

## 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, Orianse, 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 ROLLERI TYPE R1**

**DIES ROLLERI TYPE R1**

**PUNCHES ROLLERI TYPE R2**

**DIES ROLLERI TYPE R2**

**PUNCHES ROLLERI TYPE R3**

**DIES ROLLERI TYPE R3**

**TOOLS ROLLERI TYPE RX**

**ROLLERI DIES ROLLA-V**

**ROLLERI CLAMPING SYSTEMS**

**ROLLERI ADAPTERS**

**ROLLERI MARK FREE BENDING**

**ROLLERI SPECIAL AND HEAVY DUTY TOOLS**

**ROLLERI SERVICE / MODIFICATIONS**

**ROLLERI 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, Orianse, 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.



### 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, 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.

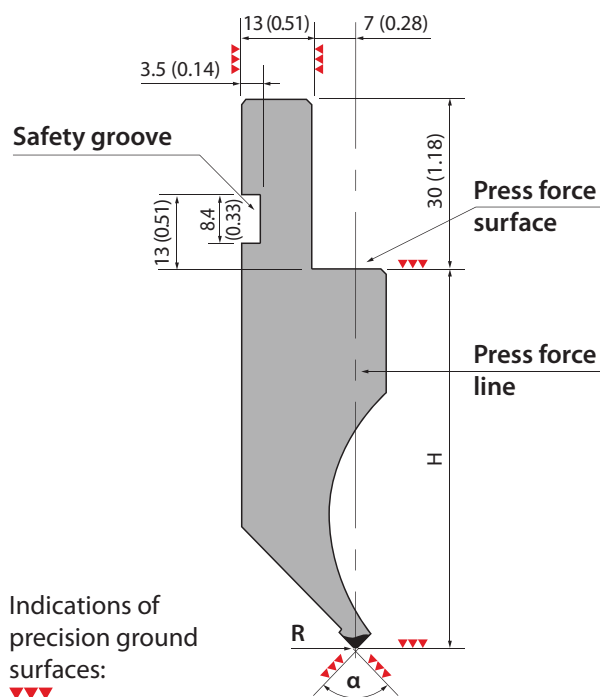
| Material Type | Mechanical resistance of the material and the tool body | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------------|---------------------------------------------------------|--------------------------------------------|------------------------------------------------------------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

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

### Tang

All punches Roller Type R1:

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



### Our Advantages – Your Convenience

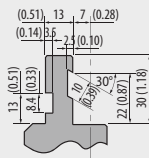
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height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

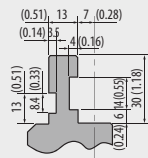
- Pneumatic clamping



#### A6

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

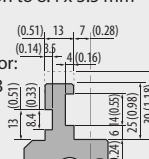
- Roller Type R3
- Bystronic-Beyeler Euro
- Safan



#### A7

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

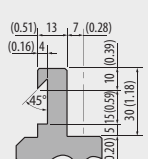
- Roller Type R3
- Bystronic-Beyeler Euro
- Safan



#### A8

Groove for:

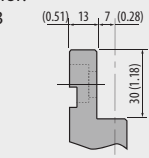
- hydraulic clamping Gasparini



#### A9

Modified groove for:

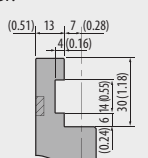
- Roller Type R3



#### A41

Modified groove for:

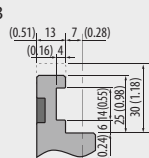
- Roller Type R3



#### A42

Modified groove for:

- Roller Type R3



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

### Tool lengths and sectioning

#### Standard

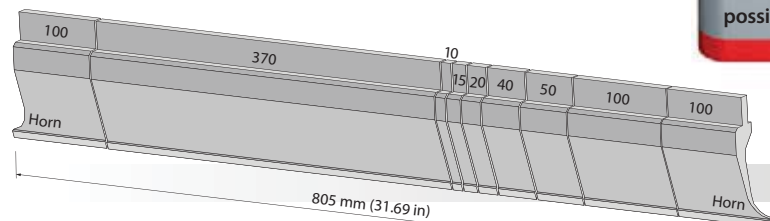
Segmented tools are delivered in complete sets. Single pieces are also available!

More lengths and sectionings are possible upon request.

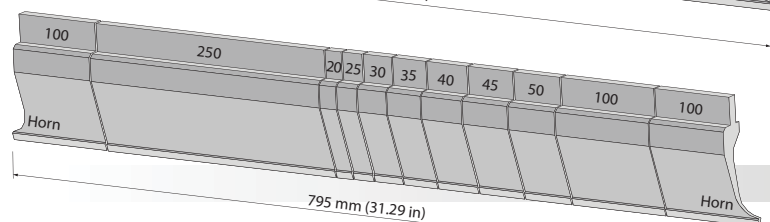
835 mm (32.87 in)

415 mm (16.34 in)

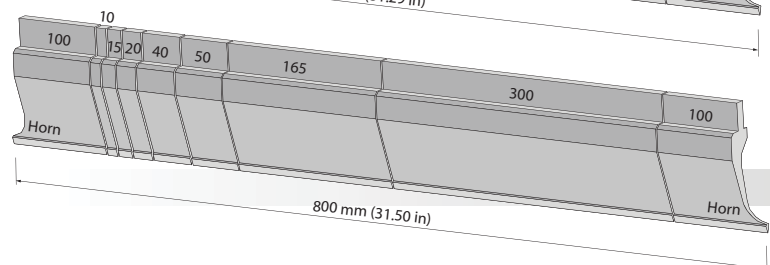
900 mm (35.43 in)



805 mm (31.69 in) segmented (9 segments)



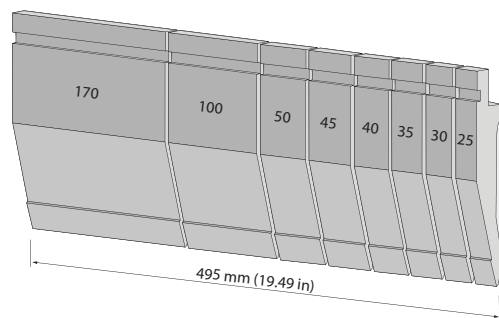
795 mm (31.29 in) segmented (11 segments)



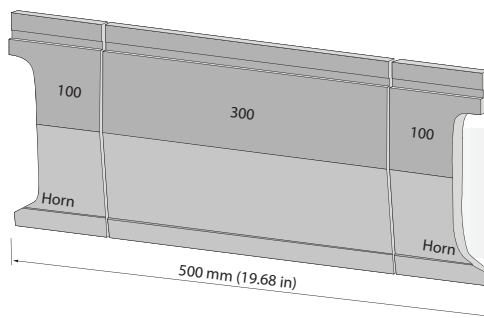
800 mm (31.50 in) segmented (9 segments)

#### Rolleri TOP-System

525 mm (20.67 in)

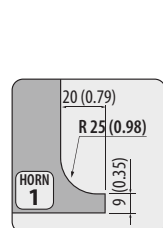


495 mm  
(19.49 in)  
segmented  
(8 segments)

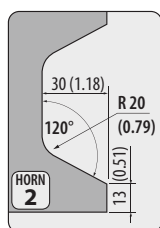


500 mm  
(19.68 in)  
segmented  
(3 segments)

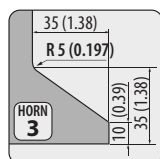
### Horn Types



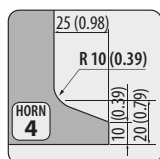
**Horn 1**  
Standard  
for all segm.  
Punches  
Rolleri Type R1



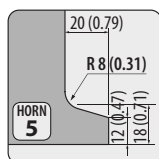
**Horn 2**  
TOP  
for all segm.  
TOP Punches  
Rolleri Type R1



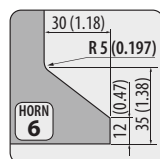
**Horn 3**  
for punches:  
00402  
00430  
11700  
04702



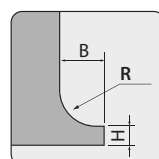
**Horn 4**  
for punches:  
20000  
20200  
10900  
10906



**Horn 5**  
for punches:  
10300



**Horn 6**  
for punches:  
00300



**Horn individual**  
produced  
according  
to your  
specifications



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)



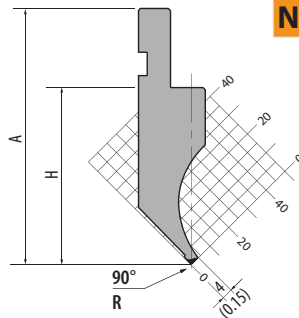
Articles on stock – Please note that  
delivery time depends on your location.

# R1 ROLLERI TYPE R1

## 90° Punches

### PK.97.90.R06 / P.97.90.R025

350 kN/m max.



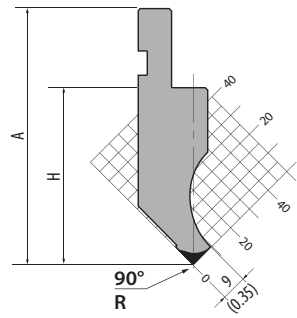
**NEW**

| PK.97.90.R06                                              |                    |         |
|-----------------------------------------------------------|--------------------|---------|
| H=66.80 / A=96.80 / R=0.6<br>(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<br>(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/mm<sup>2</sup> **HORN 1**

### PK.97.90.R08 / R025

1000 kN/m max.

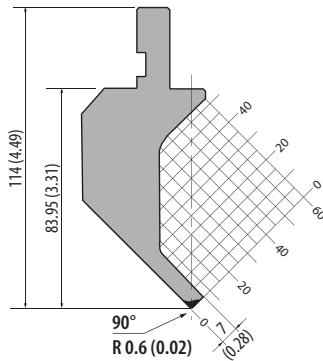


| PK.97.90.R08                                              |                    |         |
|-----------------------------------------------------------|--------------------|---------|
| H=66.35 / A=96.35 / R=0.8<br>(H=2.61 / A=3.79 / R=0.031)  |                    |         |
| 835 mm                                                    | 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<br>(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/mm<sup>2</sup> **HORN 1**

### PK.114.90.R06

200 kN/m max.



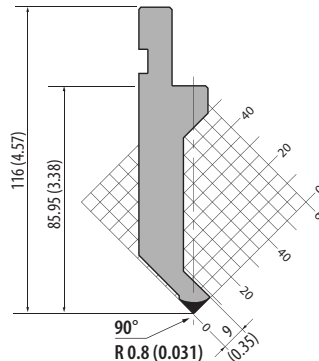
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 14.0 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 13.3 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>

**HORN 1**

### PK.116.90.R08

400 kN/m max.



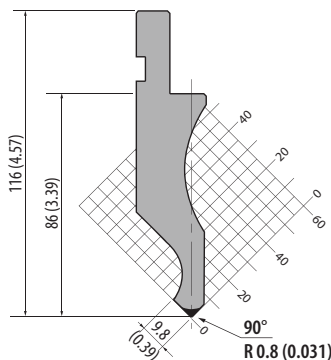
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>

**HORN 1**

### DK.116.90.R08

500 kN/m max.



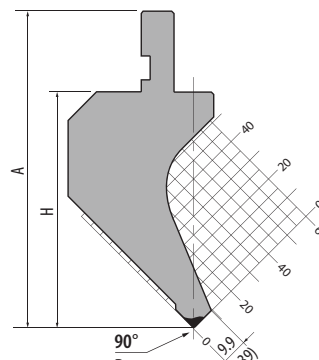
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>

**HORN 1**

### PK.120.90.R08 / R025

600 kN/m max.



| PK.120.90.R08                                              |                    |         |
|------------------------------------------------------------|--------------------|---------|
| H=89.35 / A=119.35 / R=0.8<br>(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<br>(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/mm<sup>2</sup> **HORN 1**



## Rolleri Videos

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

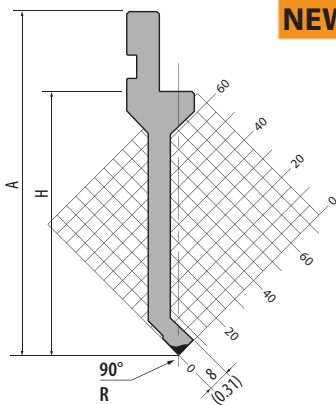


Articles on stock – Please  
note that delivery  
time varies  
according to  
your location.



### P.130.90.R06 / R025

350 kN/m max.

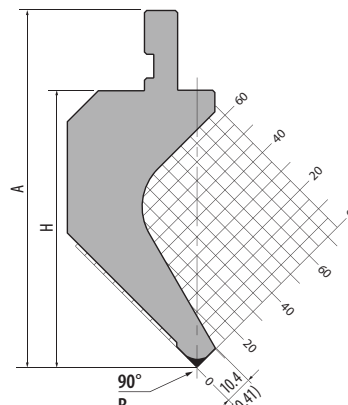

**NEW**

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

 42Cr: 900-1150 N/mm² 

### PK.135.90.R08 / R025

500 kN/m max.



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

 C45: 560-710 N/mm² 

## 90° Segmented Punches with Mobile Horns

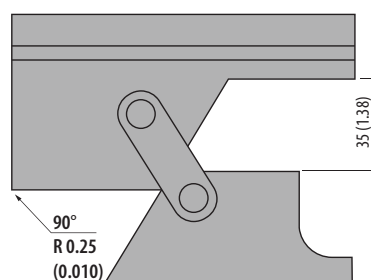
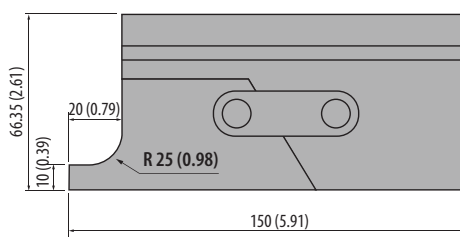


### Area of Application

- for easy bending of special box profiles

### SCA.M.90.R08

150 kN/m max.


**NEW**

per pair 3.5 kg

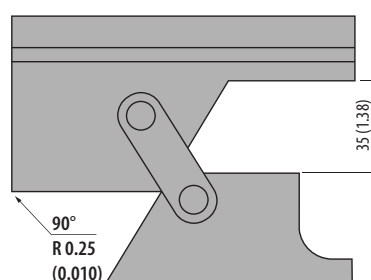
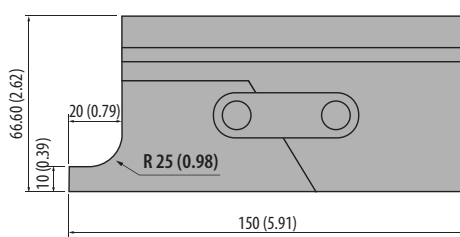
1 Pair left/right compatible with PK.97.90.R08

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



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)

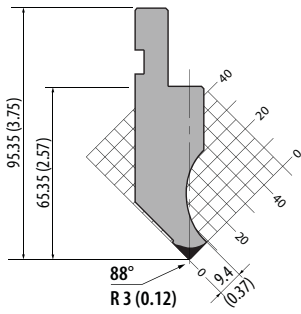

Articles on stock – Please note that delivery time depends on your location.

# R1 ROLLER TYPE R1

## 88° Punches

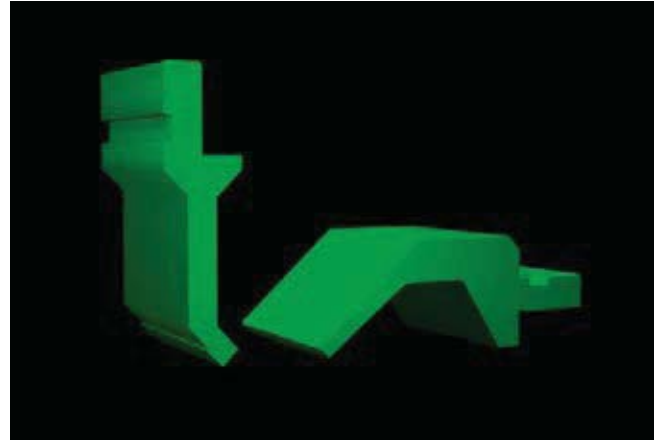
### P.95.88.R3

1000 kN/m max.



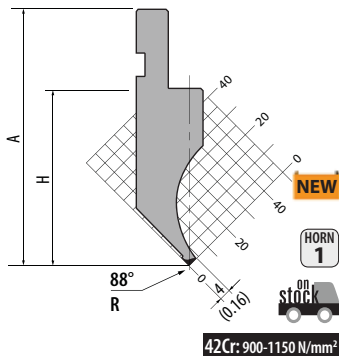
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.0 kg |
| 415 mm           | 16.34 in           | 5.5 kg  |
| 795 mm segmented | 31.29 in segmented | 10.5 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



### P.97.88.R06 / R025

350 kN/m max.

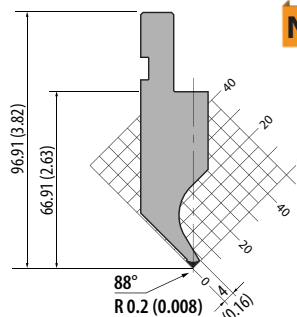


|                                                           |                    |         |
|-----------------------------------------------------------|--------------------|---------|
| P.97.88.R06                                               |                    |         |
| H=67.00 / A=97.00 / R=0.6<br>(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 |
| P.97.88.R025                                              |                    |         |
| H=66.95 / A=96.95 / R=0.25<br>(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/mm<sup>2</sup>

### 11700

200 kN/m max.



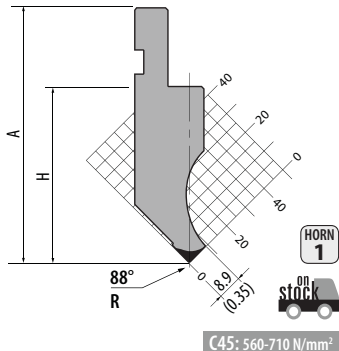
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 10.7 kg |
| 415 mm           | 16.34 in           | 5.3 kg  |
| 795 mm segmented | 31.29 in segmented | 10.2 kg |
| 800 mm segmented | 31.50 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



### P.97.88.R08 / PK.97.88.R025

1000 kN/m max.

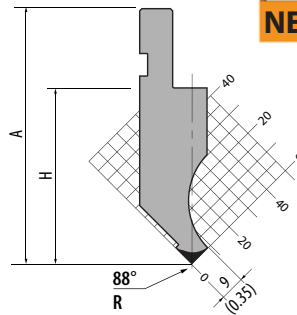


|                                                           |                    |         |
|-----------------------------------------------------------|--------------------|---------|
| P.97.88.R08                                               |                    |         |
| H=66.65 / A=96.65 / R=0.8<br>(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 |
| PK.97.88.R025                                             |                    |         |
| H=66.60 / A=96.60 / R=0.25<br>(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/mm<sup>2</sup>

### 00402 / 00430

1000 kN/m max.



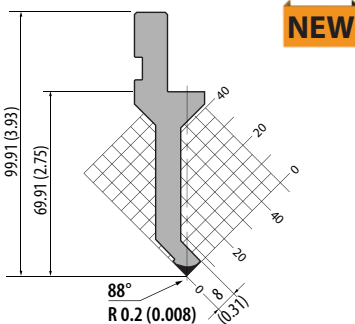
|                                                          |                    |         |
|----------------------------------------------------------|--------------------|---------|
| 00402                                                    |                    |         |
| H=66.90 / A=96.90 / R=0.2<br>(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 |
| 00430                                                    |                    |         |
| H=65.68 / A=95.68 / R=3<br>(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/mm<sup>2</sup>



### 20000

300 kN/m max.



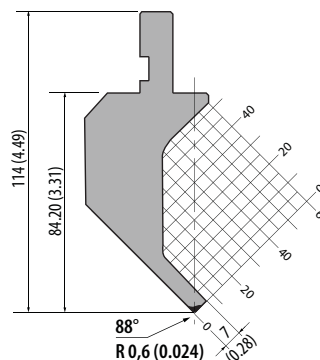
|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 7.9 kg |
| 415 mm           | 16.34 in           | 3.9 kg |
| 795 mm segmented | 31.29 in segmented | 7.5 kg |
| 800 mm segmented | 31.50 in segmented | 7.6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

42Cr: 900-1150 N/mm<sup>2</sup>



### P.114.88.R06

200 kN/m max.



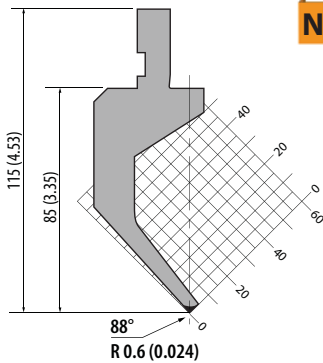
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 15.6 kg |
| 415 mm           | 16.34 in           | 7.7 kg  |
| 795 mm segmented | 31.29 in segmented | 14.8 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



### P.115.88.R06

130 kN/m max.



**NEW**

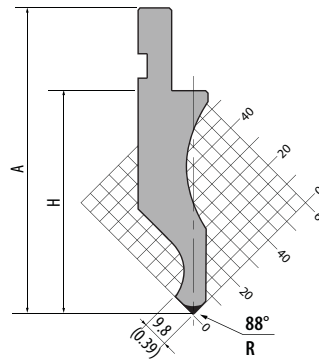
|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 6.0 kg |
| 415 mm           | 16.34 in           | 3.0 kg |
| 795 mm segmented | 31.29 in segmented | 5.7 kg |
| 805 mm segmented | 31.69 in segmented | 5.8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

42Cr: 900-1150 N/mm<sup>2</sup>



### D.116.88.R08 / R3

500 kN/m max.



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

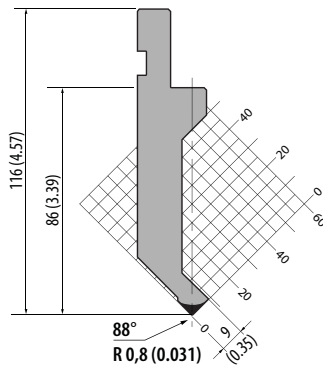
|                                                           |                    |         |
|-----------------------------------------------------------|--------------------|---------|
| H=85.00 / A=115.00 / R=3.0<br>(H=3.35 / A=4.53 / R=0.118) |                    |         |
| 835 mm                                                    | 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/mm<sup>2</sup>



### P.116.88.R08

400 kN/m max.



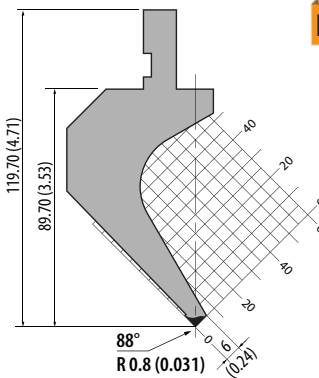
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 12.0 kg |
| 415 mm           | 16.34 in           | 6.0 kg  |
| 795 mm segmented | 31.29 in segmented | 11.4 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



### PS.120.88.R08

450 kN/m max.



**NEW**

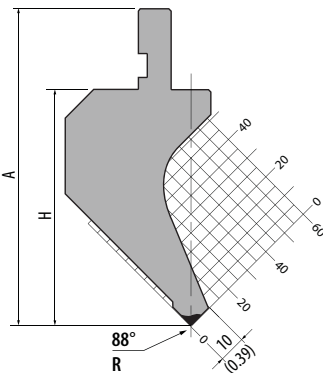
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 17.0 kg |
| 415 mm           | 16.34 in           | 8.4 kg  |
| 795 mm segmented | 31.29 in segmented | 16.2 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



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

600 kN/m max.



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

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

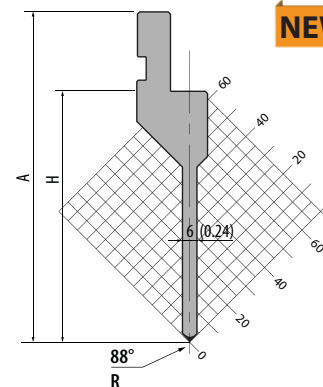
|                                                            |                    |         |
|------------------------------------------------------------|--------------------|---------|
| H=89.60 / A=120.00 / R=0.25<br>(H=3.53 / A=4.72 / R=0.010) |                    |         |
| 835 mm                                                     | 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/mm<sup>2</sup>



### 10900 / 10906

500 kN/m max.



**NEW**

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

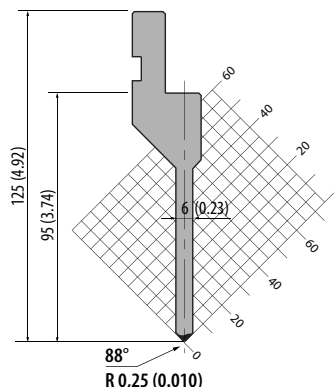
|                                                           |                    |        |
|-----------------------------------------------------------|--------------------|--------|
| H=94.74 / A=124.74 / R=0.6<br>(H=3.73 / A=4.91 / R=0.024) |                    |        |
| 835 mm                                                    | 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/mm<sup>2</sup>



### 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/mm<sup>2</sup>

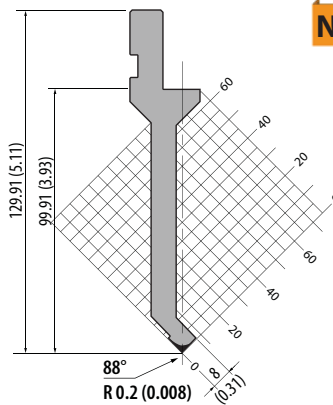


# R1 ROLLER TYPE R1

## 88° Punches

20200

300 kN/m max.



**NEW**

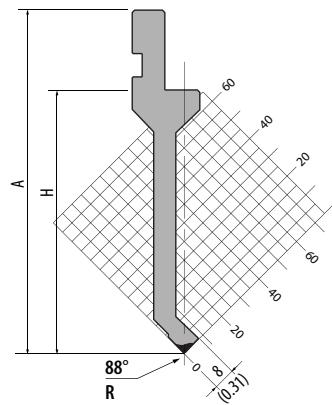
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 10.0 kg |
| 415 mm           | 16.34 in           | 5.0 kg  |
| 795 mm segmented | 31.29 in segmented | 9.5 kg  |
| 800 mm segmented | 31.50 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



P.130.88.R06 / PK.130.88.R025

350 kN/m max.



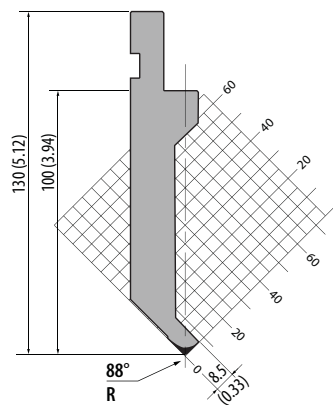
|             |                                                             |                    |         |
|-------------|-------------------------------------------------------------|--------------------|---------|
| P130.88.R06 | H=100.00 / A=130.00 / R=0.6<br>(H= 3.94 / A=5.12 / R=0.024) |                    |         |
|             | 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<br>(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<br>segmented                                        | 31.29 in<br>segmented | 9.2 kg  |
|                | 805 mm<br>segmented                                        | 31.69 in<br>segmented | 9.3 kg  |
|                | 900 mm                                                     | 35.43 in              | 10.4 kg |

42Cr: 900-1150 N/mm<sup>2</sup> **HORN 1**

P.130.88.R08 / R025

400 kN/m max.



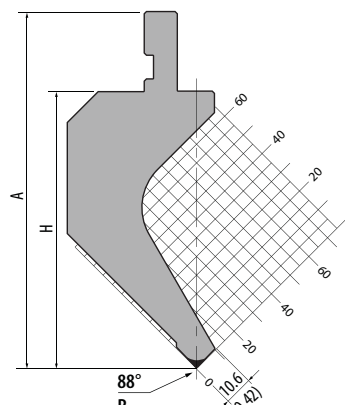
|              |                                                            |                    |         |
|--------------|------------------------------------------------------------|--------------------|---------|
| P.130.88.R08 | H=100.00 / A=130.00 / R=0.8<br>(H=3.94 / A=5.12 / R=0.031) |                    |         |
|              | 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<br>(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/mm<sup>2</sup> **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<br>(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<br>segmented                                        | 31.29 in<br>segmented | 21.4 kg |
|              | 805 mm<br>segmented                                        | 31.69 in<br>segmented | 21.7 kg |

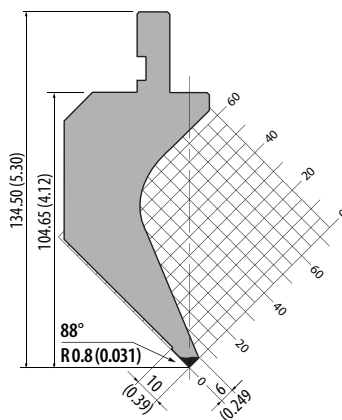
|             |                                                            |                    |         |
|-------------|------------------------------------------------------------|--------------------|---------|
| P.135.88.R3 | H=103.40 / A=133.40 / R=3.0<br>(H=4.07 / A=5.25 / R=0.118) |                    |         |
|             | 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<br>(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/mm<sup>2</sup> **HORN 1**

PS.135.88.R08

450 kN/m max.



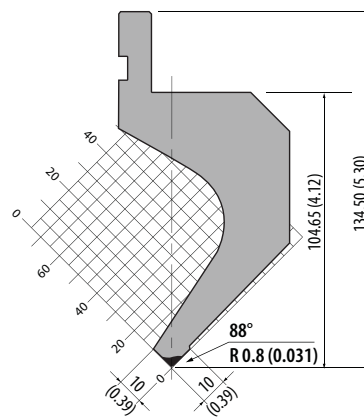
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.0 kg |
| 415 mm           | 16.34 in           | 12.5 kg |
| 795 mm segmented | 31.29 in segmented | 20.9 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



PR.135.88.R08

450 kN/m max.



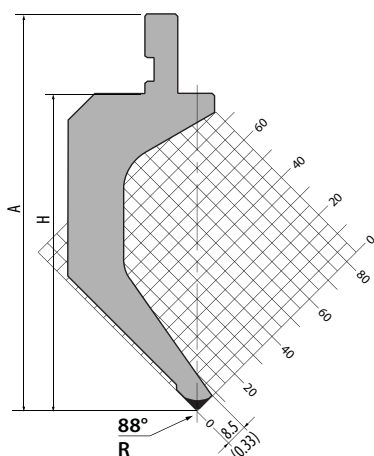
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 25.0 kg |
| 415 mm           | 16.34 in           | 11.5 kg |
| 795 mm segmented | 31.29 in segmented | 23.8 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



### P.150.88.R08 / R3

500 kN/m max.

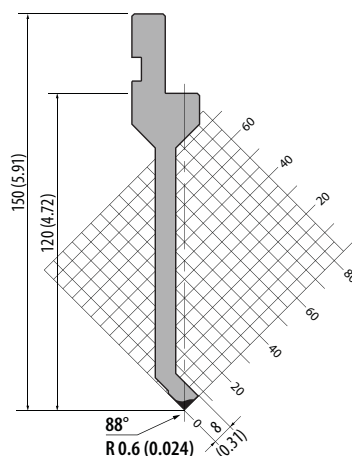


|                                                            |                    |         |
|------------------------------------------------------------|--------------------|---------|
| <b>P.150.88.R08</b>                                        |                    |         |
| H=120.00 / A=150.00 / R=0.8<br>(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 |
| <b>P.150.88.R3</b>                                         |                    |         |
| H=119.00 / A=149.00 / R=3.0<br>(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.



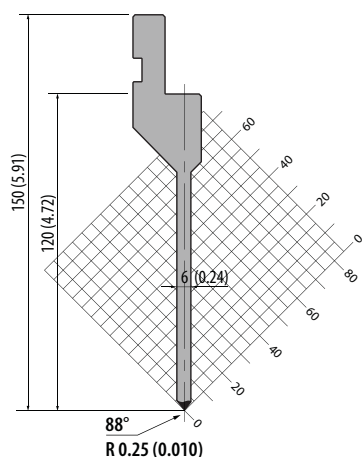
|                  |                    |         |
|------------------|--------------------|---------|
| 900 mm           | 35.43 in           | 12.9 kg |
| 415 mm           | 16.34 in           | 5.9 kg  |
| 795 mm segmented | 31.29 in segmented | 12.2 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm²



### P.150.88.R025

500 kN/m max.



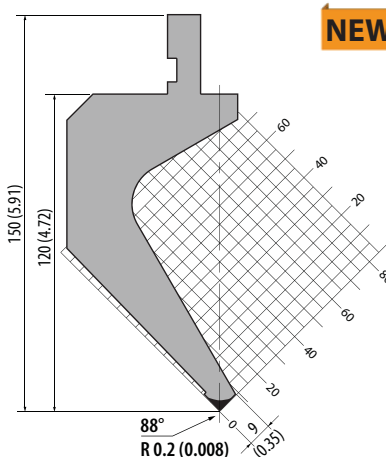
|                  |                    |         |
|------------------|--------------------|---------|
| 900 mm           | 32.87 in           | 10.0 kg |
| 415 mm           | 16.34 in           | 4.6 kg  |
| 795 mm segmented | 31.29 in segmented | 9.5 kg  |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm²



### 04702

500 kN/m max.



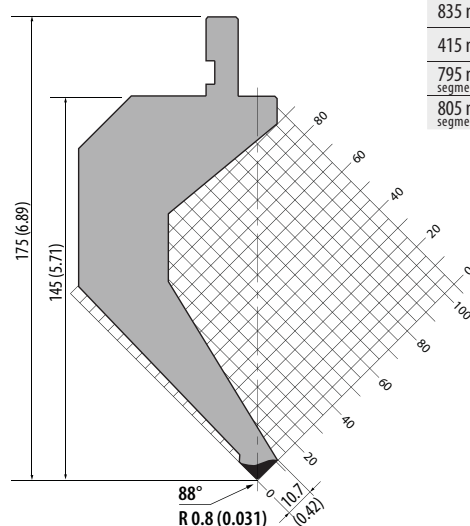
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 26.0 kg |
| 415 mm           | 16.34 in           | 12.9 kg |
| 795 mm segmented | 31.29 in segmented | 24.8 kg |
| 800 mm segmented | 31.50 in segmented |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



 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)

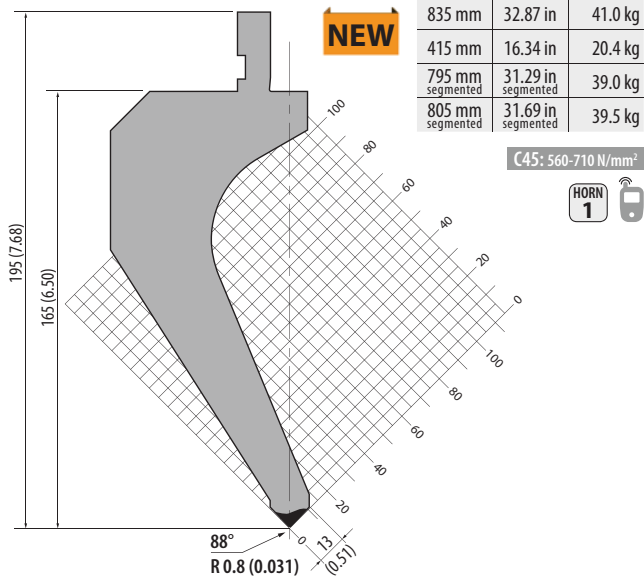
 Articles on stock – Please note that  
delivery time depends on your location.

# R1 ROLLER TYPE R1

## 88° Punches

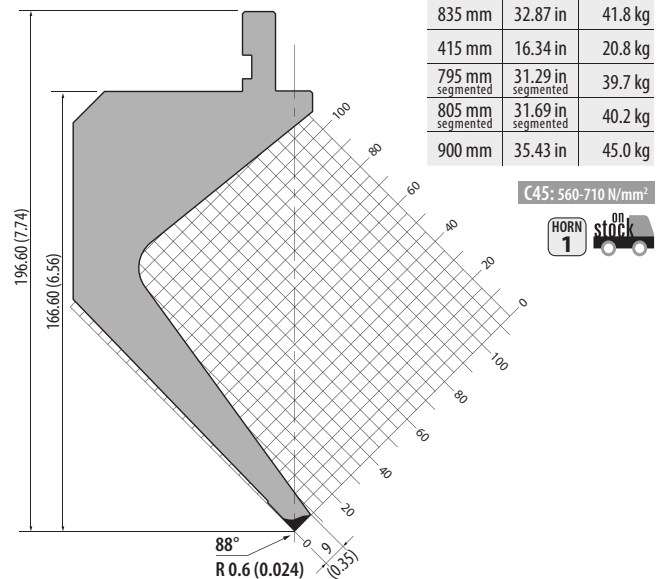
### P.195.88.R08

600 kN/m max.

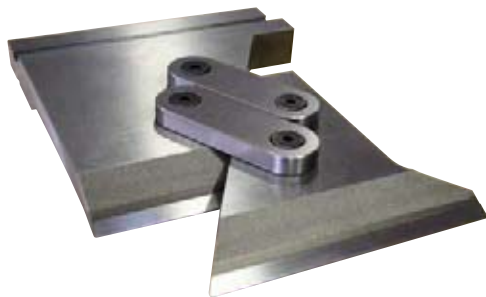


### P.196.88.R06

300 kN/m max.



## 88° Segmented Punches with Mobile Horns

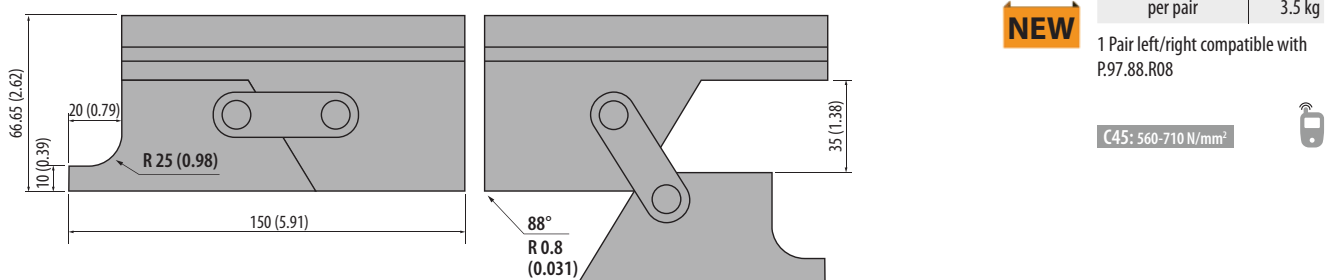


### Area of Application

- for easy bending of special box profiles

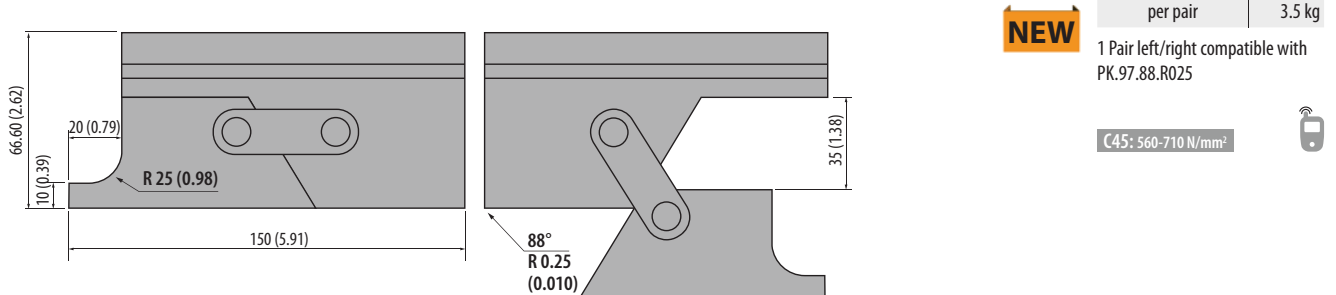
### SCA.M.88.R08

150 kN/m max.



### SCA.M.88.R025

150 kN/m max.



# R1 ROLLER TYPE R1

88° Punches for closed profiles



1  
R1

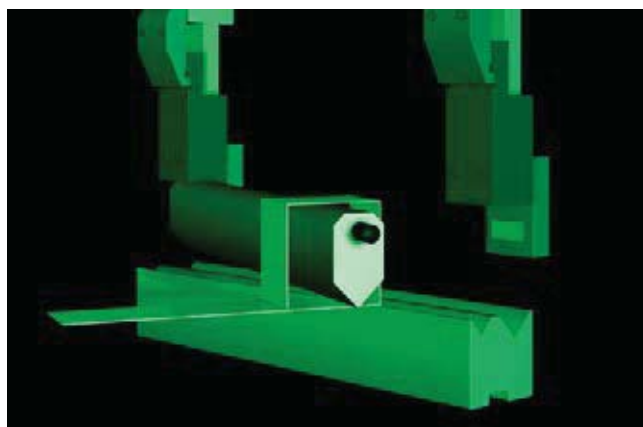
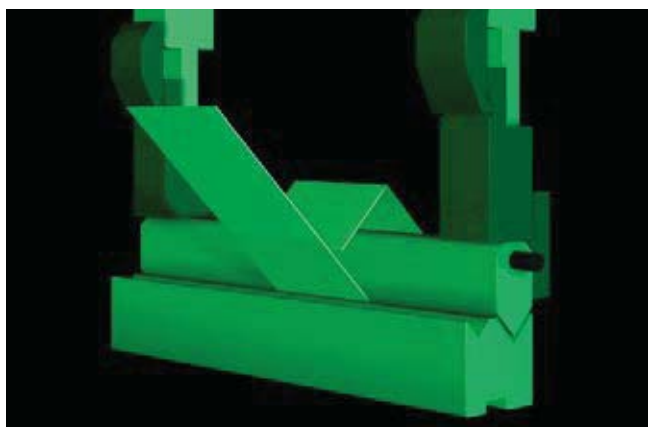
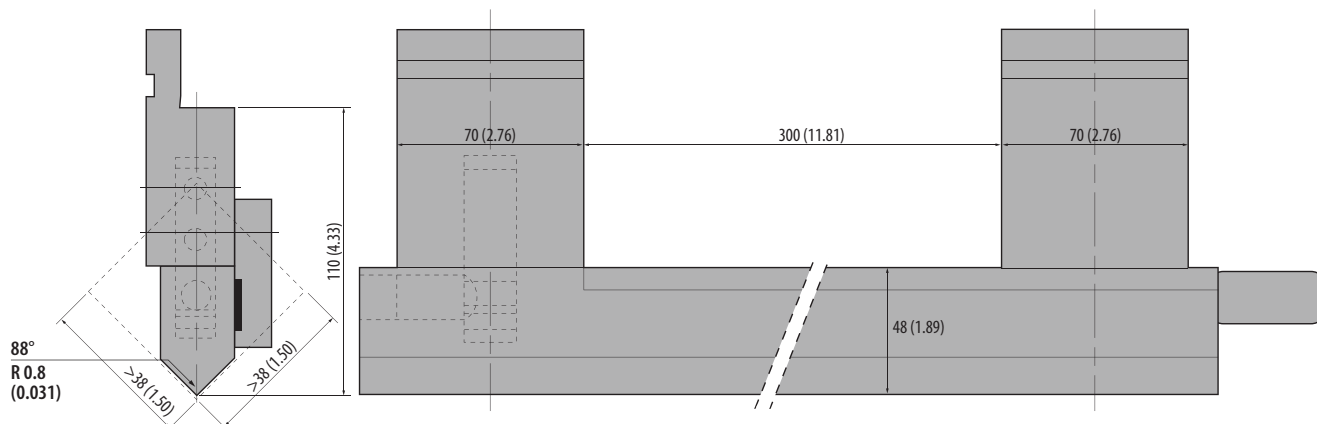
SPE.11

150 kN/m max.

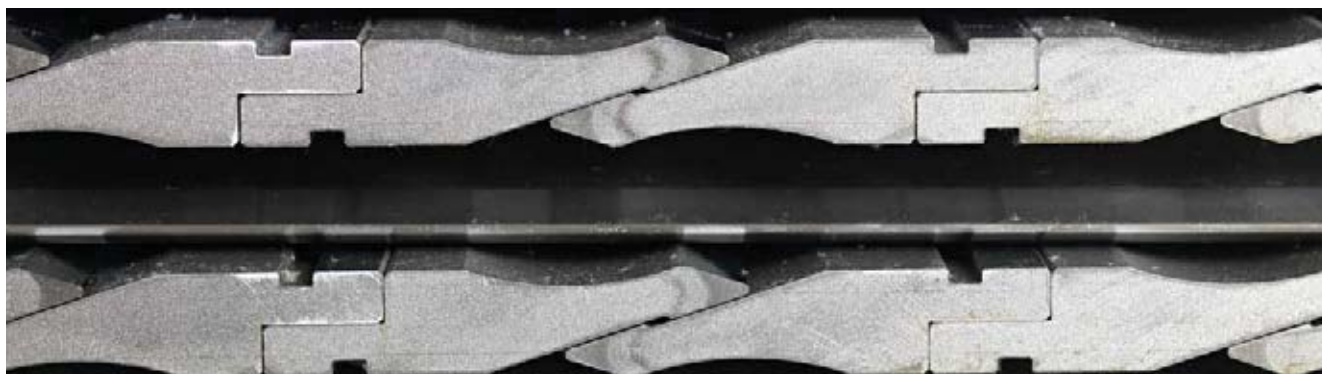
per piece

7.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



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)



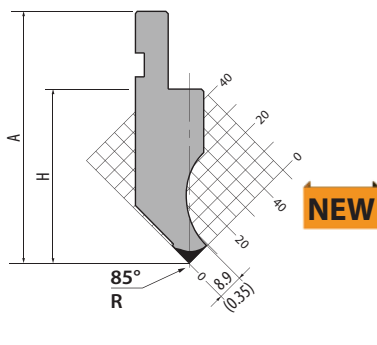
Articles on stock – Please note that delivery time depends on your location.

# R1 ROLLER TYPE R1

85° Punches

## P.97.85.R08 / PK.95.85.R3

1000 kN/m max.



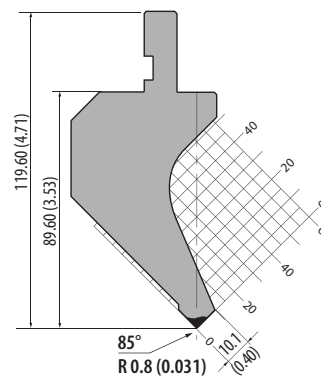
|                                                          |                    |         |
|----------------------------------------------------------|--------------------|---------|
| <b>P.97.85.R08</b>                                       |                    |         |
| H=66.60 / A=96.50 / R=0.8<br>(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 |
| <b>PK.95.85.R3</b>                                       |                    |         |
| H=65.45 / A=95.45 / R=3.0<br>(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/mm<sup>2</sup>



## PK.120.85.R08

600 kN/m max.



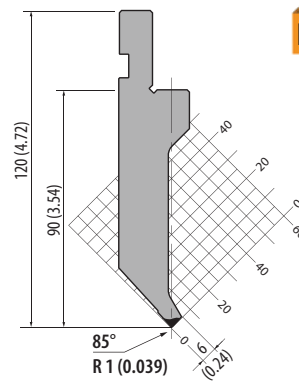
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 21.0 kg |
| 415 mm           | 16.34 in           | 10.5 kg |
| 795 mm segmented | 31.29 in segmented | 19.9 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



## P.120.85.R1

800 kN/m max.



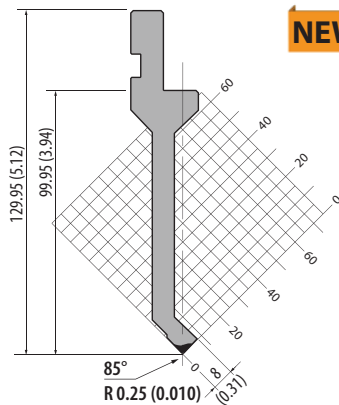
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.5 kg |
| 415 mm           | 16.34 in           | 6.7 kg  |
| 795 mm segmented | 31.29 in segmented | 12.9 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



## P.130.85.R025

350 kN/m max.



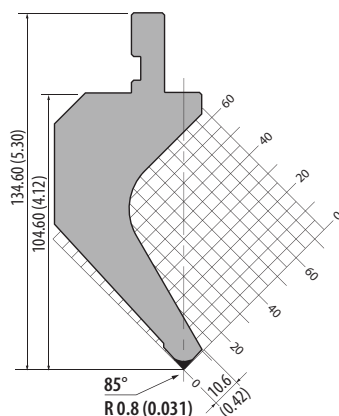
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.5 kg |
| 415 mm           | 16.34 in           | 5.7 kg  |
| 795 mm segmented | 31.29 in segmented | 10.9 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



## PK.135.85.R08

500 kN/m max.



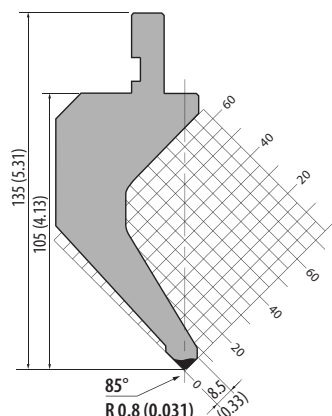
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.2 kg |
| 415 mm           | 16.34 in           | 11.0 kg |
| 795 mm segmented | 31.29 in segmented | 21.1 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



## P.135.85.R08

800 kN/m max.



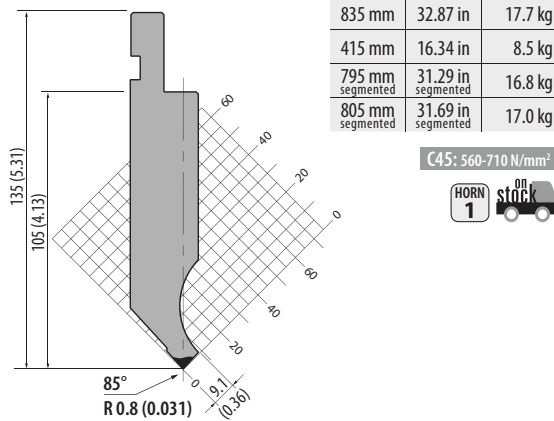
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 20.9 kg |
| 415 mm           | 16.34 in           | 10.4 kg |
| 795 mm segmented | 31.29 in segmented | 19.9 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



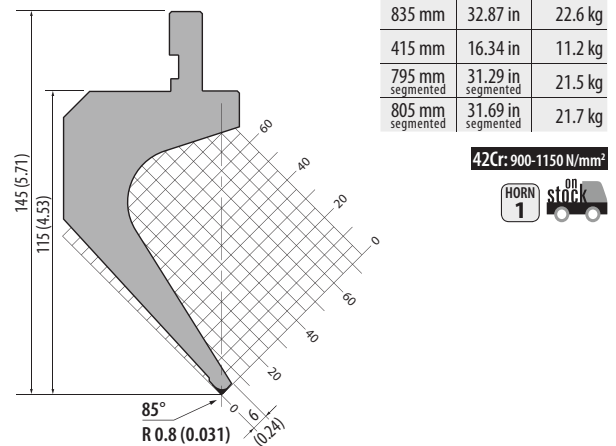
### PS.135.85.R08

1000 kN/m max.



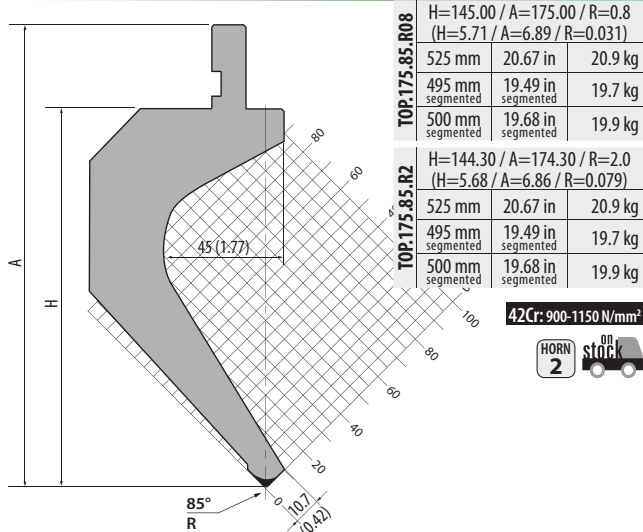
### P.145.85.R08

600 kN/m max.



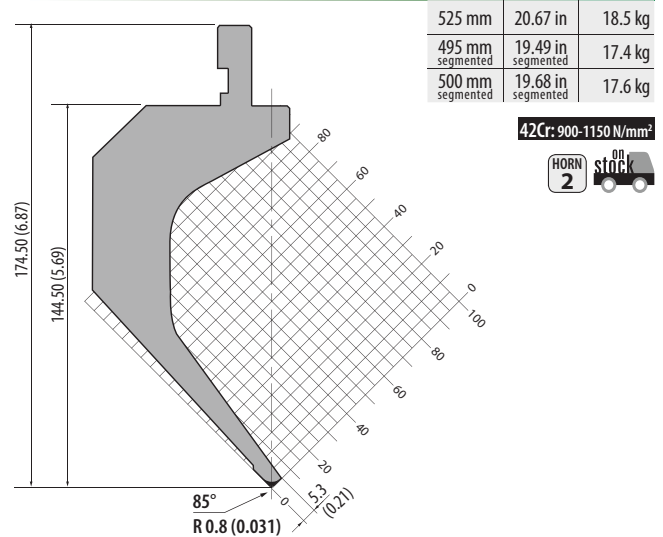
### TOP.175.85.R08 / R2

900 kN/m max.



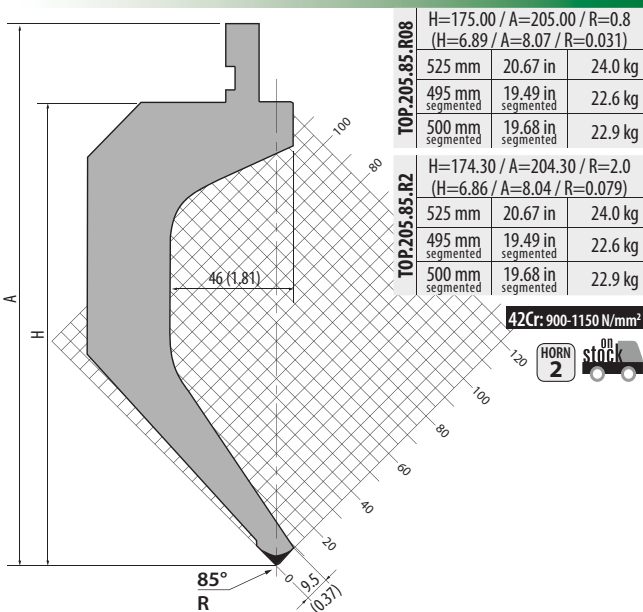
### TOP.175.85.R08.S

200 kN/m max.



### TOP.205.85.R08 / R2

700 kN/m max.



vertical

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


 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)



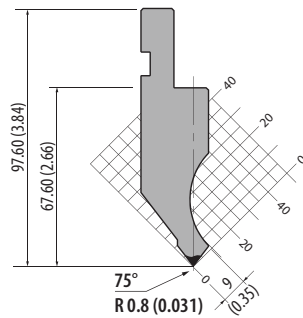
Articles on stock – Please note that  
 delivery time depends on your location.

# R1 ROLLER TYPE R1

## 75° Punches

### P.97.75.R08

1000 kN/m max.



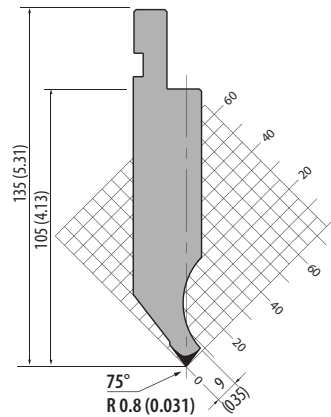
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.0 kg |
| 415 mm           | 16.34 in           | 5.5 kg  |
| 795 mm segmented | 31.29 in segmented | 10.4 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



### P.135.75.R08

1000 kN/m max.



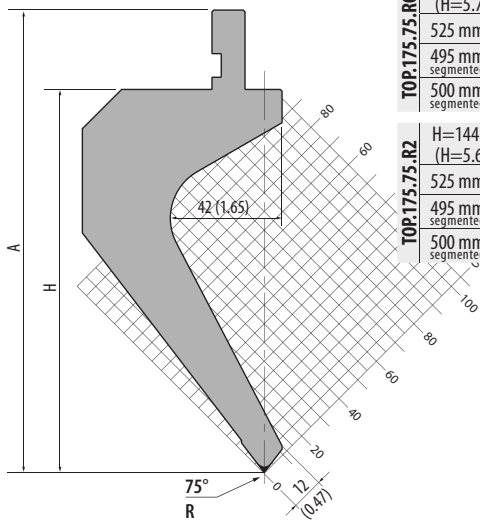
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 17.5 kg |
| 415 mm           | 16.34 in           | 8.5 kg  |
| 795 mm segmented | 31.29 in segmented | 16.7 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



### TOP.175.75.R08 / R2

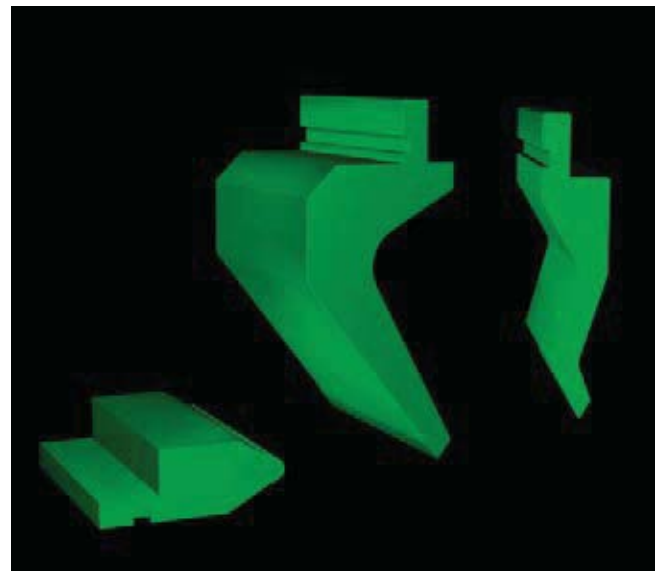
750 kN/m max.



|                |                                                            |
|----------------|------------------------------------------------------------|
| TOP.175.75.R08 | H=145.00 / A=175.00 / R=0.8<br>(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<br>(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                |

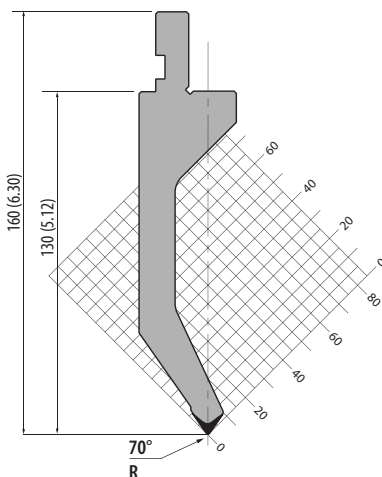
42Cr: 900-1150 N/mm<sup>2</sup>



## 70° Punches

### P.160.70.R08 / R3

450 kN/m max.



|              |                  |                            |
|--------------|------------------|----------------------------|
| P.160.70.R08 | R=0.8 (0.031)    |                            |
|              | 835 mm           | 32.87 in 18.0 kg           |
|              | 415 mm           | 16.34 in 8.9 kg            |
|              | 795 mm segmented | 31.29 in segmented 17.1 kg |
|              | 805 mm segmented | 31.69 in segmented 17.3 kg |

|             |                  |                            |
|-------------|------------------|----------------------------|
| P.160.70.R3 | R=3.0 (0.118)    |                            |
|             | 835 mm           | 32.87 in 18.0 kg           |
|             | 415 mm           | 16.34 in 8.9 kg            |
|             | 795 mm segmented | 31.29 in segmented 17.1 kg |
|             | 805 mm segmented | 31.69 in segmented 17.3 kg |

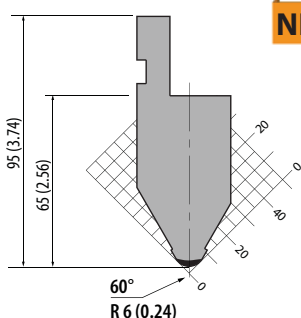
42Cr: 900-1150 N/mm<sup>2</sup>



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

### 00300

1000 kN/m max.


**NEW**

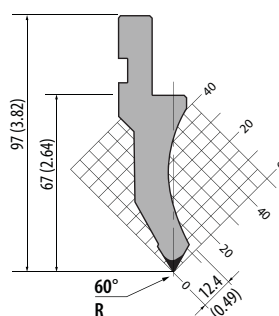
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 15.0 kg |
| 415 mm           | 16.34 in           | 7.5 kg  |
| 795 mm segmented | 31.29 in segmented | 14.2 kg |
| 800 mm segmented | 31.50 in segmented |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

C45: 560-710 N/mm²



### P.97.60.R08 / R2

600 kN/m max.



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

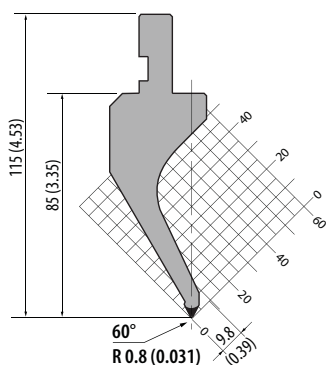
| P.97.60.R2 | R=2.0 (0.079)    |                    |        |
|------------|------------------|--------------------|--------|
|            | 835 mm           | 32.87 in           | 9.0 kg |
|            | 415 mm           | 16.34 in           | 5.0 kg |
|            | 795 mm segmented | 31.29 in segmented | 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.



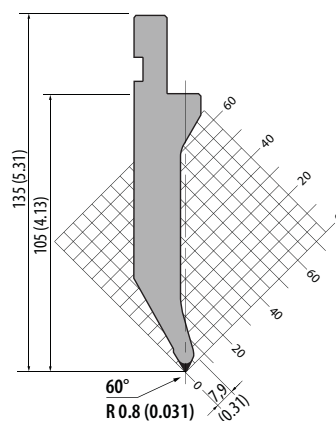
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.9 kg |
| 415 mm           | 16.34 in           | 6.0 kg  |
| 795 mm segmented | 31.29 in segmented | 11.3 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm²



### P.135.60.R08

800 kN/m max.



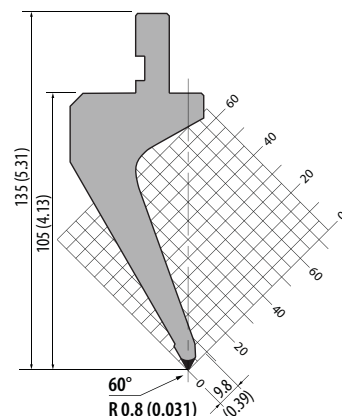
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 14.0 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 13.3 kg |
| 805 mm segmented | 31.69 in segmented |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

42Cr: 900-1150 N/mm²



### PG.135.60.R08

700 kN/m max.



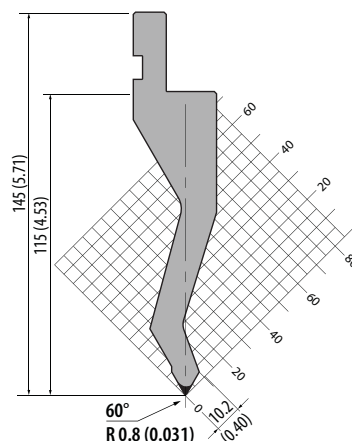
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.5 kg |
| 415 mm           | 16.34 in           | 8.5 kg  |
| 795 mm segmented | 31.29 in segmented | 15.7 kg |
| 805 mm segmented | 31.69 in segmented | 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)

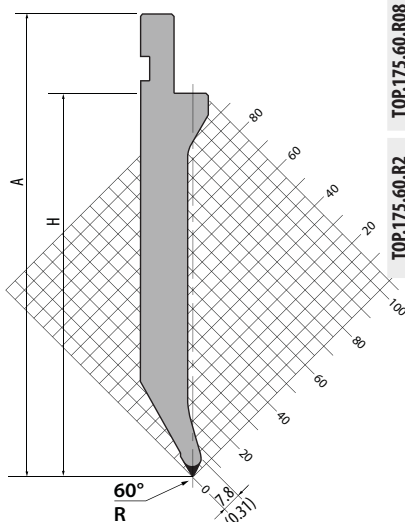
 Articles on stock – Please note that  
delivery time depends on your location.

# R1 ROLLER TYPE R1

## 60° Punches

### TOP.175.60.R08 / R2

800 kN/m max.



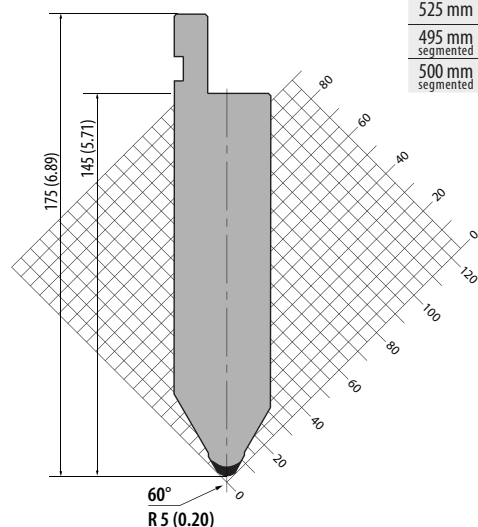
| TOP.175.60.R08                                             |                    |         |
|------------------------------------------------------------|--------------------|---------|
| H=145.00 / A=175.00 / R=0.8<br>(H=5.71 / A=6.89 / R=0.031) |                    |         |
| 525 mm                                                     | 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<br>(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/mm<sup>2</sup>



### TOP.175.60.R5

1600 kN/m max.



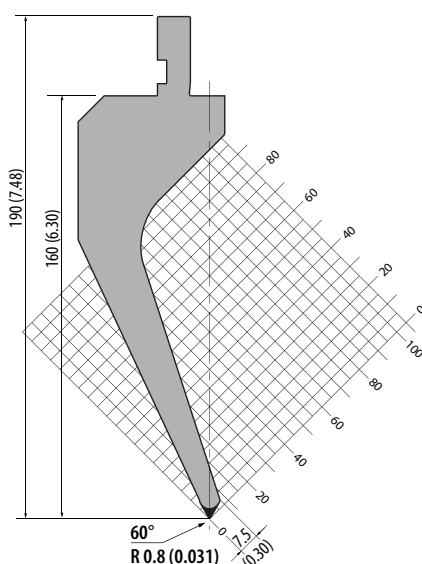
|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 22.0 kg |
| 495 mm segmented | 19.49 in segmented | 20.7 kg |
| 500 mm segmented | 19.68 in segmented | 20.9 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



### 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/mm<sup>2</sup>

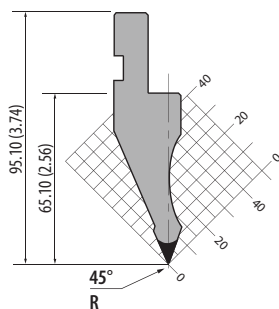


Take advantage of the wide range of Roller R1 Type punches by using our extensive number of adapters. See pages 220-225



### P.95.45.R08 / R15

800 kN/m max.



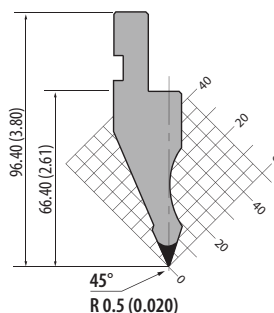
| P.95.45.R08 | R=0.8 (0.031)    |                    |        |
|-------------|------------------|--------------------|--------|
|             | 835 mm           | 32.87 in           | 9.5 kg |
|             | 415 mm           | 16.34 in           | 4.2 kg |
|             | 795 mm segmented | 31.29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



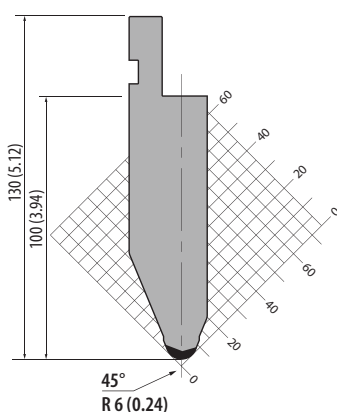
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 10.2 kg |
| 415 mm           | 16.34 in           | 5.1 kg  |
| 795 mm segmented | 31.29 in segmented | 9.7 kg  |
| 805 mm segmented | 31.69 in segmented | 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



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)



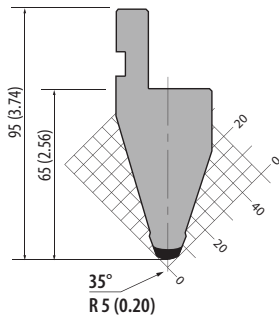
Articles on stock – Please note that  
delivery time depends on your location.

# R1 ROLLER TYPE R1

## 35° Punches

### P.95.35.R5

1000 kN/m max.



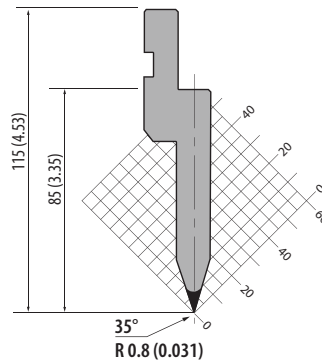
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.5 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 12.8 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



### PU.85.35.R08

1000 kN/m max.



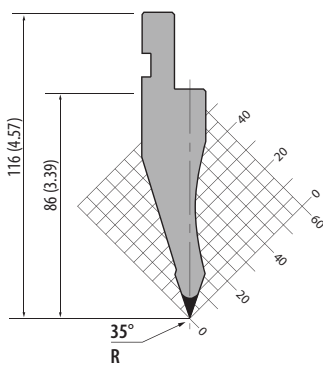
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.0 kg |
| 415 mm           | 16.34 in           | 5.5 kg  |
| 795 mm segmented | 31.29 in segmented | 10.4 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



### P.116.35.R08 / R15

700 kN/m max.



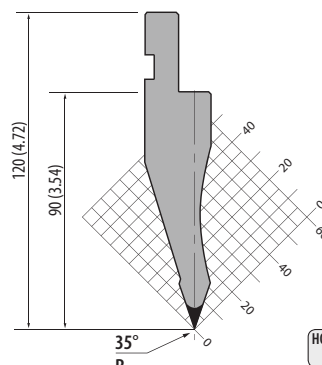
| R=0.8 (0.031) |                  |                    |
|---------------|------------------|--------------------|
| P.116.35.R08  | 835 mm           | 32.87 in           |
|               | 415 mm           | 16.34 in           |
|               | 795 mm segmented | 31.29 in segmented |
|               | 805 mm segmented | 31.69 in segmented |
|               |                  |                    |
| R=1.5 (0.059) |                  |                    |
| P.116.35.R15  | 835 mm           | 32.87 in           |
|               | 415 mm           | 16.34 in           |
|               | 795 mm segmented | 31.29 in segmented |
|               | 805 mm segmented | 31.69 in segmented |
|               |                  |                    |

C45: 560-710 N/mm<sup>2</sup>



### P.120.35.R08 / R15 / R3

700 kN/m max.



| R=0.8 (0.031) |                  |                    |
|---------------|------------------|--------------------|
| P.120.35.R08  | 835 mm           | 32.87 in           |
|               | 415 mm           | 16.34 in           |
|               | 795 mm segmented | 31.29 in segmented |
|               | 805 mm segmented | 31.69 in segmented |
|               |                  |                    |
| R=1.5 (0.059) |                  |                    |
| P.120.35.R15  | 835 mm           | 32.87 in           |
|               | 415 mm           | 16.34 in           |
|               | 795 mm segmented | 31.29 in segmented |
|               | 805 mm segmented | 31.69 in segmented |
|               |                  |                    |
| R=3.0 (0.118) |                  |                    |
| P.120.35.R3   | 835 mm           | 32.87 in           |
|               | 415 mm           | 16.34 in           |
|               | 795 mm segmented | 31.29 in segmented |
|               | 805 mm segmented | 31.69 in segmented |
|               |                  |                    |

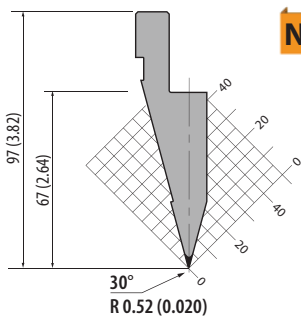
C45: 560-710 N/mm<sup>2</sup>



## 30° Punches

### 10300

1000 kN/m max.



**NEW**

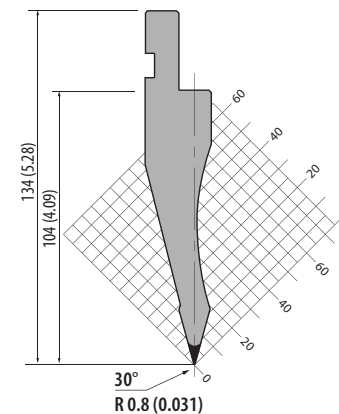
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.0 kg |
| 415 mm           | 16.34 in           | 5.5 kg  |
| 795 mm segmented | 31.29 in segmented | 10.4 kg |
| 800 mm segmented | 31.50 in segmented |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

42Cr: 900-1150 N/mm<sup>2</sup>



### PS.134.30.R08

700 kN/m max.



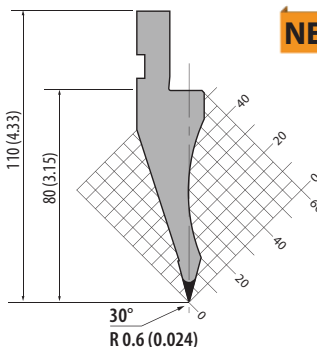
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.3 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.6 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



### P.110.30.R06

500 kN/m max.



**NEW**

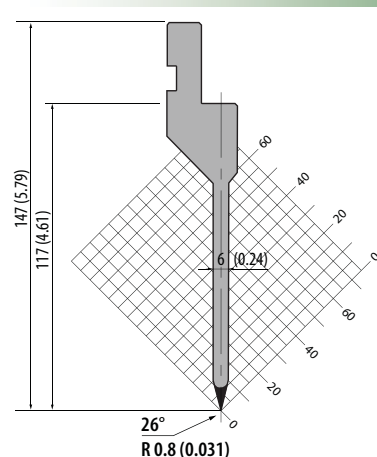
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 10.5 kg |
| 415 mm           | 16.34 in           | 5.2 kg  |
| 795 mm segmented | 31.29 in segmented | 10.0 kg |
| 805 mm segmented | 31.50 in segmented |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

C45: 560-710 N/mm<sup>2</sup>



### P.147.26.R08

500 kN/m max.



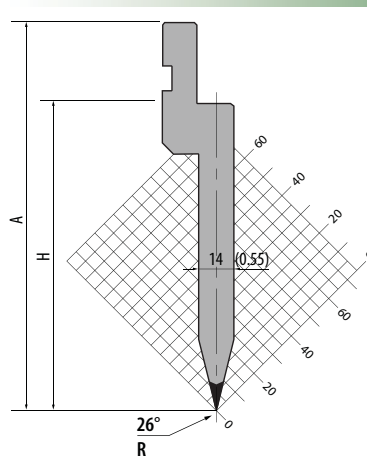
|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 9.8 kg |
| 415 mm           | 16.34 in           | 4.9 kg |
| 795 mm segmented | 31.29 in segmented | 9.3 kg |
| 805 mm segmented | 31.69 in segmented | 9.4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

42Cr: 900-1150 N/mm²



### PU.117.26.R08 / R3

1000 kN/m max.



|                                                         |                    |         |
|---------------------------------------------------------|--------------------|---------|
| PU.117.26.R08                                           |                    |         |
| H=117.00 / A=147.00 / R=0.8 (H=4.61 / A=5.79 / R=0.031) |                    |         |
| 835 mm                                                  | 32.87 in           | 13.5 kg |
| 415 mm                                                  | 16.34 in           | 6.5 kg  |
| 795 mm segmented                                        | 31.29 in segmented | 12.8 kg |
| 805 mm segmented                                        | 31.69 in segmented | 13.0 kg |

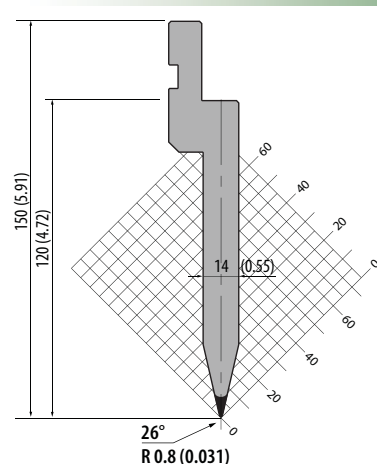
|                                                         |                    |         |
|---------------------------------------------------------|--------------------|---------|
| PU.117.26.R3                                            |                    |         |
| H=109.00 / A=139.00 / R=3.0 (H=4.29 / A=5.47 / R=0.118) |                    |         |
| 835 mm                                                  | 32.87 in           | 13.5 kg |
| 415 mm                                                  | 16.34 in           | 6.7 kg  |
| 795 mm segmented                                        | 31.29 in segmented | 12.8 kg |
| 805 mm segmented                                        | 31.69 in segmented | 13.0 kg |

C45: 560-710 N/mm²



### PU.150.26.R08.L

1000 kN/m max.



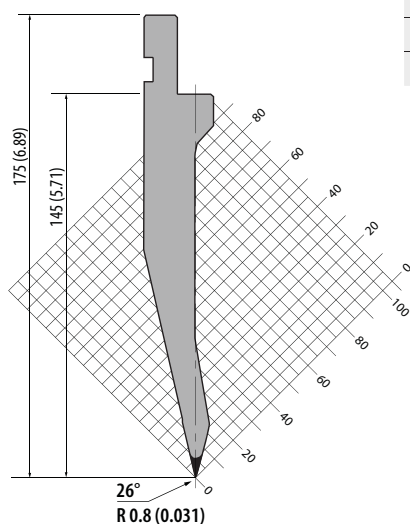
|                  |                    |         |
|------------------|--------------------|---------|
| 900 mm           | 35.43 in           | 15.0 kg |
| 415 mm           | 16.34 in           | 6.2 kg  |
| 795 mm segmented | 31.29 in segmented | 14.3 kg |
| 805 mm segmented | 31.69 in segmented |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

C45: 560-710 N/mm²



### TOP.175.26.R08

950 kN/m max.



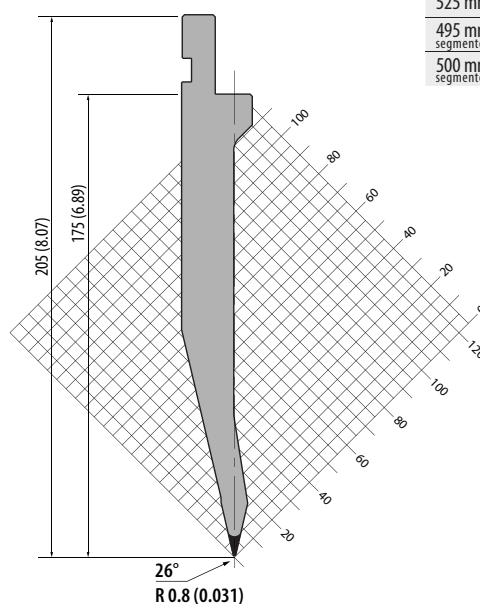
|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 11.0 kg |
| 495 mm segmented | 19.49 in segmented | 10.4 kg |
| 500 mm segmented | 19.68 in segmented | 10.5 kg |

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)

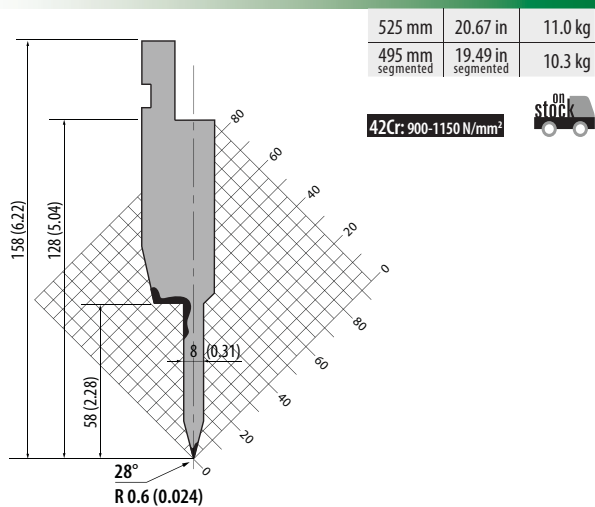


Articles on stock – Please note that delivery time depends on your location.

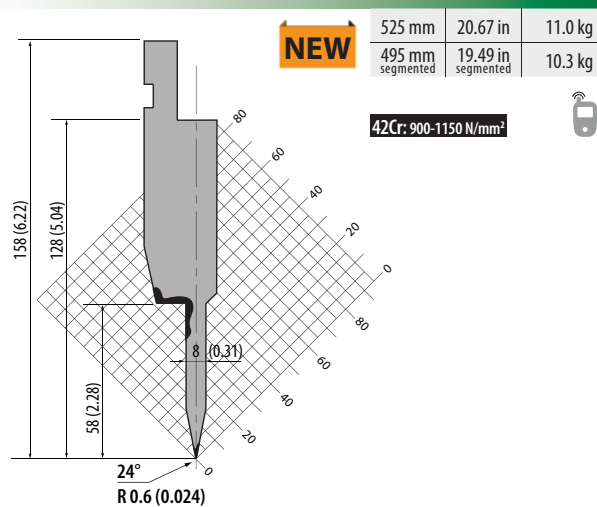
# R1 ROLLER TYPE R1

## 28°/24° Hemming tools

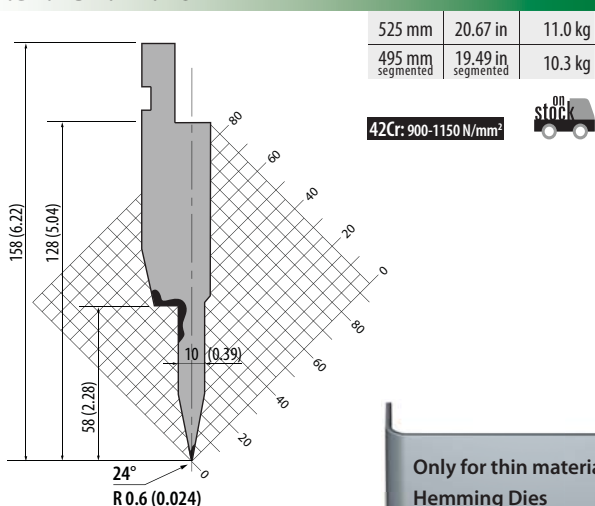
### TOP.SP.134.28.8



### TOP.SP.134.24.8

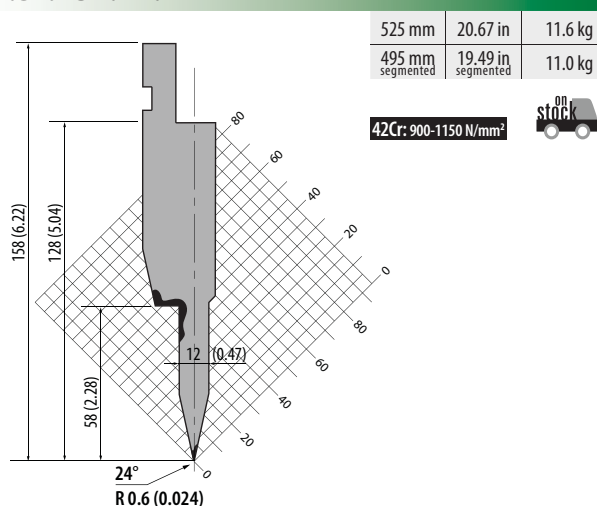


### TOP.SP.134.24.10

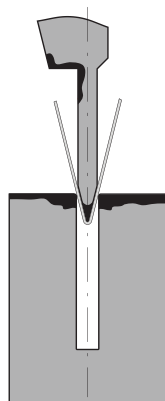


Only for thin material!  
Hemming Dies  
See page 75

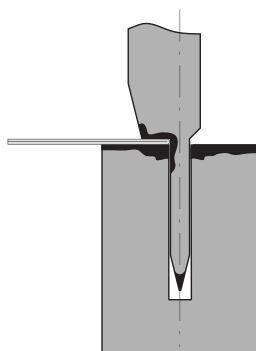
### TOP.SP.134.24.12



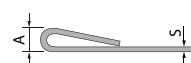
## Example of application



800 kN/m max.



1000 kN/m max.

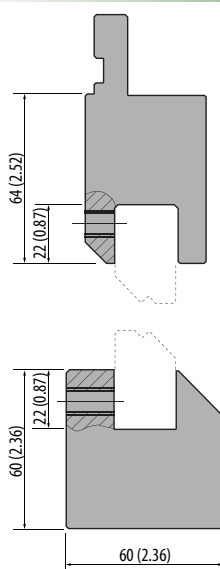


| S    | S    | A   | A    | R.45                | R.70                | S    | S    | A   | A    | R.45                | R.70                |
|------|------|-----|------|---------------------|---------------------|------|------|-----|------|---------------------|---------------------|
| mm   | in 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



### CPZ

1000 kN/m max.



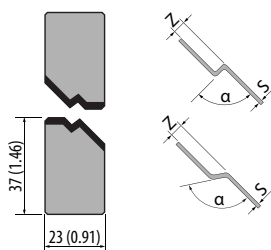
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 37.5 kg |
| 415 mm | 16.34 in | 18.7 kg |

C45: 560-710 N/mm<sup>2</sup>



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

1000 kN/m max.



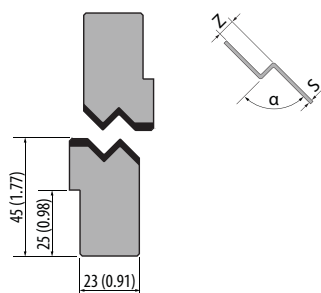
| Model      | Z mm | Z in | α    | S* mm | S* inch | Weight  | Weight |
|------------|------|------|------|-------|---------|---------|--------|
| CEZ 1.0    | 1.0  | 0.04 | 160° | 1.2   | 0.05    | 11.0 kg | 5.5 kg |
| CEZ 1.5    | 1.5  | 0.06 | 160° | 1.5   | 0.06    | 11.0 kg | 5.5 kg |
| CEZ 2.0    | 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/mm<sup>2</sup>

\* Fe Rmax = 42 Kg/mm<sup>2</sup>

### 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/mm<sup>2</sup>

\* Fe Rmax = 42 Kg/mm<sup>2</sup>



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)



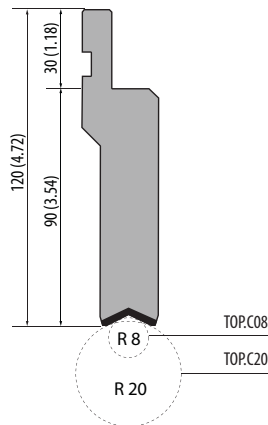
Articles on stock – Please note that  
delivery time depends on your location.

# 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/mm<sup>2</sup>

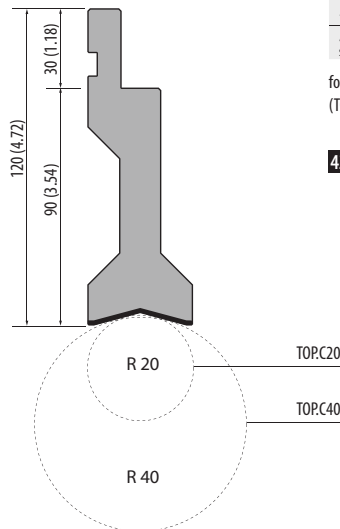


Radius Punches by  
Rolleri also sectioned  
on stock! Take advan-  
tage of this flexibility!



### 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 |

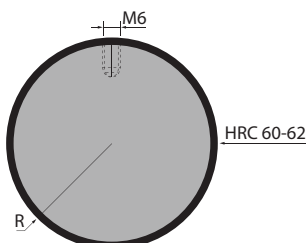
for Radius tools with R20-R40  
(TOP.C20-TOP.C40) see below

42Cr: 900-1150 N/mm<sup>2</sup>



### TOP-Radius Tools: R8-40

1000 kN/m max.



Material: C53  
induction hard-  
ened 60-62 HRC

C53: 610-760 N/mm<sup>2</sup>



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

525 mm / 20.67 in

495 mm / 16.34 in segmented

# R1 ROLLER TYPE R1

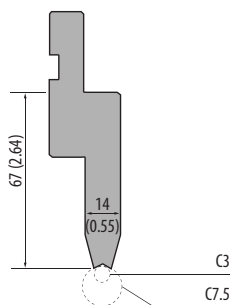
## Radius Tools



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/mm<sup>2</sup>



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

C3 - C7.5

400 kN/m max.



C45: 560-710 N/mm<sup>2</sup>

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



Article  
on stock



Please ask for  
delivery time!

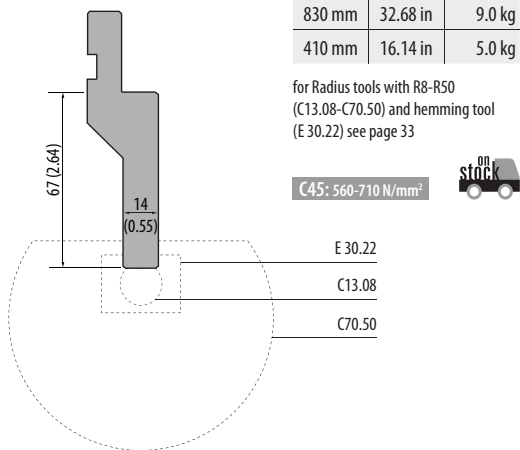
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)  
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

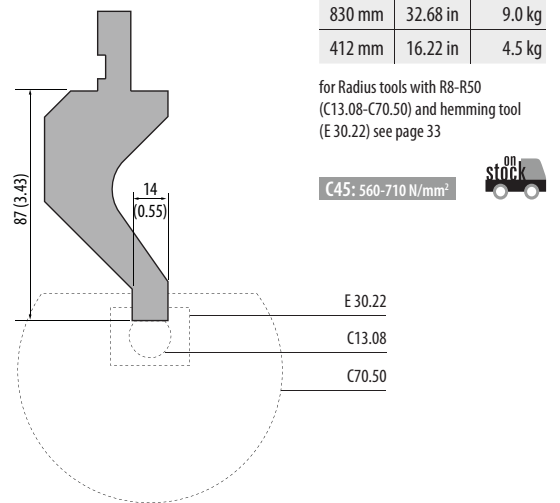
### PU.67.14

800 kN/m max.



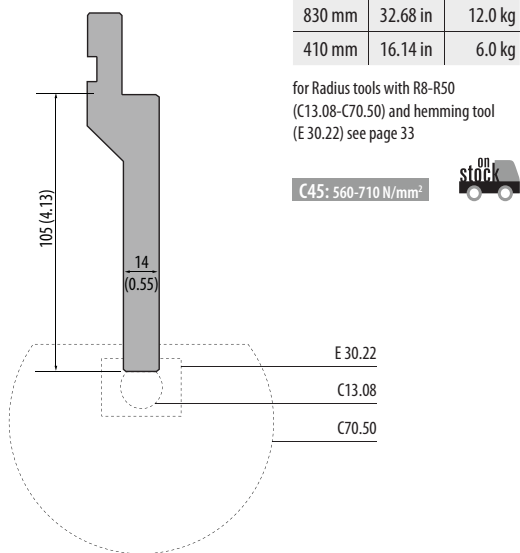
### PU.87.14

500 kN/m max.



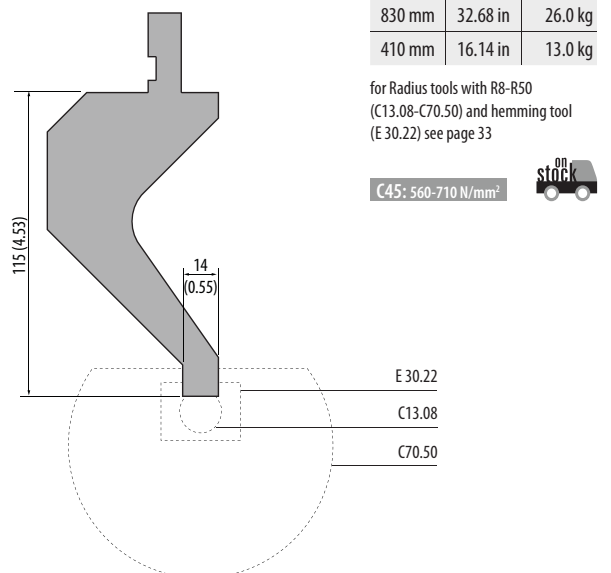
### PU.105.14

800 kN/m max.



### PU.115.14

500 kN/m max.

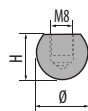


Articles on stock – Please note that delivery time varies according to your location.



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

800 kN/m max.



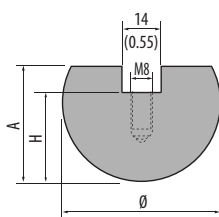
C45: 560-710 N/mm²



| Model         | Ø mm | Ø in | H mm | H in | 835 mm / 32.87 in | Weight  | 415 mm / 16.34 in | Weight  |
|---------------|------|------|------|------|-------------------|---------|-------------------|---------|
| <b>C13.08</b> | 16   | 0.63 | 13   | 0.51 | 835 mm / 32.87 in | 2.00 kg | 415 mm / 16.34 in | 1.00 kg |
| <b>C13.09</b> | 18   | 0.71 | 16   | 0.63 |                   | 2.00 kg |                   | 1.00 kg |
| <b>C16.10</b> | 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

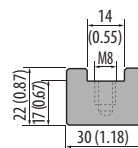
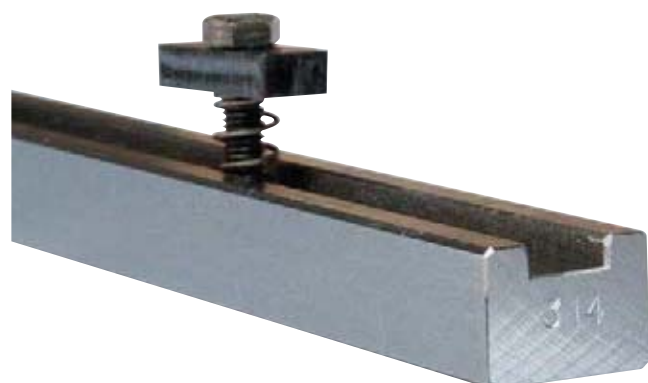


| Model         | Ø mm | Ø in | H mm | H in | A mm | A in | 835 mm / 32.87 in | Weight  | 415 mm / 16.34 in | Weight  |
|---------------|------|------|------|------|------|------|-------------------|---------|-------------------|---------|
| <b>C17.12</b> | 25   | 0.98 | 17   | 0.67 | 22   | 0.87 | 835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


 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

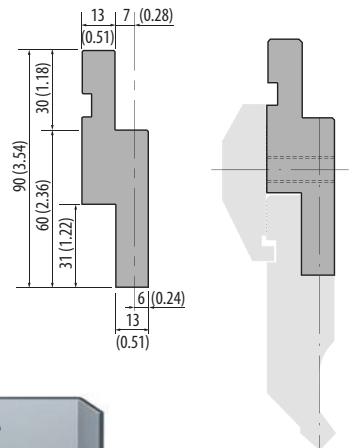
## Punch extensions / Intermediates

### 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

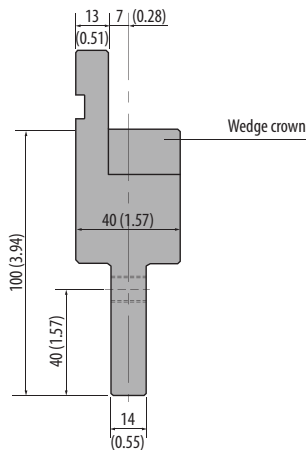
C45: 560-710 N/mm<sup>2</sup>



Compatible  
tensioner  
see page 208

### INT100

1000 kN/m max.



per piece 3.5 kg

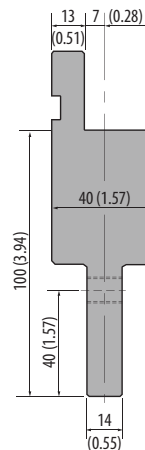
L=150 mm

C45: 560-710 N/mm<sup>2</sup>



### INT100 FISSO

1000 kN/m max.



per piece 4.0 kg

L=150 mm

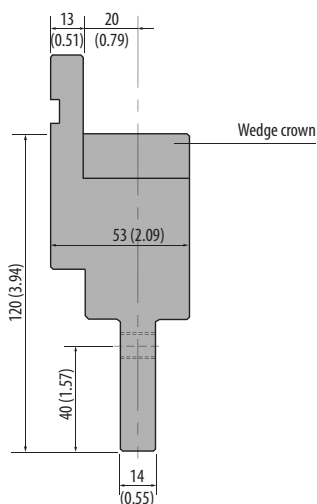
Punch extension  
without wedge crowning

C45: 560-710 N/mm<sup>2</sup>



### INT120-40

1000 kN/m max.



per piece 5.2 kg

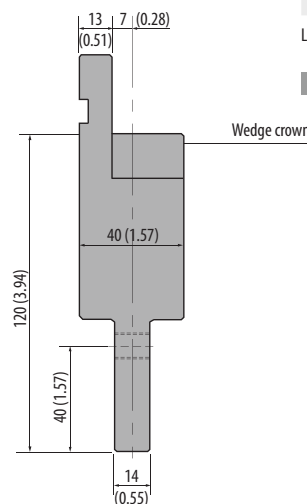
L=150 mm

C45: 560-710 N/mm<sup>2</sup>



### INT120

1000 kN/m max.



per piece 4.5 kg

L=150 mm

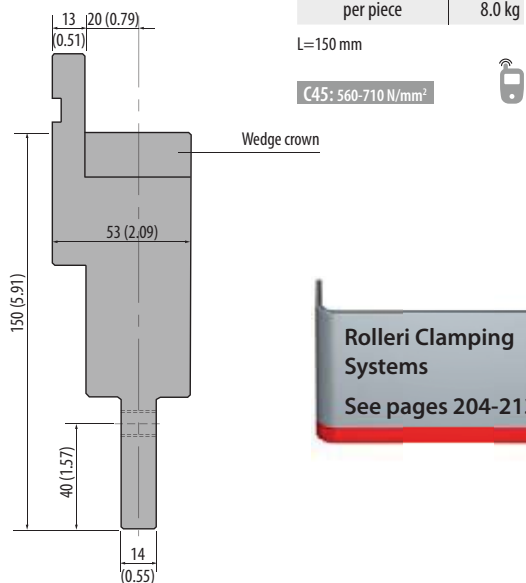
C45: 560-710 N/mm<sup>2</sup>



Intermediates also  
available in L=70 mm  
upon request.

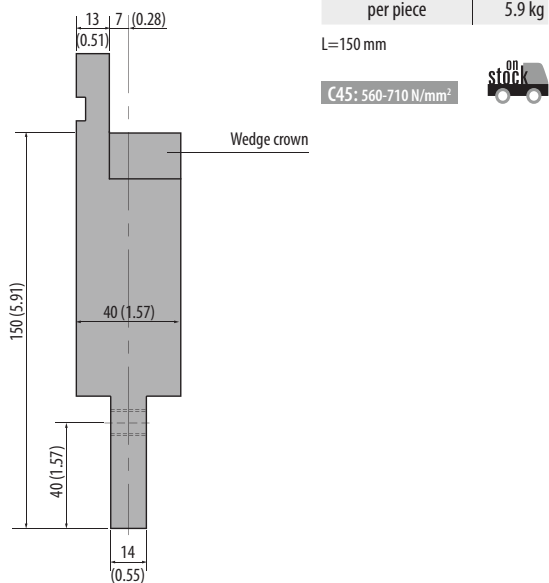
### INT150-40

1000 kN/m max.

**NEW**


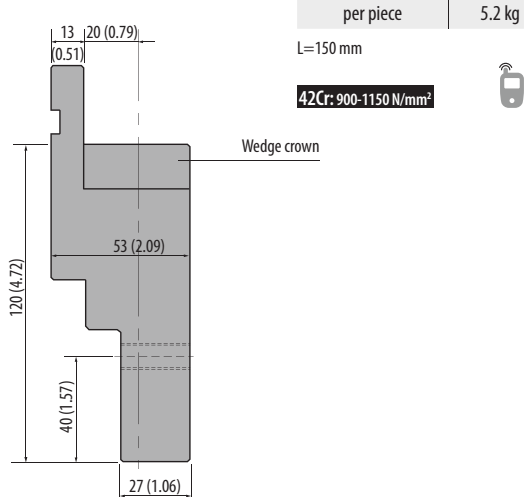
### INT150

1000 kN/m max.



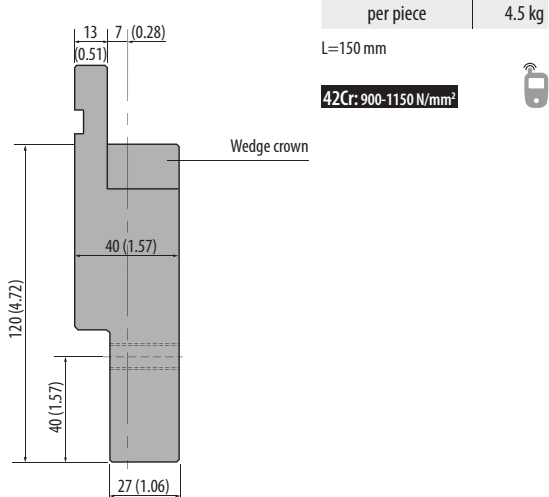
### INT120-40-HD (Heavy Duty)

1600 kN/m max.

**NEW**


### INT120-HD (Heavy Duty)

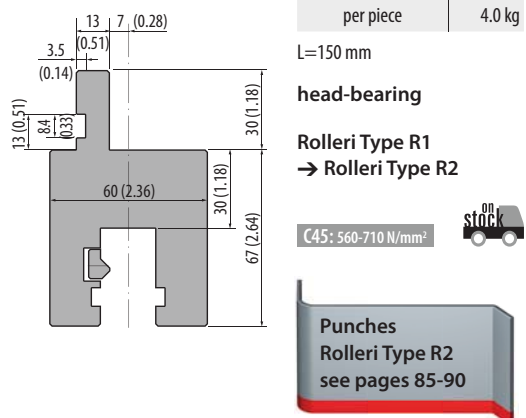
1600 kN/m max.

**NEW**


## Punch Adapters

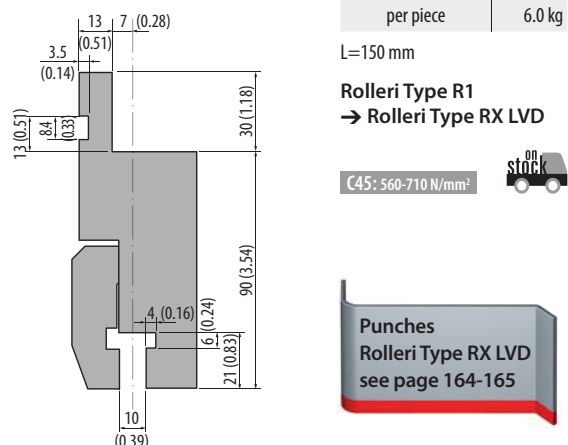
### AD20

1000 kN/m max.



### AD19-A

1000 kN/m max.


 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.