ROLLERI

TOOLING LAB

LASER CONSUMABLES

PUNCHING TOOLS - IRON WORKER

SHEAR BLADES

PANEL BENDING TOOLS

BENDING

R1 TOOLS TYPE



ISO 9001 - ISO 45001
CERTIFIED
COMPANY

Scan the QRCode or click on it and watch the video. You can follow our official Youtube channel www.youtube.com/Rollerispa or watch the video on our web site www.rolleritools.com/media



Download Rolleri **Bending App.**
You will also get our sheet metal unfolding software for free and our bending rule.
You can also scan the QRCode of this catalogue by using the app.

Request our clamping, punching and ironworker, consumables laser, panel bending tools and shear blades catalogues on www.rolleritools.com/catalogues

The **Bending handbook** target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.

Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

Click on the QRCode near the codes or scan it to check prices and delivery time.

Check the standard sectioning available. Customized sectioning is also available on request. sales@rolleri.it to know more about price and availability.

BENDING TOOLS

R1 TOOLS TYPE

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

R2-R3 TOOLS TYPE

Compatible with press brakes: Darley, LVD, Safan, Trumpf and press brakes with NSCL system, Bystronic Beyeler RFA, RF, R, S

R4 TOOLS TYPE

Compatible with press brakes: LVD

R5 TOOLS TYPE

Compatible with press brakes: American

R6 TOOLS TYPE

Compatible with press brakes: Hämmerle-Bystronic

R7 TOOLS TYPE

Compatible with press brakes: Colly

R8 TOOLS TYPE

Compatible with press brakes: Colgar

R9 TOOLS TYPE

Compatible with press brakes: Gasparini (axial)

R10 TOOLS TYPE

Compatible with press brakes: Ajial Axial

Rx TOOLS TYPE

Compatible with press brakes: EHT, Ursviken and Weinbrenner

ROLLERI TECH, MODIFICATIONS AND SERVICES

Compatible with all types of press brakes

CLAMPING SYSTEMS, INTERMEDIATES AND ADAPTERS

Compatible with all types of press brakes

ROLLA-V AND SPECIAL DIES

Compatible with all types of press brakes

MARK FREE BENDING AND ACCESSORIES

Compatible with all types of press brakes

PANEL BENDING TOOLS

SHEAR BLADES

PUNCHING TOOLS

R1 TOOLS TYPE

Compatible with punching machines Amada, Amada ABS, Wilson HP, Wilson HP WLS, Mate Ultra Tec

R2 TOOLS TYPE

Compatible with Trumpf punching machines

RS TOOLS TYPE

Compatible with Salvagnini punching machines

SPECIAL TOOLS

Compatible with different types of punching machines

ACCESSORIES

Compatible with different types of punching machines

IRON WORKER

Iron cutting tools

LASER CONSUMABLES

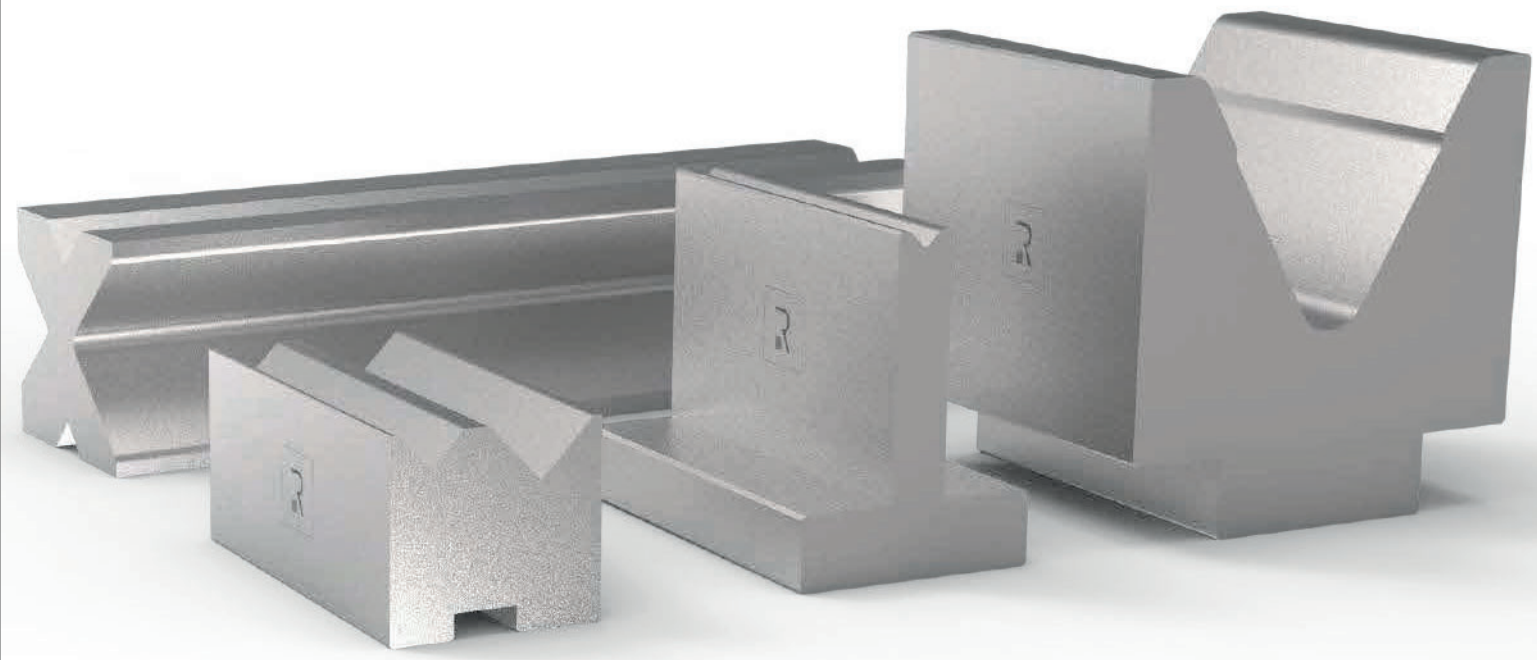
Find out more about our wide range of laser consumables: one of the most complete in the market

R1

DIES

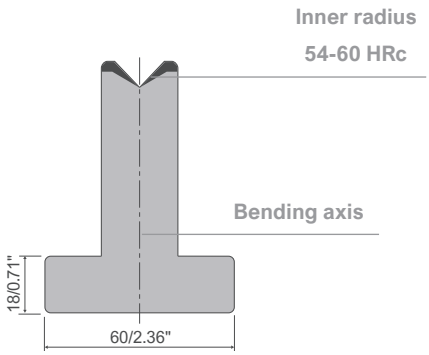
Accurl, Accurpress, ACL, Adira, Amada, Atlantic, Baykal, BL, Boschert, Boutillon, Bystronic Beyeler, Euro-B, Coastone, Colgar, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gecko, Gilardi, Gizelis, Haco, Hindustan, HPM, Iturrospe, Jfy, JMT, LFK, Metfab, MVD, Oriance, Prima Power, Promecam,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

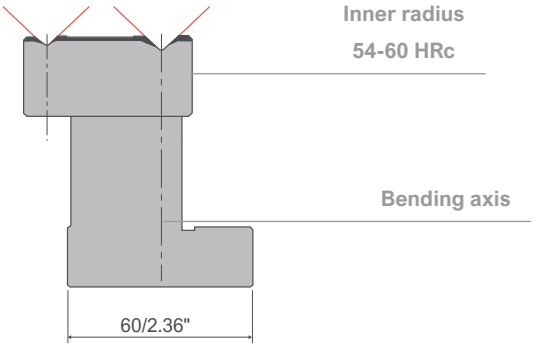
Our tool codes are listed according to the **tool angle**

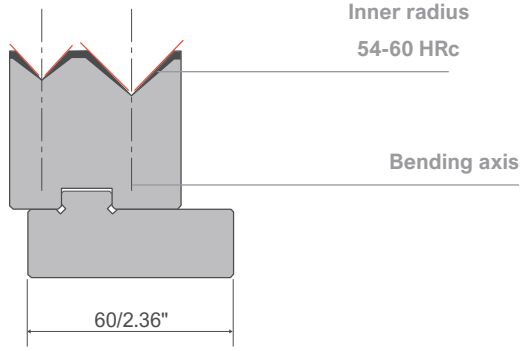


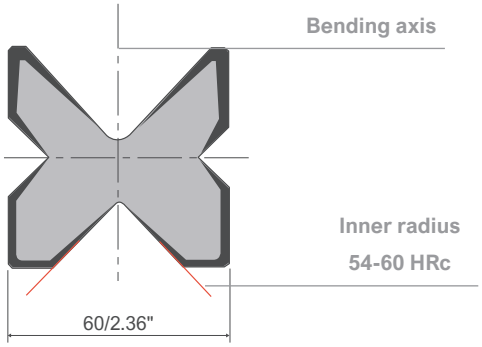
STANDARD TANG

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









STANDARD LENGTH

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

○ available for some tool models only

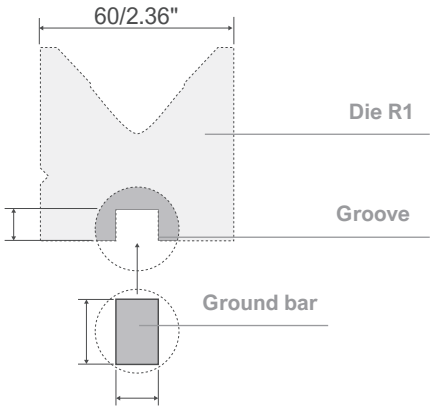
Rolleri BLACKFIRE is a surface treatment against steel oxidation. This chemical treatment is a long-term solution against oxidation and rust.

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

MODIFICATIONS WEDGE/BAR TAIL

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

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



SEGMENTATION

Special segmentation is available on request - check the feasibility with sales@rolleri.it

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



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



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



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



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



Request our clamping, punching and ironworker, consumables laser, panel bending tools and shear blades catalogues on www.rolleritools.com/catalogues

Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

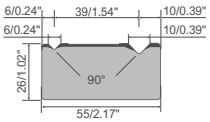
M26.90.01

835 mm *32.87"* 9.0 kg
415 mm *16.34"* 4.5 kg
900 mm *35.43"* 10.0 kg

90° >

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=26 | R=0.4 | V=6 mm
H=26 | R=0.6 | V=10 mm
H=1.02 | R=0.016 | V=0.24 in
H=1.02 | R=0.024 | V=0.39 in



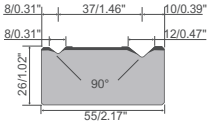


M26.90.02

835 mm *32.87"* 9.0 kg
415 mm *16.34"* 4.5 kg
900 mm *35.43"* 10.0 kg

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=26 | R=0.5 | V=8 mm
H=26 | R=0.8 | V=12 mm
H=1.02 | R=0.020 | V=0.31 in
H=1.02 | R=0.031 | V=0.47 in

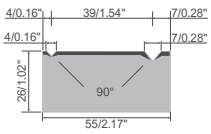


M26.90.03

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

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=26 | R=0.3 | V=4 mm
H=26 | R=0.5 | V=7 mm
H=1.02 | R=0.012 | V=0.16 in
H=1.02 | R=0.020 | V=0.28 in





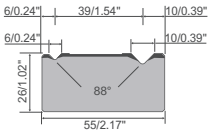
M26.88.01

88° >

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=0.4 | V=6 mm
H=26 | R=0.6 | V=10 mm
H=1.02 | R=0.016 | V=0.24 in
H=1.02 | R=0.024 | V=0.39 in

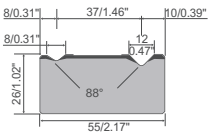


M26.88.02

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=0.5 | V=8 mm
H=26 | R=0.8 | V=12 mm
H=1.02 | R=0.020 | V=0.31 in
H=1.02 | R=0.031 | V=0.47 in



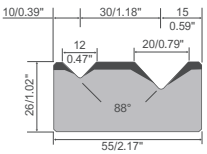


M26.88.03

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=2.75 | V=12 mm
H=26 | R=3 | V=20 mm
H=1.02 | R=0.108 | V=0.47 in
H=1.02 | R=0.118 | V=0.79 in

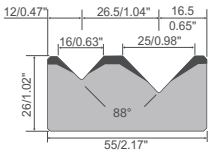


M26.88.04

835 mm *32.87"* 8.0 kg
415 mm *16.34"* 4.0 kg

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=2.75 | V=16 mm
H=26 | R=2.75 | V=25 mm
H=1.02 | R=0.108 | V=0.63 in
H=1.02 | R=0.108 | V=0.98 in



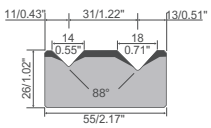


M26.88.05

835 mm *32.87"* 8.0 kg
415 mm *16.34"* 4.0 kg

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=2.75 | V=14 mm
H=26 | R=3 | V=18 mm
H=1.02 | R=0.108 | V=0.55 in
H=1.02 | R=0.118 | V=0.71 in



Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

The **Bending handbook** target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.

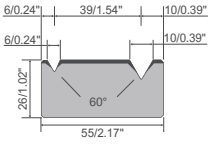
M26.60.01

835 mm *32.87"* 9.0 kg
415 mm *16.34"* 4.5 kg
900 mm *35.43"* 10.0 kg

60° >

C45: 560-710 N/mm²
600 kN/m max.

60°
H=26 | R=0.5 | V=6 mm
H=26 | R=0.8 | V=10 mm
H=1.02 | R=0.020 | V=0.24 in
H=1.02 | R=0.031 | V=0.39 in



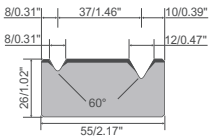


M26.60.02

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

C45: 560-710 N/mm²
800 kN/m max.

60°
H=26 | R=0.5 | V=8 mm
H=26 | R=0.8 | V=12 mm
H=1.02 | R=0.020 | V=0.31 in
H=1.02 | R=0.031 | V=0.47 in

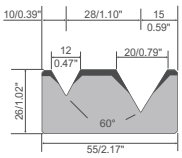


M26.60.03

835 mm *32.87"* 8.0 kg
415 mm *16.34"* 4.5 kg

C45: 560-710 N/mm²
800 kN/m max.

60°
H=26 | R=0.8 | V=12 mm
H=26 | R=3 | V=20 mm
H=1.02 | R=0.031 | V=0.24 in
H=1.02 | R=0.118 | V=0.39 in



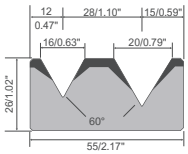


M26.60.05

835 mm *32.87"* 8.0 kg
415 mm *16.34"* 4.5 kg

C45: 560-710 N/mm²
800 kN/m max.

60°
H=26 | R=3 | V=16 mm
H=26 | R=3 | V=20 mm
H=1.02 | R=0.118 | V=0.63 in
H=1.02 | R=0.118 | V=0.79 in



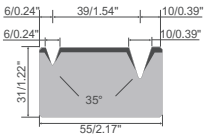
M31.35.01

835 mm *32.87"* 11 kg
415 mm *16.34"* 5.5 kg

35° >

C45: 560-710 N/mm²
300 kN/m max.

35°
H=31 | R=0.6 | V=6 mm
H=31 | R=1 | V=10 mm
H=1.22 | R=0.024 | V=0.24 in
H=1.22 | R=0.039 | V=0.39 in



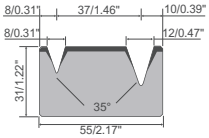


M31.35.02

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

C45: 560-710 N/mm²
300 kN/m max.

35°
H=31 | R=1 | V=8 mm
H=31 | R=1.2 | V=12 mm
H=1.22 | R=0.039 | V=0.31 in
H=1.2 | R=0.047 | V=0.47 in



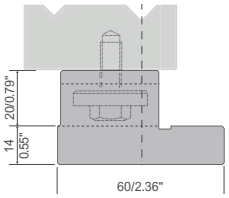
SU034

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

C45: 560-710 N/mm²

H=34 mm
H=1.34 in

Holder





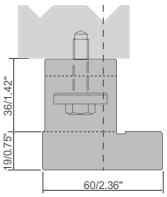
SU055

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 7.2 kg

C45: 560-710 N/mm²

H=55 mm
H=2.17 in

Holder



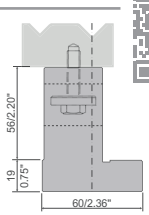
SU075

835 mm *32.87"* 20.5 kg
415 mm *16.34"* 10.0 kg

C45: 560-710 N/mm²

H=75 mm
H=2.95

Holder





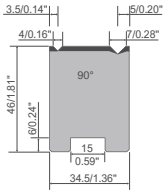
46-10

90° >

835 mm *32.87"* 9.7 kg
415 mm *16.34"* 4.8.0 kg
795 mm *31.29"* 9.7 kg FX
805 mm *31.69"* 9.7 kg F

C45: 560-710 N/mm²
800 kN/m max.

90°
H=46 | R=0.3 | V=4 mm
H=46 | R=0.5 | V=7 mm
H=1.81 | R=0.012 | V=0.16 in
H=1.81 | R=0.020 | V=0.28 in



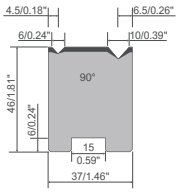


46-11

835 mm *32.87"* 10.3 kg
415 mm *16.34"* 5.1 kg
795 mm *31.29"* 9.9 kg FX
805 mm *31.69"* 9.0 kg F

C45: 560-710 N/mm²
800 kN/m max.

90°
H=46 | R=0.4 | V=6 mm
H=46 | R=0.6 | V=10 mm
H=1.81 | R=0.016 | V=0.24 in
H=1.81 | R=0.024 | V=0.39 in

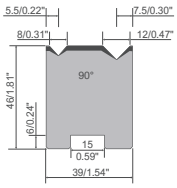


46-12

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

C45: 560-710 N/mm²
800 kN/m max.

90°
H=46 | R=0.5 | V=8 mm
H=46 | R=0.8 | V=12 mm
H=1.81 | R=0.020 | V=0.31 in
H=1.81 | R=0.031 | V=0.47 in





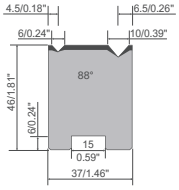
46.11.88

88° >

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

C45: 560-710 N/mm²
800 kN/m max.

88°
H=46 | R=0.4 | V=6 mm
H=46 | R=0.6 | V=10 mm
H=1.81 | R=0.016 | V=0.24 in
H=1.81 | R=0.024 | V=0.39 in

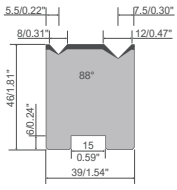


46.13

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

C45: 560-710 N/mm²
800 kN/m max.

88°
H=46 | R=0.5 | V=8 mm
H=46 | R=0.8 | V=12 mm
H=1.81 | R=0.020 | V=0.31 in
H=1.81 | R=0.031 | V=0.47 in



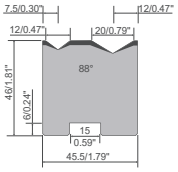


46.14

835 mm *32.87"* 12 kg
415 mm *16.34"* 6 kg
795 mm *31.29"* 11.4 kg FX
805 mm *31.69"* 11.5 kg F

C45: 560-710 N/mm²
800 kN/m max.

88°
H=46 | R=0.8 | V=12 mm
H=46 | R=1.75 | V=20 mm
H=1.81 | R=0.031 | V=0.47 in
H=1.81 | R=0.069 | V=0.79 in

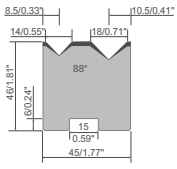


46.15

835 mm *32.87"* 12.6 kg
415 mm *16.34"* 6 kg
795 mm *31.29"* 12 kg FX
805 mm *31.69"* 12.1 kg F

C45: 560-710 N/mm²
800 kN/m max.

88°
H=46 | R=1.25 | V=14 mm
H=46 | R=1.5 | V=18 mm
H=1.81 | R=0.049 | V=0.55 in
H=1.81 | R=0.059 | V=0.71 in



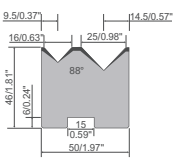


46.16

835 mm *32.87"* 13 kg
415 mm *16.34"* 6.5 kg
795 mm *31.29"* 12.4 kg FX
805 mm *31.69"* 12.5 kg F

C45: 560-710 N/mm²
800 kN/m max.

88°
H=46 | R=1.5 | V=16 mm
H=46 | R=1.75 | V=25 mm
H=1.81 | R=0.059 | V=0.63 in
H=1.81 | R=0.069 | V=0.98 in



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



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



Scan the QRCode or click on it to check PRICES and AVAILABILITY www.rolleritools.com

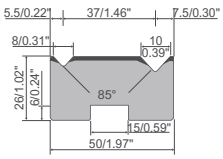
M26.85.02

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

85° >

42Cr: 900-1150 N/mm²
1000 kN/m max.

85°
H=26 | R=0.5 | V=8 mm
H=26 | R=0.8 | V=12 mm
H=1.02 | R=0.020 | V=0.31 in
H=1.02 | R=0.031 | V=0.47 in





PM50 + Support is needed

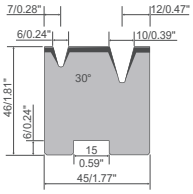
46.17

835 mm *32.87"* 12.2 kg
415 mm *16.34"* 6 kg
795 mm *31.29"* 12.2 kg FX
805 mm *31.69"* 12.2 kg F

30° >

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=46 | R=0.6 | V=6 mm
H=46 | R=1 | V=10 mm
H=1.81 | R=0.024 | V=0.24 in
H=1.81 | R=0.039 | V=0.39 in



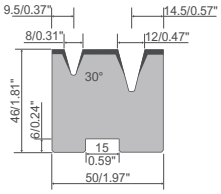


46.18

835 mm *32.87"* 13.2 kg
415 mm *16.34"* 6.6 kg
795 mm *31.29"* 13 kg FX
805 mm *31.69"* 13 kg F

C45: 560-710 N/mm²
400 kN/m max.

30°
H=46 | R=0.8 | V=8 mm
H=46 | R=1.5 | V=12 mm
H=1.81 | R=0.031 | V=0.31 in
H=1.81 | R=0.059 | V=0.47 in



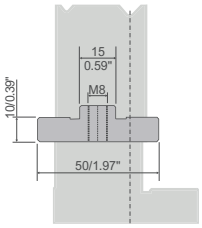
PM50

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

C45: 560-710 N/mm²
1000 kN/m max.

H=15 mm
H=0.59 in

Holder





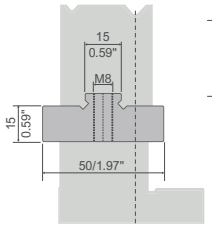
PM50.20

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

C45: 560-710 N/mm²
1000 kN/m max.

H=20 mm
H=0.79 in

Holder



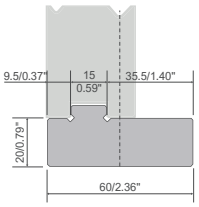
PM60

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

C45: 560-710 N/mm²
1000 kN/m max.

H=25 mm
H=0.98 in

Holder





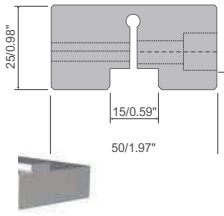
PB60

0.2 kg

Fe37: 370-470 N/mm²

H=25 mm
H=0.98 in

Holder



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



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



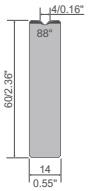
AMR60.04.88

88° >

835 mm	*32.87"*	5.4 kg	
415 mm	*16.34"*	2.7 kg	
795 mm	*31.29"*	5.1 kg	FX
805 mm	*31.69"*	5.2 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=0.6 | V=4 mm
H=2.36 | R=0.024 | V=4 in



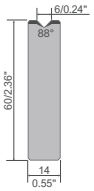


AMR60.06.88

835 mm	*32.87"*	5.4 kg	
415 mm	*16.34"*	2.7 kg	
795 mm	*31.29"*	5.2 kg	FX
805 mm	*31.69"*	5.2 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=0.8 | V=6 mm
H=2.36 | R=0.031 | V=0.24 in

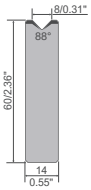


AMR60.08.88

835 mm	*32.87"*	5.4 kg	
415 mm	*16.34"*	2.7 kg	
795 mm	*31.29"*	5.2 kg	FX
805 mm	*31.69"*	5.2 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=1.0 | V=8 mm
H=2.36 | R=0.039 | V=0.31 in



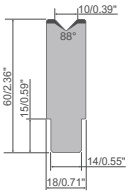


AMR60.10.88

835 mm	*32.87"*	5.6 kg	
415 mm	*16.34"*	2.8 kg	
795 mm	*31.29"*	5.4 kg	FX
805 mm	*31.69"*	5.4 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=1.2 | V=10 mm
H=2.36 | R=0.047 | V=0.39 in

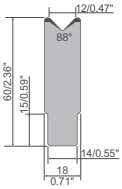


AMR60.12.88

835 mm	*32.87"*	6.1 kg	
415 mm	*16.34"*	3 kg	
795 mm	*31.29"*	5.8 kg	FX
805 mm	*31.69"*	5.9 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=1.5 | V=12 mm
H=2.36 | R=0.059 | V=0.47 in



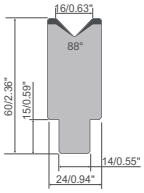


AMR60.16.88

835 mm	*32.87"*	7.1 kg	
415 mm	*16.34"*	3.5 kg	
795 mm	*31.29"*	6.8 kg	FX
805 mm	*31.69"*	6.9 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=2 | V=16 mm
H=2.36 | R=0.079 | V=0.63 in

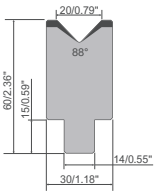


AMR60.20.88

835 mm	*32.87"*	8.0 kg	
415 mm	*16.34"*	4.0 kg	
795 mm	*31.29"*	7.8 kg	FX
805 mm	*31.69"*	7.8 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=2 | V=20 mm
H=2.36 | R=0.079 | V=0.79 in



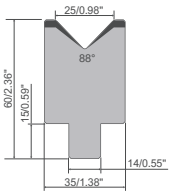


AMR60.25.88

835 mm	*32.87"*	9.1 kg	
415 mm	*16.34"*	4.6 kg	
795 mm	*31.29"*	8.9 kg	FX
805 mm	*31.69"*	8.9 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=60 | R=3 | V=25 mm
H=2.36 | R=0.118 | V=0.98 in



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



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



Scan the QRCode or click on it to check PRICES and AVAILABILITY www.rolleritools.com

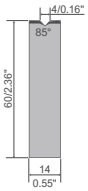
AMR60.04.85

835 mm *32.87"* 5.4 kg
415 mm *16.34"* 2.7 kg
795 mm *31.29"* 5.2 kg FX
805 mm *31.69"* 5.2 kg F

85° >

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=0.6 | V=4 mm
H=2.36 | R=0.024 | V=0.114 in



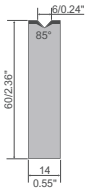


AMR60.06.85

835 mm *32.87"* 5.4 kg
415 mm *16.34"* 2.7 kg
795 mm *31.29"* 5.1 kg FX
805 mm *31.69"* 5.2 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=0.8 | V=6 mm
H=2.36 | R=0.031 | V=0.24 in

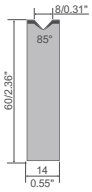


AMR60.08.85

835 mm *32.87"* 5.4 kg
415 mm *16.34"* 2.7 kg
795 mm *31.29"* 5.1 kg FX
805 mm *31.69"* 5.2 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=1 | V=8 mm
H=2.36 | R=0.39 | V=0.31 in



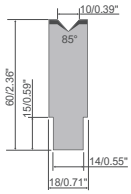


AMR60.10.85

835 mm *32.87"* 5.6 kg
415 mm *16.34"* 2.8 kg
795 mm *31.29"* 5.3 kg FX
805 mm *31.69"* 5.4 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=1.2 | V=10 mm
H=2.36 | R=0.047 | V=0.39 in

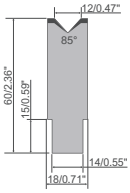


AMR60.12.85

835 mm *32.87"* 6.1 kg
415 mm *16.34"* 3.0 kg
795 mm *31.29"* 5.8 kg FX
805 mm *31.69"* 5.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=1.5 | V=12 mm
H=2.36 | R=0.059 | V=0.47 in



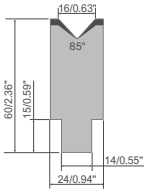


AMR60.16.85

835 mm *32.87"* 7.1 kg
415 mm *16.34"* 3.5 kg
795 mm *31.29"* 6.8 kg FX
805 mm *31.69"* 6.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=2 | V=16 mm
H=2.36 | R=0.079 | V=0.63 in

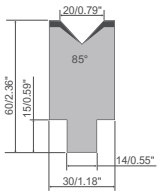


AMR60.20.85

835 mm *32.87"* 8.0 kg
415 mm *16.34"* 4.0 kg
795 mm *31.29"* 7.6 kg FX
805 mm *31.69"* 7.7 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=2 | V=20 mm
H=2.36 | R=0.079 | V=0.79 in



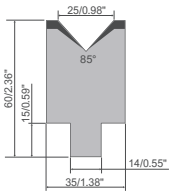


AMR60.25.85

835 mm *32.87"* 9.2 kg
415 mm *16.34"* 4.6 kg
795 mm *31.29"* 8.8 kg FX
805 mm *31.69"* 8.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=3 | V=25 mm
H=2.36 | R=0.118 | V=0.98 in



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



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



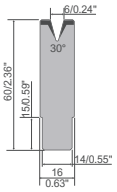
AMR60.06.30

30° >

835 mm	*32.87"*	5.9 kg	
415 mm	*16.34"*	2.9 kg	
795 mm	*31.29"*	5.6 kg	FX
805 mm	*31.69"*	5.7 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=60 | R=0.6 | V=6 mm
H=2.36 | R=0.024 | V=0.24 in



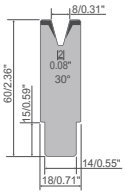


AMR60.08.30

835 mm	*32.87"*	6.6 kg	
415 mm	*16.34"*	3.3 kg	
795 mm	*31.29"*	6.3 kg	FX
805 mm	*31.69"*	6.4 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=60 | R=0.8 | V=8 mm
H=2.36 | R=0.031 | V=0.31 in

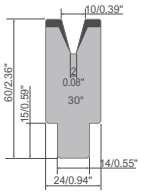


AMR60.10.30

835 mm	*32.87"*	7.8 kg	
415 mm	*16.34"*	3.9 kg	
795 mm	*31.29"*	7.4 kg	FX
805 mm	*31.69"*	7.5 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=60 | R=1 | V=10 mm
H=2.36 | R=0.039 | V=0.39 in



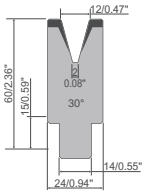


AMR60.12.30

835 mm	*32.87"*	7.8 kg	
415 mm	*16.34"*	3.9 kg	
795 mm	*31.29"*	7.5 kg	FX
805 mm	*31.69"*	7.6 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=60 | R=1.5 | V=12 mm
H=2.36 | R=0.059 | V=0.47 in

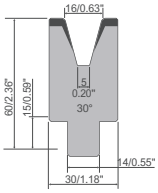


AMR60.16.30

835 mm	*32.87"*	8.8 kg	
415 mm	*16.34"*	4.7 kg	
795 mm	*31.29"*	8.4 kg	FX
805 mm	*31.69"*	9.2 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=60 | R=2 | V=16 mm
H=2.36 | R=0.079 | V=0.63 in



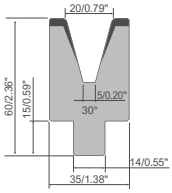


AMR60.20.30

835 mm	*32.87"*	15.9 kg	
415 mm	*16.34"*	7.9 kg	
795 mm	*31.29"*	15.3 kg	FX
805 mm	*31.69"*	15.3 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=60 | R=2.5 | V=20 mm
H=2.36 | R=0.098 | V=0.79 in

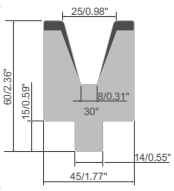


AMR65.25.30

835 mm	*32.87"*	13.0 kg	
415 mm	*16.34"*	6.4 kg	
795 mm	*31.29"*	12.4 kg	FX
805 mm	*31.69"*	12.2 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

30°
H=60 | R=3 | V=25 mm
H=2.36 | R=0.118 | V=0.98 in





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



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



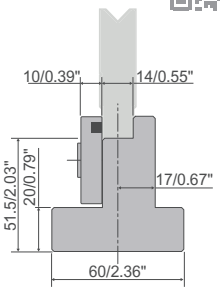
SU61F

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

C45: 560-710 N/mm²
1000 kN/m max.

H=61.5 mm
H=2.42 in

Holder





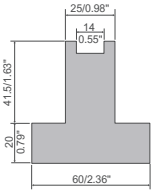
08000

1050 mm *41.34"* 14.0 kg

C45: 560-710 N/mm²
950 kN/m max.

H=61.5 mm
H=2.42 in

Holder





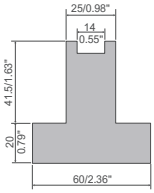
08100

1260 mm *49.61"* 14.0 kg

C45: 560-710 N/mm²
950 kN/m max.

H=61.5 mm
H=2.42 in

Holder



T dies CLASSIC series

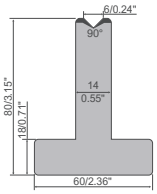
T80.06.90

835 mm *32.87"* 13.0 kg
415 mm *16.34"* 6.5 kg
795 mm *31.29"* 12.4 kg FX
805 mm *31.69"* 12.5 kg F
900 mm *35.43"* 14.0 kg

90° >

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=80 | R=0.4 | V=6 mm
H=3.15 | R=0.01 | V=0.24 in



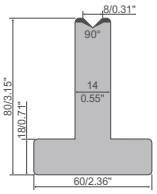


T80.08.90

835 mm *32.87"* 13.0 kg
415 mm *16.34"* 6.5 kg
795 mm *31.29"* 12.4 kg FX
805 mm *31.69"* 12.5 kg F
900 mm *35.43"* 14.0 kg

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=80 | R=0.5 | V=8 mm
H=3.15 | R=0.02 | V=0.31 in

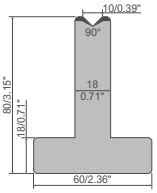


T80.10.90

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

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=80 | R=0.6 | V=10 mm
H=3.15 | R=0.02 | V=0.39 in



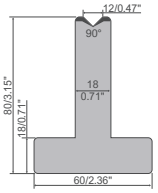


T80.12.90

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 7.0kg
795 mm *31.29"* 13.3 kg FX
805 mm *31.69"* 13.5 kg F

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=80 | R=0.8 | V=12 mm
H=3.15 | R=0.03 | V=0.47 in



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



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

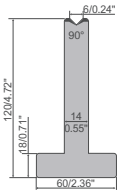


T120.06.90

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

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=120 | R=0.4 | V=6 mm
H=4.72 | R=0.01 | V=0.24 in



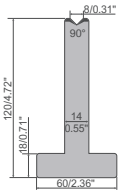


T120.08.90

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

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=120 | R=0.5 | V=8 mm
H=4.72 | R=0.02 | V=0.31 in

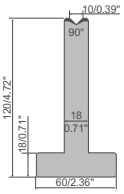


T120.10.90

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.1 kg FX
805 mm *31.69"* 18.3 kg F

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=120 | R=0.6 | V=10 mm
H=4.72 | R=0.02 | V=0.39 in



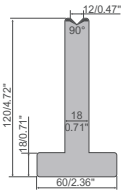


T120.12.90

835 mm *32.87"* 18.9 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.0 kg FX
805 mm *31.69"* 18.2 kg F

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=120 | R=0.8 | V=12 mm
H=4.72 | R=0.03 | V=0.47 in



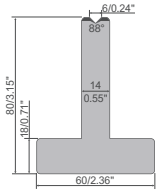
T80.06.88

88° >

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=0.4 | V=6 mm
H=3.15 | R=0.01 | V=0.24 in



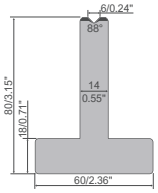


TR80.06.88

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=2.75 | V=6 mm
H=3.15 | R=0.11 | V=0.24 in

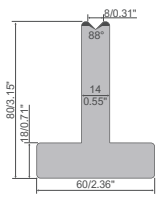


T80.08.88

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=0.5 | V=8 mm
H=3.15 | R=0.02 | V=0.31 in



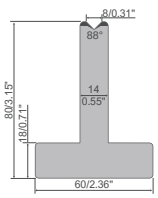


TR80.08.88

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=2.75 | V=8 mm
H=3.15 | R=0.11 | V=0.31 in



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



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

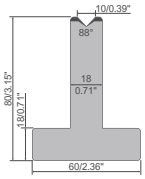


T80.10.88

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=0.8 | V=10 mm
H=3.15 | R=0.03 | V=0.39 in



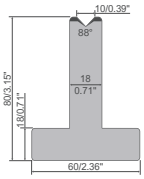


TR80.10.88

835 mm *32.87"* 15 kg
415 mm *16.34"* 7.5 kg
795 mm *31.29"* 15 kg FX
805 mm *31.69"* 15 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=2.75 | V=10 mm
H=3.15 | R=0.11 | V=0.39 in

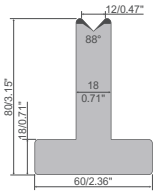


T80.12.88

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 7.0 kg
795 mm *31.29"* 13.3 kg FX
805 mm *31.69"* 13.5 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=2.75 | V=12 mm
H=3.15 | R=0.108 | V=0.47 in



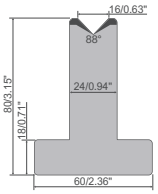


T80.16.88

835 mm *32.87"* 16.6 kg
415 mm *16.34"* 8.3 kg
795 mm *31.29"* 15.8 kg FX
805 mm *31.69"* 16.0 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=2.75 | V=16 mm
H=3.15 | R=0.108 | V=0.63 in

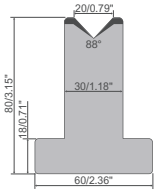


T80.20.88

835 mm *32.87"* 18.5 kg
415 mm *16.34"* 9.2 kg
795 mm *31.29"* 17.6 kg FX
805 mm *31.69"* 17.8 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=3 | V=20 mm
H=3.15 | R=0.118 | V=0.78 in



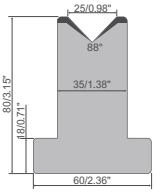


T80.25.88

835 mm *32.87"* 20.2 kg
415 mm *16.34"* 10.0 kg
795 mm *31.29"* 19.2 kg FX
805 mm *31.69"* 19.5 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.118 | V=0.98 in

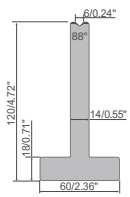


T120.06.88

835 mm *32.87"* 16.5 kg
415 mm *16.34"* 8.2 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=0.4 | V=6 mm
H=4.72 | R=0.01 | V=0.24 in



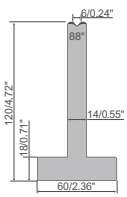


TR120.06.88

835 mm *32.87"* 16 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 16 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=2.75 | V=6 mm
H=4.72 | R=0.11 | V=0.24 in



Bent sheet metal often shows two lines in the contact area with die. This is the consequence of friction between sheet metal and too small die radius. To avoid such bending marks you can use TR dies with bigger radius (we can also modify your dies) with ROLFILM

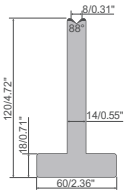
Click on the QRCode or scan it to watch the video and discover more about TR dies.

T120.08.88

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=0.5 | V=8 mm
H=4.72 | R=0.02 | V=0.31 in



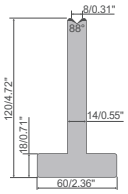


TR120.08.88

835 mm *32.87"* 16 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 16 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=2.75 | V=8 mm
H=4.72 | R=0.11 | V=0.31 in

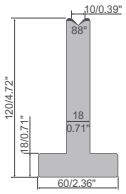


T120.10.88

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.1 kg FX
805 mm *31.69"* 18.3 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=0.8 | V=10 mm
H=4.72 | R=0.03 | V=0.39 in



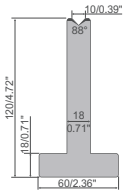


TR120.10.88

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=2.75 | V=10 mm
H=4.72 | R=0.11 | V=0.39 in

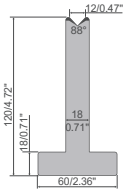


T120.12.88

835 mm *32.87"* 18.9 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.0 kg FX
805 mm *31.69"* 18.2 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=2.75 | V=12 mm
H=4.72 | R=0.11 | V=0.47 in



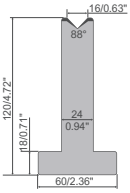


T120.16.88

835 mm *32.87"* 22.0 kg
415 mm *16.34"* 10.9 kg
795 mm *31.29"* 20.9 kg FX
805 mm *31.69"* 21.2 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=2.75 | V=16 mm
H=4.72 | R=0.11 | V=0.63 in

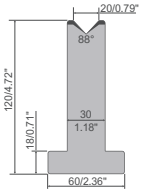


T120.20.88

835 mm *32.87"* 27.0 kg
415 mm *16.34"* 13.4 kg
795 mm *31.29"* 25.7 kg FX
805 mm *31.69"* 26.0 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=3 | V=20 mm
H=4.72 | R=0.118 | V=0.79 in



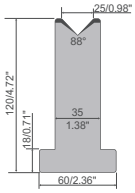


T120.25.88

835 mm *32.87"* 30.0 kg
415 mm *16.34"* 14.9 kg
795 mm *31.29"* 28.6 kg FX
805 mm *31.69"* 28.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=120 | R=3 | V=25 mm
H=4.72 | R=0.118 | V=0.98 in



Bent sheet metal often shows two lines in the contact area with die. This is the consequence of friction between sheet metal and too small die radius. To avoid such bending marks you can use TR dies with bigger radius (we can also modify your dies) with ROLFILM

Click on the QRCode or scan it to watch the video and discover more about TR dies.

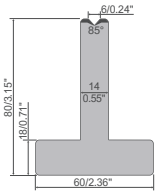
T80.06.85

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

85° >

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=80 | R=2.75 | V=6 mm
H=3.15 | R=0.108 | V=0.24 in



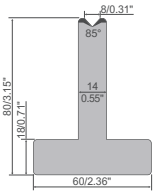


T80.08.85

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

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=80 | R=2.75 | V=8 mm
H=3.15 | R=0.108 | V=0.31 in

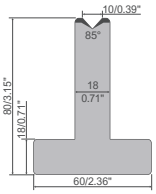


T80.10.85

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

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=80 | R=2.75 | V=10 mm
H=3.15 | R=0.108 | V=0.39 in



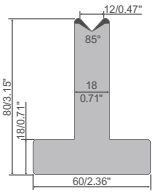


T80.12.85

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 7 kg
795 mm *31.29"* 13.3 kg FX
805 mm *31.69"* 13.5 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=80 | R=2.75 | V=12 mm
H=3.15 | R=0.108 | V=0.47 in

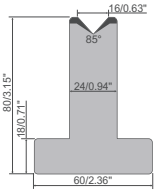


T80.16.85

835 mm *32.87"* 16.6 kg
415 mm *16.34"* 8.3 kg
795 mm *31.29"* 15.8 kg FX
805 mm *31.69"* 16.0 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=80 | R=2.75 | V=16 mm
H=3.15 | R=0.108 | V=0.63 in



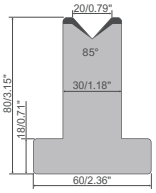


T80.20.85

835 mm *32.87"* 18.5 kg
415 mm *16.34"* 9.2 kg
795 mm *31.29"* 17.6 kg FX
805 mm *31.69"* 17.8 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=80 | R=3 | V=20 mm
H=3.15 | R=0.118 | V=0.78 in

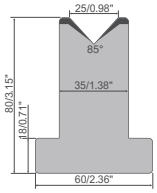


T80.25.85

835 mm *32.87"* 20.2 kg
415 mm *16.34"* 10.0 kg
795 mm *31.29"* 19.2 kg FX
805 mm *31.69"* 19.5 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.118 | V=0.98 in





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



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

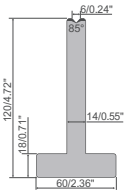


T120.06.85

835 mm *32.87"* 16.3 kg
415 mm *16.34"* 8.1 kg
795 mm *31.29"* 15.7 kg FX
805 mm *31.69"* 15.7 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=120 | R=2.75 | V=6 mm
H=4.72 | R=0.108 | V=0.24 in



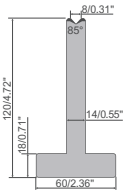


T120.08.85

835 mm *32.87"* 16.3 kg
415 mm *16.34"* 8.1 kg
795 mm *31.29"* 15.7 kg FX
805 mm *31.69"* 15.7 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=120 | R=2.75 | V=8 mm
H=4.72 | R=0.108 | V=0.31 in

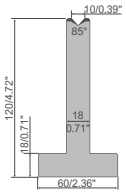


T120.10.85

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.5.0 kg
795 mm *31.29"* 19.0 kg FX
805 mm *31.69"* 19.0 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=120 | R=2.75 | V=10 mm
H=4.72 | R=0.108 | V=0.39 in



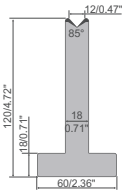


T120.12.85

835 mm *32.87"* 18.9 kg
415 mm *16.34"* 9.4.0 kg
795 mm *31.29"* 18.2 kg FX
805 mm *31.69"* 18.2 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=120 | R=2.75 | V=12 mm
H=4.72 | R=0.108 | V=0.47 in

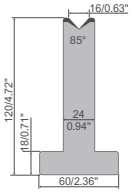


T120.16.85

835 mm *32.87"* 22.7 kg
415 mm *16.34"* 11.3 kg
795 mm *31.29"* 21.9 kg FX
805 mm *31.69"* 21.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=120 | R=2.75 | V=16 mm
H=4.72 | R=0.108 | V=0.63 in



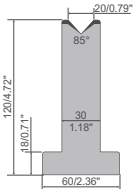


T120.20.85

835 mm *32.87"* 26.4 kg
415 mm *16.34"* 13 kg
795 mm *31.29"* 25.5 kg FX
805 mm *31.69"* 25.5 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=120 | R=3 | V=20 mm
H=4.72 | R=0.118 | V=0.79 in

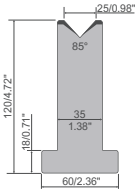


T120.25.85

835 mm *32.87"* 30 kg
415 mm *16.34"* 15 kg
795 mm *31.29"* 30 kg FX
805 mm *31.69"* 30 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=120 | R=3 | V=25 mm
H=4.72 | R=0.118 | V=0.98 in





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



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



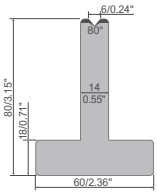
T80.06.80

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

80° >

C45: 560-710 N/mm²
950 kN/m max.

80°
H=80 | R=2.75 | V=6 mm
H=3.15 | R=0.108 | V=0.24 in



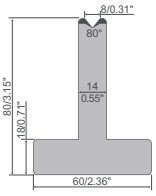


T80.08.80

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

C45: 560-710 N/mm²
950 kN/m max.

80°
H=80 | R=2.75 | V=8 mm
H=3.15 | R=0.108 | V=0.31 in

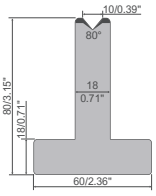


T80.10.80

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

C45: 560-710 N/mm²
950 kN/m max.

80°
H=80 | R=2.75 | V=10 mm
H=3.15 | R=0.108 | V=0.39 in



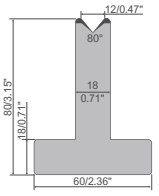


T80.12.80

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 7.0 kg
795 mm *31.29"* 13.3 kg FX
805 mm *31.69"* 13.5 kg F

C45: 560-710 N/mm²
950 kN/m max.

80°
H=80 | R=2.75 | V=12 mm
H=3.15 | R=0.108 | V=0.47 in

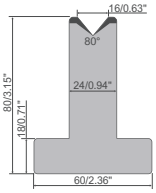


T80.16.80

835 mm 32.87" 16.6 kg
415 mm 16.34" 8.3 kg
795 mm 31.29" 15.8 kg FX
805 mm 31.69" 16.0 kg F

C45: 560-710 N/mm²
950 kN/m max.

80°
H=80 | R=2.75 | V=16 mm
H=3.15 | R=0.108 | V=0.63 in



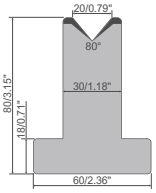


T80.20.80

835 mm 32.87" 18.5 kg
415 mm 16.34" 9.2 kg
795 mm 31.29" 17.6 kg FX
805 mm 31.69" 17.8 kg F

C45: 560-710 N/mm²
950 kN/m max.

80°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.118 | V=0.98 in

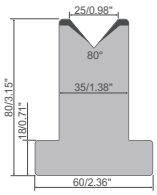


T80.25.80

835 mm 32.87" 20.2 kg
415 mm 16.34" 10.0 kg
795 mm 31.29" 19.2 kg FX
805 mm 31.69" 19.5 kg F

C45: 560-710 N/mm²
1000 kN/m max.

80°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.118 | V=0.98 in





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



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

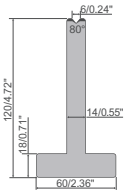


T120.06.80

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

C45: 560-710 N/mm²
950 kN/m max.

80°
H=120 | R=2.75 | V=6 mm
H=4.72 | R=0.108 | V=0.24 in



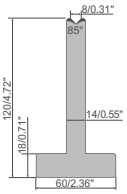


T120.08.80

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

C45: 560-710 N/mm²
1000 kN/m max.

80°
H=120 | R=2.75 | V=8 mm
H=4.72 | R=0.108 | V=0.31 in

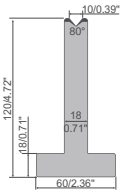


T120.10.80

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.1 kg FX
805 mm *31.69"* 18.3 kg F

C45: 560-710 N/mm²
950 kN/m max.

80°
H=120 | R=2.75 | V=10 mm
H=4.72 | R=0.108 | V=0.39 in



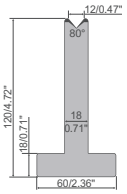


T120.12.80

835 mm *32.87"* 18.9 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.0 kg FX
805 mm *31.69"* 18.2 kg F

C45: 560-710 N/mm²
950 kN/m max.

80°
H=120 | R=2.75 | V=12 mm
H=4.72 | R=0.108 | V=0.47 in

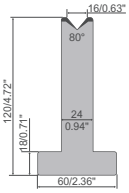


T120.16.80

835 mm *32.87"* 22.0 kg
415 mm *16.34"* 10.9 kg
795 mm *31.29"* 20.9 kg FX
805 mm *31.69"* 21.2 kg F

C45: 560-710 N/mm²
950 kN/m max.

80°
H=120 | R=2.75 | V=16 mm
H=4.72 | R=0.108 | V=0.63 in



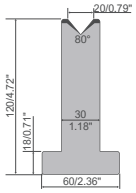


T120.20.80

835 mm *32.87"* 27.0 kg
415 mm *16.34"* 13.4 kg
795 mm *31.29"* 25.7 kg FX
805 mm *31.69"* 26.0 kg F

C45: 560-710 N/mm²
950 kN/m max.

80°
H=120 | R=3 | V=20 mm
H=4.72 | R=0.118 | V=0.79 in

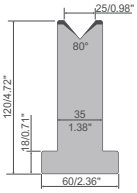


T120.25.80

835 mm *32.87"* 30.0 kg
415 mm *16.34"* 14.9 kg
795 mm *31.29"* 28.6 kg FX
805 mm *31.69"* 28.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

80°
H=120 | R=3 | V=25 mm
H=4.72 | R=0.118 | V=0.98 in





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



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



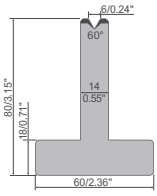
T80.06.60

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

60° >

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=0.5 | V=6 mm
H=3.15 | R=0.02 | V=0.24 in



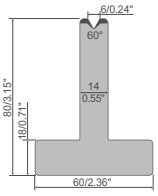


TR80.06.60

835 mm *32.87"* 13 kg
415 mm *16.34"* 6.5 kg
795 mm *31.29"* 13 kg FX
805 mm *31.69"* 13 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=1.5 | V=6 mm
H=3.15 | R=0.06 | V=0.24 in

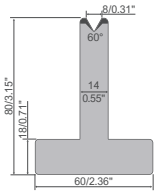


T80.08.60

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

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=0.8 | V=8 mm
H=3.15 | R=0.03 | V=0.31 in



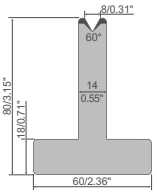


TR80.08.60

835 mm *32.87"* 13 kg
415 mm *16.34"* 6.5 kg
795 mm *31.29"* 13 kg FX
805 mm *31.69"* 13 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=1.5 | V=8 mm
H=3.15 | R=0.06 | V=0.31 in

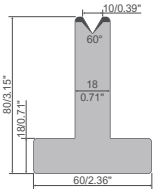


T80.10.60

835 mm *32.87"* 14.9 kg
415 mm *16.34"* 7.4 kg
795 mm *31.29"* 14.2 kg FX
805 mm *31.69"* 14.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=0.8 | V=10 mm
H=3.15 | R=0.031 | V=0.39 in



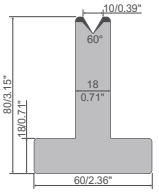


TR80.10.60

835 mm *32.87"* 15 kg
415 mm *16.34"* 7.5 kg
795 mm *31.29"* 15 kg FX
805 mm *31.69"* 15 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=2.75 | V=10 mm
H=3.15 | R=0.108 | V=0.39 in

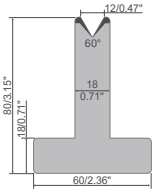


T80.12.60

835 mm *32.87"* 14.9 kg
415 mm *16.34"* 7.4 kg
795 mm *31.29"* 14.2 kg FX
805 mm *31.69"* 14.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=0.8 | V=12 mm
H=3.15 | R=0.031 | V=0.47 in



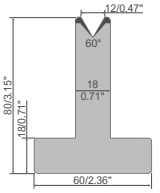


TR80.12.60

835 mm *32.87"* 15 kg
415 mm *16.34"* 7.5 kg
795 mm *31.29"* 15 kg FX
805 mm *31.69"* 15 kg F

C45: 560-710 N/mm²
1000 kN/m max.

60°
H=80 | R=2.75 | V=12 mm
H=3.15 | R=0.11 | V=0.47 in



Bent sheet metal often shows two lines in the contact area with die. This is the consequence of friction between sheet metal and too small die radius. To avoid such bending marks you can use TR dies with bigger radius (we can also modify your dies) with ROLFILM

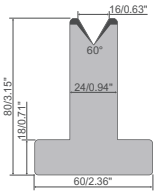
Click on the QRCode or scan it to watch the video and discover more about TR dies.

T80.16.60

835 mm *32.87"* 16.1 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.3 kg FX
805 mm *31.69"* 15.5 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=2.75 | V=16 mm
H=3.15 | R=0.108 | V=0.63 in



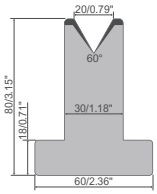


T80.20.60

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=3 | V=20 mm
H=3.15 | R=0.118 | V=0.79 in

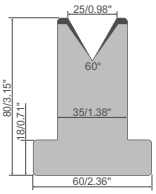


T80.25.60

835 mm *32.87"* 19.5 kg
415 mm *16.34"* 9.7 kg
795 mm *31.29"* 18.6 kg FX
805 mm *31.69"* 18.8 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.118 | V=0.98 in



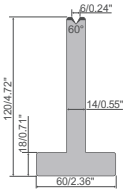


T120.06.60

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=0.5 | V=6 mm
H=4.72 | R=0.02 | V=0.24 in



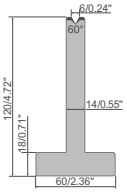


TR120.06.60

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=1.5 | V=6 mm
H=4.72 | R=0.06 | V=0.24 in

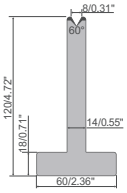


T120.08.60

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=0.8 | V=8 mm
H=4.72 | R=0.031 | V=0.31 in



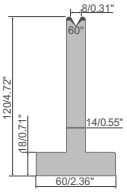


TR120.08.60

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=1.5 | V=8 mm
H=4.72 | R=0.06 | V=0.31 in



Bent sheet metal often shows two lines in the contact area with die. This is the consequence of friction between sheet metal and too small die radius. To avoid such bending marks you can use TR dies with bigger radius (we can also modify your dies) with ROLFILM

Click on the QRCode or scan it to watch the video and discover more about TR dies.

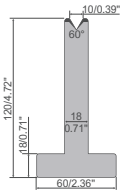
Scan the QRCode or click on it to check PRICES and AVAILABILITY www.rolleritools.com

T120.10.60

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=0.8 | V=10 mm
H=4.72 | R=0.031 | V=0.39 in



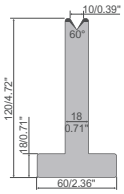


TR120.10.60

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=2.75 | V=10 mm
H=4.72 | R=0.108 | V=0.39 in

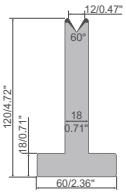


T120.12.60

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=0.8 | V=12 mm
H=4.72 | R=0.03 | V=0.47 in



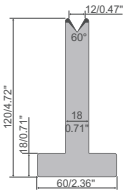


TR120.12.60

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=2.75 | V=12 mm
H=4.72 | R=0.108 | V=0.47 in

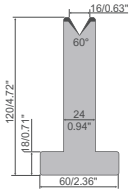


T120.16.60

835 mm *32.87"* 22.4 kg
415 mm *16.34"* 11.1 kg
795 mm *31.29"* 21.3 kg FX
805 mm *31.69"* 21.6 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=2.75 | V=16 mm
H=4.72 | R=0.108 | V=0.63 in



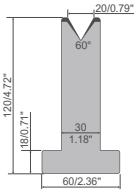


T120.20.60

835 mm *32.87"* 26.0 kg
415 mm *16.34"* 12.9 kg
795 mm *31.29"* 24.8 kg FX
805 mm *31.69"* 25.1 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=3 | V=20 mm
H=4.72 | R=0.118 | V=0.79 in

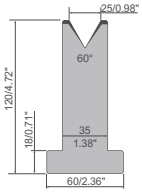


T120.25.60

835 mm *32.87"* 28.5 kg
415 mm *16.34"* 14.2 kg
795 mm *31.29"* 27.1 kg FX
805 mm *31.69"* 27.5 kg F

C45: 560-710 N/mm²
600 kN/m max.

60°
H=120 | R=3 | V=25 mm
H=4.72 | R=0.118 | V=0.98 in





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



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



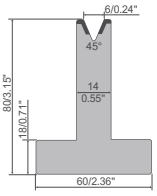
T80.06.45

835 mm *32.87"* 12.6 kg
415 mm *16.34"* 6.3 kg
795 mm *31.29"* 12.0 kg FX
805 mm *31.69"* 12.1 kg F

45° >

C45: 560-710 N/mm²
500 kN/m max.

45°
H=80 | R=0.8 | V=6 mm
H=3.15 | R=0.03 | V=0.24 in



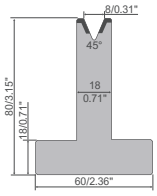


T80.08.45

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

C45: 560-710 N/mm²
500 kN/m max.

45°
H=80 | R=1.0 | V=8 mm
H=3.15 | R=0.04 | V=0.31 in

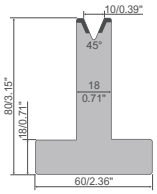


T80.10.45

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 7.0 kg
795 mm *31.29"* 13.3 kg FX
805 mm *31.69"* 13.5 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=80 | R=1.2 | V=8 mm
H=3.15 | R=0.04 | V=0.31 in



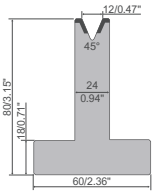


T80.12.45

835 mm *32.87"* 16.2 kg
415 mm *16.34"* 8.1 kg
795 mm *31.29"* 15.4 kg FX
805 mm *31.69"* 15.6 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=80 | R=1.6 | V=12 mm
H=3.15 | R=0.06 | V=0.47 in

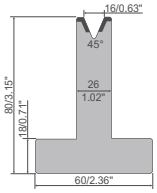


T80.16.45

835 mm *32.87"* 16.6 kg
415 mm *16.34"* 8.3 kg
795 mm *31.29"* 15.8 kg FX
805 mm *31.69"* 16.0 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=80 | R=2.75 | V=16 mm
H=3.15 | R=0.11 | V=0.63 in



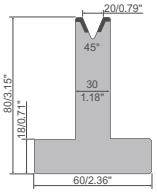


T80.20.45

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=80 | R=3 | V=20 mm
H=3.15 | R=0.12 | V=0.79 in

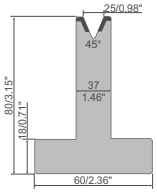


T80.25.45

835 mm *32.87"* 20.0 kg
415 mm *16.34"* 9.9 kg
795 mm *31.29"* 19.0 kg FX
805 mm *31.69"* 19.3 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.12 | V=0.98 in





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



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

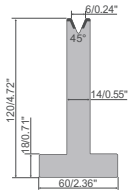


T120.06.45

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=120 | R=0.8 | V=6 mm
H=4.72 | R=0.03 | V=0.24 in



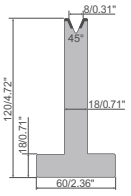


T120.08.45

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=120 | R=1 | V=8 mm
H=4.72 | R=0.04 | V=0.31 in

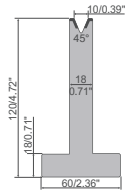


T120.10.45

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=120 | R=1.2 | V=10 mm
H=4.72 | R=0.05 | V=0.39 in



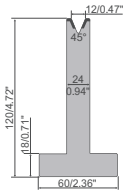


T120.12.45

835 mm *32.87"* 22.9 kg
415 mm *16.34"* 11.4 kg
795 mm *31.29"* 21.8 kg FX
805 mm *31.69"* 22.1 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=120 | R=1.6 | V=12 mm
H=4.72 | R=0.06 | V=0.47 in

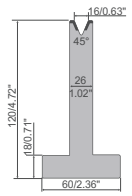


T120.16.45

835 mm *32.87"* 25.0 kg
415 mm *16.34"* 12.4 kg
795 mm *31.29"* 23.8 kg FX
805 mm *31.69"* 24.1 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=120 | R=2.75 | V=16 mm
H=4.72 | R=0.11 | V=0.63 in



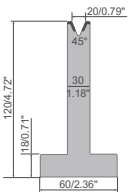


T120.20.45

835 mm *32.87"* 26.0 kg
415 mm *16.34"* 12.9 kg
795 mm *31.29"* 24.8 kg FX
805 mm *31.69"* 25.1 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=120 | R=3 | V=20 mm
H=4.72 | R=0.12 | V=0.79 in

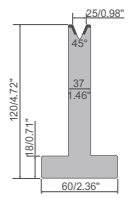


T120.25.45

835 mm *32.87"* 30.0 kg
415 mm *16.34"* 14.9 kg
795 mm *31.29"* 28.6 kg FX
805 mm *31.69"* 28.9 kg F

C45: 560-710 N/mm²
500 kN/m max.

45°
H=120 | R=3 | V=25 mm
H=4.72 | R=0.12 | V=0.98 in





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



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



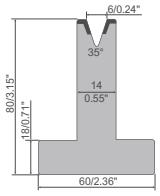
T80.06.35

835 mm *32.87"* 12.5 kg
415 mm *16.34"* 6.2 kg
795 mm *31.29"* 11.9 kg FX
805 mm *31.69"* 12.1 kg F

35° >

C45: 560-710 N/mm²
350 kN/m max.

35°
H=80 | R=0.8 | V=6 mm
H=3.15 | R=0.03 | V=0.24 in



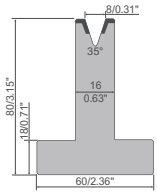


T80.08.35

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

C45: 560-710 N/mm²
350 kN/m max.

35°
H=80 | R=1 | V=8 mm
H=3.15 | R=0.04 | V=0.31 in

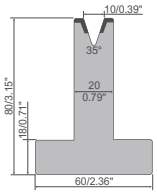


T80.10.35

835 mm *32.87"* 14.7 kg
415 mm *16.34"* 7.3 kg
795 mm *31.29"* 14.0 kg FX
805 mm *31.69"* 14.2 kg F

C45: 560-710 N/mm²
400 kN/m max.

35°
H=80 | R=1.2 | V=10 mm
H=3.15 | R=0.05 | V=0.39 in



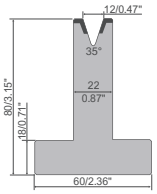


T80.12.35

835 mm *32.87"* 15.5 kg
415 mm *16.34"* 7.7 kg
795 mm *31.29"* 14.8 kg FX
805 mm *31.69"* 14.9 kg F

C45: 560-710 N/mm²
400 kN/m max.

35°
H=80 | R=1.6 | V=12 mm
H=3.15 | R=0.06 | V=0.47 in

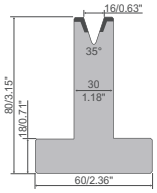


T80.16.35

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
450 kN/m max.

35°
H=80 | R=3 | V=16 mm
H=3.15 | R=0.12 | V=0.63 in



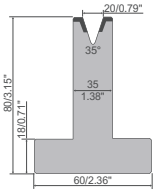


T80.20.35

835 mm *32.87"* 19.3 kg
415 mm *16.34"* 9.6 kg
795 mm *31.29"* 18.4 kg FX
805 mm *31.69"* 18.6 kg F

C45: 560-710 N/mm²
500 kN/m max.

35°
H=80 | R=3 | V=20 mm
H=3.15 | R=0.12 | V=0.79 in

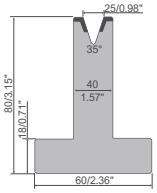


T80.25.35

835 mm *32.87"* 20.0 kg
415 mm *16.34"* 9.0 kg
795 mm *31.29"* 19.0 kg FX
805 mm *31.69"* 19.3 kg F

C45: 560-710 N/mm²
500 kN/m max.

35°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.12 | V=0.98 in





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



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

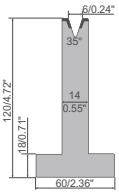


T120.06.35

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
350 kN/m max.

35°
H=120 | R=0.8 | V=6 mm
H=4.72 | R=0.03 | V=0.24 in



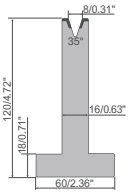


T120.08.35

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
350 kN/m max.

35°
H=120 | R=1.0 | V=8 mm
H=4.72 | R=0.04 | V=0.31 in

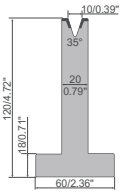


T120.10.35

835 mm *32.87"* 19.9 kg
415 mm *16.34"* 9.9 kg
795 mm *31.29"* 18.9 kg FX
805 mm *31.69"* 19.2 kg F

C45: 560-710 N/mm²
400 kN/m max.

35°
H=120 | R=1.2 | V=10 mm
H=4.72 | R=0.05 | V=0.39 in



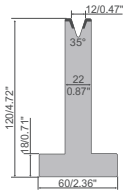


T120.12.35

835 mm *32.87"* 21.0 kg
415 mm *16.34"* 10.4 kg
795 mm *31.29"* 20.0 kg FX
805 mm *31.69"* 20.2 kg F

C45: 560-710 N/mm²
400 kN/m max.

35°
H=120 | R=1.6 | V=12 mm
H=4.72 | R=0.06 | V=0.47 in

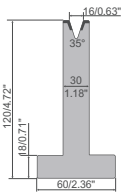


T120.16.35

835 mm *32.87"* 25.8 kg
415 mm *16.34"* 12.8 kg
795 mm *31.29"* 24.6 kg FX
805 mm *31.69"* 24.9 kg F

C45: 560-710 N/mm²
450 kN/m max.

35°
H=120 | R=3 | V=16 mm
H=4.72 | R=0.12 | V=0.63 in



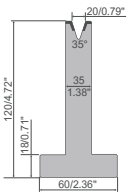


T120.20.35

835 mm *32.87"* 28.0 kg
415 mm *16.34"* 13.9 kg
795 mm *31.29"* 26.7 kg FX
805 mm *31.69"* 27.0 kg F

C45: 560-710 N/mm²
500 kN/m max.

35°
H=120 | R=3 | V=20 mm
H=4.72 | R=0.12 | V=0.79 in

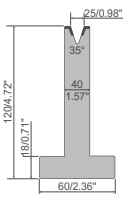


T120.25.35

835 mm *32.87"* 30.5 kg
415 mm *16.34"* 15.2 kg
795 mm *31.29"* 29.0 kg FX
805 mm *31.69"* 29.4 kg F

C45: 560-710 N/mm²
500 kN/m max.

35°
H=120 | R=3 | V=25 mm
H=4.72 | R=0.12 | V=0.98 in





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



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



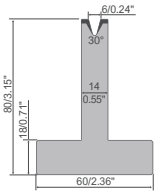
T80.06.30

835 mm *32.87"* 12.4 kg
415 mm *16.34"* 6.2 kg
795 mm *31.29"* 11.8 kg FX
805 mm *31.69"* 12.0 kg F

30° >

C45: 560-710 N/mm²
350 kN/m max.

30°
H=80 | R=0.6 | V=6 mm
H=3.15 | R=0.024 | V=0.24 in



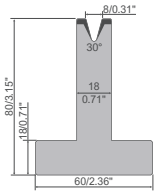


T80.08.30

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

C45: 560-710 N/mm²
350 kN/m max.

30°
H=80 | R=0.8 | V=8 mm
H=3.15 | R=0.031 | V=0.31 in

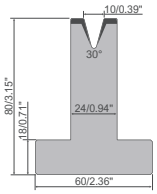


T80.10.30

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
500 kN/m max.

30°
H=80 | R=1 | V=10 mm
H=3.15 | R=0.039 | V=0.39 in



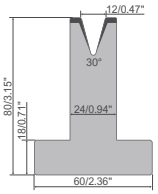


T80.12.30

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
400 kN/m max.

30°
H=80 | R=1.5 | V=12 mm
H=3.15 | R=0.059 | V=0.47 in

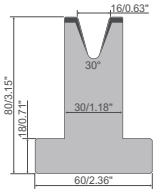


T80.16.30

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
450 kN/m max.

30°
H=80 | R=2 | V=16 mm
H=3.15 | R=0.079 | V=0.63 in



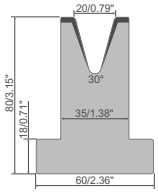


T80.20.30

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.1 kg FX
805 mm *31.69"* 18.3 kg F

C45: 560-710 N/mm²
500 kN/m max.

30°
H=80 | R=2.5 | V=20 mm
H=3.15 | R=0.098 | V=0.79 in

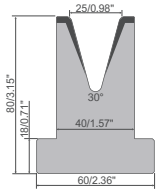


T80.25.30

835 mm *32.87"* 19.6 kg
415 mm *16.34"* 9.7 kg
795 mm *31.29"* 18.7 kg FX
805 mm *31.69"* 18.9 kg F

C45: 560-710 N/mm²
500 kN/m max.

30°
H=80 | R=3 | V=25 mm
H=3.15 | R=0.12 | V=0.98 in





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



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

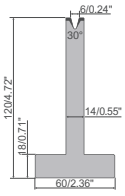


T120.06.30

835 mm *32.87"* 16.0 kg
415 mm *16.34"* 8.0 kg
795 mm *31.29"* 15.2 kg FX
805 mm *31.69"* 15.4 kg F

C45: 560-710 N/mm²
350 kN/m max.

30°
H=120 | R=0.6 | V=6 mm
H=4.72 | R=0.024 | V=0.24 in



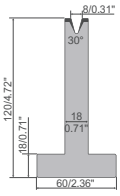


T120.08.30

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.1 kg FX
805 mm *31.69"* 18.3 kg F

C45: 560-710 N/mm²
350 kN/m max.

30°
H=120 | R=0.8 | V=8 mm
H=4.72 | R=0.031 | V=0.31 in

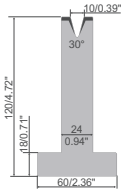


T120.10.30

835 mm *32.87"* 22.0 kg
415 mm *16.34"* 10.9 kg
795 mm *31.29"* 20.9 kg FX
805 mm *31.69"* 21.2 kg F

C45: 560-710 N/mm²
500 kN/m max.

30°
H=120 | R=1 | V=10 mm
H=4.72 | R=0.039 | V=0.39 in



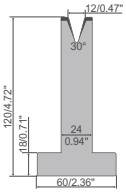


T120.12.30

835 mm *32.87"* 22.0 kg
415 mm *16.34"* 10.9 kg
795 mm *31.29"* 20.9 kg FX
805 mm *31.69"* 21.2 kg F

C45: 560-710 N/mm²
400 kN/m max.

30°
H=120 | R=1.5 | V=12 mm
H=4.72 | R=0.024 | V=0.47 in

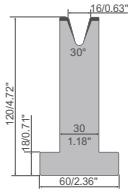


T120.16.30

835 mm *32.87"* 25.8 kg
415 mm *16.34"* 12.8 kg
795 mm *31.29"* 24.6 kg FX
805 mm *31.69"* 24.9 kg F

C45: 560-710 N/mm²
450 kN/m max.

30°
H=120 | R=2 | V=16 mm
H=4.72 | R=0.079 | V=0.63 in



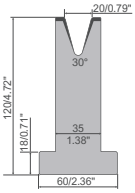


T120.20.30

835 mm *32.87"* 28.0 kg
415 mm *16.34"* 13.9 kg
795 mm *31.29"* 26.7 kg FX
805 mm *31.69"* 27.0 kg F

C45: 560-710 N/mm²
500 kN/m max.

30°
H=120 | R=2.5 | V=20 mm
H=4.72 | R=0.098 | V=0.79 in

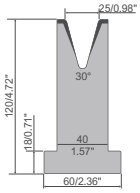


T120.25.30

835 mm *32.87"* 30.5 kg
415 mm *16.34"* 15.2 kg
795 mm *31.29"* 29.0 kg FX
805 mm *31.69"* 29.4 kg F

C45: 560-710 N/mm²
500 kN/m max.

30°
H=120 | R=3 | V=25 mm
H=4.72 | R=0.118 | V=0.98 in





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



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



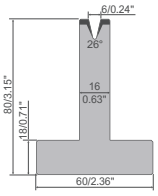
T80.06.26

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 7.0 kg
795 mm *31.29"* 13.3 kg FX
805 mm *31.69"* 13.5 kg F

26° >

C45: 560-710 N/mm²
200 kN/m max.

26°
H=80 | R=0.8 | V=6 mm
H=3.15 | R=0.031 | V=0.24 in



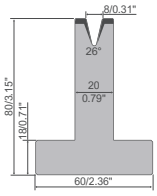


T80.08.26

835 mm *32.87"* 15.0 kg
415 mm *16.34"* 7.5 kg
795 mm *31.29"* 14.3 kg FX
805 mm *31.69"* 14.5 kg F

C45: 560-710 N/mm²
200 kN/m max.

26°
H=80 | R=1 | V=8 mm
H=3.15 | R=0.039 | V=0.31 in

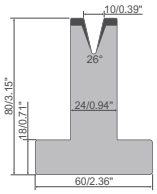


T80.10.26

835 mm *32.87"* 15.5 kg
415 mm *16.34"* 7.7 kg
795 mm *31.29"* 14.8 kg FX
805 mm *31.69"* 14.9 kg F

C45: 560-710 N/mm²
200 kN/m max.

26°
H=80 | R=1.2 | V=10 mm
H=3.15 | R=0.047 | V=0.39 in



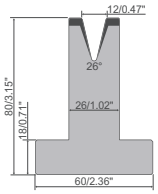


T80.12.26

835 mm *32.87"* 16.6 kg
415 mm *16.34"* 8.3 kg
795 mm *31.29"* 15.8 kg FX
805 mm *31.69"* 16.0 kg F

C45: 560-710 N/mm²
200 kN/m max.

26°
H=80 | R=1.6 | V=12 mm
H=3.15 | R=0.063 | V=0.47 in

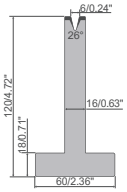


T120.06.26

835 mm *32.87"* 18.0 kg
415 mm *16.34"* 8.9 kg
795 mm *31.29"* 17.1 kg FX
805 mm *31.69"* 17.4 kg F

C45: 560-710 N/mm²
200 kN/m max.

26°
H=120 | R=0.8 | V=6 mm
H=4.72 | R=0.031 | V=0.24 in



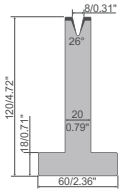


T120.08.26

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.4 kg
795 mm *31.29"* 18.1 kg FX
805 mm *31.69"* 18.3 kg F

C45: 560-710 N/mm²
200 kN/m max.

26°
H=120 | R=1 | V=8 mm
H=4.72 | R=0.039 | V=0.31 in

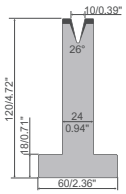


T120.10.26

835 mm *32.87"* 22.0 kg
415 mm *16.34"* 10.9 kg
795 mm *31.29"* 20.9 kg FX
805 mm *31.69"* 21.2 kg F

C45: 560-710 N/mm²
200 kN/m max.

26°
H=120 | R=1.2 | V=10 mm
H=4.72 | R=0.047 | V=0.39 in



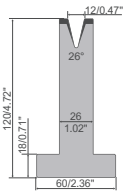


T120.12.26

835 mm *32.87"* 23.4 kg
415 mm *16.34"* 11.6 kg
795 mm *31.29"* 22.3 kg FX
805 mm *31.69"* 22.6 kg F

C45: 560-710 N/mm²
200 kN/m max.

26°
H=120 | R=1.6 | V=12 mm
H=4.72 | R=0.063 | V=0.47 in



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



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



Scan the QRCode or click on it to check PRICES and AVAILABILITY www.rolleritools.com

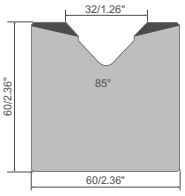
M60.85.32

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

85° >

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=4 | V=32 mm
H=2.36 | R=0.157 | V=1.26 in



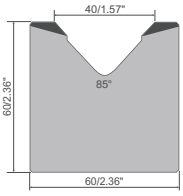


M60.85.40

835 mm *32.87"* 20 kg
415 mm *16.34"* 10.5 kg
795 mm *31.29"* 19.0 kg FX
805 mm *31.69"* 19.0 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=4 | V=40 mm
H=2.36 | R=0.157 | V=1.57 in

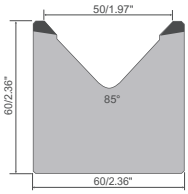


M60.85.50

835 mm *32.87"* 19.0 kg
415 mm *16.34"* 9.5.0 kg
795 mm *31.29"* 19.0 kg FX
805 mm *31.69"* 19.0 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=4 | V=50 mm
H=2.36 | R=0.157 | V=1.97 in



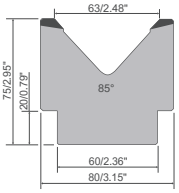


M75.85.63

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

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=5 | V=63 mm
H=2.36 | R=0.197 | V=2.48 in



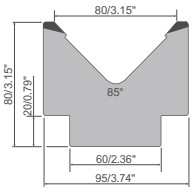


M80.85.80

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

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=6 | V=80 mm
H=2.36 | R=0.236 | V=3.15 in





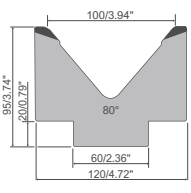
M95.80.100

80° >

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

C45: 560-710 N/mm²
1000 kN/m max.

80°
H=60 | R=8 | V=100 mm
H=2.36 | R=0.315 | V=3.94 in



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



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

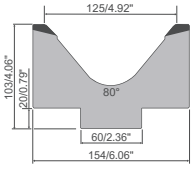


MK103.80.125

835 mm *32.87"* 62 kg
415 mm *16.34"* 31 kg
795 mm *31.29"* 59.8 kg FX
805 mm *31.69"* 59.8 kg F

C45: 560-710 N/mm²
700 kN/m max.

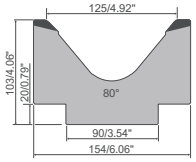
85°
H=103 | R=15 | V=125 mm
H=4.06 | R=0.591 | V=4.92 in





M103.80.125

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



C45: 560-710 N/mm²
1000 kN/m max.

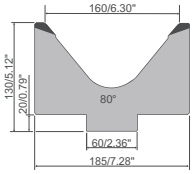
85°
H=103 | R=15 | V=125 mm
H=4.06 | R=0.591 | V=4.92 in

MK130.80.160

835 mm *32.87"* 93 kg
415 mm *16.34"* 46.5 kg
795 mm *31.29"* 88.5 kg FX
805 mm *31.69"* 89.7 kg F

C45: 560-710 N/mm²
700 kN/m max.

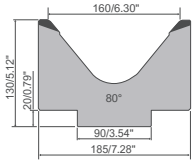
80°
H=130 | R=10 | V=160 mm
H=5.12 | R=0.394 | V=6.30 in





M130.80.160

835 mm *32.87"* 97 kg
415 mm *16.34"* 47.4 kg
795 mm *31.29"* 88.5 kg FX
805 mm *31.69"* 89.7 kg F



C45: 560-710 N/mm²
1000 kN/m max.

80°
H=130 | R=10 | V=160 mm
H=5.12 | R=0.394 | V=6.30 in

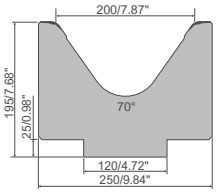
M195.70.200

415 mm *16.34"* 104 kg

70° >

C45: 560-710 N/mm²
1800 kN/m max.

70°
H=195 | R=15 | V=200 mm
H=7.68 | R=0.591 | V=7.87 in





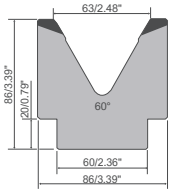
M86.60.63

835 mm *32.87"* 33.3 kg
415 mm *16.34"* 17 kg
795 mm *31.29"* 34.0 kg FX
805 mm *31.69"* 34.0 kg F

60° >

C45: 560-710 N/mm²
1000 kN/m max.

60°
H=85 | R=5 | V=63 mm
H=3.39 | R=0.197 | V=2.48 in





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



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

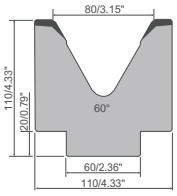


M110.60.80

835 mm *32.87"* 53 kg
415 mm *16.34"* 26.5 kg
795 mm *31.29"* 50.5 kg FX
805 mm *31.69"* 51.1 kg F

C45: 560-710 N/mm²
1000 kN/m max.

60°
H=110 | R=6 | V=80 mm
H=4.33 | R=0.236 | V=3.15 in





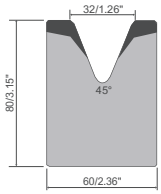
M80.45.32

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

45° >

C45: 560-710 N/mm²
1000 kN/m max.

45°
H=80 | R=4 | V=32 mm
H=3.15 | R=0.157 | V=1.26 in



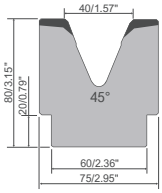


M80.45.40

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

C45: 560-710 N/mm²
1000 kN/m max.

45°
H=80 | R=4 | V=40 mm
H=3.15 | R=0.157 | V=1.57 in



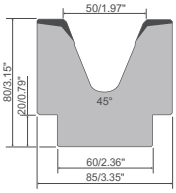


M80.45.50

835 mm *32.87"* 31 kg
415 mm *16.34"* 15.5 kg
795 mm *31.29"* 31 kg FX
805 mm *31.69"* 31 kg F

C45: 560-710 N/mm²
950 kN/m max.

45°
H=80 | R=4 | V=50 mm
H=3.15 | R=0.157 | V=1.97 in





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



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

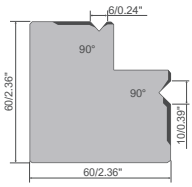


M60.90.01

835 mm	32.87"	20 kg	
415 mm	16.34"	10.0 kg	
795 mm	31.29"	20 kg	FX
805 mm	31.69"	20 kg	F

C45: 560-710 N/mm²
950 kN/m max.

90°
R=0.4 | V=6 mm
R=0.6 | V=10 mm
R=0.016 | V=0.24 in
R=0.024 | V=0.39 in



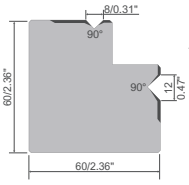


M60.90.02

835 mm	32.87"	20 kg	
415 mm	16.34"	10.0 kg	
795 mm	31.29"	20 kg	FX
805 mm	31.69"	20 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

90°
R=0.5 | V=8 mm
R=0.8 | V=12 mm
R=0.020 | V=0.31 in
R=0.031 | V=0.47 in

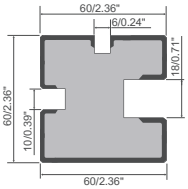


M.360.R

835 mm	*32.87"*	20 kg	
415 mm	*16.34"*	10.0 kg	
795 mm	*31.29"*	20 kg	FX
805 mm	*31.69"*	20 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

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



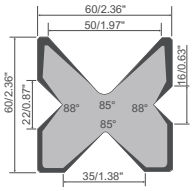


M.460

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

C45: 560-710 N/mm²
800 kN/m max.

85° R=2 | V=35 mm	*R=0.079 | V=1.38 in*
85° R=3 | V=50 mm	*R=0.118 | V=1.97 in*
88° R=2 | V=16 mm	*R=0.079 | V=0.63 in*
88° R=3 | V=60 mm	*R=0.079 | V=2.36 in*





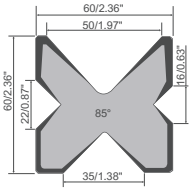
M.460.R

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

C45: 560-710 N/mm²
800 kN/m max.

85°

R=2 | V=16 mm	*R=0.079 | V=0.63 in*
R=2 | V=35 mm	*R=0.079 | V=1.38 in*
R=2 | V=60 mm	*R=0.079 | V=2.36 in*
R=3 | V=50 mm	*R=0.118 | V=1.97 in*



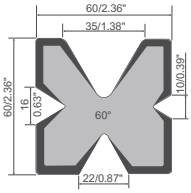
M.460.60

835 mm	*32.87"*	18.0 kg	
415 mm	*16.34"*	9.0 kg	
795 mm	*31.29"*	16 kg	FX
805 mm	*31.69"*	16 kg	F

C45: 560-710 N/mm²
600 kN/m max.

60°

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





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



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



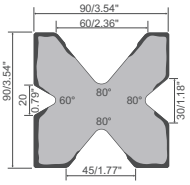
Scan the QRCode or click on it to check PRICES and AVAILABILITY www.rolleritools.com

M.490

835 mm	*32.87"*	38.9 kg	
415 mm	*16.34"*	20 kg	
795 mm	*31.29"*	39.0 kg	FX
805 mm	*31.69"*	39.0 kg	F

C45: 560-710 N/mm²
1000 kN/m max.

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



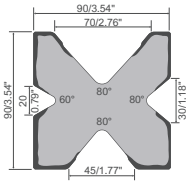


M.490.70

835 mm	*32.87"*	35.8 kg	
415 mm	*16.34"*	17.9 kg	
795 mm	*31.29"*	36 kg	FX
805 mm	*31.69"*	36 kg	F

C45: 560-710 N/mm²
600 kN/m max.

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

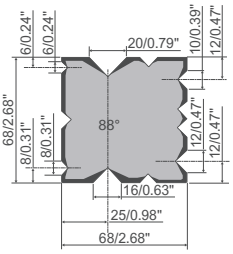


T70-88

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

42Cr: 900-1150 N/mm²
1000 kN/m max.

88°	
R=0.4 | V=6 mm	*R=0.016 | V=0.24 in*
R=0.5 | V=8 mm	*R=0.020 | V=0.31 in*
R=0.8 | V=10 mm	*R=0.031 | V=0.39 in*
R=2.75 | V=12 mm	*R=0.108 | V=0.47 in*
R=2.75 | V=16 mm	*R=0.108 | V=0.63 in*
R=3.0 | V=20 mm	*R=0.118 | V=0.79 in*



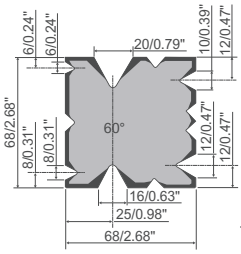


T70-60

525 mm *20.67"* 16.8 kg
495 mm *19.49"* 15.8 kg

42Cr: 900-1150 N/mm²

60°		kN/m max.
R=0.8 | V=10 mm	*R=0.031 | V=0.39 in*	600
R=0.8 | V=12 mm	*R=0.031 | V=0.47 in*	600
R=2.75 | V=16 mm	*R=0.108 | V=0.63 in*	800
R=0.8 | V=8 mm	*R=0.031 | V=0.31 in*	600
R=0.5 | V=6 mm	*R=0.020 | V=0.24 in*	600
R=3.0 | V=20 mm	*R=0.118 | V=0.79 in*	800

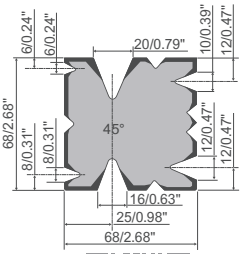


T70-45

525 mm *20.67"* 16.1 kg
495 mm *19.49"* 15.2 kg

42Cr: 900-1150 N/mm²

45°		kN/m max.
R=0.8 | V=6 mm	*R=0.031 | V=0.24 in*	400
R=1.0 | V=8 mm	*R=0.039 | V=0.31 in*	400
R=1.2 | V=10 mm	*R=0.047 | V=0.39 in*	500
R=1.6 | V=12 mm	*R=0.063 | V=0.47 in*	500
R=2.75 | V=16 mm	*R=0.108 | V=0.63 in*	700
R=3.0 | V=20 mm	*R=0.118 | V=0.79 in*	700



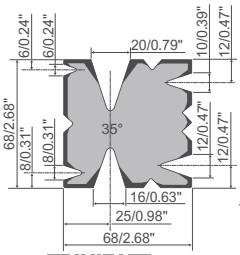


T70-35

525 mm *20.67"* 15.3 kg
495 mm *19.49"* 14.4 kg

42Cr: 900-1150 N/mm²

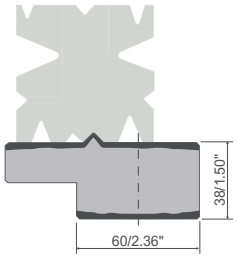
35°		kN/m max.
R=0.8 | V=6 mm	*R=0.031 | V=0.24 in*	300
R=1.0 | V=8 mm	*R=0.039 | V=0.31 in*	350
R=1.2 | V=10 mm	*R=0.047 | V=0.39 in*	450
R=1.6 | V=12 mm	*R=0.063 | V=0.47 in*	450
R=3.0 | V=16 mm	*R=0.118 | V=0.63 in*	500
R=3.0 | V=20 mm	*R=0.118 | V=0.79 in*	500

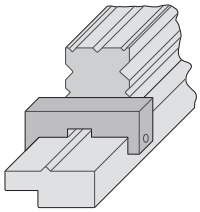


SU-T70

525 mm *20.67"* 12.4 kg

C45: 560-710 N/mm²





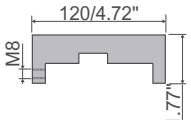
PB-T70

525 mm *20.67"* 12.4 kg

Fe37

Retainer





Scan the QRCode or click on it and watch the video to discover more about T70

Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

Hemming tools are used to prebend and afterwards flatten a sheet metal edge by using the same tool set.

Thanks to this operation you can strengthen sheet metal edges and avoid burr on their external side. For this reason, this operation is especially used for safety reason, in order to avoid operators' accidental injuries which may occurr to those who have to handle sheet metal parts.

The maximum sheet metal thickness usually recommended for this operation is 3mm mild steel and 2mm stainless steel. However, for thicker sheet metal special solutions can be proposed, which consider the necessary bending force involved to flatten.

There are 2 types of flattening: partial flattening and total flattening.

Partial flattening is a kind of flattening which doesn't win against the sheet metal springback. For this reason, if you measure the flattened point, it won't be twice the sheet metal thickness but a bigger measure; for example, if you flatten 1.5mm partially, the flattened point will be about 4mm. This dimension depends on the bending force only. Hence, if you want to flatten 1.5mm mild steel and get 3mm high flattened point, you have to increase the tonnage.

In the table below you can check the necessary tonnage according to sheet metal thickness and type.

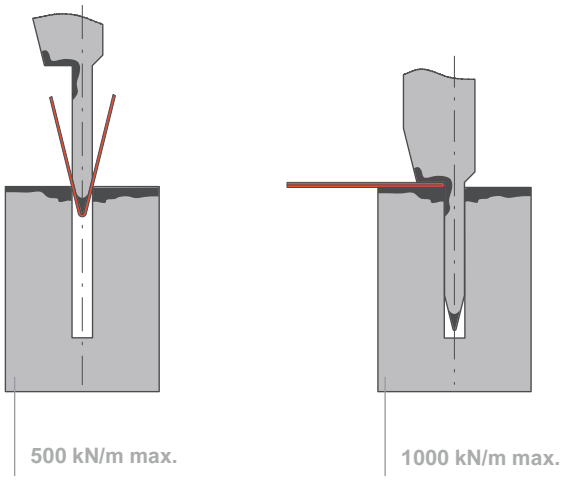
The choice of hemming tools should be influenced by the sheet metal type to be flattened; 35° punch and dies are recommended to flatten aluminium and mild steel, which have small springback, whereas more resitant sheet metal types like stainless steel require at least 30°, or better 26°, punch and die.

Springback control is fundamental to win against sheet metal resistance during the flattening phase. In fact, if the angle obtained during the pre-bending phase is too wide, sheet metal will slip towards the operator during the flattening phase.

In case you want to flatten sheet metal by using spring-loaded or pneumatic hemming dies, the chosen punch must have exactly the same angle of the die. Such dies are available in 835mm and 415mm length and they cannot be sectioned.

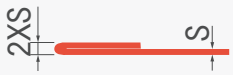
The choice of TOP Series hemming tools with dies with U shape opening has to take into consideration the fact that the U opening of the die has to match perfectly with the punch tip width. These tools are 525mm long and the sectioned set is also available.

MAX. CAPACITY





S mm	S *in*	A mm	A *in*	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.60	*0.02*	3.0	*0.12*	90	150
0.80	*0.03*	3.0	*0.12*	120	200
1.00	*0.04*	3.5	*0.14*	150	250
1.25	*0.05*	3.5	*0.14*	170	260



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

The **Bending handbook** target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.

Scan the QRCode or click on it and watch the video to discover more about hemming tools.

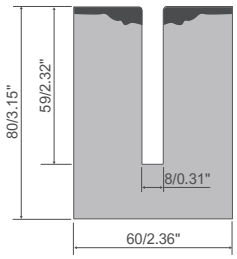
TOP.SM-134.28.8

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

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

H=80 | R=1 | V=8 mm
H=3.15 | R=0.039 | V=0.31 in

To use with:
TOP.SP.134.28.8





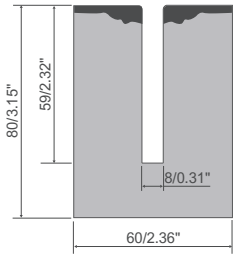
TOP.SM-134.24.8

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

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

H=80 | R=1 | V=8 mm
H=3.15 | R=0.039 | V=0.31 in

To use with:
TOP.SP.134.24.8





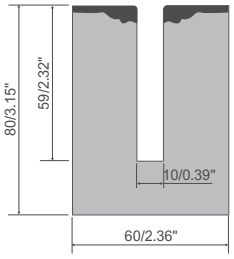
TOP.SM-134.24.10

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

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

H=80 | R=1 | V=10 mm
H=3.15 | R=0.039 | V=0.39 in

To use with:
TOP.SP.134.24.10





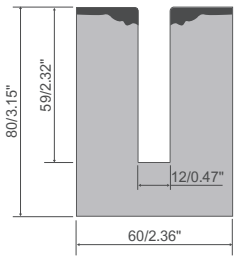
TOP.SM-134.24.12

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

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

H=80 | R=1 | V=12 mm
H=3.15 | R=0.039 | V=0.47 in

To use with:
TOP.SP.134.24.12





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



Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.



S mm	*S in*	A mm	*A in*	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	*0.02*	3.0	0.12	90	150
0.8	*0.03*	3.0	0.12	120	200
1.0	*0.04*	3.5	0.14	150	250
1.25	*0.05*	3.5	0.14	170	260
1.5	*0.06*	4.6	0.18	220	380
2.0	*0.08*	5.5	0.22	300	500
2.5	*0.10*	6.5	0.26	550	-
3.0	*0.12*	8.0	*0.31*	700	.



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

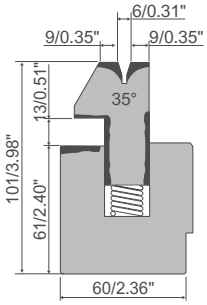
S101.35.06

835 mm *32.87"* 30 kg
415 mm *16.34"* 15.4 kg

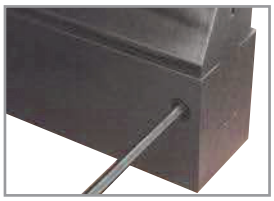
35° >

C45: 560-710 N/mm²
600 kN/m max.

35°
H=101 | R=1 | V=6 mm
H=3.98 | R=0.039 | V=0.24 in







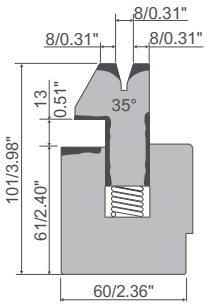


S101.35.08

835 mm *32.87"* 30 kg
415 mm *16.34"* 15 kg

C45: 560-710 N/mm²
600 kN/m max.

35°
H=101 | R=1 | V=8 mm
H=3.98 | R=0.039 | V=0.31 in



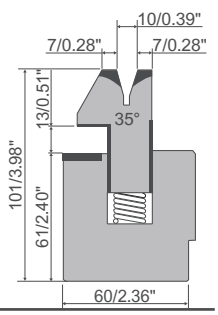


S101.35.10

835 mm *32.87"* 30 kg
415 mm *16.34"* 15.5 kg

C45: 560-710 N/mm²
600 kN/m max.

35°
H=101 | R=1 | V=10 mm
H=3.98 | R=0.039 | V=0.39 in





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

Request our clamping, punching and ironworker, consumables laser, panel bending tools and shear blades catalogues on www.rolleritools.com/catalogues

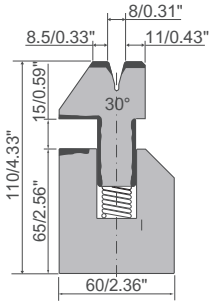
S110.30.08

835 mm *32.87"* 30 kg
415 mm *16.34"* 15 kg

30° >

C45: 560-710 N/mm²
800 kN/m max.

30°
H=110 | R=1.5 | V=8 mm
H=4.33 | R=0.059 | V=0.31 in





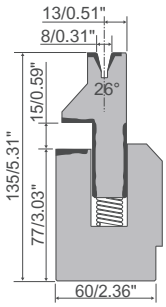
S135.26.08

835 mm *32.87"* 39.8 kg
415 mm *16.34"* 21 kg

26° >

42Cr:900-1150 N/mm²
400 kN/m max.

26°
H=135 | R=1.5 | V=8 mm
H=5.31 | R=0.059 | V=0.31 in



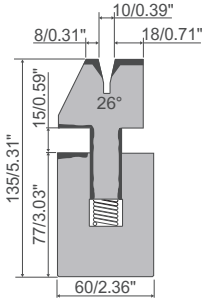


S135.26.10

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

C45: 560-710 N/mm²
1000 kN/m max.

26°
H=135 | R=1.5 | V=10 mm
H=5.31 | R=0.059 | V=0.39 in



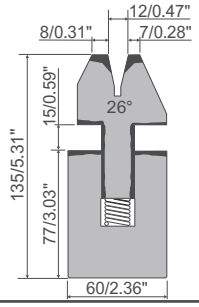


SA135.26.12

835 mm *32.87"* 41 kg
415 mm *16.34"* 20.5 kg

C45: 560-710 N/mm²
1000 kN/m max.

26°
H=135 | R=2 | V=10 mm
H=5.31 | R=0.079 | V=0.39 in





Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.



Download Rolleri **Bending App**
You will have access to our online store where you can get what you need. You will also get our sheet metal unfolding software for free and our bending rule.



S mm	*S in*	A mm	*A in*	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	*0.02*	3.0	*0.12*	90	150
0.8	*0.03*	3.0	*0.12*	120	200
1.0	*0.04*	3.5	*0.14*	150	250
1.25	*0.05*	3.5	*0.14*	170	260
1.5	*0.06*	4.6	*0.18*	220	380
2.0	*0.08*	5.5	*0.22*	300	500
2.5	*0.10*	6.5	*0.26*	550	-
3.0	*0.12*	8.0	*0.31*	700	-



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

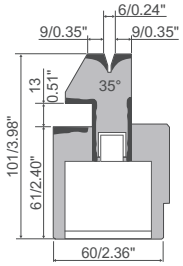
S101PN.35.06

835 mm *32.87"* 30 kg
415 mm *16.34"* 15.5 kg

35° >

C45: 560-710 N/mm²
600 kN/m max.

35°
H=101 | R=1 | V=6 mm
H=3.98 | R=0.039 | V=0.24 in



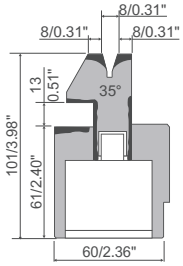


S101PN.35.08

835 mm *32.87"* 31 kg
415 mm *16.34"* 15.5 kg

C45: 560-710 N/mm²
600 kN/m max.

35°
H=101 | R=1 | V=8 mm
H=3.98 | R=0.039 | V=0.31 in



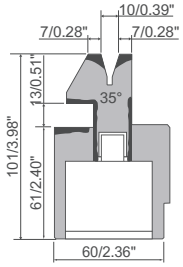


S101PN.35.10

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

C45: 560-710 N/mm²
600 kN/m max.

35°
H=101 | R=1 | V=10 mm
H=3.98 | R=0.039 | V=0.39 in





Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.



KPN

1 kg

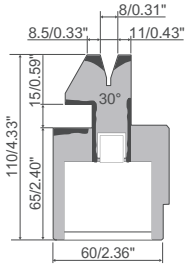
S110PN.30.08

835 mm *32.87"* 30 kg
415 mm *16.34"* 15 kg

30° >

C45: 560-710 N/mm²
800 kN/m max.

30°
H=110 | R=1.5 | V=8 mm
H=4.33 | R=0.059 | V=0.31 in





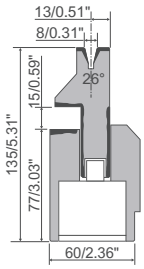
S135PN.26.08

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

26° >

42Cr:900-1150 N/mm²
400 kN/m max.

26°
H=135 | R=1.5 | V=8 mm
H=5.31 | R=0.059 | V=0.31 in



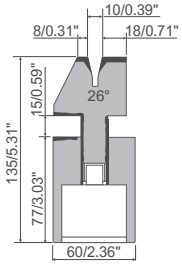


S135PN.26.10

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

C45: 560-710 N/mm²
1000 kN/m max.

26°
H=135 | R=1.5 | V=10 mm
H=5.31 | R=0.059 | V=0.39 in



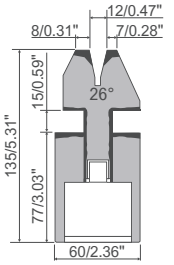


SA135PN.26.12

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

C45: 560-710 N/mm²
1000 kN/m max.

26°
H=135 | R=2 | V=12 mm
H=5.31 | R=0.079 | V=0.47 in



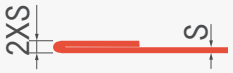


KPN kit for pneumatic hemming dies is a device which opens and closes the hemming die automatically.
KPN contains an electrovalve which receives the impulse directly by the press brake CNC and, according to the impulse, it opens and closes air supply to the system.

Such feature is very important as it enables operators to improve the bending sequence safely and time-saving.



S mm	*S in*	A mm	*A in*	R.420 N/mm² kN/m	R.700 N/mm² kN/m
0.6	*0.02*	3.0	*0.12*	90	150
0.8	*0.03*	3.0	*0.12*	120	200
1.0	*0.04*	3.5	*0.14*	150	250
1.25	*0.05*	3.5	*0.14*	170	260
1.5	*0.06*	4.6	*0.18*	220	380
2.0	*0.08*	5.5	*0.22*	300	500
2.5	*0.10*	6.5	*0.26*	550	-
3.0	*0.12*	8.0	*0.31*	700	-



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

The new system TOP.SC.130 and TOP.SC.130PN has been designed to flatten sheet metal thicker than 2mm, depending on press brake force.

Dies SM55.12.30 and SM55.14.30 can be used with this new system, as they are made of 42CrMo4, have a wider body and can bear up to 1000kN/m. Flattening with close counterbends has never been so easy.

Dies are interchangeable and have R2 13mm tang.

All standard dies can be mounted with TOP.SC.130. They are fixed by screws positioned on the operator's side.

A very important feature is hemming die opening: being 18mm, pre-bent sheet metal can be easily positioned and flattened without any risk to be slided out.

Standard length is 500mm and hemming dies are available in 2 versions: manual with springs or pneumatic and press brake CNC driven.

The ideal punch to be used with this system is TOP150.30.R12.



TOP.SC.130

500 mm *19.68"* 8.0 kg

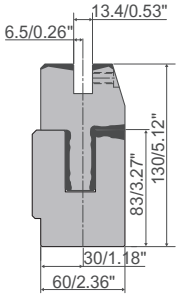
42Cr:900-1150 N/mm²
1000 kN/m max.

H=130 mm
H=5.12 in

Spring-loaded hemming dies

NEW

To use with:
TOP150.30.R12



TOP.SC.130PN

500 mm *19.68"* 30 kg

42Cr:900-1150 N/mm²
1000 kN/m max.

H=130 mm
H=5.12 in

Pneumatic hemming dies

NEW



Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.



KPN

1 kg

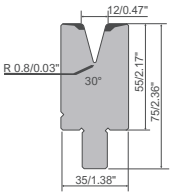
SM55.12.30/C

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

30° >

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

NEW



To use with:
TOP.SC.130
TOP.SC.130PN



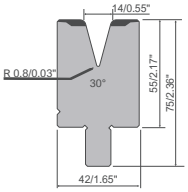
SM55.14.30/C

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

42Cr:900-1150 N/mm²
Bending: 600 kN/m max.
Hemming: 1000 kN/m max.

30°
W=55 | H=75 | R=3.0 | V=14 mm
W=2.17 | H=2.36 | R=0.12 | V=0.55 in

NEW



To use with:
TOP.SC.130
TOP.SC.130PN

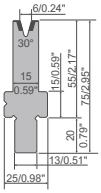


BMR55.06.30/C

500 mm *19.68"* 4 kg

42Cr: 900-1150 N/mm²
350 kN/m max.

30°
W=55 | H=75 | R=0.6 | V=6 mm
W=2.17 | H=2.36 | R=0.024 | V=0.24 in



To use with:
TOP.SC.130
TOP.SC.130PN

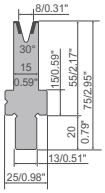


BMR55.08.30/C

500 mm *19.68"* 4 kg

42Cr: 900-1150 N/mm²
200 kN/m max.

30°
W=55 | H=75 | R=0.8 | V=8 mm
W=2.17 | H=2.36 | R=0.031 | V=0.31 in

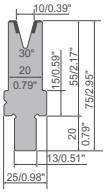


BMR55.10.30/C

500 mm *19.68"* 5 kg

42Cr: 900-1150 N/mm²
350 kN/m max.

30°
W=55 | H=75 | R=1.0 | V=10 mm
W=2.17 | H=2.36 | R=0.039 | V=0.39 in



To use with:
TOP.SC.130
TOP.SC.130PN



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

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



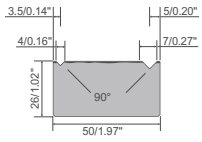
12100

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

90° >

C45: 560-710 N/mm²
600 kN/m max.

90°
H=26 | R=0.4 | V=4 mm
H=26 | R=0.4 | V=7 mm
H=1.02 | R=0.016 | V=0.16 in
H=1.02 | R=0.016 | V=0.28 in



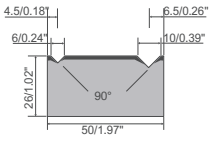


12300

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

C45: 560-710 N/mm²
700 kN/m max.

90°
H=26 | R=0.4 | V=6 mm
H=26 | R=0.6 | V=10 mm
H=1.02 | R=0.016 | V=0.24 in
H=1.02 | R=0.024 | V=0.39 in

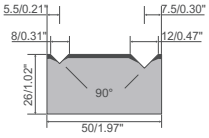


12400

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

C45: 560-710 N/mm²
800 kN/m max.

90°
H=26 | R=0.5 | V=8 mm
H=26 | R=0.8 | V=12 mm
H=1.02 | R=0.020 | V=0.31 in
H=1.02 | R=0.031 | V=0.47 in



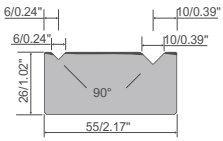


31100

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

C45: 560-710 N/mm²
800 kN/m max.

90°
H=26 | R=1.5 | V=6 mm
H=26 | R=2.5 | V=10 mm
H=1.02 | R=0.06 | V=0.24 in
H=1.02 | R=0.098 | V=0.39 in





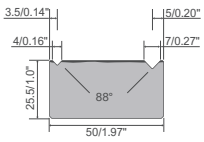
12106

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

88° >

C45: 560-710 N/mm²
600 kN/m max.

88°
H=25.5 | R=0.4 | V=4 mm
H=25.5 | R=0.4 | V=7 mm
H=1.00 | R=0.016 | V=0.16 in
H=1.00 | R=0.016 | V=0.28 in



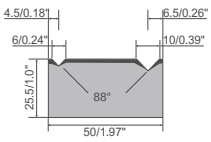


12306

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

C45: 560-710 N/mm²
700 kN/m max.

88°
H=25.5 | R=0.4 | V=6 mm
H=25.5 | R=0.6 | V=10 mm
H=1.00 | R=0.016 | V=0.24 in
H=1.00 | R=0.024 | V=0.39 in



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



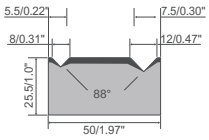
Download Rolleri **Bending App.**
You will have access to our online store where you can get what you need. You will also get our sheet metal unfolding software for free and our bending rule.

12406

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

C45: 560-710 N/mm²
800 kN/m max.

88°
H=25.5 | R=0.5 | V=8 mm
H=25.5 | R=0.8 | V=12 mm
H=1.00 | R=0.020 | V=0.31 in
H=1.00 | R=0.031 | V=0.47 in



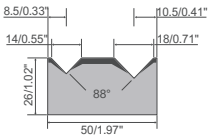


12500

835 mm *32.87"* 7.7 kg
415 mm *16.34"* 3.8.0 kg

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=0.5 | V=14 mm
H=26 | R=0.5 | V=18 mm
H=1.02 | R=0.020 | V=0.55 in
H=1.02 | R=0.020 | V=0.71 in

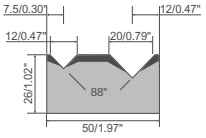


12600

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=0.5 | V=12 mm
H=26 | R=0.5 | V=20 mm
H=1.02 | R=0.020 | V=0.47 in
H=1.02 | R=0.020 | V=0.79 in



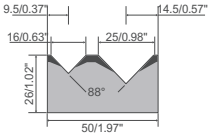


12700

835 mm *32.87"* 7 kg
415 mm *16.34"* 3.4.0 kg

C45: 560-710 N/mm²
700 kN/m max.

88°
H=26 | R=0.8 | V=16 mm
H=26 | R=0.8 | V=25 mm
H=1.02 | R=0.031 | V=0.63 in
H=1.02 | R=0.031 | V=0.98 in

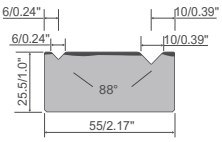


31106

835 mm *32.87"* 8.9 kg
415 mm *16.34"* 4.4.0 kg

C45: 560-710 N/mm²
800 kN/m max.

88°
H=25.5 | R=1.5 | V=6 mm
H=25.5 | R=2.5 | V=10 mm
H=1.00 | R=0.06 | V=0.24 in
H=1.00 | R=0.098 | V=0.39 in



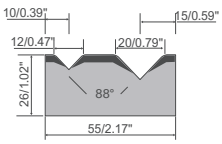


31400

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

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=26 | R=3 | V=12 mm
H=26 | R=4 | V=20 mm
H=1.02 | R=0.118 | V=0.47 in
H=1.02 | R=0.157 | V=0.79 in





Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

The **Bending handbook** target is to supply practicle and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.

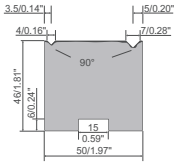
30148

835 mm *32.87"* 14.2 kg
415 mm *16.34"* 7.1 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

90° >

C45: 560-710 N/mm²
600 kN/m max.

90°
H=46 | R=0.4 | V=4 mm
H=46 | R=0.4 | V=7 mm
H=1.81 | R=0.016 | V=0.16 in
H=1.81 | R=0.016 | V=0.28 in



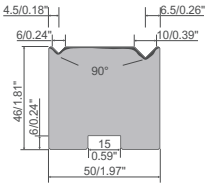


30248

835 mm *32.87"* 14.2 kg
415 mm *16.34"* 7.1 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

C45: 560-710 N/mm²
700 kN/m max.

90°
H=46 | R=0.4 | V=6 mm
H=46 | R=0.6 | V=10 mm
H=1.81 | R=0.016 | V=0.24 in
H=1.81 | R=0.023 | V=0.39 in



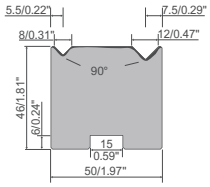


30348

835 mm *32.87"* 14.2 kg
415 mm *16.34"* 7.1 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

C45: 560-710 N/mm²
700 kN/m max.

90°
H=46 | R=0.5 | V=8 mm
H=46 | R=0.8 | V=12 mm
H=1.81 | R=0.016 | V=0.31 in
H=1.81 | R=0.016 | V=0.47 in



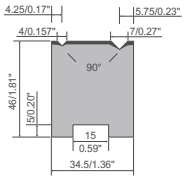
50190

835 mm *32.87"* 9.7 kg
415 mm *16.34"* 4.8.0 kg
795 mm *31.29"* 9.2 kg FX
835 mm *32.87"* 9.4.0 kg FC

Self centering

C45: 560-710 N/mm²
600 kN/m max.

90°
H=46 | R=0.4 | V=4 mm
H=46 | R=0.4 | V=7 mm
H=1.81 | R=0.016 | V=0.16 in
H=1.81 | R=0.016 | V=0.28 in





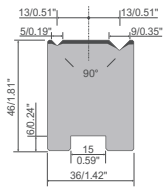
50790

835 mm *32.87"* 10.0 kg
415 mm *16.34"* 5.0 kg
795 mm *31.29"* 9.5.0 kg FX
835 mm *32.87"* 9.7 kg FC

Self centering

C45: 560-710 N/mm²
600 kN/m max.

90°
H=46 | R=0.4 | V=5 mm
H=46 | R=0.6 | V=9 mm
H=1.81 | R=0.016 | V=0.196 in
H=1.81 | R=0.023 | V=0.35 in





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



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



Scan the QRCode or click on it to check PRICES and AVAILABILITY www.rolleritools.com

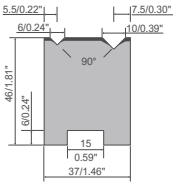
50290

835 mm *32.87"* 10.3 kg
415 mm *16.34"* 5.2 kg
795 mm *31.29"* 10.0 kg FX
835 mm *32.87"* 10.1 kg FC

Self centering

C45: 560-710 N/mm²
700 kN/m max.

90°
H=46 | R=0.4 | V=6 mm
H=46 | R=0.6 | V=10 mm
H=1.81 | R=0.016 | V=0.24 in
H=1.81 | R=0.024 | V=0.39 in





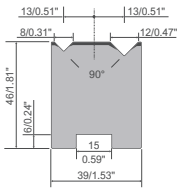
50390

835 mm *32.87"* 10.7 kg
415 mm *16.34"* 5.3 kg
795 mm *31.29"* 10.7 kg FX
835 mm *32.87"* 10.7 kg FC

Self centering

C45: 560-710 N/mm²
700 kN/m max.

90°
H=46 | R=0.5 | V=8 mm
H=46 | R=0.8 | V=12 mm
H=1.81 | R=0.019 | V=0.31 in
H=1.81 | R=0.031 | V=0.47 in



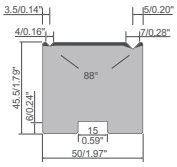
30147

835 mm *32.87"* 14.2 kg
415 mm *16.34"* 7.1 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

88° >

C45: 560-710 N/mm²
600 kN/m max.

88°
H=45.5 | R=0.4 | V=4 mm
H=45.5 | R=0.4 | V=7 mm
H=1.79 | R=0.016 | V=0.16 in
H=1.79 | R=0.016 | V=0.27 in



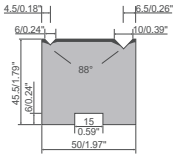


30247

835 mm *32.87"* 14.0 kg
415 mm *16.34"* 8.4 kg
795 mm *31.29"* 16.2 kg FX
835 mm *32.87"* 16.4 kg FC

C45: 560-710 N/mm²
700 kN/m max.

88°
H=45.5 | R=0.4 | V=6 mm
H=45.5 | R=0.6 | V=10 mm
H=1.79 | R=0.016 | V=0.24 in
H=1.79 | R=0.024 | V=0.39 in

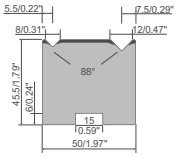


30347

835 mm *32.87"* 14.2 kg
415 mm *16.34"* 7.1 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

C45: 560-710 N/mm²
700 kN/m max.

88°
H=45.5| R=0.5 | V=8 mm
H=45.5 | R=0.8 | V=12 mm
H=1.79 | R=0.019 | V=0.31 in
H=1.79 | R=0.031 | V=0.47 in



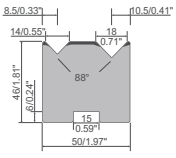


30448

835 mm *32.87"* 13.5 kg
415 mm *16.34"* 6.7 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=46 | R=0.5 | V=14 mm
H=46 | R=0.5 | V=18 mm
H=1.81 | R=0.019 | V=0.55 in
H=1.81 | R=0.019 | V=0.71 in

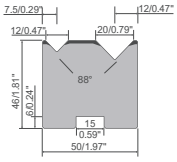


30548

835 mm *32.87"* 13.5 kg
415 mm *16.34"* 6.7 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=46 | R=0.5 | V=12 mm
H=46 | R=0.5 | V=20 mm
H=1.81 | R=0.019 | V=0.47 in
H=1.81 | R=0.019 | V=0.79 in



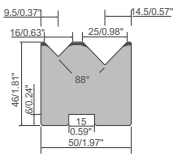


30648

835 mm *32.87"* 12.9 kg
415 mm *16.34"* 6.4 kg
795 mm *31.29"* 13.5 kg FX
835 mm *32.87"* 13.7 kg FC

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=46 | R=0.8 | V=16 mm
H=46 | R=0.8 | V=25 mm
H=1.81 | R=0.031 | V=0.63 in
H=1.81 | R=0.031 | V=0.98 in



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



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



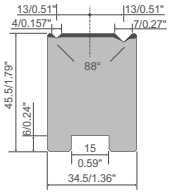
50196

835 mm	*32.87"*	9.5.0 kg	
415 mm	*16.34"*	4.8.0 kg	
795 mm	*31.29"*	9.5.0 kg	FX
835 mm	*32.87"*	9.5.0 kg	FC

Self centering

C45: 560-710 N/mm²
600 kN/m max.

88°
H=45.5 | R=0.4 | V=4 mm
H=45.5 | R=0.4 | V=7 mm
H=1.79 | R=0.016 | V=0.16 in
H=1.79 | R=0.016 | V=0.28 in





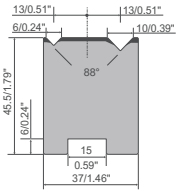
50296

835 mm	*32.87"*	10.4 kg	
415 mm	*16.34"*	5.2 kg	
795 mm	*31.29"*	10.4 kg	FX
835 mm	*32.87"*	10.4 kg	FC

Self centering

C45: 560-710 N/mm²
700 kN/m max.

88°
H=45.5 | R=0.4 | V=6 mm
H=45.5 | R=0.6 | V=10 mm
H=1.76 | R=0.016 | V=0.24 in
H=1.76 | R=0.023 | V=0.39 in



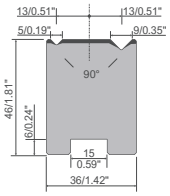
50796

835 mm	*32.87"*	10.0 kg	
415 mm	*16.34"*	5.0 kg	
795 mm	*31.29"*	9.5.0 kg	FX
835 mm	*32.87"*	9.5.0 kg	FC

Self centering

C45: 560-710 N/mm²
600 kN/m max.

88°
H=45.5 | R=0.4 | V=5 mm
H=45.5 | R=0.6 | V=9 mm
H=1.79 | R=0.016 | V=0.2 in
H=1.79 | R=0.024 | V=0.35 in





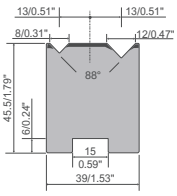
50396

835 mm	*32.87"*	10.8 kg	
415 mm	*16.34"*	5.3 kg	
795 mm	*31.29"*	10.8 kg	FX
835 mm	*32.87"*	10.8 kg	FC

Self centering

C45: 560-710 N/mm²
700 kN/m max.

88°
H=45.5 | R=0.5 | V=8 mm
H=45.5 | R=0.8 | V=12 mm
H=1.79 | R=0.019 | V=0.31 in
H=1.79 | R=0.019 | V=0.47 in



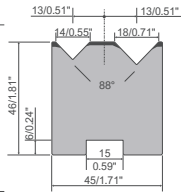
50490

835 mm	*32.87"*	12 kg	
415 mm	*16.34"*	5.3 kg	
795 mm	*31.29"*	10.8 kg	FX
835 mm	*32.87"*	10.8 kg	FC

Self centering

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=46 | R=0.5 | V=14 mm
H=46 | R=0.5 | V=18 mm
H=1.81 | R=0.019 | V=0.55 in
H=1.81 | R=0.019 | V=0.71 in





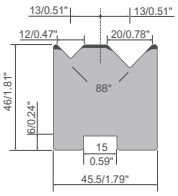
50590

835 mm	*32.87"*	12.2 kg	
415 mm	*16.34"*	6.1 kg	
795 mm	*31.29"*	12.2 kg	FX
835 mm	*32.87"*	12.2 kg	FC

Self centering

C45: 560-710 N/mm²
700 kN/m max.

88°
H=46 | R=0.5 | V=12 mm
H=46 | R=0.5 | V=20 mm
H=1.81 | R=0.019 | V=0.47 in
H=1.81 | R=0.019 | V=0.78 in



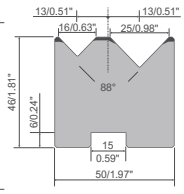
50690

835 mm	*32.87"*	13 kg	
415 mm	*16.34"*	6.5 kg	
795 mm	*31.29"*	12.4 kg	FX
835 mm	*32.87"*	12.6 kg	FC

Self centering

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=46 | R=0.8 | V=16 mm
H=46 | R=0.8 | V=25 mm
H=1.81 | R=0.031 | V=0.63 in
H=1.81 | R=0.031 | V=0.98 in





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



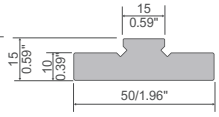
FC: 835 mm - *32.87"*
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96-3.94 -7.87-15.75



30000

835 mm *32.87"* 3.7 kg
415 mm *16.34"* 1.9.0 kg

C45: 560-710 N/mm²
1000 kN/m max.





Example of application

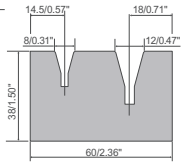


33700

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

42Cr:900-1500 N/mm²
300 kN/m max.

90°
R=1 | V=8 mm
R=1 | V=12 mm
R=0.039 | V=0.31 in
R=0.039 | V=0.47 in





Request our clamping, punching and ironworker, consumables laser, panel bending tools and shear blades catalogues on www.rolleritools.com/catalogues

Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

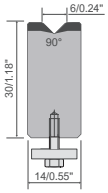
32000

835 mm *32.87"* 3 kg
415 mm *16.34"* 1.5.0 kg

90° >

C45: 560-710 N/mm²
950 kN/m max.

90°
H=30 | R=1.5 | V=6 mm
H=1.18 | R=0.059 | V=0.24 in



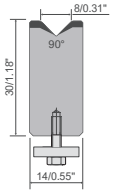


32100

835 mm *32.87"* 3 kg
415 mm *16.34"* 1.5.0 kg

C45: 560-710 N/mm²
950 kN/m max.

90°
H=30 | R=1.5 | V=8 mm
H=1.18 | R=0.059 | V=0.31 in

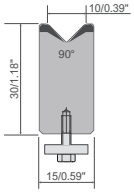


32300

835 mm *32.87"* 3 kg
415 mm *16.34"* 1.5.0 kg

C45: 560-710 N/mm²
950 kN/m max.

90°
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in



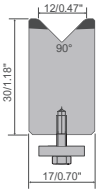


32600

835 mm *32.87"* 2.9 kg
415 mm *16.34"* 1.5.0 kg

C45: 560-710 N/mm²
1000 kN/m max.

90°
H=30 | R=2.5 | V=12 mm
H=1.18 | R=0.098 | V=0.47 in



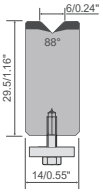
32006

835 mm *32.87"* 3 kg
415 mm *16.34"* 1.5.0 kg

88° >

C45: 560-710 N/mm²
950 kN/m max.

88°
H=29.5 | R=1.5 | V=6 mm
H=1.16 | R=0.059 | V=0.24 in



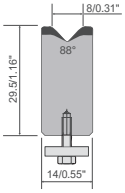


32106

835 mm *32.87"* 3 kg
415 mm *16.34"* 1.5.0 kg

C45: 560-710 N/mm²
950 kN/m max.

88°
H=29.5 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

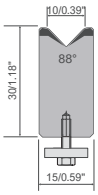


32200

835 mm *32.87"* 3 kg
415 mm *16.34"* 1.5.0 kg

C45: 560-710 N/mm²
950 kN/m max.

88°
H=30 | R=2 | V=10 mm
H=1.18 | R=0.079 | V=0.39 in





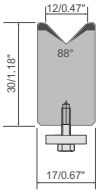
R1A self centering dies are designed to be mounted with 33000 Series holders.
Hole pitch is standard.
Such 1-V dies align the V opening with the punch tip axis autonomously, so the press brake upper beam has to go down without sheet metal to position the dies properly. Afterwards, the operator can screw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

32400

835 mm *32.87"* 3 kg
415 mm *16.34"* 1.5.0 kg

C45: 560-710 N/mm²
1000 kN/m max.

88°
H=30 | R=2.5 | V=12 mm
H=1.18 | R=0.098 | V=0.47



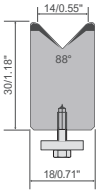


32500

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

C45: 560-710 N/mm²
1000 kN/m max.

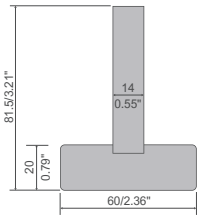
88°
H=60 | R=2.5 | V=14 mm
H=2.36 | R=0.098 | V=0.55



33000

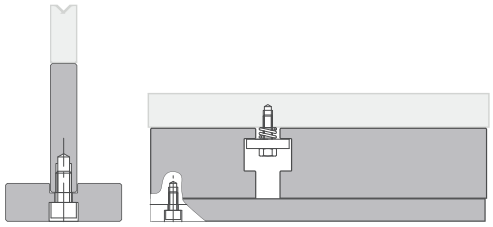
835 mm *32.87"* 12.7 kg
415 mm *16.34"* 6.3 kg

C45: 560-710 N/mm²
1000 kN/m max.





Example of application



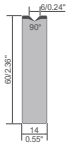
07000

90° >

835 mm *32.87"* 5.5 kg
415 mm *16.34"* 2.7 kg
795 mm *31.29"* 5.2 kg FX
835 mm *32.87"* 5.3 kg F

C45: 560-710 N/mm²
950 kN/m max.

90°
H=60 | R=1.5 | V=6 mm
H=2.36 | R=0.059 | V=0.24 in



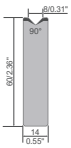


07100

835 mm *32.87"* 5.5 kg
415 mm *16.34"* 2.7 kg
795 mm *31.29"* 5.2 kg FX
835 mm *32.87"* 5.3 kg F

C45: 560-710 N/mm²
950 kN/m max.

90°
H=60 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

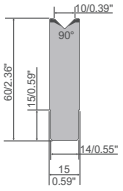


07300

835 mm *32.87"* 6 kg
415 mm *16.34"* 3 kg
795 mm *31.29"* 5.3 kg FX
835 mm *32.87"* 5.4 kg F

C45: 560-710 N/mm²
950 kN/m max.

90°
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in



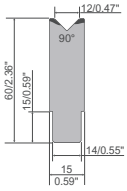


07500

835 mm *32.87"* 6.1 kg
415 mm *16.34"* 3 kg
795 mm *31.29"* 5.8 kg FX
835 mm *32.87"* 5.9 kg F

C45: 560-710 N/mm²
950 kN/m max.

90°
H=60 | R=2.5 | V=12 mm
H=2.36 | R=0.098 | V=0.47 in





Download Rolleri **Bending App.**
You will have access to our online store where you can get what you need. You will also get our sheet metal unfolding software for free and our bending rule.

Create your account on **www.rolleritools.com**
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

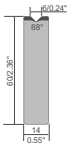
07006

835 mm	*32.87"*	5.5 kg	
415 mm	*16.34"*	2.7 kg	
795 mm	*31.29"*	5.2 kg	FX
835 mm	*32.87"*	5.3 kg	FC

88° >

C45: 560-710 N/mm²
950 kN/m max.

88°
H=60 | R=1.5 | V=6 mm
H=2.36 | R=0.059 | V=0.24 in



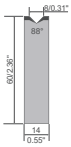


07106

835 mm	*32.87"*	6 kg	
415 mm	*16.34"*	3 kg	
795 mm	*31.29"*	5.4 kg	FX
835 mm	*32.87"*	5.5 kg	FC

C45: 560-710 N/mm²
950 kN/m max.

88°
H=60 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

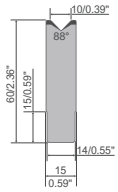


07200

835 mm	*32.87"*	6 kg	
415 mm	*16.34"*	3 kg	
795 mm	*31.29"*	5.4 kg	FX
835 mm	*32.87"*	5.5 kg	FC

C45: 560-710 N/mm²
950 kN/m max.

88°
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in



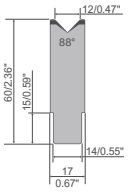


07400

835 mm	*32.87"*	6 kg	
415 mm	*16.34"*	3 kg	
795 mm	*31.29"*	5.8 kg	FX
835 mm	*32.87"*	5.9 kg	FC

C45: 560-710 N/mm²
950 kN/m max.

88°
H=60 | R=2.5 | V=12 mm
H=2.36 | R=0.098 | V=0.31 in

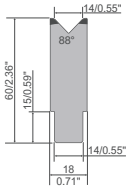


07600

835 mm	*32.87"*	6.1 kg	
415 mm	*16.34"*	3 kg	
795 mm	*31.29"*	5.8 kg	FX
835 mm	*32.87"*	5.9 kg	FC

C45: 560-710 N/mm²
950 kN/m max.

88°
H=60 | R=2.5 | V=14 mm
H=2.36 | R=0.098 | V=0.55 in





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



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

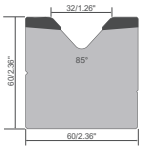


03500

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

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=4 | V=32 mm
H=2.36 | R=0.157 | V=1.26 in



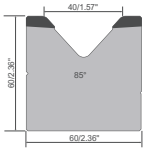


03600

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

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=4 | V=40 mm
H=2.36 | R=0.157 | V=1.57 in



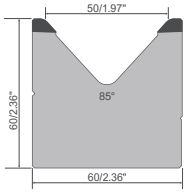


03700

835 mm *32.87"* 18.9 kg
415 mm *16.34"* 9.4.0 kg
795 mm *31.29"* 18.9 kg FX
805 mm *31.69"* 18.9 kg F

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=60 | R=4 | V=50 mm
H=2.36 | R=0.157 | V=1.97 in



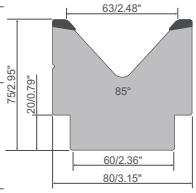


03800

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

C45: 560-710 N/mm²
1000 kN/m max.

85°
H=75 | R=5 | V=63 mm
H=2.95 | R=0.196 | V=2.48 in





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



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



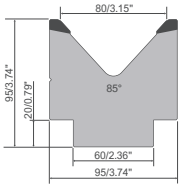
01360

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

85° >

C45: 560-710 N/mm²
700 kN/m max.

85°
H=95 | R=6 | V=80 mm
H=3.74 | R=0.236 | V=3.15 in





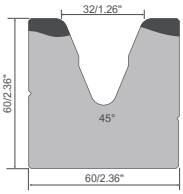
34200

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

45° >

C45: 560-710 N/mm²
400 kN/m max.

45°
H=60 | R=5 | V=32 mm
H=2.36 | R=0.196 | V=1.26 in



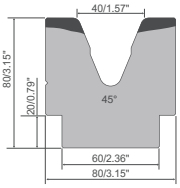


34300

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

C45: 560-710 N/mm²
700 kN/m max.

45°
H=80 | R=5 | V=40 mm
H=3.15 | R=0.196 | V=1.57 in





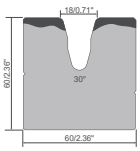
34000

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

30° >

C45: 560-710 N/mm²
800 kN/m max.

30°
H=60 | R=3 | V=18 mm
H=2.36 | R=0.118 | V=0.71 in





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



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

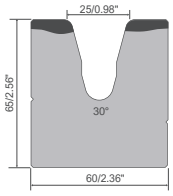


34100

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

C45: 560-710 N/mm²
600 kN/m max.

30°
H=65 | R=4 | V=25 mm
H=2.56 | R=0.0.157 | V=0.98 in



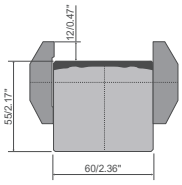


05500

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

C45: 560-710 N/mm²
1000 kN/m max.

Holder





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



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



CFH dies are designed to complete the range of CFH tools and guarantee the same dimensions of Amada style tools.

Rolleri CFH dies range from 86° to 30°, are 835mm *32.87"*, 510mm *20.08"*, 415mm *16.34"*, 200mm *7.87"* long and have 805mm, 795mm and 370mm sectioned sets.

Furthermore, in order to meet all bending requirements, they are made of 42CrMo4 tool steel and undergo a specific heating treatment to reach certain hardness level which can improve the tool operational life.

Available on request:

510 mm | *20.08"*

200 mm | *7.87"*

370 mm | *14.57"* mm: 100-300-150-50-40-20-15-15-10-100

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

CFH60.06.86

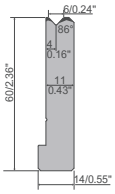
835 mm *32.87"* 5.1 kg
415 mm *16.34"* 2.5 kg
800 mm *31.50"* 4.8 kg F

86° >

42Cr:900-1500 N/mm²
800 kN/m max.

86°
H=60 | R=1.5 | V=6 mm
H=2.36 | R=0.059 | V=0.23 in

NEW





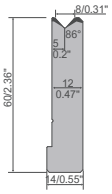
CFH60.08.86

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

42Cr:900-1500 N/mm²
900 kN/m max.

86°
H=60 | R=1.5 | V=8 mm
H=2.36 | R=0.059 | V=0.31 in

NEW



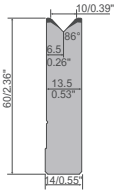
CFH60.10.86

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

42Cr:900-1500 N/mm²
1000 kN/m max.

86°
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in

NEW





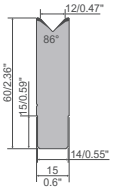
CFH60.12.86

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

42Cr:900-1500 N/mm²
650 kN/m max.

86°
H=60 | R=2.5 | V=12 mm
H=2.36 | R=0.098 | V=0.47 in

NEW



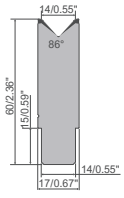
CFH60.14.86

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

42Cr:900-1500 N/mm²
1000 kN/m max.

86°
H=60 | R=2.5 | V=14 mm
H=2.36 | R=0.098 | V=0.55 in

NEW





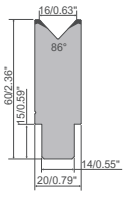
CFH60.16.86

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

42Cr:900-1500 N/mm²
1000 kN/m max.

86°
H=60 | R=2.5 | V=16 mm
H=2.36 | R=0.098 | V=0.63 in

NEW



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

Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.

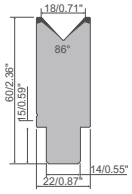
CFH60.18.86

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

42Cr:900-1500 N/mm²
1000 kN/m max.

86°
H=60 | R=2.5 | V=18 mm
H=2.36 | R=0.098 | V=0.71 in

NEW





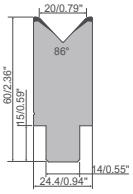
CFH60.20.86

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

42Cr:900-1500 N/mm²
1000 kN/m max.

86°
H=60 | R=3 | V=20 mm
H=2.36 | R=0.118 | V=0.79 in

NEW



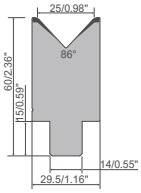
CFH60.25.86

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

42Cr:900-1500 N/mm²
1000 kN/m max.

86°
H=60 | R=3 | V=25 mm
H=2.36 | R=0.118 | V=0.98 in

NEW





CFH.60.04.30

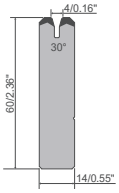
30° >

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

42Cr:900-1500 N/mm²
300 kN/m max.

30°
H=60 | R=1 | V=4 mm
H=2.36 | R=0.039 | V=0.16 in

NEW



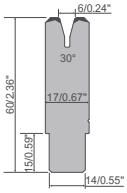
CFH.60.06.30

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

42Cr:900-1500 N/mm²
300 kN/m max.

30°
H=60 | R=1 | V=6 mm
H=2.36 | R=0.039 | V=0.24 in

NEW





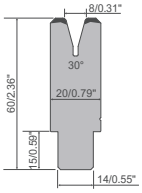
CFH.60.08.30

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

42Cr:900-1500 N/mm²
350 kN/m max.

30°
H=60 | R=1.5 | V=8 mm
H=3.15 | R=0.059 | V=0.31 in

NEW



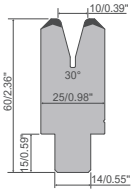
CFH.60.10.30

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

42Cr:900-1500 N/mm²
350 kN/m max.

30°
H=60 | R=2 | V=10 mm
H=2.36 | R=0.079 | V=0.39 in

NEW





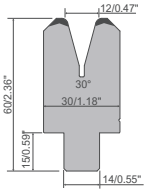
CFH.60.12.30

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

42Cr:900-1500 N/mm²
350 kN/m max.

30°
H=60 | R=2.5 | V=12 mm
H=3.15 | R=0.098 | V=0.47 in

NEW



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

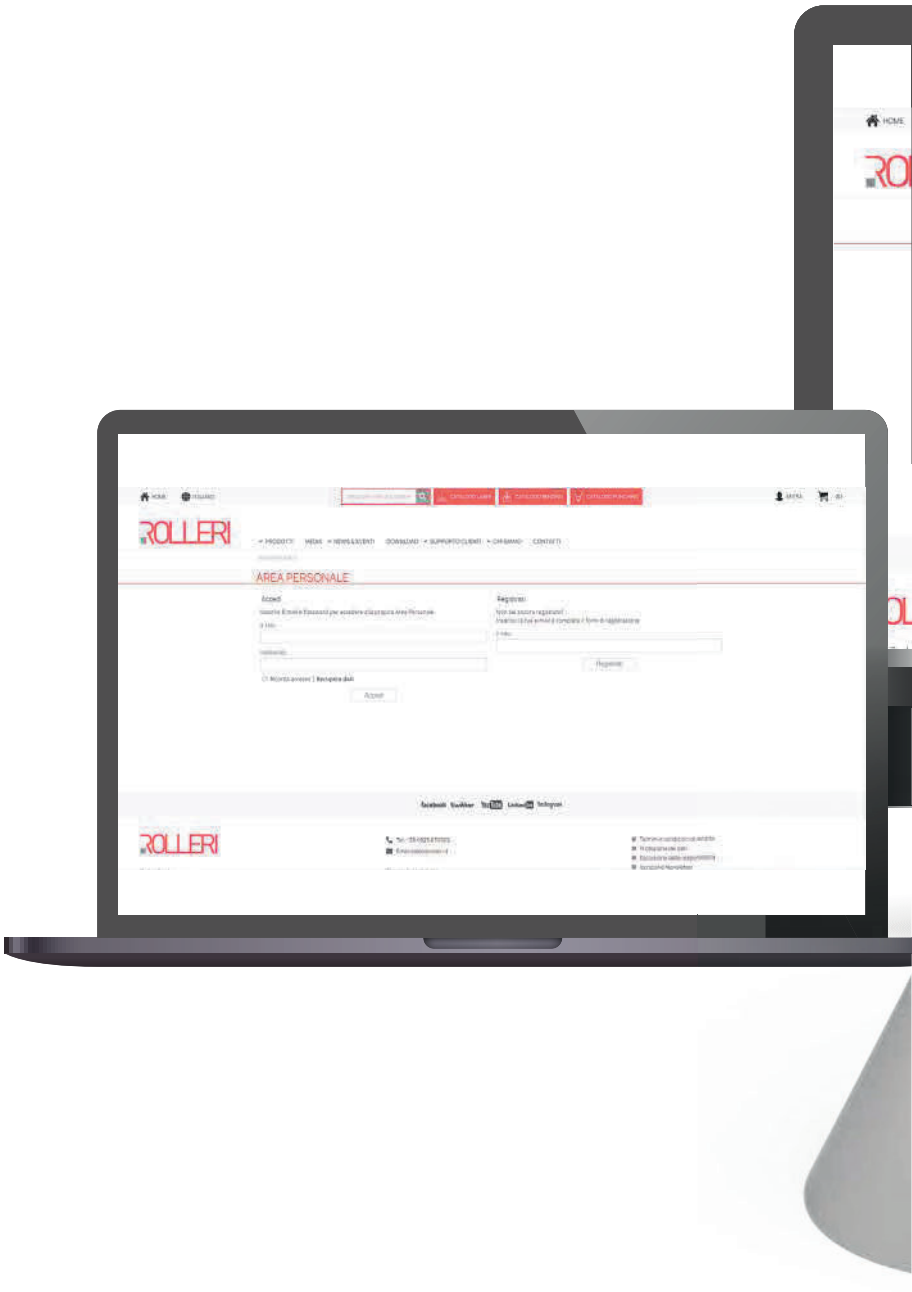


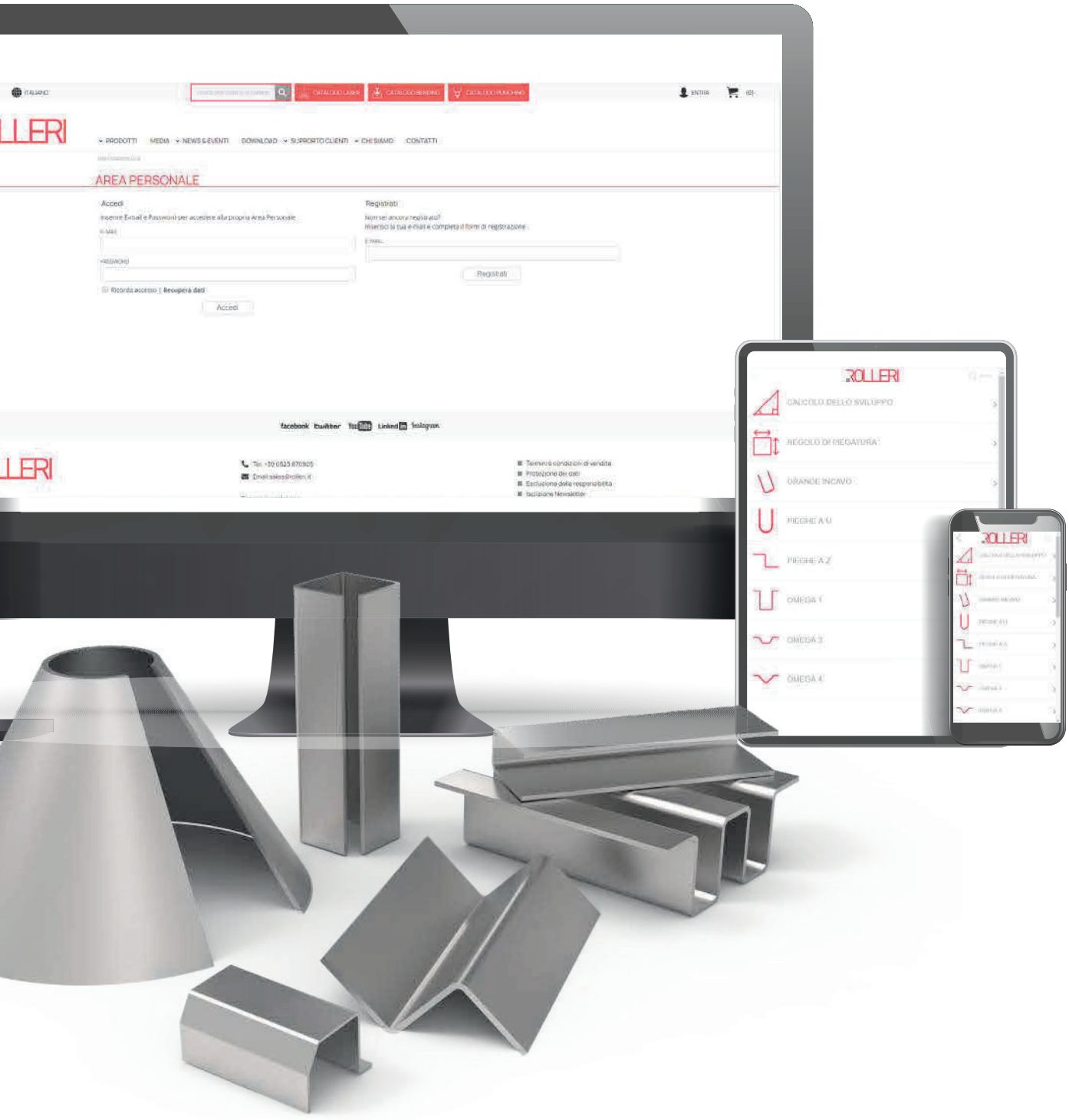


Download Rolleri **Bending App**.
You will have access to our online store where you can get what you need. You will also get our sheet metal unfolding software for free and our bending rule.

REGISTER AT **WWW.ROLLERITOOLS.COM** AND BY SIGNING IN YOU CAN USE MANY USEFUL TOOLS FOR SHEET METAL WORKING.

NEW ROLLERI **BENDING APP** CONTAINS USEFUL CALCULATION TOOLS FOR SHEET METAL WORKING.
YOU CAN FIND BENDING RULERS FOR MANY PROFILES LIKE JOGGLES, U PROFILES, OMEGA 1, OMEGA 3, OMEGA 4, HINGES, Z BENDS, FLATTENING, LARGE-RADIII, BIG GOOSENECK PUNCHES, ROLLA-V.




AREA PERSONALE
ROLLERI
CALCOLO DELLO SVILUPPO
REGOLO DI PIEGATURA
GRANDE INCAVO
PIEGHE A U
PIEGHE A Z
OMEGA 1
OMEGA 3
OMEGA 4



English edition 1.0 | 2021

Rolleri S.p.A.
Via Artigiani · Loc. Cabina · 29020
Vigolzone (PC) · Italy
Tel. +39 0523 870905
Fax +39 0523 879030
www.rolleritools.com
sales@rolleri.it

linkedin | *facebook* | *instagram* | *twitter* | *youtube* | *vimeo*

Rolleri is committed to protecting the environment by using FSC certified paper