	120	4.72	163	6.42	16	0.63	835	32.87	70.0

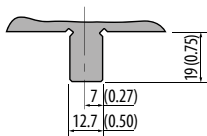
A10



A11



A13



ROLLERI SPECIAL AND HEAVY DUTY TOOLS

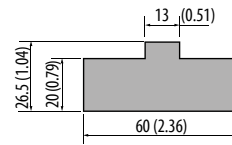
Dies with Rollers

Our Advantages – Your Convenience

- increase in wear resistance through rollers
- induction hardened rollers (approx. 60 HRC)
- decrease in bending marks
- decrease in press force
- easy and economic exchange of rollers

AD MR60

NEW



98 mm | 3.86 in

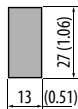
Adapter for Roller Type R1

C45: 560-710 N/mm²



AD MR13

NEW



98 mm | 3.86 in

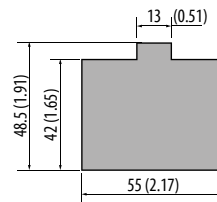
Adapter for Roller Type R2/R3

C45: 560-710 N/mm²



AD MR55

NEW



98 mm | 3.86 in

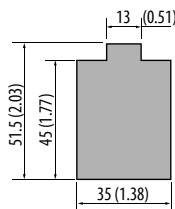
Adapter for Roller Type RX EHT

C45: 560-710 N/mm²



AD MR35

NEW



98 mm | 3.86 in

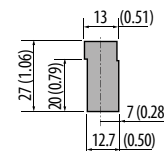
Adapter for Roller Type RX Weinbrenner

C45: 560-710 N/mm²



AD MR12.7

NEW



98 mm | 3.86 in

Adapter for Roller Type RX LVD

C45: 560-710 N/mm²



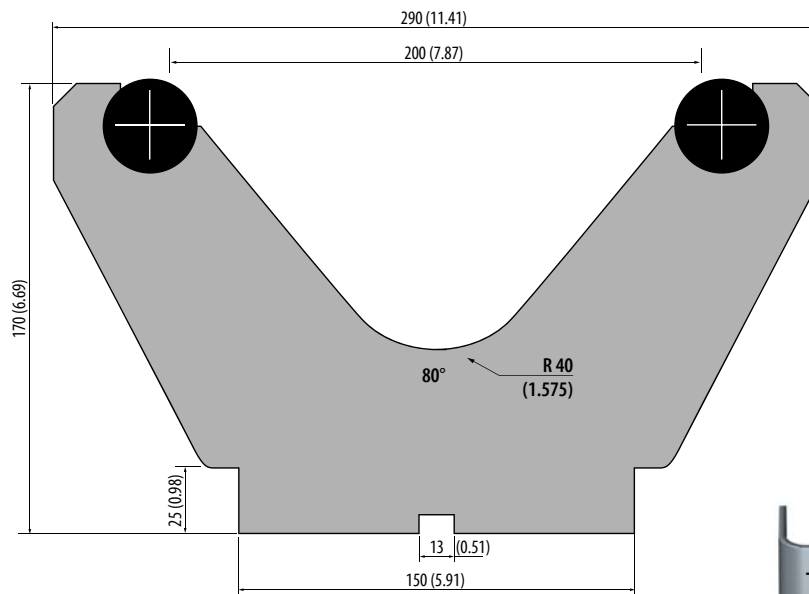
MR170.200.80

2000 kN/m max.

NEW

100 mm | 3.94 in | 19.0 kg

42Cr: 900-1150 N/mm²



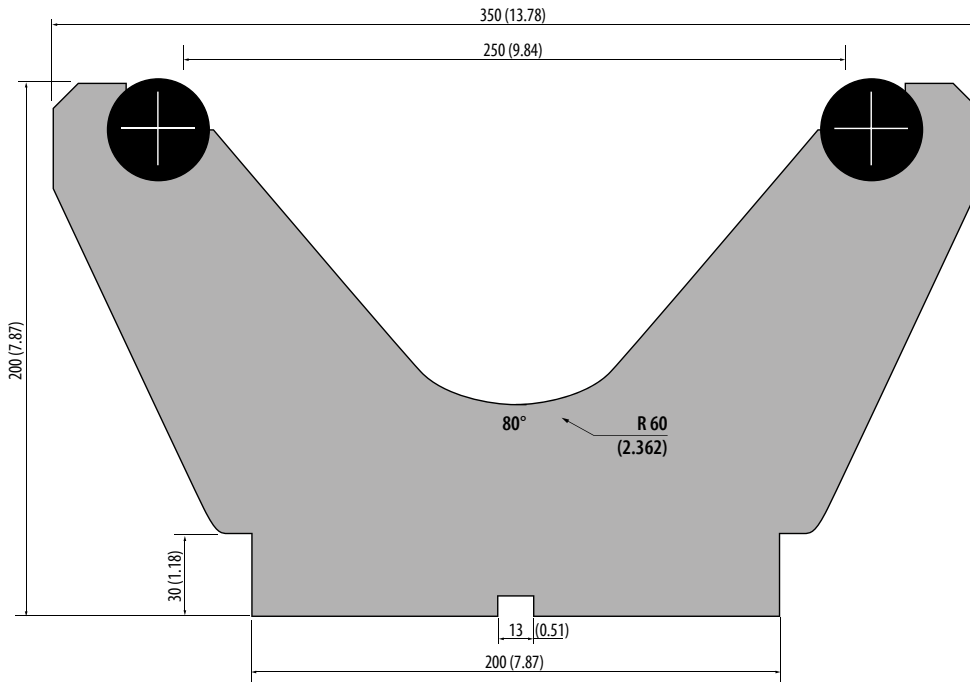
Take advantage of our dies with rollers with means of groove bars/tails to use on other press brake machines.

MR200.250.80

2000 kN/m max.

100 mm | 3.94 in | 28.0 kg

NEW



42Cr-900-1150 N/mm²

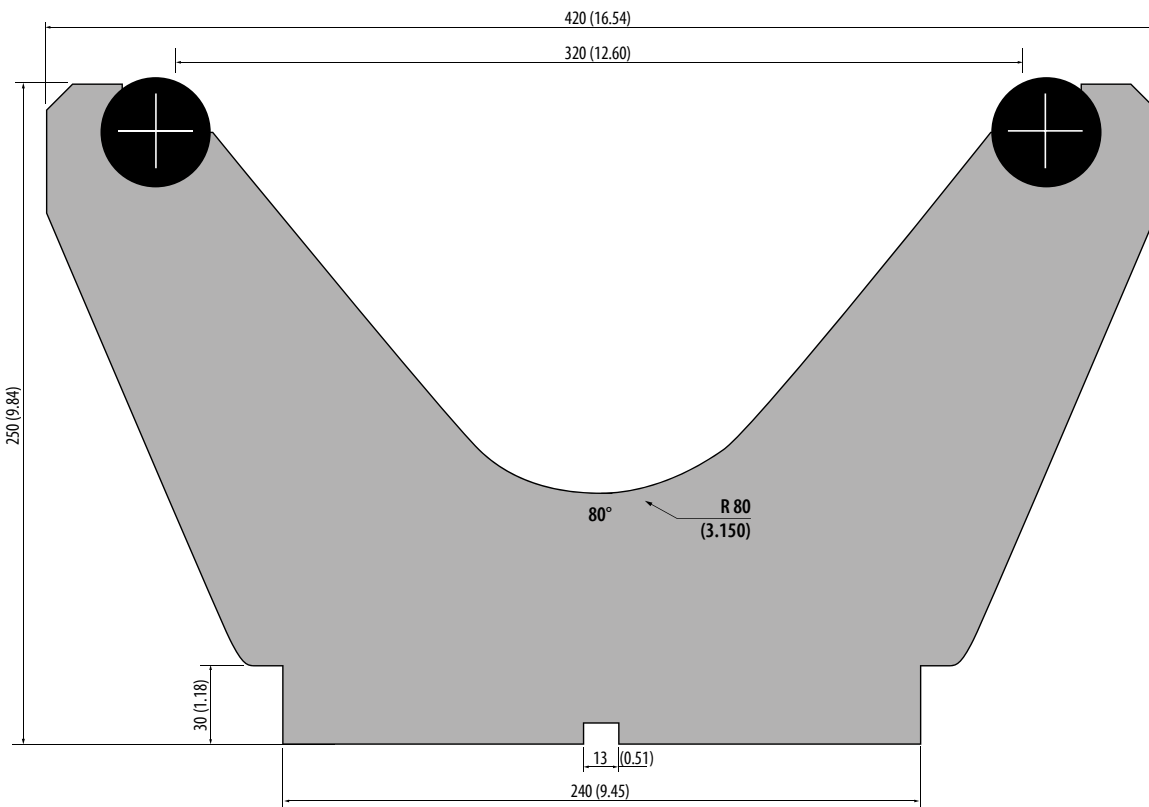


MR250.320.80

2000 kN/m max.

100 mm | 3.94 in | 42.0 kg

NEW



42Cr-900-1150 N/mm²



12



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

ROLLERI SPECIAL AND HEAVY DUTY TOOLS

ROL6-System

Our Advantages – Your Convenience

- various V-Openings: 40-360 mm (1.57-14.17 in)
- Instructions:
 - secured manually with steering wheel
 - driven by gear motor or
 - CNC-system

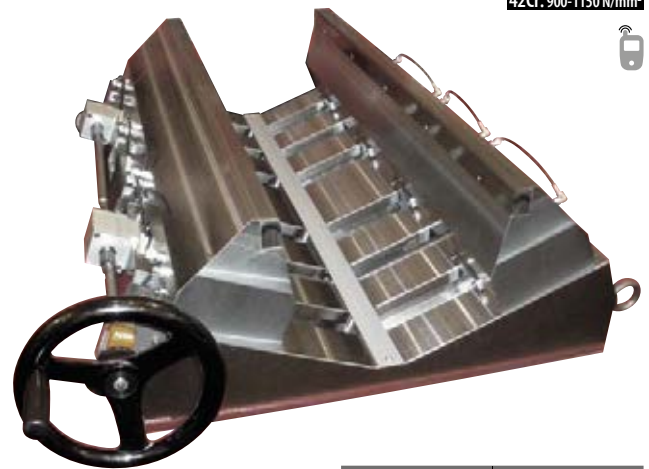
While using the manual version, the opening is set in place by a turn of the steering wheel, or with a gear reduction which is attached to the die.

The automatic version, on the other hand, is operated by a control panel. The standard system does not come with the CNC-Connection for the press brake. It is available upon request at an additional cost.

The base of the ROL6-system is 720 mm (28.35 in) wide, but can also be fitted onto narrow designed tables. There is a adapter available in order to secure the system onto a table with a width of 400 mm (15.75 in). The inserts in the opening radius are exchangeable. The standard version comes with an opening radius of R=10 mm (0.39 in).

Die weight: approx. 1 ton/m

ROL6



42Cr: 900-1150 N/mm²

bending angle	kN/m max.
0°	6000
90°	6000
60°	4000



Rolleri Videos

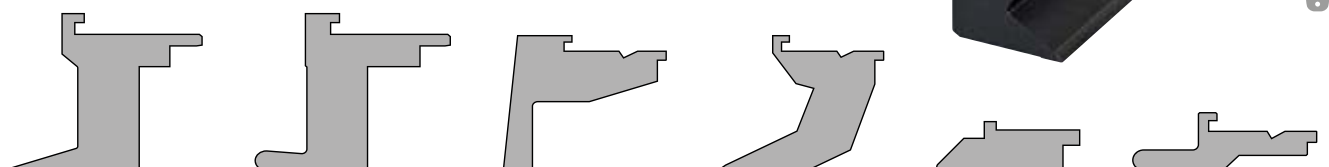


Application of various dies ROL6:
www.rolleritools.com/videos/rol6

Panelling Tools

Our Advantages – Your Convenience

- in-house construction (no reseller or dealer)
- production according to your specifications
- tracking of every tool possible, with a unique serial number on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- exact parallelism
- use of the best materials, guaranteed high resistance and tensile strength



BLACKFIRE**■ The Unique Coating**

Rolleri BLACKFIRE is a particular coating of your tools which defines itself by its increased corrosion resistance and special design.

The chemical treatment permanently solves the problem of oxidation.

The top surface of the metals changes through the phosphate process. It builds phosphate-like crystals, that attach themselves chemically on the substance. This improves the durability of the surface against corrosion.

Your equipment will have a long-term lifecycle left unchanged. The glossy black color of BLACKFIRE is compatible with the new technology and that allows a unique and esthetic look which connects well with the advantages of it.

You can have the BLACKFIRE treatment on all standard tools with a surcharge of 30 %.

Please note that the delivery times vary by a BLACKFIRE Treatment.

■ Our Advantages – Your Convenience

- no corrosion
- better gliding by the exchange of tools
- appealing design
- long-life cycle



ROLLERI SERVICES / MODIFICATIONS

Our Production Department	254 - 255
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Gaps and Windows	261



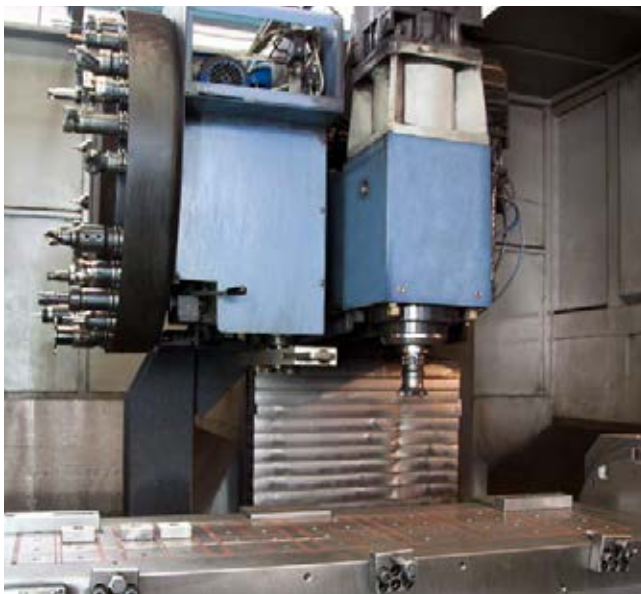
Our Production Department

Our Machine Park

Our comprehensive machinery with state-of-the-art technology ensures you the highest quality in tools.

In addition to the manufactured standard and special tools, we perform all modifications individually according to your requirements.

Take advantage the modifications to reduce costs and increase the productivity of your existing tools!



CNC-Milling

With our state-of-the-art milling centers we can do your modification requests fast, precise and with high-quality.

Swivel milling heads with high swivel range allows flexible and universal production.

This is where, grooves, gaps, and openings are created.

CNC-Profile Grinding

Our CNC-Professional grinding machines guarantee, highest precision ground (tolerance of ± 0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tool pieces. Radius and angle modifications are precisely grounded after your measurements.





■ Hardening

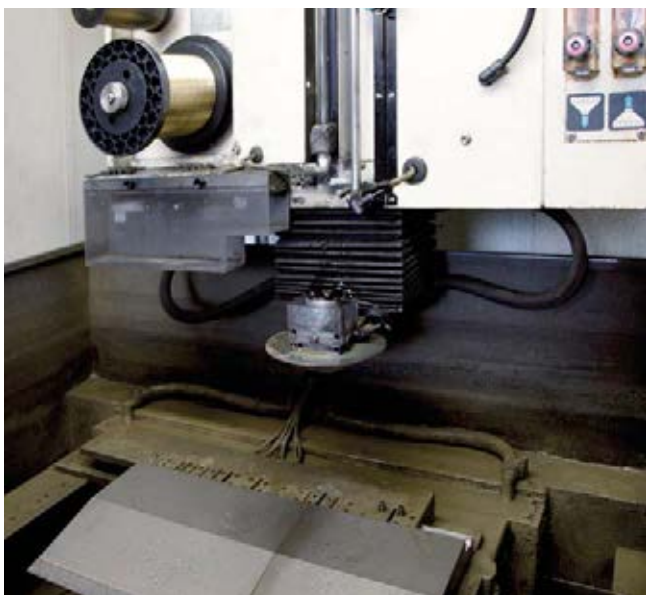
The surface areas of the tools are exposed to the highest mechanical stress. Due to the fact that, the whole press force of the press brake machine is focused on small surface of the sheet metal. Therefore the stress is very high on these surfaces. During the bending process of the sheet metal, friction occurs.

For more resistance strength the hardening of the surfaces can be increased. The depth of the hardening must be at least 3 mm to avoid deformations. We use the electromagnetic technique also known as induction hardening to the best quality for your money's worth.

■ Quality Control and Laser Marking

After the laser marking, tracking of every tool is possible with a unique serial number on every article. Therefore the tracking of your tools is guaranteed and a new productions with the exact same measurements (angle, radius, hardening, etc.) is possible. This step is happens after quality control.

Individual markings are upon request possible.



■ EDM Wire

By using EDM wire, hardened and very tough material can be retrofitted. The process is operated based on a CAD-system which can also process high dimensions such as special shapes.

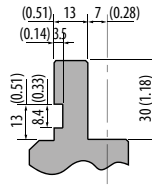
ROLLERI MODIFICATIONS

... for standard tangs

Modified Tangs

- Rolleri Punches Type R1, R2, and R3 can be used on other press brake machines by modifying the tang.
- Precision ground (Tolerance of +/-0.01 mm)
- exact parallelism
- fast, economic, precise

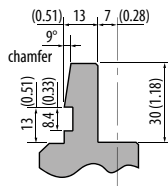
Standard Rolleri Type R1



Fast delivery on these items guaranteed. Please note that delivery terms vary according to your location.

OT

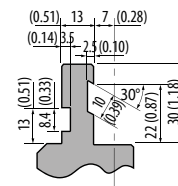
Modification for:
• for Amada fast clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A1

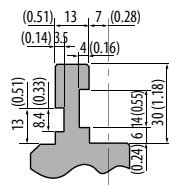
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
• pneumatic clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A6

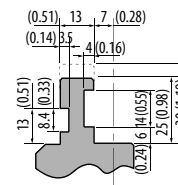
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
• Rolleri Type R3
• Bystronic-Beyeler Euro
• Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A7

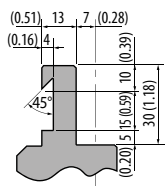
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
• Rolleri Type R3
• Bystronic-Beyeler Euro
• Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A8

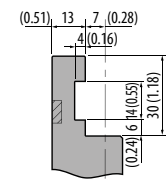
Groove Bar/Tail for:
• hydraulic clamping system Gasparini



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A41

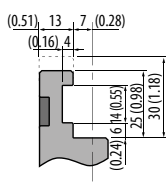
older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A42

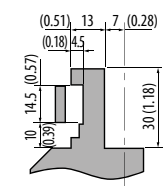
older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

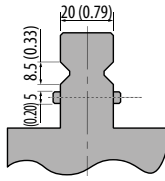
A43

Groove with steel bar for:
• segmented punches



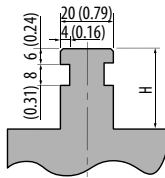
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

Standard Roller Type R2

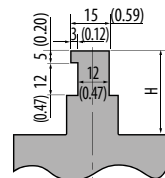


Modification examples Type R2

production according to your specifications

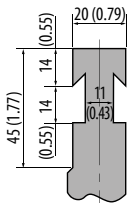


production according to your specifications



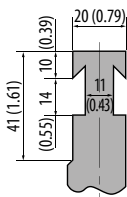
Take advantage of your existing tools with means of modifications.

Standard Roller Type R3

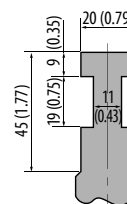


Modification examples Type R3

production according to your specifications



production according to your specifications



ROLLERI MODIFICATIONS

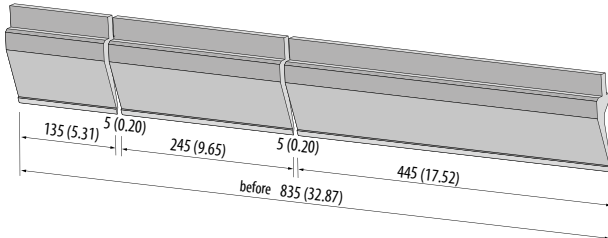
Special Sectioning

- Individual sectioning of your punches and dies
- fast, economic, precise

Pro separation cutting causes a decrease in length of approx. 5 mm

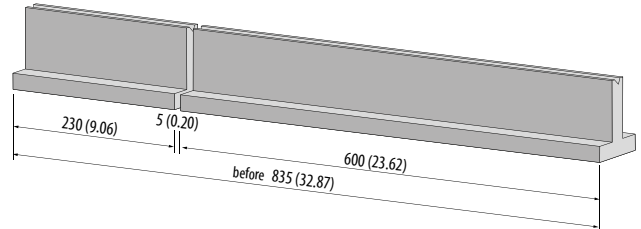
Special Sectioning of Punches

Example of punches production according to your specifications



Special Sectioning of Dies

Example of Dies production according to your specifications

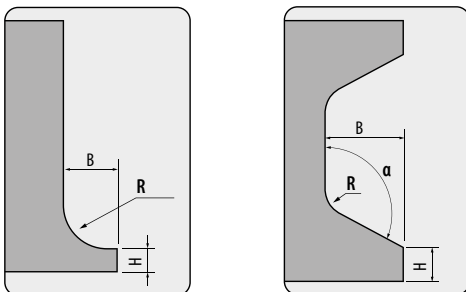


Horn Pieces

- individual horn pieces on punches and dies
- on one or both sides
- fast, economic, precise

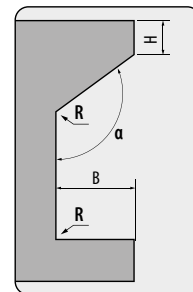
Horn Pieces for Punches

Punch example production according to your specifications



Horn Pieces for Dies

Die example production according to your specifications

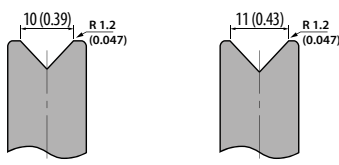


Modifying the V-Opening

- individual modification for dies
- fast, economic, precise

Modifying the V-Opening

Example production according to your specifications



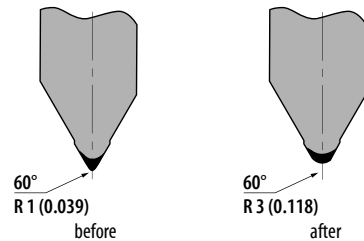
Give us a call for more information!

Radius and Angle Modifications

- Individual modifications of your punches and dies
- fast, economic, precise

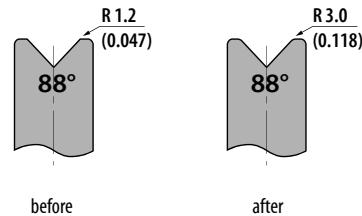
Radius Modifications for Punches

Radii modification Punch example production according to your specifications



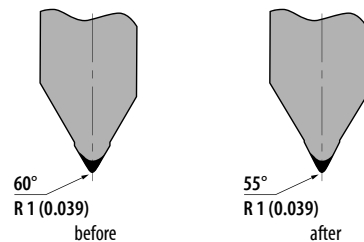
Radius Modifications for Dies

Opening Radius modification die example production according to your specifications



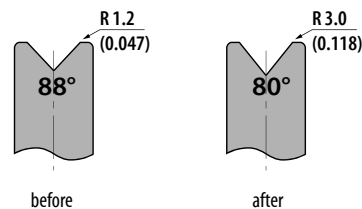
Angle Modification Punches

Angle modification punch example production according to your specifications



Angle Modification Dies

Angle modification die example production according to your specifications

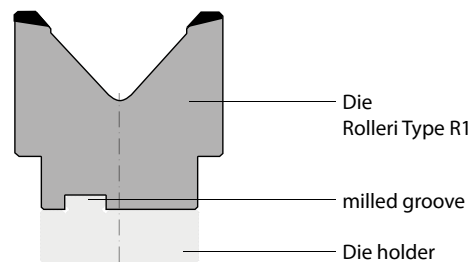


Grooves for Dies

- Milling of grooves for use on other press brake systems
- fast, economic, precise

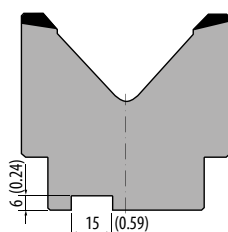


Mounting example



A28

Groove for die holder

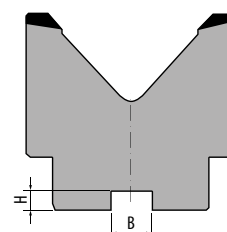


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A29

groove production according to your specifications



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

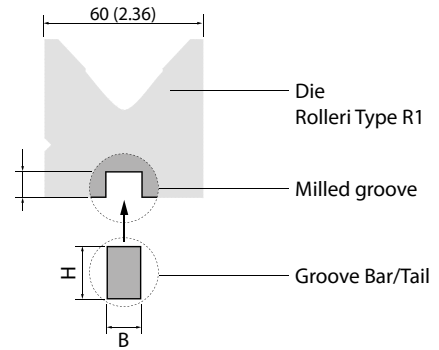


ROLLERI MODIFICATIONS

Grooves und Groove Bars/Tails for Dies

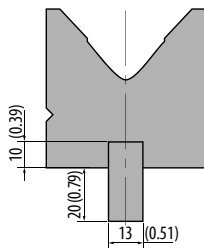
- For milling of the groove and the insert of a ground groove bar/tail the exact measurement is needed to use on other press brake systems
- fast, economic, precise

Mounting example



A30

- Groove Bars/Tails:
13 x 30 mm (0.51 x 1.18 in) for
- Roller Type R2
 - Roller Type R3

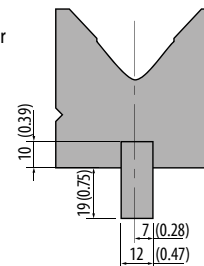


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A31

- Groove Bars/Tails:
12 x 29 mm (0.47 x 1.14 in) for
- Roller Type RX LVD

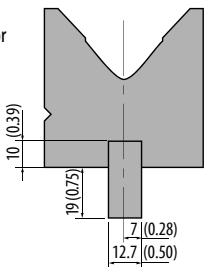


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A32

- Groove Bars/Tails:
12.7 x 29 mm (0.50 x 1.14 in) for
- Roller Type RX LVD

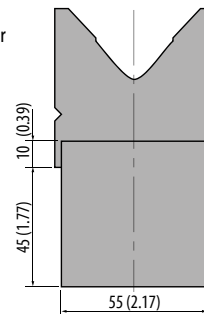


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A44

- Groove Bars/Tails:
55 x 55 mm (2.17 x 2.17 in) for
- Roller Type RX EHT

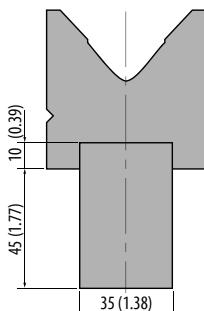


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A45

- Groove Bars/Tails:
35 x 55 mm (1.38 x 2.17 in) for
- Roller Type RX Weinbrenner

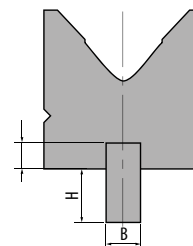


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



AX

- individual Groove Bars/Tails
for other systems

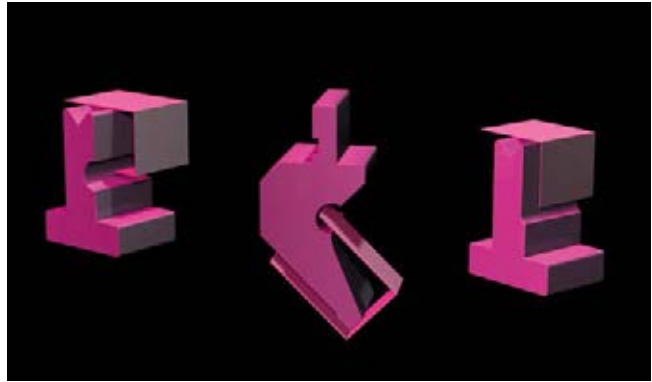


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



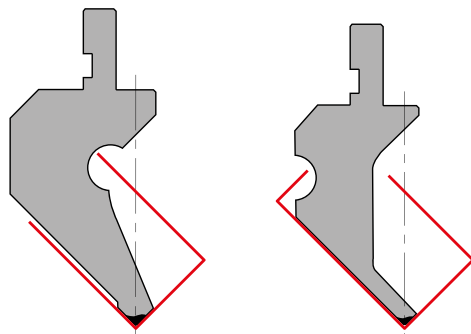
Gaps and Windows

- The retrofitting of the tool edges of long parts, short U-profiles and similar
- fast, economic, precise



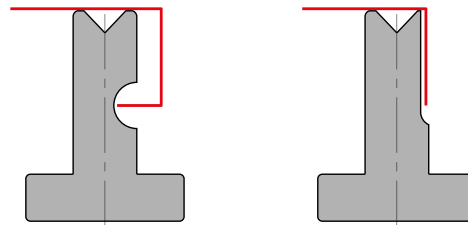
Gaps on Punches

Example Punches
production according to your specifications



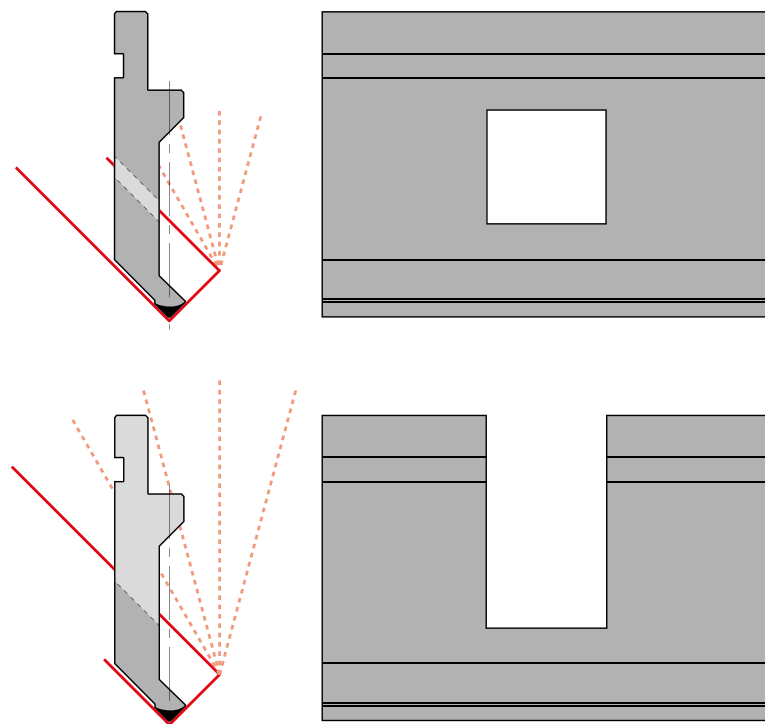
Gaps on Dies

Example Dies
production according to your specifications



Windows for Punches

Example Punches
production according to your specifications



For Rolleri BLACKFIRE
see page 251



Article on stock



Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

ROLLERI SHEAR BLADES AND ACCESSORIES

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ROLLERI ACCESSORIES

Tooling Cabinets

Our Advantages – Your Convenience

- Protection against contamination and damage
- Faster access
- Robust construction
- Clear and tidy storage
- Cabinet doors specially designed for lift trucks and truck
- Adjustable height, zinc-plated shelves



Rolleri Videos

Tool storage demonstration at:
www.rolleritools.com/videos/tooling-cabinets



ARM 835-4 for max. tool length = 835 mm (32.87 in)



850 x 1240 x 1050 (W x H x D)
 33.46 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1
 approx. 20 m (787.40 in)
 Storage capacity



Equipment	
4 Drawers	vertical, on wheels (see CS-1)
16 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
4 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	271.0 kg

ARM 835-5 for max. tool length = 835 mm (32.87 in)



1040 x 1240 x 1050 (W x H x D)
 40.94 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1
 approx. 25 m (984.25 in)
 Storage capacity



Equipment	
5 Drawers	vertical, on wheels (see CS-1)
20 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
5 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	350.0 kg

ARM 1060-4 / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)
 33.46 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3
 approx. 26 m / 39 m (1023.62 in /
 1535.43 in) Storage capacity



Equipment ARM 1060-4	
4 Drawers	vertical, on wheels (see CS-2)
16 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
4 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	340.0 kg

Equipment ARM 1060-4-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	351.0 kg

ARM 1060-5 / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)
 40.94 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3
 approx. 32.5 m / 52 m (1279.52 in /
 2047.24 in) Storage capacity



Equipment ARM 1060-5	
5 Drawers	vertical, on wheels (see CS-2)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
5 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	400.0 kg

Equipment ARM 1060-5-CV	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
30 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	490.0 kg

Tool Cabinets

ARM 1060-4-T / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)
33.46 x 48.82 x 53.54 (W x H x D)

for tools Roller Type R2/R3
approx. 20.8 m / 31.2 m (818.89 in / 1228.34 in) Storage capacity

ARM 1060-5-T / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)
40.94 x 48.82 x 53.54 (W x H x D)

for tools Roller Type R2/R3
approx. 26 m / 41.6 m (1023.62 in / 1637.79 in) Storage capacity

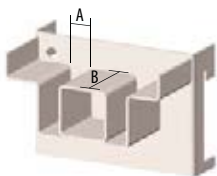
Equipment ARM 1060-4-T	
4 Drawers	vertical, on wheels (see CS-2)
8 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	383.0 kg

Equipment ARM 1060-5-T	
5 Drawers	vertical, on wheels (see CS-2)
10 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
10 Shelves	for type R2/R3 (see shelves UT-4)
Weight	447.0 kg

Equipment ARM 1060-4-T-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
16 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	360.0 kg

Equipment ARM 1060-5-T-CV	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
24 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	500.0 kg

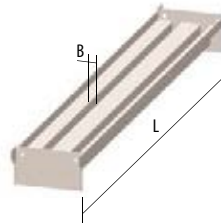
UC-Shelves



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

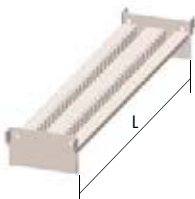
2 pieces

UL-Shelves



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

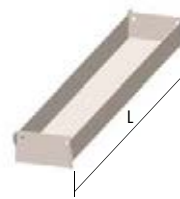
UT-Shelves



Model	L (mm)	L (in)	Weight
UT-1	270	10.63	1.4 kg
UT-2	580	22.83	3.2 kg
UT-3	1050	41.34	5.8 kg
UT-4	1360	53.54	7.5 kg

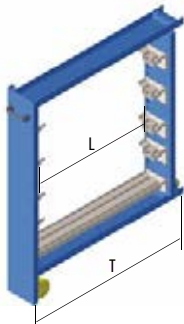
enough room for punches with safety pins

UV-Shelves



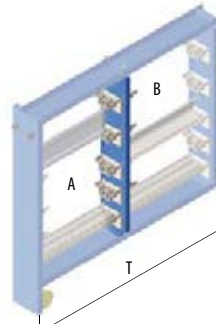
Model	L (mm)	L (in)	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg

CS-Drawers



Model	T mm (in)	L mm (in)	Weight
CS-1	1050 (41.34)	856 (33.70)	22.0 kg
CS-2	1360 (53.54)	1166 (45.91)	25.0 kg

CV-Dividers



Model	T mm (in)	A mm (in)	B mm (in)	Weight
CV-1	1050 (41.34)	580 (22.83)	270 (10.63)	7.0 kg
CV-2	1360 (53.54)	580 (22.83)	580 (22.83)	7.0 kg

ROLLERI ACCESSORIES

Tool Trolley

Our Advantages – Your Convenience

- faster access
- robust construction
- clear and tidy storage
- visibility of tools

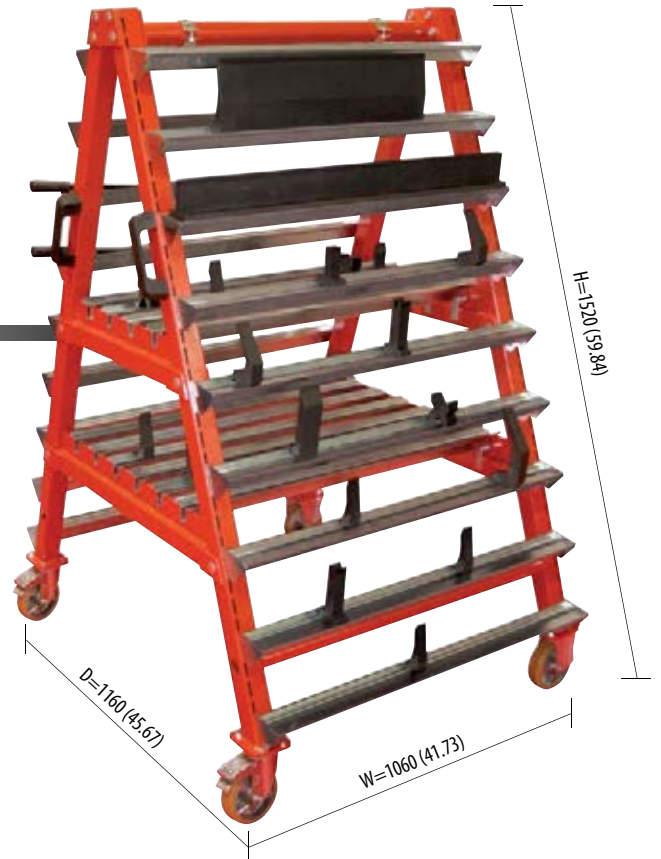
Tool Trolleys

Model	Content	Tool System	Weight
A Trolley	30 Shelves	for R1 tools	108.0 kg
T Trolley	21 Shelves	for R2 tools	175.0 kg
B Trolley	21 Shelves	for R3 tools	135.0 kg



Rolleri Videos

Secure storage and mobility:
[www.rolleritools.com/
 videos/tool-trolley](http://www.rolleritools.com/videos/tool-trolley)



Bending Box

Bending Box

per piece 1.6 kg



Squaring Arms

Our Advantages – Your Convenience

- easy and fast securing
- precise and flexible adjustability
- adjustable angle stop
- mountable on all dies
- ideal for long, and thin sheet metals



Rolleri Videos

Magnetic Squaring Arms :
[www.rolleritools.com/
videos/squaring-arms](http://www.rolleritools.com/videos/squaring-arms)



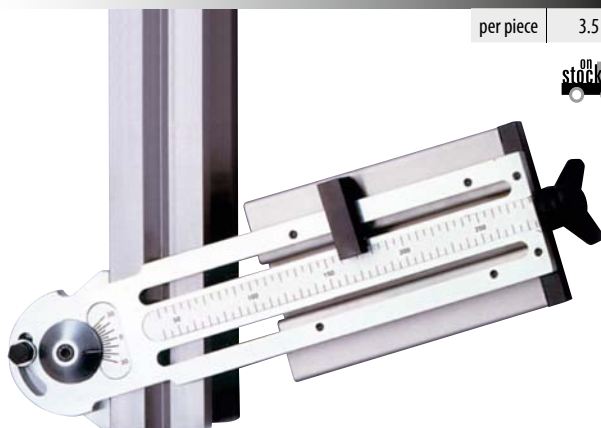
MSA – magnetic

MSA.D (right)	per piece	1.4 kg
MSA.S (left)	per piece	1.4 kg



AS

per piece	3.5 kg
-----------	--------



AS FIX

per piece	3.0 kg
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ROLLERI ACCESSORIES

Supporting Arms and Back Gauge

RIF-Supporting Arm

Model	Length mm (in)		Weight
RIF500	500	(19.68)	7.0 kg
RIF1000	1000	(39.37)	12.0 kg
RIF1500	1500	(59.05)	17.0 kg



- for secure support for high volume sheet metals
- greater surface guarantees a trouble-free support for sheet metals
- easy handling

RP-Back Gauge

Model	Weight
RP500A	8.0 kg
RP500B	8.0 kg



- ensures for the correct positioning of tools on the press brake and secures herewith the exact border distance.
- fast and exact repeatability
- easy handling

Give us a call for
more information!

Shear Blades

We manufacture in our company over more than 20 years shear blades.

High-quality steels are finished according to your specifications.

New production and
retrofitting service: fast,
economic, precise!

Please provide us with the following information:

- What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.
- How thick is the material in diameter?
- How often do you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

Our Advantages – Your Convenience

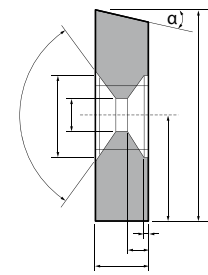
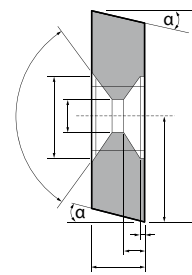
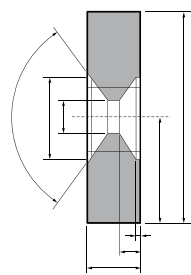
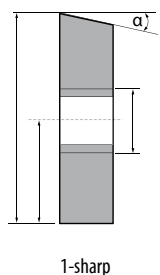
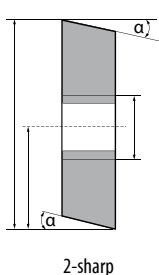
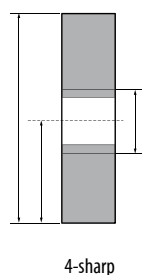
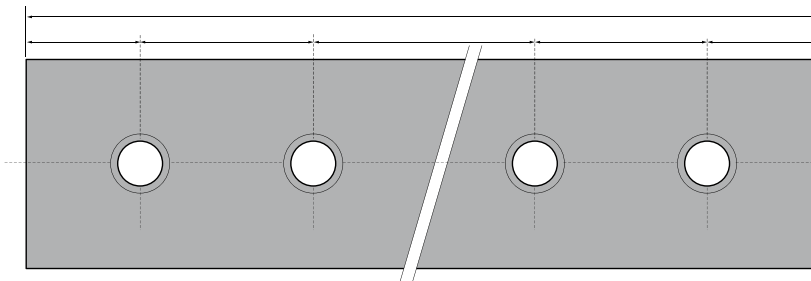
- own production
- custom production
- depending on the cutting material
- high quality Materials
- 4-, 2- or 1-sharp
- with threaded holes or bilateral reduction
- hardened according to your specifications and request



available sizes mm (in)				
50 x 10 (1.97 x 0.39)	55 x 12 (2.17 x 0.47)	60 x 12 (2.36 x 0.47)	65 x 13 (2.56 x 0.51)	70 x 13 (2.76 x 0.51)
50 x 11 (1.97 x 0.43)	55 x 13 (2.17 x 0.51)	60 x 13 (2.36 x 0.51)	65 x 14 (2.56 x 0.55)	70 x 14 (2.76 x 0.55)
50 x 12 (1.97 x 0.47)	55 x 14 (2.17 x 0.55)	60 x 14 (2.36 x 0.55)	65 x 15 (2.56 x 0.59)	70 x 15 (2.76 x 0.59)
50 x 13 (1.97 x 0.51)	55 x 15 (2.17 x 0.59)	60 x 15 (2.36 x 0.59)	65 x 16 (2.56 x 0.63)	70 x 16 (2.76 x 0.63)
50 x 14 (1.97 x 0.55)	55 x 16 (2.17 x 0.63)	60 x 16 (2.36 x 0.63)	65 x 17 (2.56 x 0.67)	70 x 17 (2.76 x 0.67)
50 x 15 (1.97 x 0.59)	55 x 17 (2.17 x 0.67)	60 x 17 (2.36 x 0.67)	65 x 18 (2.56 x 0.71)	70 x 18 (2.76 x 0.71)
	55 x 18 (2.17 x 0.71)	60 x 18 (2.36 x 0.71)	65 x 19 (2.56 x 0.75)	70 x 19 (2.76 x 0.75)
	55 x 19 (2.17 x 0.75)	60 x 19 (2.36 x 0.75)	65 x 20 (2.56 x 0.79)	70 x 20 (2.76 x 0.79)
	55 x 20 (2.17 x 0.79)	60 x 20 (2.36 x 0.79)		



available sizes mm (in)				
75 x 15 (2.95 x 0.59)	80 x 16 (3.15 x 0.63)	85 x 18 (3.35 x 0.71)	90 x 20 (3.54 x 0.79)	100 x 20 (3.94 x 0.79)
75 x 16 (2.95 x 0.63)	80 x 18 (3.15 x 0.71)	85 x 19 (3.35 x 0.75)	90 x 21 (3.54 x 0.83)	100 x 22 (3.94 x 0.87)
75 x 17 (2.95 x 0.67)	80 x 19 (3.15 x 0.75)	85 x 20 (3.35 x 0.79)	90 x 22 (3.54 x 0.87)	100 x 25 (3.94 x 0.98)
75 x 18 (2.95 x 0.71)	80 x 20 (3.15 x 0.79)	85 x 21 (3.35 x 0.83)	90 x 23 (3.54 x 0.91)	100 x 26 (3.94 x 1.02)
75 x 19 (2.95 x 0.75)	80 x 21 (3.15 x 0.83)	85 x 22 (3.35 x 0.87)	90 x 24 (3.54 x 0.94)	100 x 27 (3.94 x 1.06)
75 x 20 (2.95 x 0.79)	80 x 22 (3.15 x 0.87)	85 x 23 (3.35 x 0.91)	90 x 25 (3.54 x 0.98)	100 x 28 (3.94 x 1.10)
75 x 21 (2.95 x 0.83)	80 x 23 (3.15 x 0.91)	85 x 24 (3.35 x 0.94)		100 x 29 (3.94 x 1.14)
75 x 22 (2.95 x 0.87)	80 x 24 (3.15 x 0.94)	85 x 25 (3.35 x 0.98)		100 x 30 (3.94 x 1.18)
75 x 23 (2.95 x 0.91)	80 x 25 (3.15 x 0.98)			
75 x 24 (2.95 x 0.94)				
75 x 25 (2.95 x 0.98)				

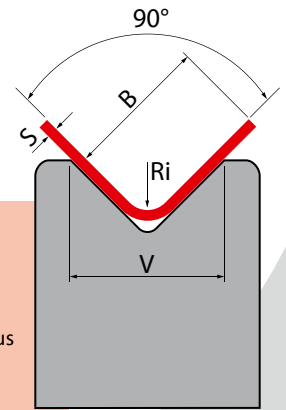


Press Force Table

The press force table is based on the press force caliper and is very useful to those who deal with sheet metal profiles. It can assist you from the projection of profiles, to technical construction, to the buying of tools, and to the finished profile from the press brake machine.

In the first left column the thickness of the sheet metal is noted as (S). In the three first lines you can find the die width (V), the minimum boarder (B), and the ideal inner profile radius (Ri).

By crossing the thickness with the die width, you will find the necessary press force per meter. Furthermore, depicted are the span of 5 different die widths. The correction factors are found below in the table.



S = Thickness
 V = Die Width
 B = Min. Boarder
 Ri = Inner Profile Radius

420 N/mm ²																					
S (mm)	4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V	
	3.0	3.5	4.0	5.5	6.5	8.0	10.5	13.0	16.5	21.0	26.0	32.5	41.0	52.0	65.0	81.5	104.0	130.0	163.0	B	
	0.5	0.7	0.8	1.0	1.3	1.5	2.0	2.5	3.2	4.4	5.0	6.5	8.0	10.0	12.0	15.0	20.0	25.0	37.0	Ri	
0.6	60	50	30	20																	
0.8	120	90	70	50	40																
1.0		150	110	80	60	50															
1.2			180	120	90	70	50														
1.5				210	150	120	80	60													
2.0					300	230	160	120	90												
2.5						390	270	200	140	110											
3.0							430	310	230	160	120										
4.0								600	440	320	230	180									
5.0									760	540	390	290	220								
6.0										850	620	450	330	250							
8.0											1210	880	700	460	350						
10.0												1510	1090	790	580	440					
12.0													1730	1240	910	660	500				
15.0		INOX – stainless steel R 700 N/mm ² Ton x 1.7												2130	1550	1130	810	620			
20.0		AL – aluminium R 200 N/mm ² Ton x 0.5													3020	2200	1580	1150	890		
25.0		(R = tensile strength)														3780	2690	1970	1440		

F
kN/m

30°	B x 1.6	R=200 N/mm ²	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm ²	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm ²	r x 1.4	INOX

www.rolleritools.com

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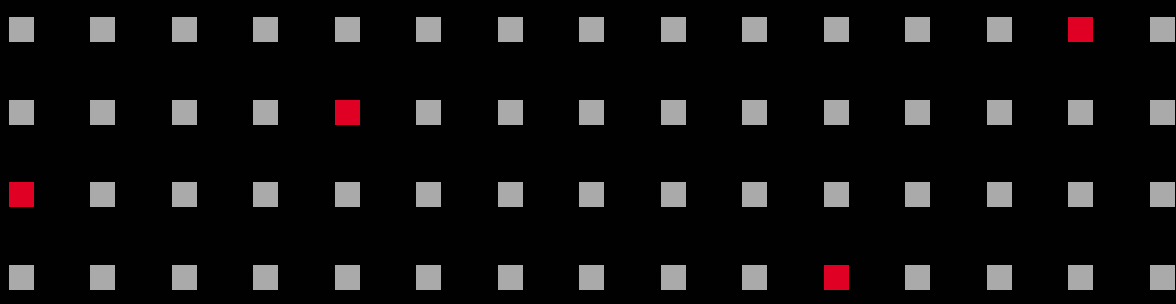
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