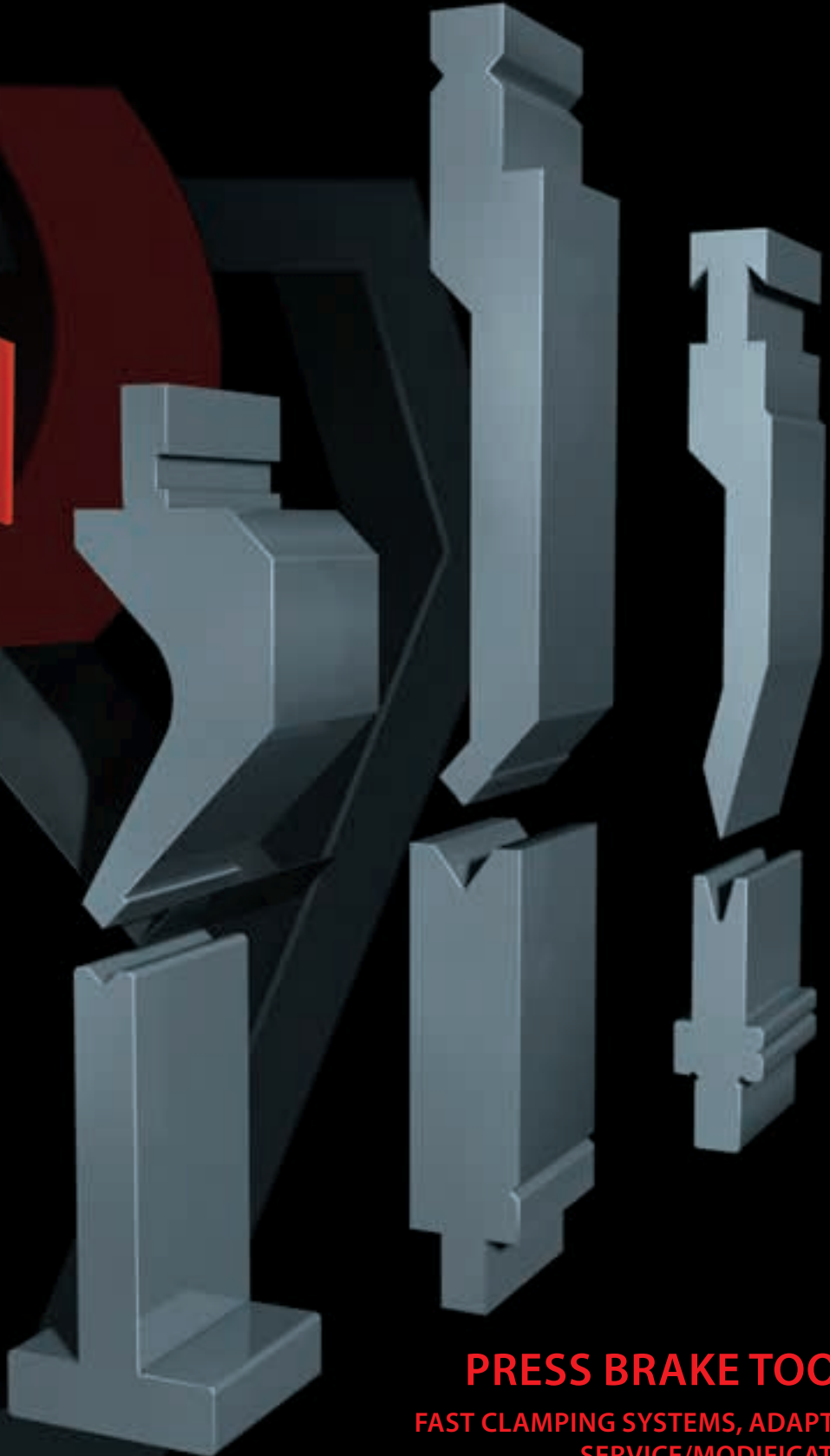




**ROLLERI®**

**PROFESSIONAL  
BENDING**

**DIRECTLY  
FROM THE  
MANUFACTURER!**



**PRESS BRAKE TOOLS**

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

## ROLLERI

### WELCOME ...

... to the new Rolleri catalogue!

Rolleri is one of the few **real manufacturers** of press brake tools – not a reseller and not a dealer. Therefore we emphasize great importance as being **producer** of press brake tools to bring you further advantages.

- no margin division
- direct access to the production
- direct communication, not only by specific and special bending tools.
- Competent and truthful statement about prices and delivery times – without tedious queries!

**Convince yourself of our service and quality of tools!**



### THE COMPANY

Since 1987 we have been producing standard and special tooling. The family owned company (Francesco and Marco Rolleri) can nowadays be considered one of the largest press brake tooling manufacturers in Europe. We are internationally available with our branches Rolleri Brasil, Rolleri USA, Rolleri India, Rolleri Deutschland GmbH, Rolleri China, Rolleri Ukraine and Rolleri Benelux, for you to utilize our global experience and footprints.

We offer fast and reliable service through our partners in all of Europe. In 2012, we have completely restructured our facilities internally. The focus of direct sales structures in the individual countries has greatly improved. We present to you, a new expanded portfolio, a significantly enlarged stock, new corporate design, and a completely new catalog that you now hold in your hands. Our promise to an alternative for you Worldwide.

### THE TEAM

The Rolleri team is made up of all ages. We are innovative, dynamic and experienced, with consistency and harmony. Our mission is to bring you the best results in tool production. At Rolleri teamwork is the key to achieve outstanding customer service, research and development, great warehouse efficiency, and vast productivity.

The exceptional atmosphere in our facilities always has a positive impact on our products.



### Rolleri Videos

Company Presentation  
[www.rolleritools.com/videos/company-rolleri](http://www.rolleritools.com/videos/company-rolleri)



### THE PRODUCTION

All production phases are certified and up to quality check standards and safety regulations. Thereby we guarantee you consistent high quality with modern CNC-machines.

All tools are laser marked with a serial number. Thus, allowing every single tool to be identified and easily tracked for reproduction.

This is what we call accurate repetition.

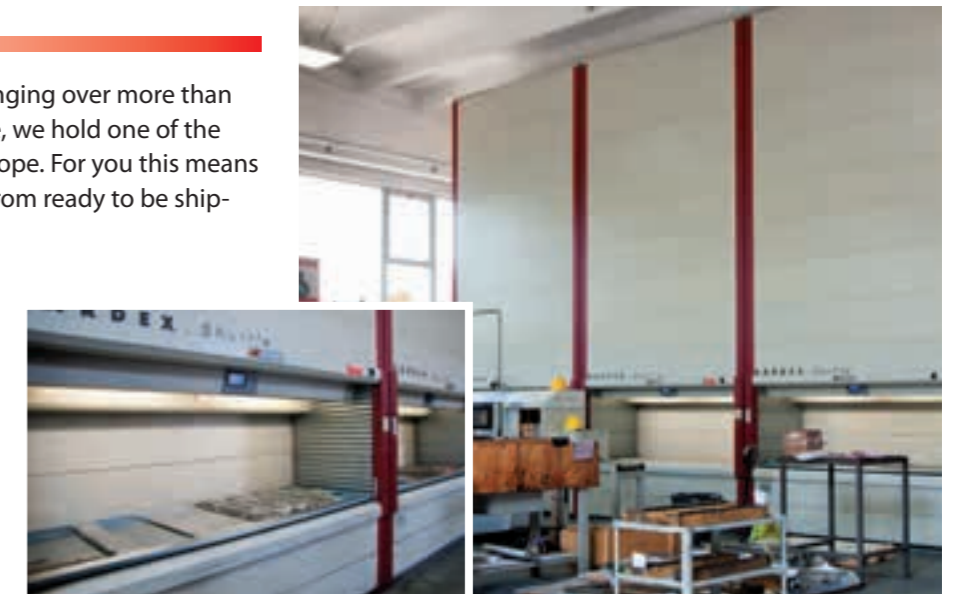


### THE WAREHOUSE

We at Rolleri, have a wide stock ranging over more than 20,000 press brake tools. Therefore, we hold one of the largest in house stocks in all of Europe. For you this means a vast amount of tools to choose from ready to be shipped all around the world.



Look for this symbol in the catalogue!



### THE SERVICE

We understand that finding the right tool for the right application is of your importance. Thus, we have invested hard work into our quality service:

- Consulting,
  - Technical assistance,
  - Training for your bending specialists,
- this is our daily business bringing you great support!

Check out our **website: [www.rolleritools.com](http://www.rolleritools.com)**



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

THE CONSTRUCTION

Besides constructing many special tools, our research and development team also innovates special clamping systems which increases your productivity. Technicians and Engineers develop for you solutions which are economic and practical.

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

Inquire with us today!



THE RAW MATERIAL

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



THE QUALITY

Rolleri ISO 9001:2008 certified. To be your choice supplier means much more to us; together we can find the best and most economic tool and develop a vast number of bending solutions. We also offer training for your employees in the bending department. These are qualities, where we are glad to assist you along with our extravagant number of bending products.

THE PRESS BRAKE TOOLS

Rolleri manufactures all tools in their own production facilities. We put great importance into our precision grinding, guaranteeing accurate reproduction of tools, exact concurrency. We induction harden all tools at 54-60 HRC to get the best results for your punches and dies. Each tool is subjected to quality control and then provided with a serial number to simplify and guarantee tracking.



THE QUALITY CONTROL

An extra quality control department reviews and tests every single tool after a complete production cycle.

Every tool is given a serial number and batch number, after being carefully examined. This process guarantees a 100% retracing possibility of the tool.

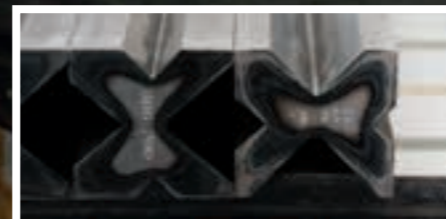
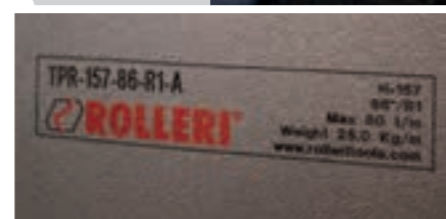
Of course Rolleri also guarantees accurate reproduction, high-quality material, induction hardening, and precision grinding.



INNOVATIONS

Rolleri produces for many press brake manufacturers the clamping systems - whether they are hydraulic, pneumatic, or manual.

Our new QuickLock-System, compatible for our Rolleri Type R2 or our new ROL 100 for Rolleri Type R1, are all new developments from Rolleri which are manufactured in our production facilities.



## Compatibility

### ■ Tools Roller Type R1

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

### ■ Tools Roller Type R2

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

### ■ Tools Roller Type R3

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

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

### ■ Tools Roller Type RX

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

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

PUNCHES ROLLERI TYPE R1

DIES ROLLERI TYPE R1

PUNCHES ROLLERI TYPE R2

DIES ROLLERI TYPE R2

PUNCHES ROLLERI TYPE R3

DIES ROLLERI TYPE R3

TOOLS ROLLERI TYPE RX

ROLLERI DIES ROLLA-V

ROLLERI CLAMPING SYSTEMS

ROLLERI ADAPTERS

ROLLERI MARK FREE BENDING

ROLLERI SPECIAL AND HEAVY DUTY TOOLS

ROLLERI SERVICE / MODIFICATIONS

ROLLERI SHEAR BLADES / ACCESSORIES

## PUNCHES ROLLERI TYPE R1

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### Compatibility

Punches RollerI Type R1 are compatible with press brake machines from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.

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



### Compatibility

Punches Roller Type R1 are:

- compatible with press brake machines from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brake machines with adapter-systems (see pages 212-217).

### Material

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

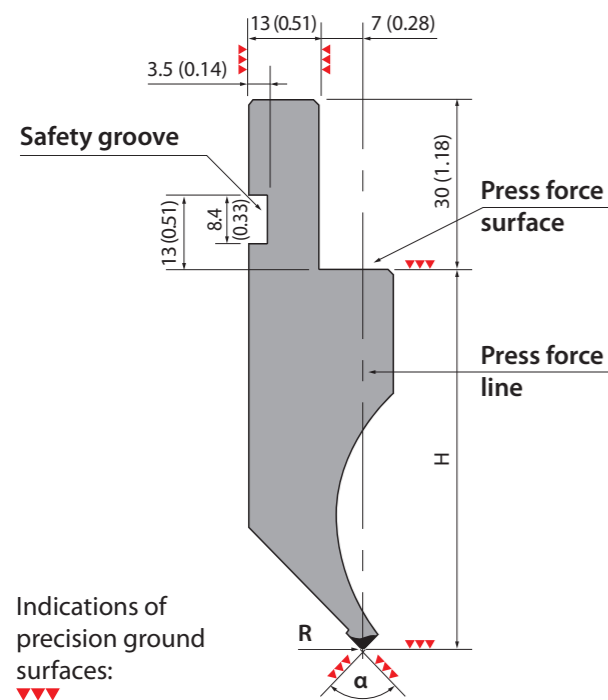
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm <sup>2</sup>	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC

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

### Tang

All punches Roller Type R1:

- are standardized with a **8.4 x 3.5 mm (0.331 x 0.138 in) safety groove**, that keeps the tool from falling out.
- depending on the clamping system: **horizontal** or **vertical**, tool exchange is possible (see pages 198-205)



Indications of precision ground surfaces:  
▲▲▲

### Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 248-249)
- very large stock availability

### Modifications from Safety Grooves

**A1**

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

- Pneumatic clamping

**A6**

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

- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan

**A7**

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

- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan

**A8**

Groove for:

- hydraulic clamping Gasparini

**A9**

Modified groove for:

- Rolleri Type R3

**A41**

Modified groove for:

- Rolleri Type R3

**A42**

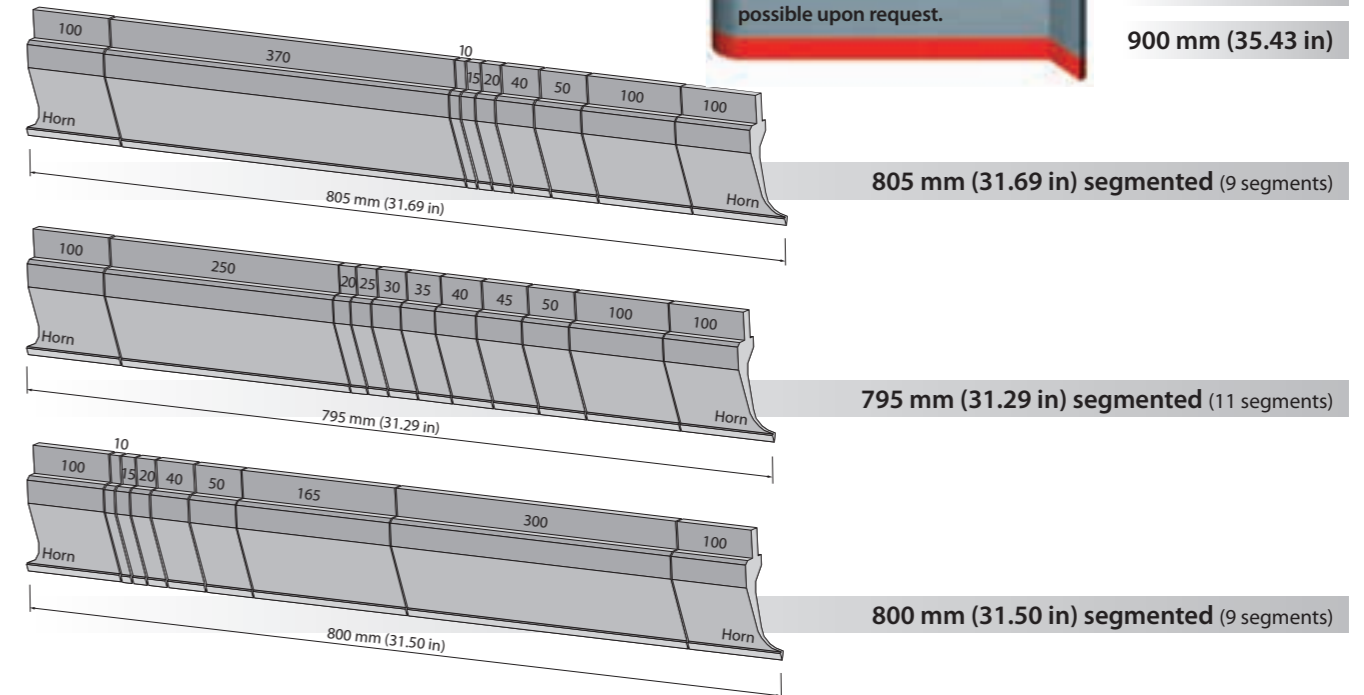
Modified groove for:

- Rolleri Type R3

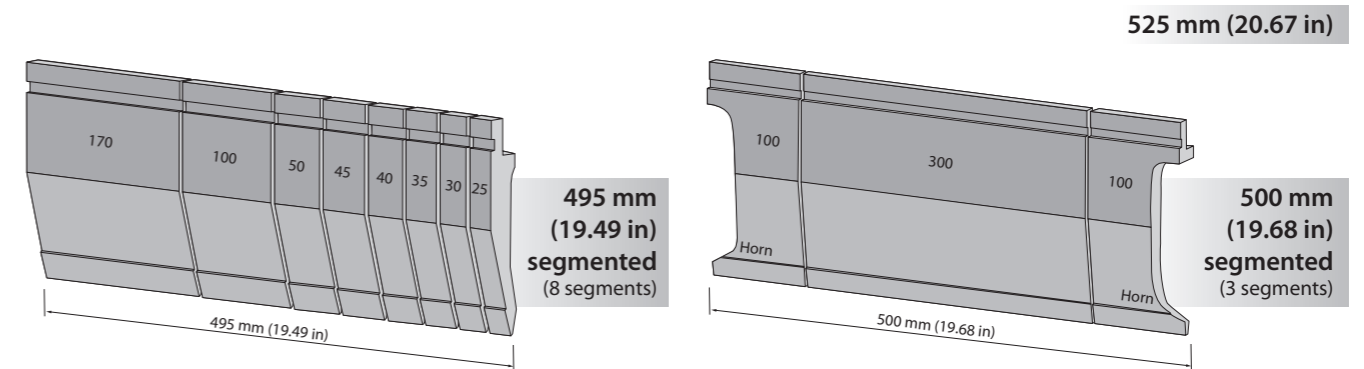
More modifications possible upon your request!  
Give us a call or send us an inquiry!

### Tool lengths and sectioning

Standard



Rolleri TOP-System



### Horn Types

**HORN 1**

20 (0.79)  
R 25 (0.98)  
9 (0.35)

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

**HORN 2**

30 (1.18)  
R 20 (0.79)  
13 (0.51)

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

**HORN 3**

35 (1.38)  
R 5 (0.197)  
10 (0.39)  
35 (1.38)

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

**HORN 4**

25 (0.98)  
R 10 (0.39)  
10 (0.39)  
20 (0.79)

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

**HORN 5**

20 (0.79)  
R 8 (0.31)  
12 (0.47)  
18 (0.71)

**Horn 5 for punches:**  
10300

**HORN 6**

30 (1.18)  
R 5 (0.197)  
12 (0.47)  
35 (1.38)

**Horn 6 for punches:**  
00300

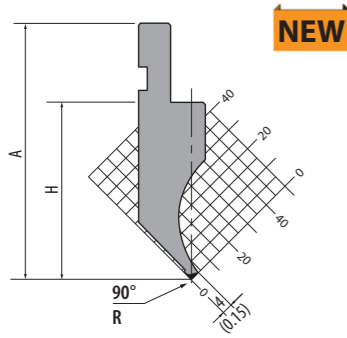
**Horn individual**  
produced according to your specifications

# R1 ROLLERI TYPE R1

## 90° Punches

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

350 kN/m max.

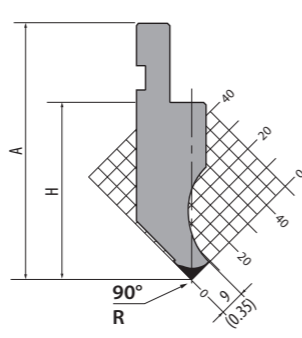


<b>PK.97.90.R06</b>		
H=66.80 / A=96.80 / R=0.6 (H=2.63 / A=3.81 / R=0.024)		
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.69 in segmented	10.1 kg
<b>P.97.90.R025</b>		
H=66.80 / A=96.80 / R=0.25 (H=2.63 / A=3.81 / R=0.010)		
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.69 in segmented	10.1 kg

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

### PK.97.90.R08 / R025

1000 kN/m max.

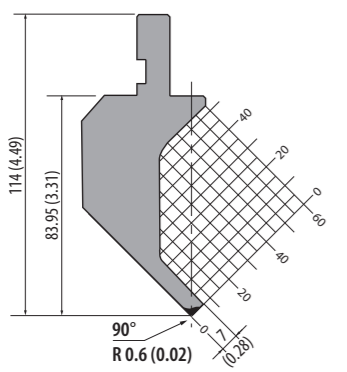


<b>PK.97.90.R08</b>		
H=66.35 / A=96.35 / R=0.8 (H=2.61 / A=3.79 / R=0.031)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.5 kg
<b>PK.97.90.R025</b>		
H=66.60 / A=96.60 / R=0.25 (H=2.62 / A=3.80 / R=0.010)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.5 kg

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

### PK.114.90.R06

200 kN/m max.

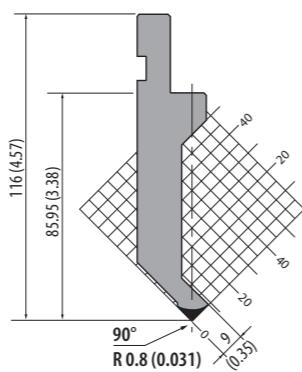


835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

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

### PK.116.90.R08

400 kN/m max.

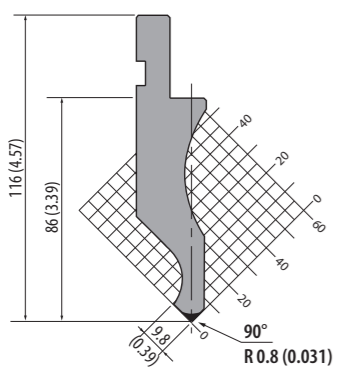


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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

### DK.116.90.R08

500 kN/m max.

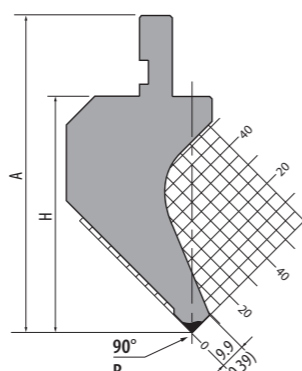


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.4 kg

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

### PK.120.90.R08 / R025

600 kN/m max.



<b>PK.120.90.R08</b>		
H=89.35 / A=119.35 / R=0.8 (H=3.52 / A=4.70 / R=0.031)		
835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	20.0 kg
805 mm segmented	31.69 in segmented	20.2 kg
<b>PK.120.90.R025</b>		
H=89.60 / A=119.60 / R=0.25 (H=3.53 / A=4.71 / R=0.010)		
835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	20.0 kg
805 mm segmented	31.69 in segmented	20.2 kg

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

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

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

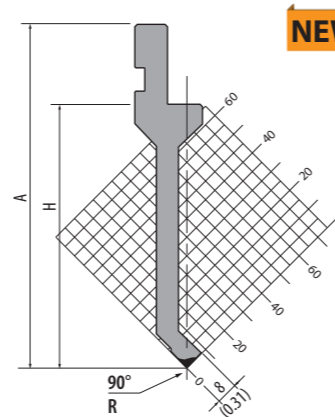
# R1 ROLLERI TYPE R1

## 90° Punches



### P.130.90.R06 / R025

350 kN/m max.

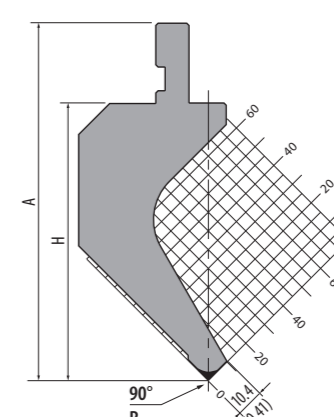


<b>P.130.90.R06</b>		
H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024)		
835 mm	32.87 in	11.5 kg
415 mm	16.34 in	5.7 kg
795 mm segmented	31.29 in segmented	10.9 kg
805 mm segmented	31.69 in segmented	11.0 kg
<b>P.130.90.R025</b>		
H=100.00 / A=130.00 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
835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

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

### PK.135.90.R08 / R025

500 kN/m max.



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

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

## 90° Segmented Punches with Mobile Horns



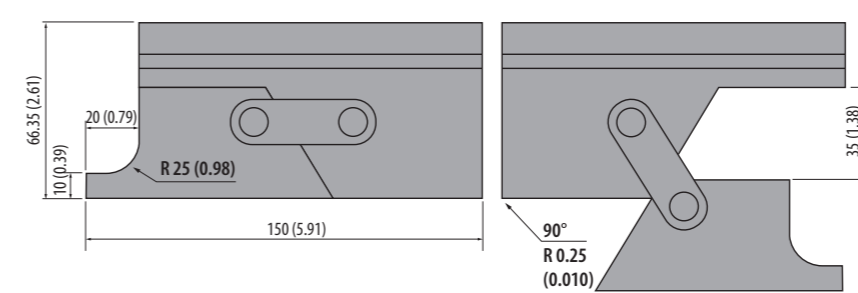
### Area of Application

- for easy bending of special box profiles

**Rolleri Videos**  
mobile horn demonstration at:  
[www.rolleritools.com/videos/mobile-horns](http://www.rolleritools.com/videos/mobile-horns)

### SCA.M.90.R08

150 kN/m max.

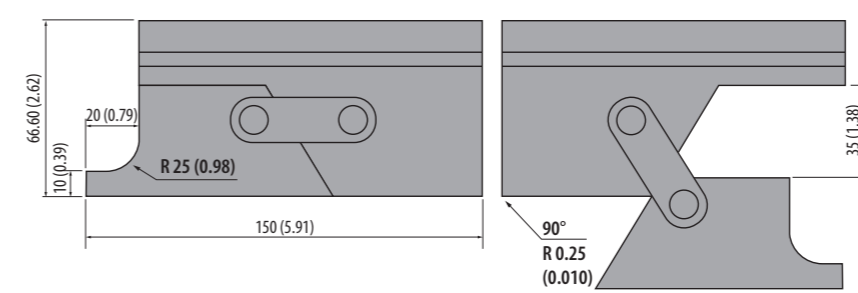


**NEW** per pair 3.5 kg  
1 Pair left/right compatible with PK.97.90.R08

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

### SCA.M.90.R025

150 kN/m max.



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

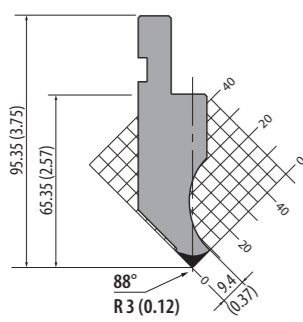
C45: 560-710 N/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

## 88° Punches

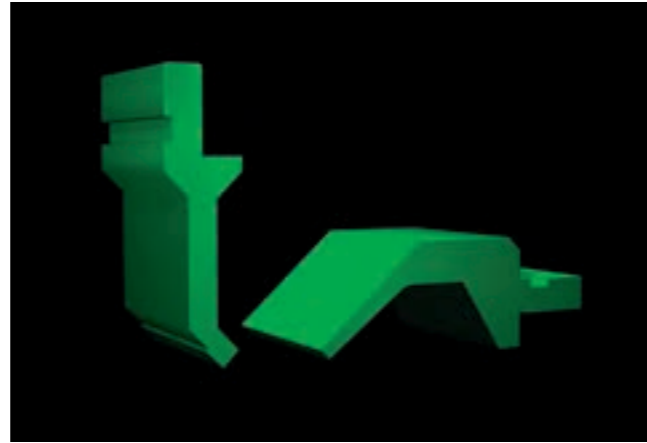
### P.95.88.R3

1000 kN/m max.



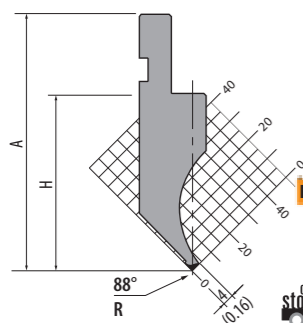
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.6 kg

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



### P.97.88.R06 / R025

350 kN/m max.



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

H=66.95 / A=96.95 / R=0.25  
(H=2.64 / A=3.82 / R=0.010)

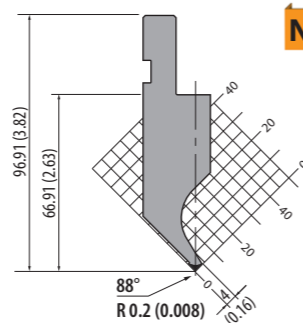
835 mm	32.87 in	9.5 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.0 kg
805 mm segmented	31.69 in segmented	9.2 kg
900 mm	35.43 in	11.0 kg

C42Cr: 900-1150 N/mm<sup>2</sup>



### 11700

200 kN/m max.



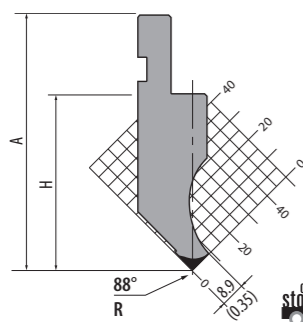
835 mm	32.87 in	10.7 kg
415 mm	16.34 in	5.3 kg
795 mm segmented	31.29 in segmented	10.2 kg
800 mm segmented	31.50 in segmented	10.3 kg

C42Cr: 900-1150 N/mm<sup>2</sup>



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

1000 kN/m max.



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

H=66.60 / A=96.60 / R=0.25  
(H=2.62 / A=3.80 / R=0.010)

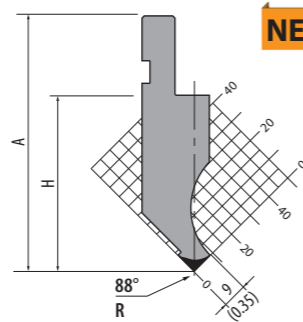
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.6 kg
900 mm	35.43 in	11.8 kg

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



### 00402 / 00430

1000 kN/m max.



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

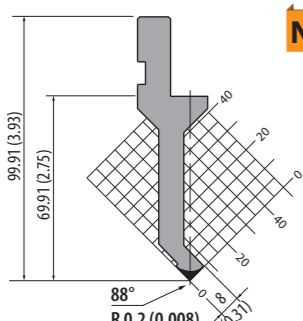
H=65.68 / A=95.68 / R=3 (H=2.59 / A=3.77 / R=0.118)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
800 mm segmented	31.50 in segmented	10.5 kg

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



### 20000

300 kN/m max.



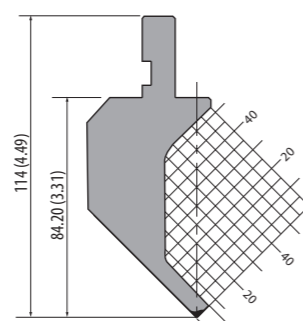
835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
800 mm segmented	31.50 in segmented	7.6 kg

C42Cr: 900-1150 N/mm<sup>2</sup>



### P.114.88.R06

200 kN/m max.



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

C42Cr: 900-1150 N/mm<sup>2</sup>



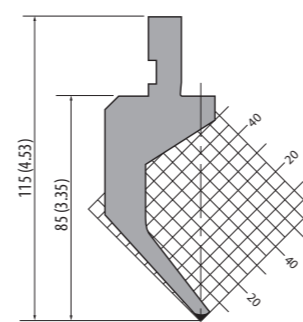
# R1 ROLLERI TYPE R1

## 88° Punches



### P.115.88.R06

130 kN/m max.



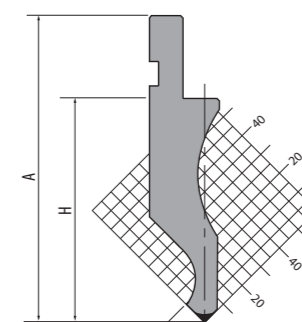
835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.7 kg
805 mm segmented	31.69 in segmented	5.8 kg

C42Cr: 900-1150 N/mm<sup>2</sup>



### D.116.88.R08 / R3

500 kN/m max.



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

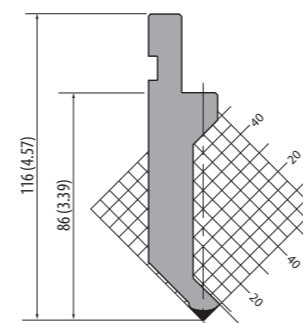
H=85.00 / A=115.00 / R=3.0 (H=3.35 / A=4.53 / R=0.118)		
835 mm	32.87 in	11.9 kg
415 mm	16.34 in	5.9 kg
795 mm segmented	31.29 in segmented	11.3 kg
805 mm segmented	31.69 in segmented	11.5 kg

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



### P.116.88.R08

400 kN/m max.



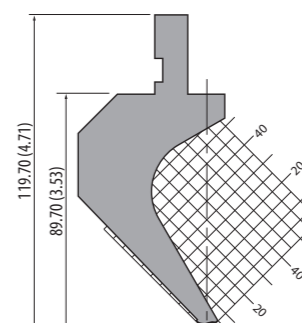
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.4 kg
805 mm segmented	31.69 in segmented	11.5 kg

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



### PS.120.88.R08

450 kN/m max.



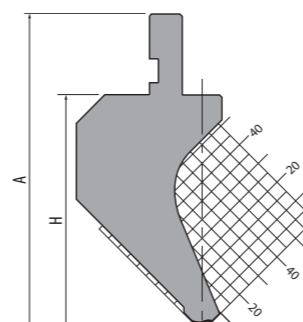
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg

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



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

600 kN/m max.



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

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

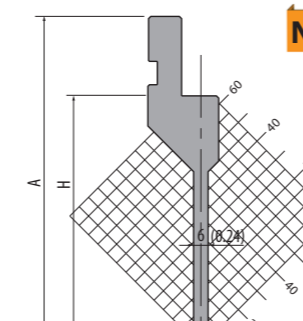
H=89.60 / A=120.00 / R=0.25 (H=3.53 / A=4.72 / R=0.010)		
835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	20.0 kg
805 mm segmented	31.69 in segmented	20.2 kg

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



### 10900 / 10906

500 kN/m max.



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

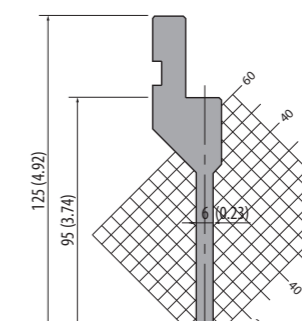
H=94.74 / A=124.74 / R=0.6 (H=3.73 / A=4.91 / R=0.024)		
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
795 mm segmented	31.29 in segmented	8.5 kg
800 mm segmented	31.50 in segmented	8.6 kg

C42Cr: 900-1150 N/mm<sup>2</sup>



### P.125.88.R025

500 kN/m max.



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

C42Cr: 900-1150 N/mm<sup>2</sup>





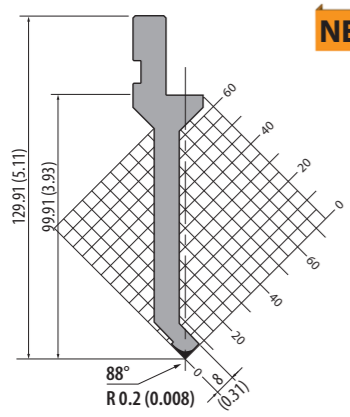
# R1 ROLLERI TYPE R1

88° Punches



1  
R1

## 20200 300 kN/m max.

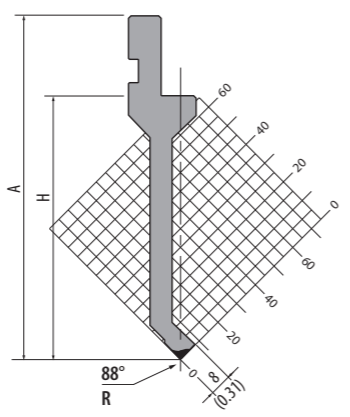


835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
800 mm segmented	31.50 in segmented	9.6 kg

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



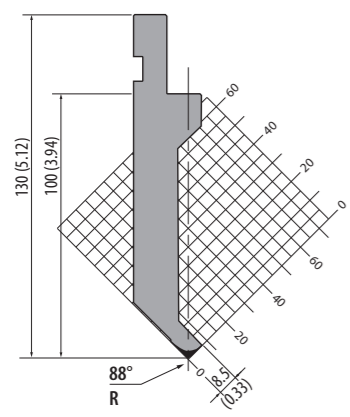
## P.130.88.R06 / PK.130.88.R025 350 kN/m max.



P.130.88.R06		
H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024)		
835 mm	32.87 in	9.8 kg
415 mm	16.34 in	4.9 kg
795 mm segmented	31.29 in segmented	9.3 kg
805 mm segmented	31.69 in segmented	9.4 kg
900 mm	35.43 in	10.5 kg
PK.130.88.R025		
H=99.95 / A=129.95 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
795 mm segmented	31.29 in segmented	9.2 kg
805 mm segmented	31.69 in segmented	9.3 kg
900 mm	35.43 in	10.4 kg

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

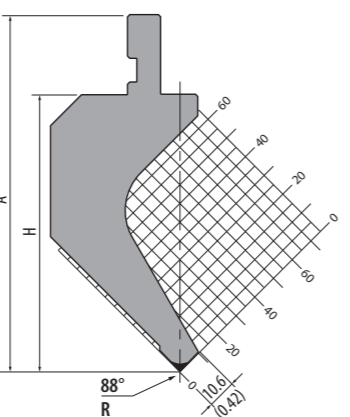
## P.130.88.R08 / R025 400 kN/m max.



P.130.88.R08		
H=100.00 / A=130.00 / R=0.8 (H=3.94 / A=5.12 / R=0.031)		
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.4 kg
P.130.88.R025		
H=100.00 / A=130.00 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
835 mm	32.87 in	13.7 kg
415 mm	16.34 in	6.8 kg
795 mm segmented	31.29 in segmented	13.0 kg
805 mm segmented	31.69 in segmented	13.2 kg

C45: 560-710 N/mm<sup>2</sup> HORN 1

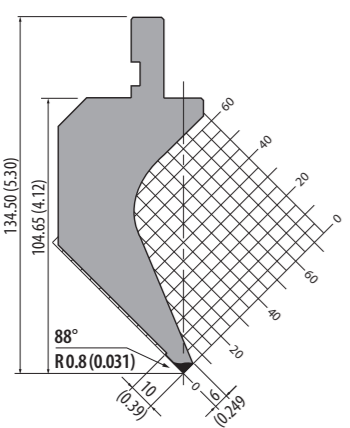
## P.135.88.R08 / R3 / PK.135.88.R025 500 kN/m max.



P.135.88.R08		
H=104.65 / A=134.50 / R=0.8 (H=4.12 / A=5.30 / R=0.031)		
835 mm	32.87 in	22.5 kg
415 mm	16.34 in	11.2 kg
795 mm segmented	31.29 in segmented	21.4 kg
805 mm segmented	31.69 in segmented	21.7 kg
P.135.88.R3		
H=103.40 / A=133.40 / R=3.0 (H=4.07 / A=5.25 / R=0.118)		
835 mm	32.87 in	22.5 kg
415 mm	16.34 in	11.2 kg
795 mm segmented	31.29 in segmented	21.4 kg
805 mm segmented	31.69 in segmented	21.7 kg
PK.135.88.R025		
H=104.60 / A=134.50 / R=0.25 (H=4.12 / A=5.30 / R=0.010)		
835 mm	32.87 in	22.7 kg
415 mm	16.34 in	11.5 kg
795 mm segmented	31.29 in segmented	21.6 kg
805 mm segmented	31.69 in segmented	21.8 kg

C45: 560-710 N/mm<sup>2</sup> HORN 1

## PS.135.88.R08 450 kN/m max.

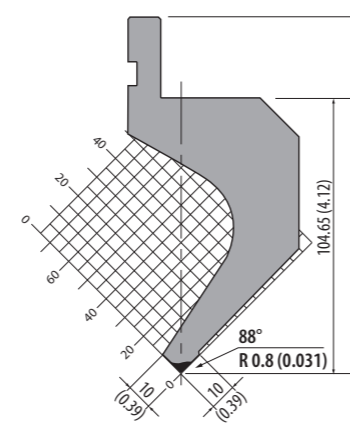


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	12.5 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

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



## PR.135.88.R08 450 kN/m max.



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

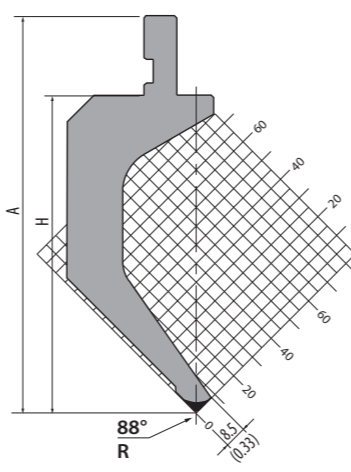
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

88° Punches

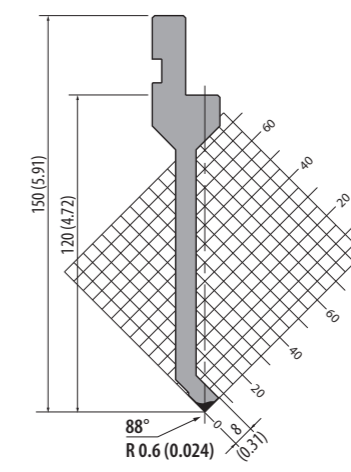
## P.150.88.R08 / R3 500 kN/m max.



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

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

## P.150.88.R06 350 kN/m max.

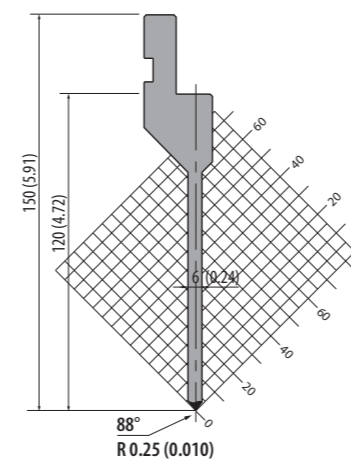


900 mm	35.43 in	12.9 kg
415 mm	16.34 in	5.9 kg
795 mm segmented	31.29 in segmented	12.2 kg
805 mm segmented	31.69 in segmented	12.4 kg

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



## P.150.88.R025 500 kN/m max.

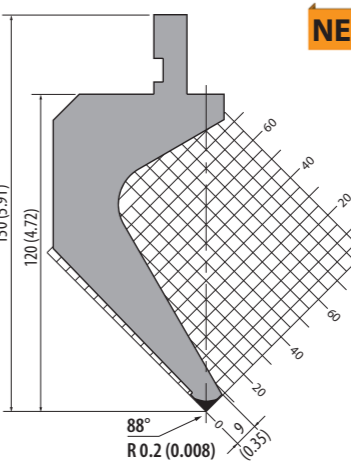


900 mm	32.87 in	10.0 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.6 kg

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



## 04702 500 kN/m max.

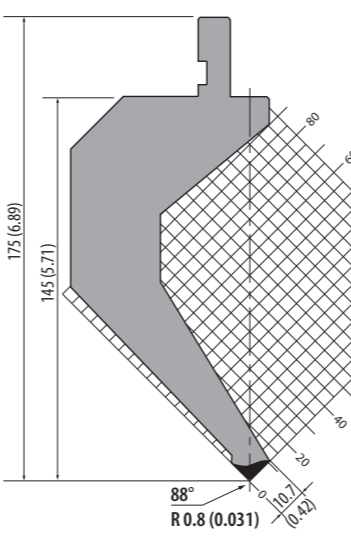


835 mm	32.87 in	26.0 kg
415 mm	16.34 in	12.9 kg
795 mm segmented	31.29 in segmented	24.8 kg
800 mm segmented	31.50 in segmented	24.9 kg

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



## P.175.88.R08 500 kN/m max.



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

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

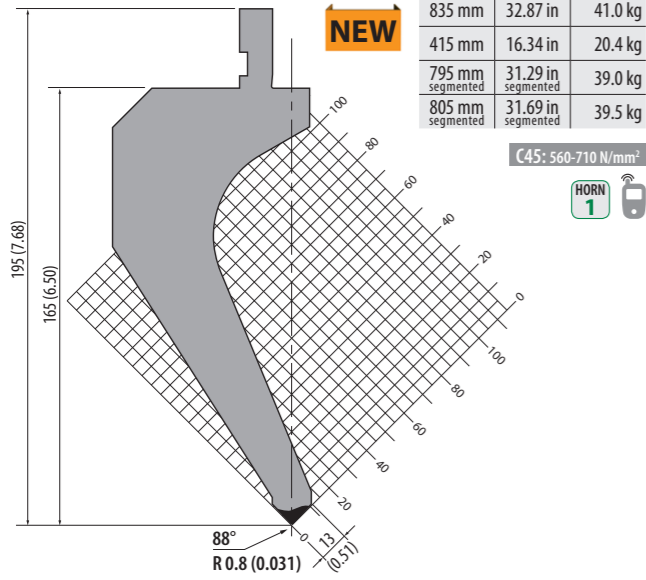


# R1 ROLLERI TYPE R1

88° Punches

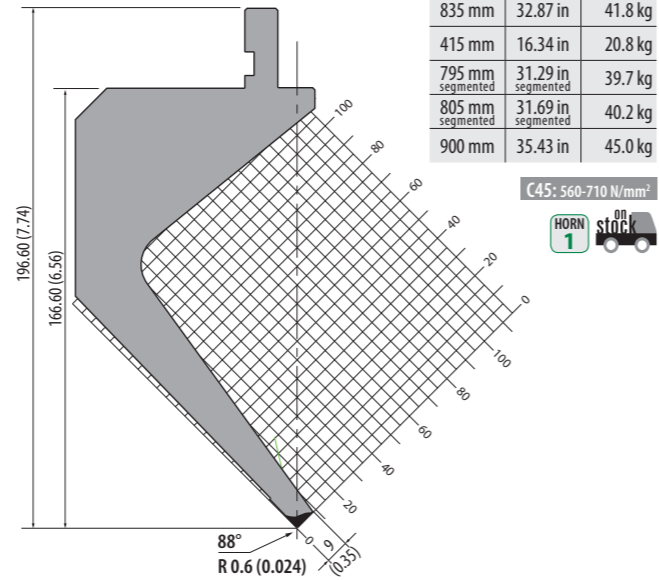
## P.195.88.R08

600 kN/m max.



## P.196.88.R06

300 kN/m max.



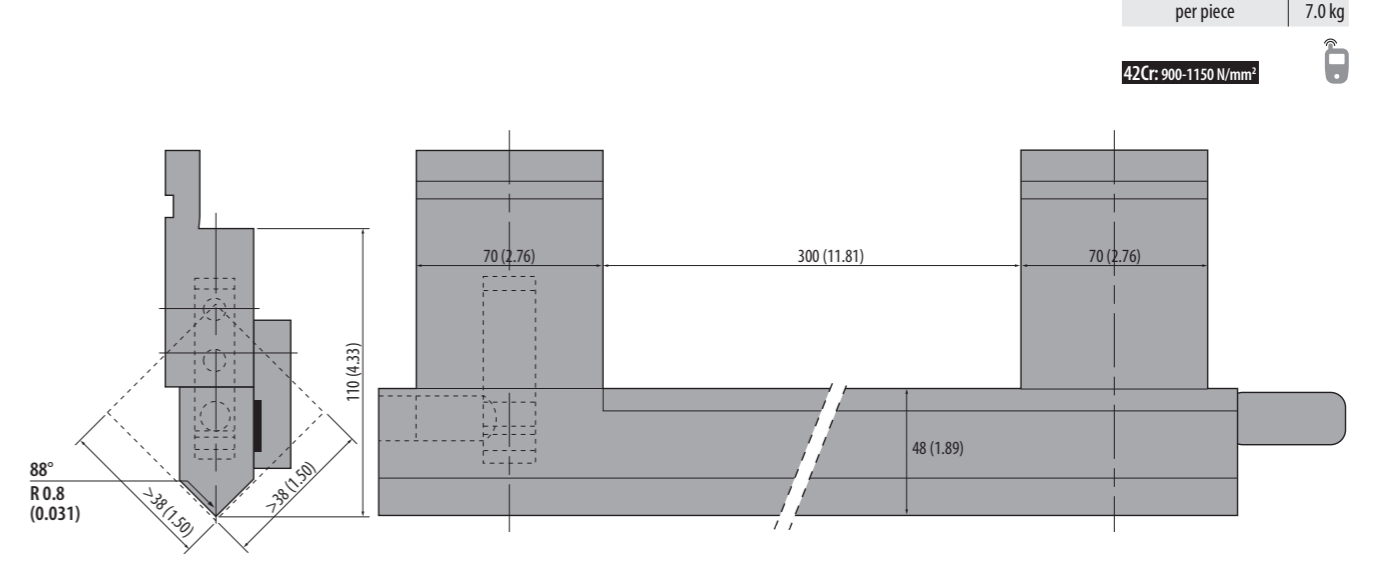
# R1 ROLLERI TYPE R1

88° Punches for closed profiles

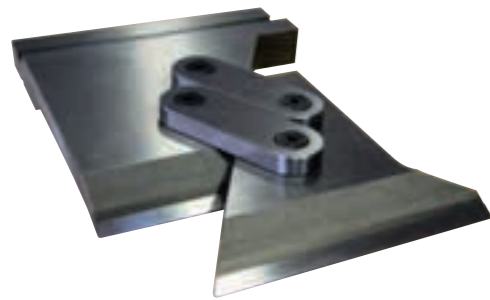


## SPE.11

150 kN/m max.



## 88° Segmented Punches with Mobile Horns



### Area of Application

- for easy bending of special box profiles

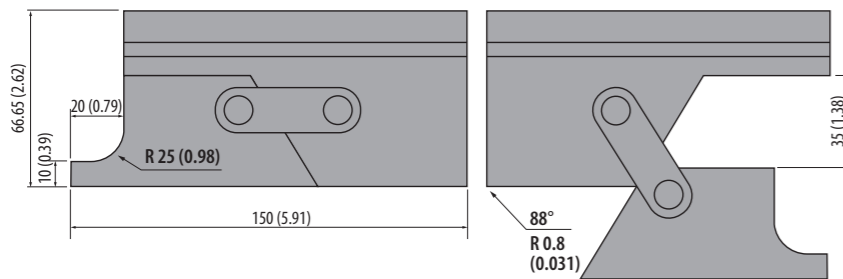


### Rolleri Videos

mobile horn demonstration at:  
[www.rolleritools.com/videos/mobile-horns](http://www.rolleritools.com/videos/mobile-horns)

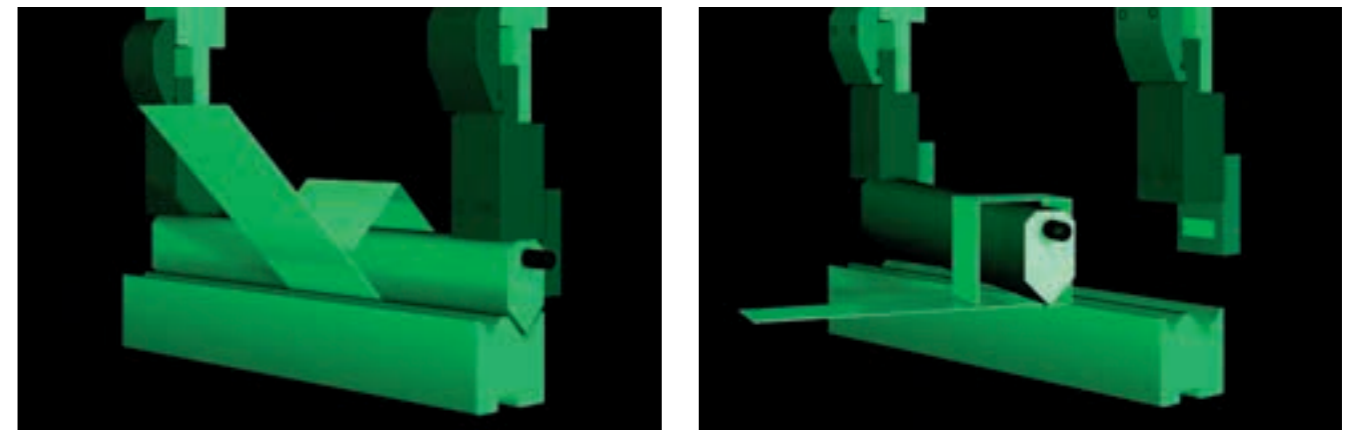
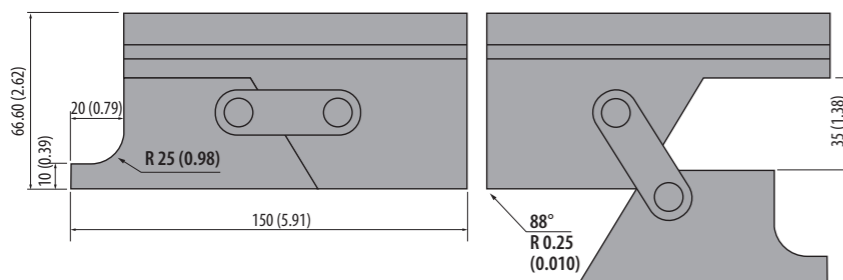
## SCA.M.88.R08

150 kN/m max.

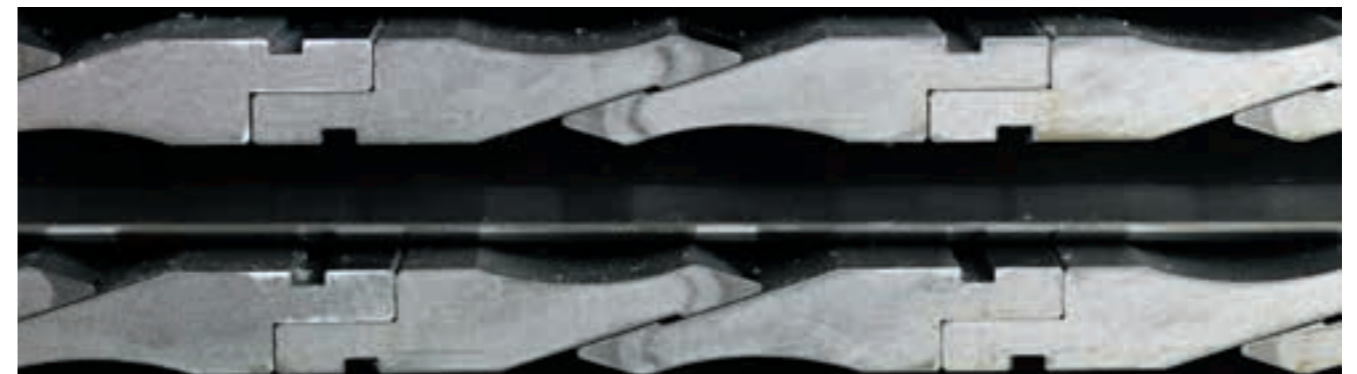


## SCA.M.88.R025

150 kN/m max.



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



# R1 ROLLERI TYPE R1

## 85° Punches

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

1000 kN/m max.

H=66.60 / A=96.50 / R=0.8 (H=2.62 / A=3.80 / R=0.031)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

**NEW**

H=65.45 / A=95.45 / R=3.0 (H=2.58 / A=3.76 / R=0.118)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm<sup>2</sup> **HORN 1**

### PK.120.85.R08

600 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup> **HORN 1**

# R1 ROLLERI TYPE R1

## 85° Punches



### PS.135.85.R08

1000 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup> **HORN 1**

### P.145.85.R08

600 kN/m max.

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

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



### P.120.85.R1

800 kN/m max.

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

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

### TOP.175.85.R08 / R2

900 kN/m max.

H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
525 mm	20.67 in	20.9 kg
495 mm segmented	19.49 in segmented	19.7 kg
500 mm segmented	19.68 in segmented	19.9 kg

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

### TOP.175.85.R08.S

200 kN/m max.

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

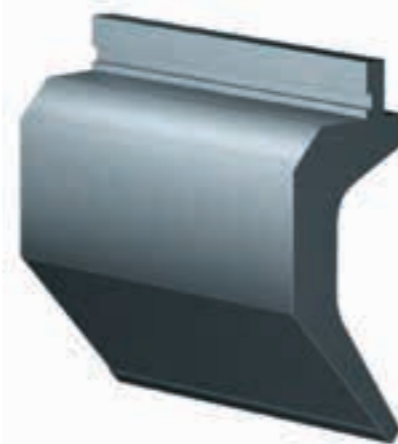
42Cr: 900-1150 N/mm<sup>2</sup> **HORN 2**

### P.130.85.R025

350 kN/m max.

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

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



### PK.135.85.R08

500 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup> **HORN 1**

### P.135.85.R08

800 kN/m max.

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

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

### TOP.205.85.R08 / R2

700 kN/m max.

H=175.00 / A=205.00 / R=0.8 (H=6.89 / A=8.07 / R=0.031)		
525 mm	20.67 in	24.0 kg
495 mm segmented	19.49 in segmented	22.6 kg
500 mm segmented	19.68 in segmented	22.9 kg

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



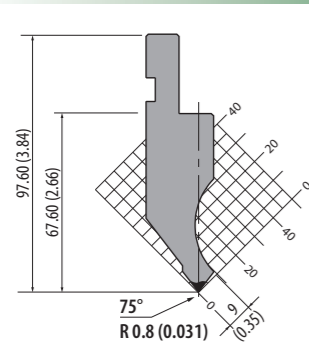
For a rapid vertical tool exchange, punches Rolleri R1 Type can be equipped with the spring-loaded ROL1-System (20% Surcharge). Retrofitted or new! See pages 204-205

# R1 ROLLERI TYPE R1

## 75° Punches

### P.97.75.R08

1000 kN/m max.

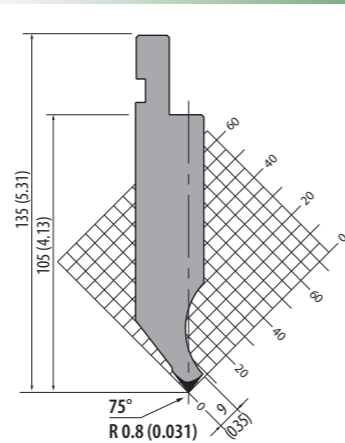


835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

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

### P.135.75.R08

1000 kN/m max.

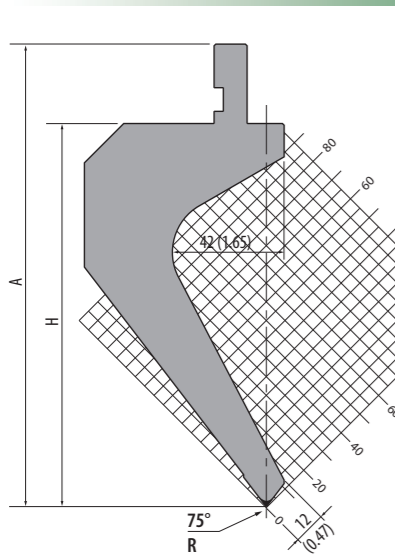


835 mm	32.87 in	17.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	16.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

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

### TOP.175.75.R08 / R2

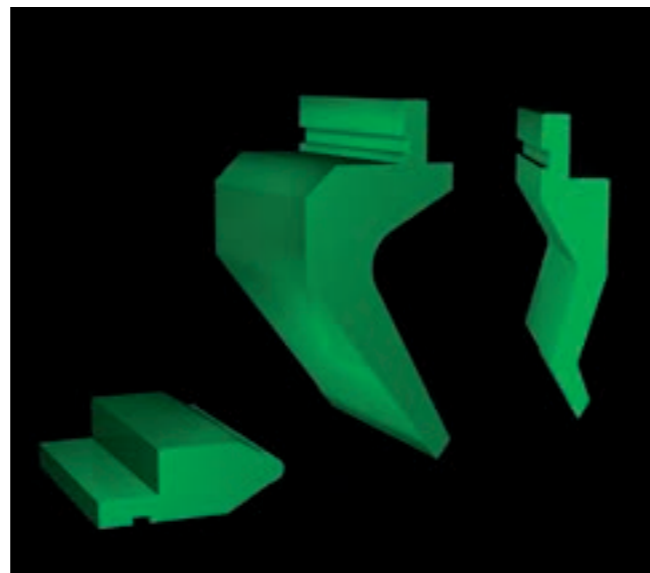
750 kN/m max.



TOP.175.75.R08		
H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
525 mm	20.67 in	21.5 kg
495 mm segmented	19.49 in segmented	20.3 kg
500 mm segmented	19.68 in segmented	20.5 kg

TOP.175.75.R2		
H=144.20 / A=174.20 / R=2.0 (H=5.68 / A=6.86 / R=0.079)		
525 mm	20.67 in	21.5 kg
495 mm segmented	19.49 in segmented	20.3 kg
500 mm segmented	19.68 in segmented	20.5 kg

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



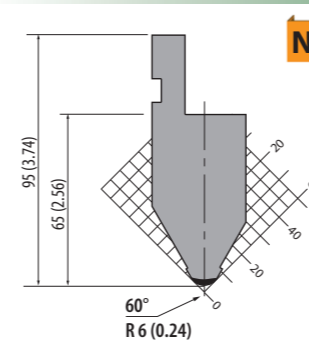
# R1 ROLLERI TYPE R1

## 60° Punches



### 00300

1000 kN/m max.

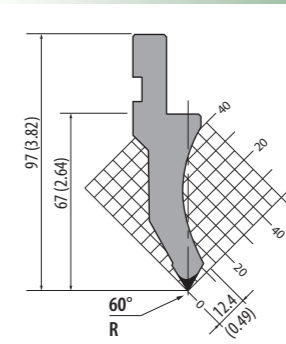


835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.2 kg
800 mm segmented	31.50 in segmented	14.4 kg

C45: 560-710 N/mm<sup>2</sup>  
HORN 6

### P.97.60.R08 / R2

600 kN/m max.



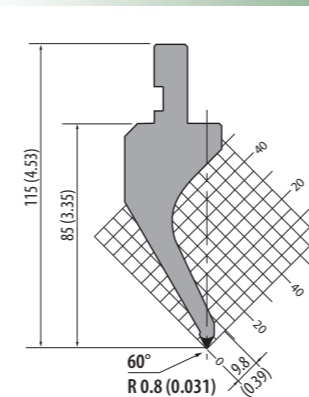
R=0.8 (0.031)		
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
795 mm segmented	31.29 in segmented	8.5 kg
805 mm segmented	31.69 in segmented	8.7 kg

R=2.0 (0.079)		
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	8.5 kg
805 mm segmented	31.69 in segmented	8.7 kg

C45: 560-710 N/mm<sup>2</sup>  
HORN 1

### P.115.60.R08

400 kN/m max.

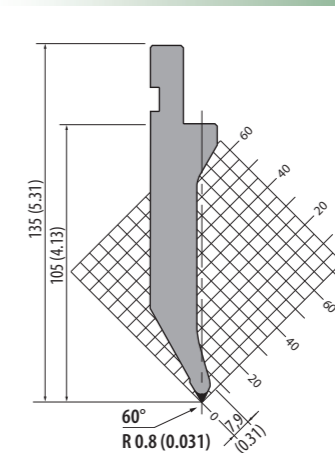


835 mm	32.87 in	11.9 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.3 kg
805 mm segmented	31.69 in segmented	11.4 kg

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

### P.135.60.R08

800 kN/m max.

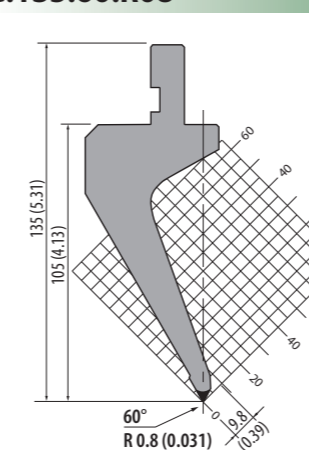


835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

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

### PG.135.60.R08

700 kN/m max.

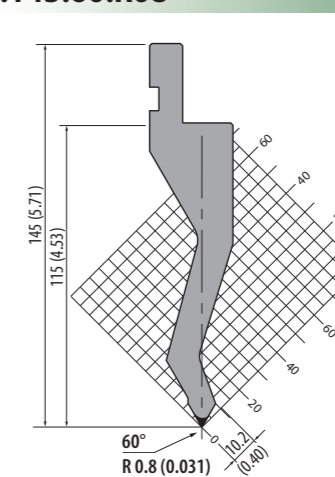


835 mm	32.87 in	16.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	15.7 kg
805 mm segmented	31.69 in segmented	15.9 kg

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

### P.145.60.R08

700 kN/m max.



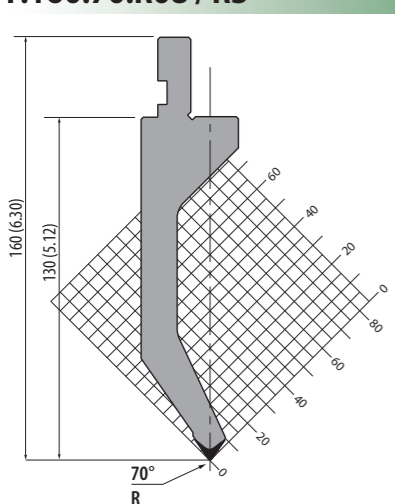
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	14.4 kg

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

## 70° Punches

### P.160.70.R08 / R3

450 kN/m max.



R=0.8 (0.031)		
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

R=3.0 (0.118)		
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

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

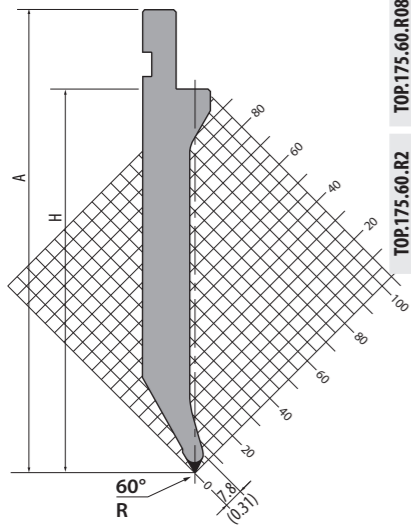
**Modifications of Standard Tools: rapid and precise, directly from the manufacturer!**  
See pages 248-253

# R1 ROLLERI TYPE R1

60° Punches

## TOP.175.60.R08 / R2

800 kN/m max.



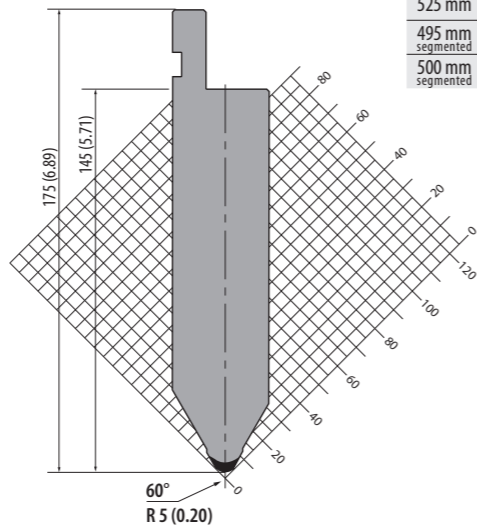
<b>TOP.175.60.R08</b>		
H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg
<b>TOP.175.60.R2</b>		
H=143.80 / A=173.80 / R=2.0 (H=5.66 / A=6.84 / R=0.079)		
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

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



## TOP.175.60.R5

1600 kN/m max.



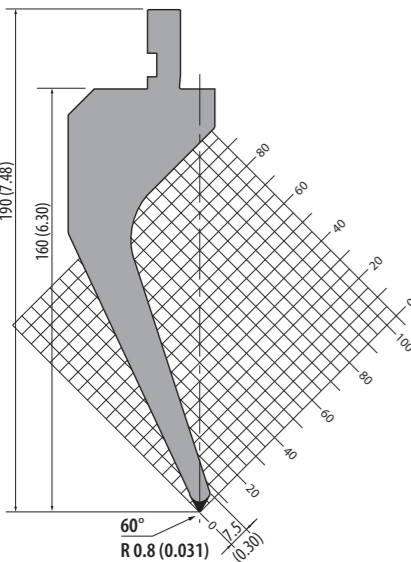
525 mm	20.67 in	22.0 kg
495 mm segmented	19.49 in segmented	20.7 kg
500 mm segmented	19.68 in segmented	20.9 kg

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



## P.190.60.R08

400 kN/m max.



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

C45: 800-850 N/mm<sup>2</sup>



Take advantage of the wide range of Rolleri R1 Type punches by using our extensive number of adapters. See pages 212-217



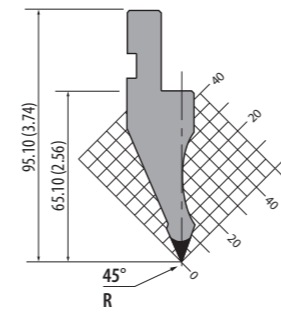
# R1 ROLLERI TYPE R1

45° Punches



## P.95.45.R08 / R15

800 kN/m max.



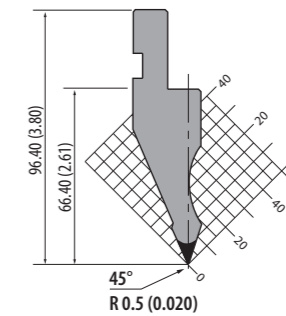
<b>R=0.8 (0.031)</b>		
<b>P.95.45.R08</b>		
835 mm	32.87 in	9.5 kg
415 mm	16.34 in	4.2 kg
795 mm segmented	31.29 in segmented	9.0 kg
805 mm segmented	31.69 in segmented	9.0 kg
<b>R=1.5 (0.059)</b>		
<b>P.95.45.R15</b>		
835 mm	32.87 in	9.5 kg
415 mm	16.34 in	4.2 kg
795 mm segmented	31.29 in segmented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

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



## P.97.45.R05

800 kN/m max.



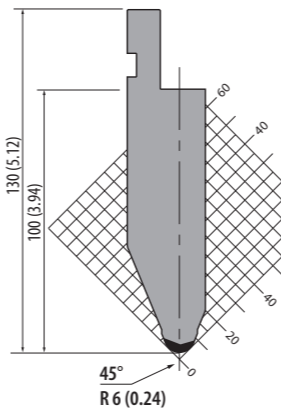
835 mm	32.87 in	10.2 kg
415 mm	16.34 in	5.1 kg
795 mm segmented	31.29 in segmented	9.7 kg
805 mm segmented	31.69 in segmented	9.8 kg
900 mm	35.43 in	10.9 kg

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



## P.130.45.R6

1000 kN/m max.



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

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



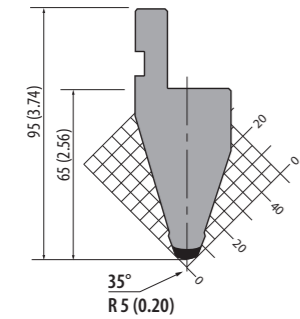
Faster vertical tool exchange with ROL100  
See pages 202-203



# R1 ROLLERI TYPE R1

## 35° Punches

**P.95.35.R5**

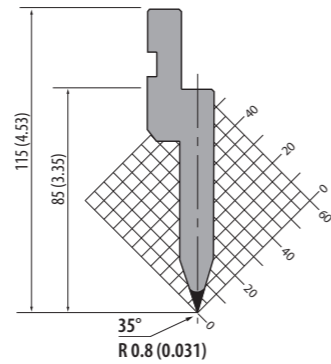


1000 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup>  
HORN 1

**PU.85.35.R08**

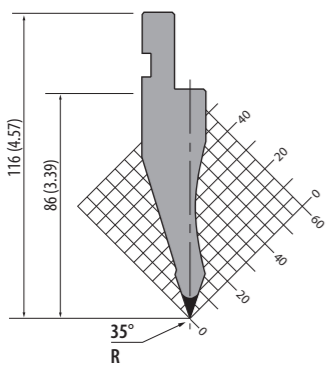


1000 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup>  
HORN 1

**P.116.35.R08 / R15**

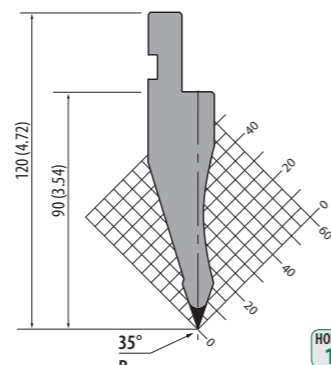


700 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup>  
HORN 1

**P.120.35.R08 / R15 / R3**



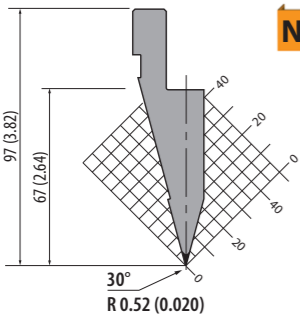
700 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup>  
HORN 1

## 30° Punches

**10300**

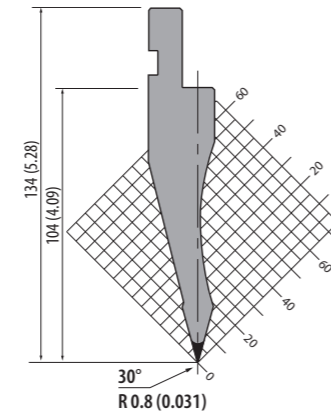


1000 kN/m max.

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

NEW  
42Cr: 900-1150 N/mm<sup>2</sup>  
HORN 5

**PS.134.30.R08**

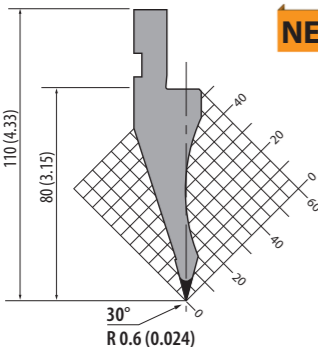


700 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup>  
HORN 1

**P.110.30.R06**



500 kN/m max.

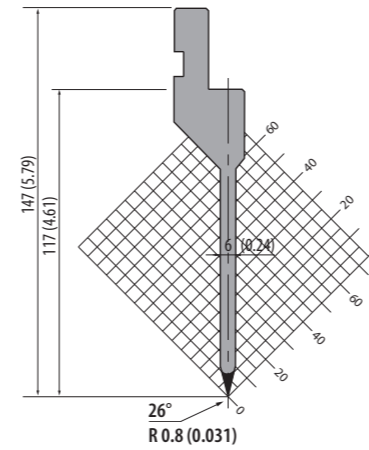
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.50 in segmented	10.1 kg

NEW  
C45: 560-710 N/mm<sup>2</sup>  
HORN 1

# R1 ROLLERI TYPE R1

## 26° Punches

**P.147.26.R08**

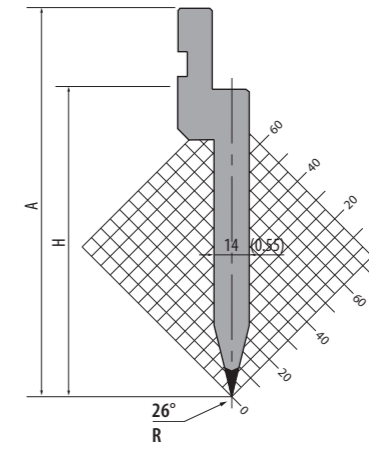


500 kN/m max.

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

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

**PU.117.26.R08 / R3**

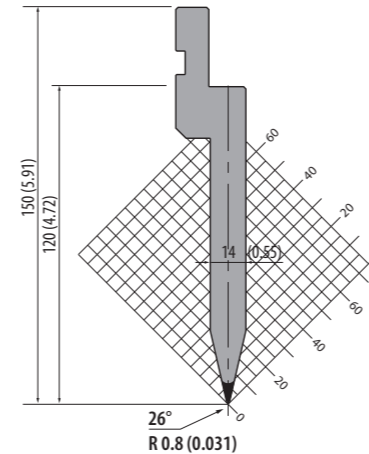


1000 kN/m max.

PU.117.26.R08		
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg
PU.117.26.R3		
H=109.00 / A=139.00 / R=3.0 (H=4.29 / A=5.47 / R=0.118)		
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.7 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm<sup>2</sup>  
HORN 1

**PU.150.26.R08.L**



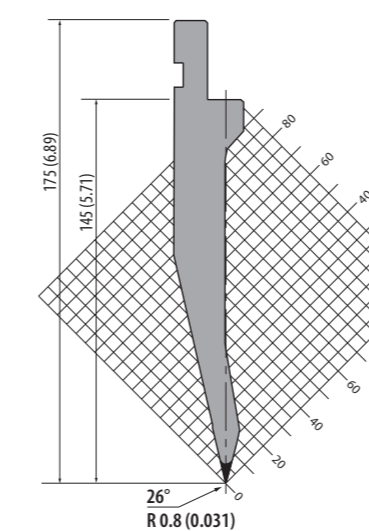
1000 kN/m max.

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

C45: 560-710 N/mm<sup>2</sup>  
HORN 1



**TOP.175.26.R08**

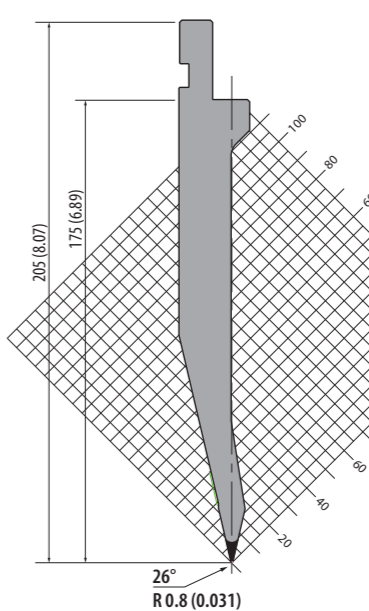


950 kN/m max.

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

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

**TOP.205.26.R08**



950 kN/m max.

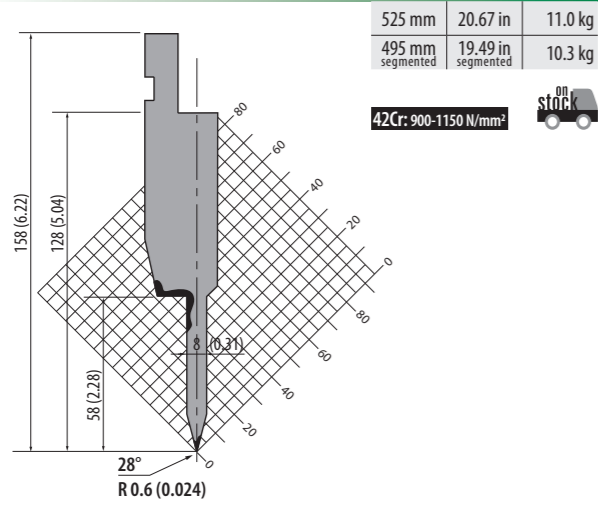
525 mm	20.67 in	14.0 kg
495 mm segmented	19.49 in segmented	13.2 kg
500 mm segmented	19.68 in segmented	13.3 kg

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

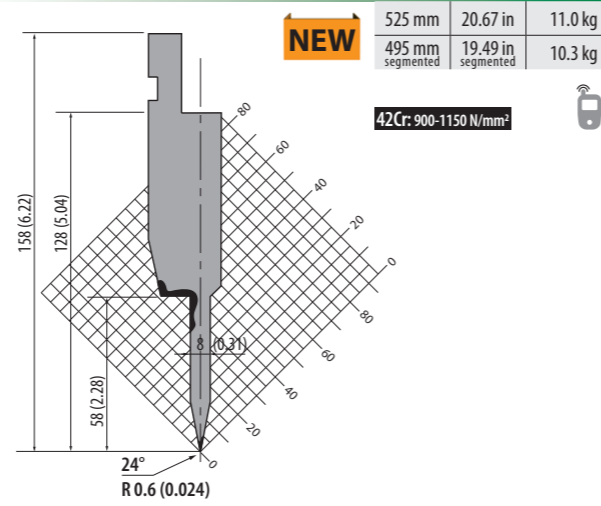
# R1 ROLLERI TYPE R1

28°/24° Hemming tools

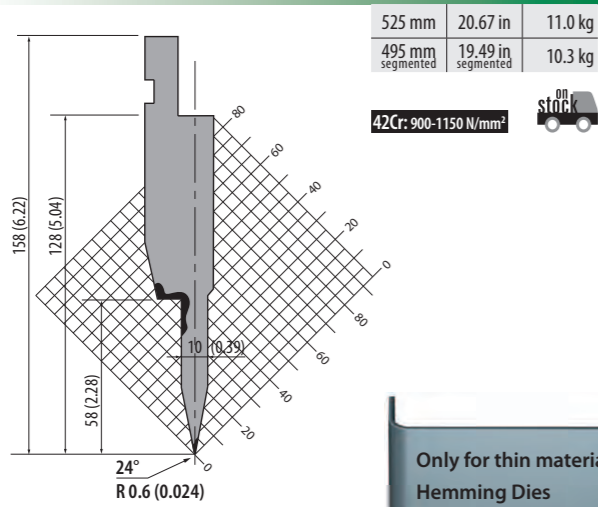
## TOP.SP.134.28.8



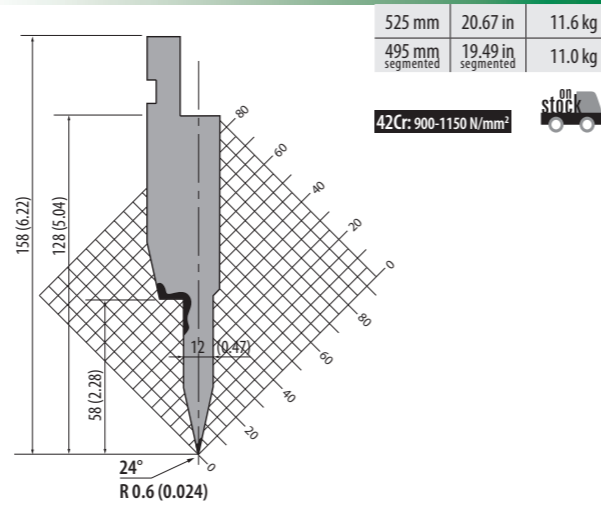
## TOP.SP.134.24.8



## TOP.SP.134.24.10

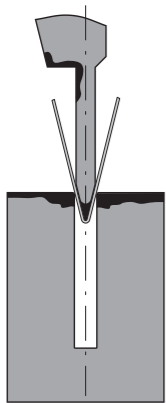


## TOP.SP.134.24.12

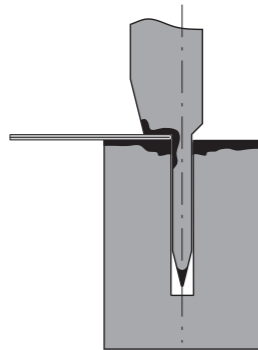


Only for thin material!  
Hemming Dies  
See page 75

## Example of application



800 kN/m max.



1000 kN/m max.

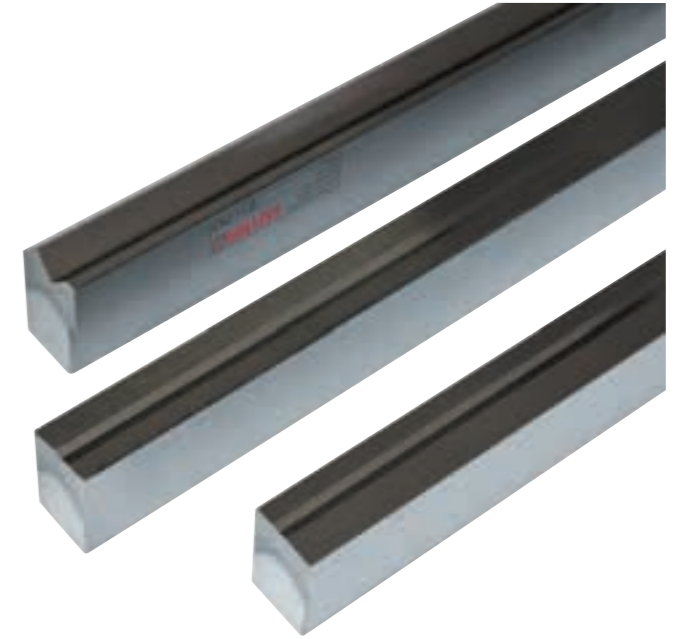
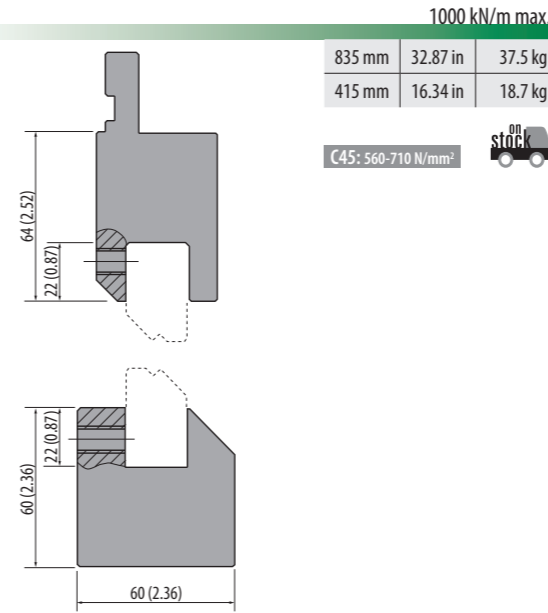
S mm	S in	A mm	A in	R.45 Kg/mm <sup>2</sup> t/m	R.70 Kg/mm <sup>2</sup> t/m	S mm	S in	A mm	A in	R.45 Kg/mm <sup>2</sup> t/m	R.70 Kg/mm <sup>2</sup> t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05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

# R1 ROLLERI TYPE R1

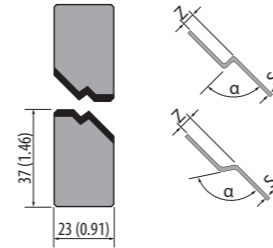
Z-Profile Tools



## CPZ



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

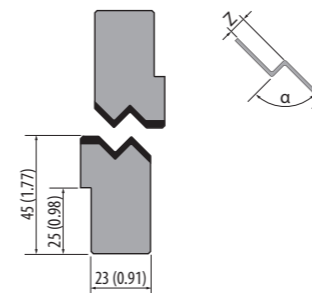


Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°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

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

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

## Z-Tool Inserts 90°



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

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

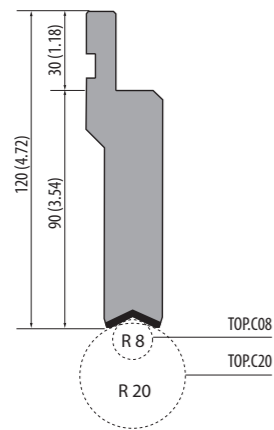
\* Fe Rmax = 42 Kg/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

## Radius Tools

### TOP.PC.120-08

1000 kN/m max.



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

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

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

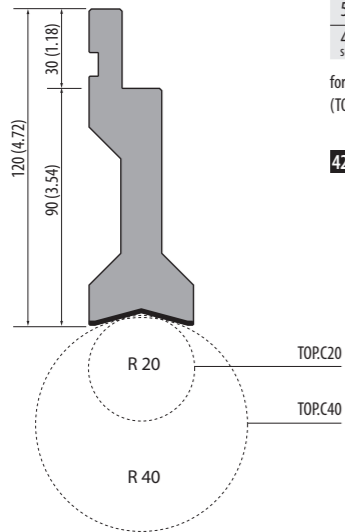


Radius Punches by Rolleri also sectioned on stock! Take advantage of this flexibility!



### TOP.PC.120-20

1000 kN/m max.



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

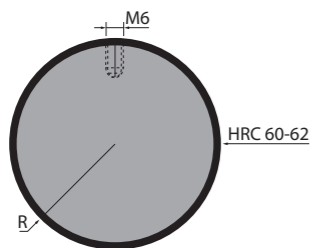
for Radius tools with R20-R40 (TOP.C20-TOP.C40) see below

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



### TOP-Radius Tools: R8-40

1000 kN/m max.



Material: C53 induction hardened 60-62 HRC

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



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

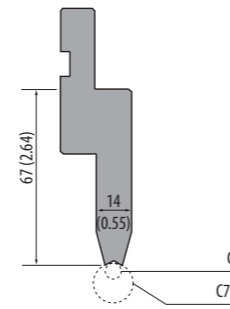
# R1 ROLLERI TYPE R1

## Radius Tools



### PU.67.14-S

400 kN/m max.



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

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

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



Mark-free bending with PU-Upholstery  
See pages 226-227

### C3 - C7.5

400 kN/m max.



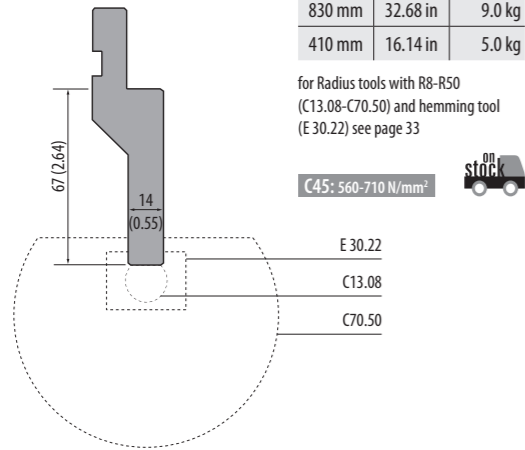
C45: 560-710 N/mm<sup>2</sup>



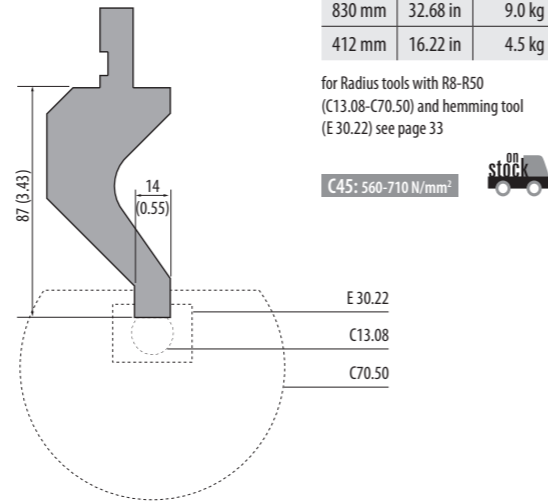
Model	R mm	R in	Weight	Weight
C3	3.0	0.12	0.20 kg	0.10 kg
C3.5	3.5	0.14	0.20 kg	0.10 kg
C4	4.0	0.16	0.35 kg	0.17 kg
C4.5	4.5	0.18	0.50 kg	0.25 kg
C5	5.0	0.20	0.60 kg	0.30 kg
C5.5	5.5	0.22	0.70 kg	0.35 kg
C6	6.0	0.24	0.80 kg	0.40 kg
C6.5	6.5	0.26	1.00 kg	0.50 kg
C7	7.0	0.28	0.80 kg	0.40 kg
C7.5	7.5	0.30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



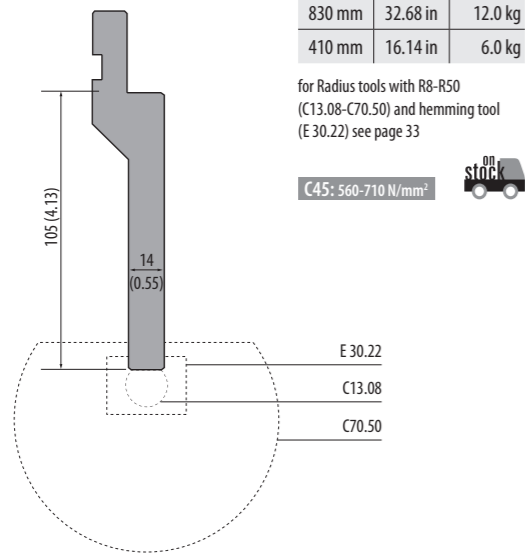
### PU.67.14 800 kN/m max.



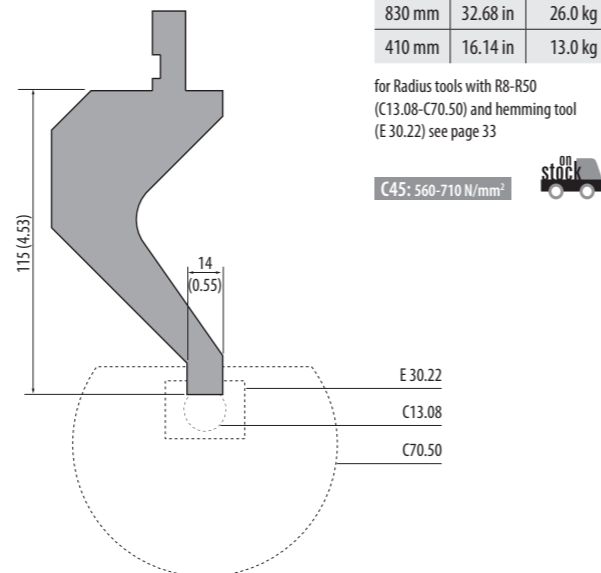
### PU.87.14 500 kN/m max.



### PU.105.14 800 kN/m max.



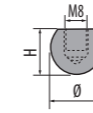
### PU.115.14 500 kN/m max.



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



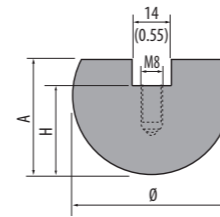
### Radius Tool: Ø 16-20 mm (0.63-0.79 in) 800 kN/m max.



Model	Ø mm	Ø in	H mm	H in	Weight
<b>C13.08</b>	16	0.63	13	0.51	2.00 kg
<b>C13.09</b>	18	0.71	16	0.63	2.00 kg
<b>C16.10</b>	20	0.79	16	0.63	2.00 kg

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

### Radius Tool: Ø 25-100 mm (0.98-3.94) 800 kN/m max.

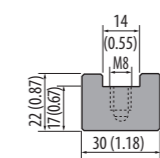


Model	Ø mm	Ø in	H mm	H in	A mm	A in	Weight
<b>C17.12</b>	25	0.98	17	0.67	22	0.87	2.5 kg
<b>C20.15</b>	30	1.18	20	0.79	27	1.06	3.7 kg
<b>C22.17</b>	35	1.38	22	0.87	32	1.26	5.0 kg
<b>C24.20</b>	40	1.57	24	0.94	34	1.34	7.0 kg
<b>C29.25</b>	50	1.97	29	1.14	39	1.54	10.0 kg
<b>C34.30</b>	60	2.36	34	1.34	44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

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

## Hemming Tool

### E30.22 800 kN/m max.



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

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

# R1 ROLLERI TYPE R1

## Punch extensions / Intermediates

### Our Advantages – Your Convenience

- Wedge crowning prevents deflection
- Increase in leg length
- for special increase in leg length see SPE-p4 in the area of special tools on page 237

**AD4** 1000 kN/m max.

per piece 1.8 kg

L=150 mm (5.91 in)

Punch extension without wedge crowning

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

Compatible tensioner see page 200

# R1 ROLLERI TYPE R1

## Intermediates



**INT150-40** 1000 kN/m max.

**NEW**

per piece 8.0 kg

L=150 mm (5.91 in)

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

Wedge crown

53 (2.09)

150 (5.91)

40 (1.57)

14 (0.55)

Rolleri Clamping Systems  
See pages 198-205

**INT150** 1000 kN/m max.

per piece 5.9 kg

L=150 mm (5.91 in)

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

Wedge crown

13 (0.51) 7 (0.28)

150 (5.91)

40 (1.57)

14 (0.55)

**INT100** 1000 kN/m max.

per piece 3.5 kg

L=150 mm (5.91 in)

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

Wedge crown

13 (0.51) 7 (0.28)

100 (3.94)

40 (1.57)

14 (0.55)

**INT100 FISSO** 1000 kN/m max.

per piece 4.0 kg

L=150 mm (5.91 in)

Punch extension without wedge crowning

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

Wedge crown

13 (0.51) 7 (0.28)

100 (3.94)

40 (1.57)

14 (0.55)

**INT120-40-HD (Heavy Duty)** 1600 kN/m max.

**NEW**

per piece 5.2 kg

L=150 mm (5.91 in)

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

Wedge crown

13 (0.51) 20 (0.79)

120 (4.72)

53 (2.09)

40 (1.57)

27 (1.06)

**INT120-HD (Heavy Duty)** 1600 kN/m max.

**NEW**

per piece 4.5 kg

L=150 mm (5.91 in)

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

Wedge crown

13 (0.51) 7 (0.28)

120 (4.72)

40 (1.57)

27 (1.06)

**INT120-40** 1000 kN/m max.

per piece 5.2 kg

L=150 mm (5.91 in)

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

Wedge crown

13 (0.51) 20 (0.79)

120 (3.94)

53 (2.09)

40 (1.57)

14 (0.55)

**INT120** 1000 kN/m max.

per piece 4.5 kg

L=150 mm (5.91 in)

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

Wedge crown

13 (0.51) 7 (0.28)

120 (3.94)

40 (1.57)

14 (0.55)

Intermediates also available in L=70 mm upon request.

### Punch Adapters

**AD20** 1000 kN/m max.

per piece 4.0 kg

L=150 mm (5.91 in)

head-bearing

Rolleri Type R1 → Roller Type R2

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

Punches Roller Type R2 see pages 85-90

**AD19-A** 1000 kN/m max.

per piece 6.0 kg

L=150 mm (5.91 in)

Rolleri Type R1 → Roller Type RX LVD

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

Punches Roller Type RX LVD see page 162

## DIES ROLLERI TYPE R1

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

### Compatibility

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

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

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



### Compatibility

Dies Roller Type R1 are:

- compatible with press brake machines (60 mm clamping-width) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brake machines with Adapter-Systems and Adapter Rails (see pages 218-221).

### Material

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

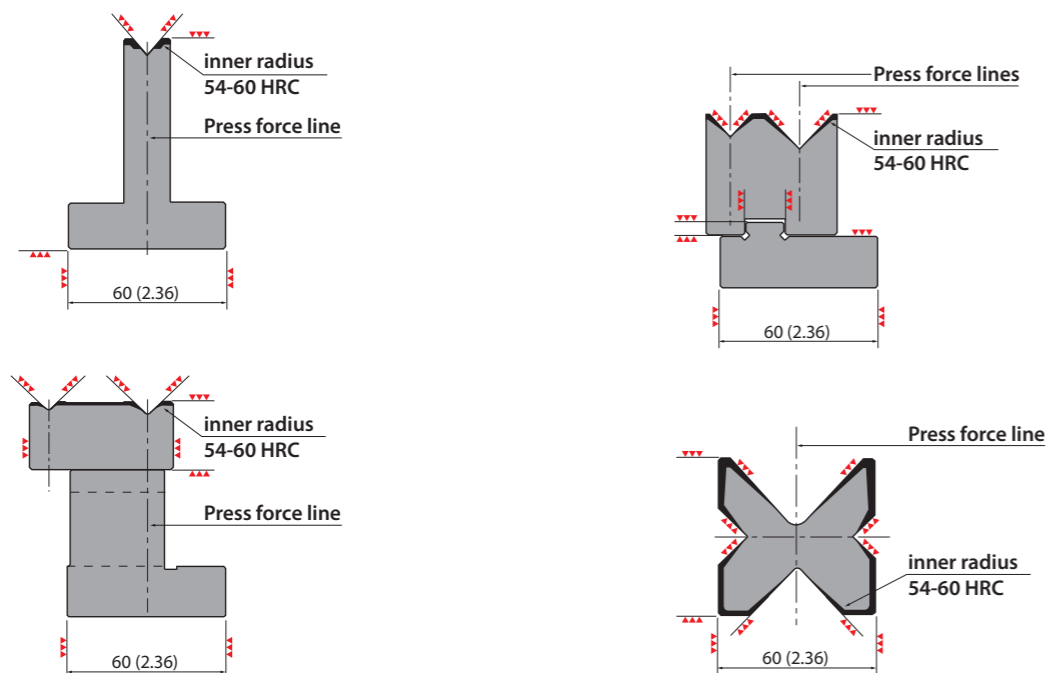
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm <sup>2</sup>	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC

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

### Tang

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

Indications of precision ground surfaces:



### Our Advantages – Your Convenience

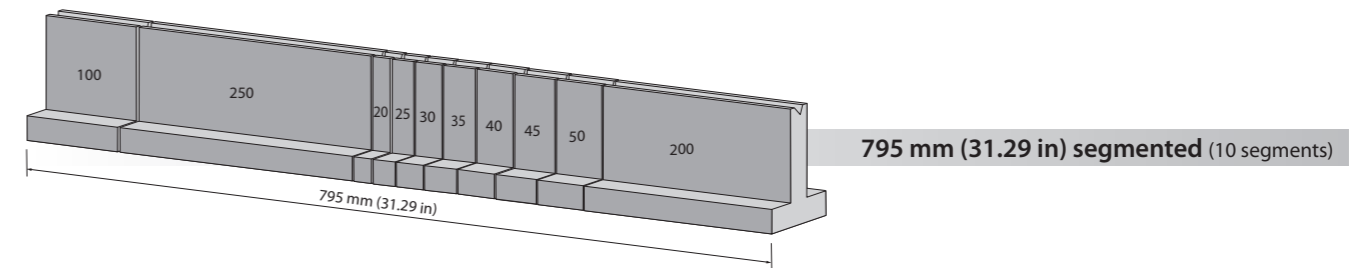
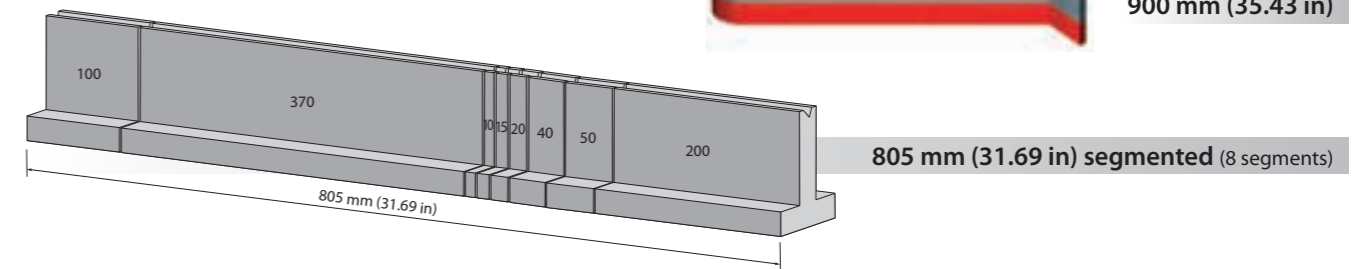
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 250-253)
- very large stock availability

### Tool lengths and sectioning

Standard

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

- 835 mm (32.87 in)
- 415 mm (16.34 in)
- 900 mm (35.43 in)



Rolleri TOP-System

525 mm (20.67 in)

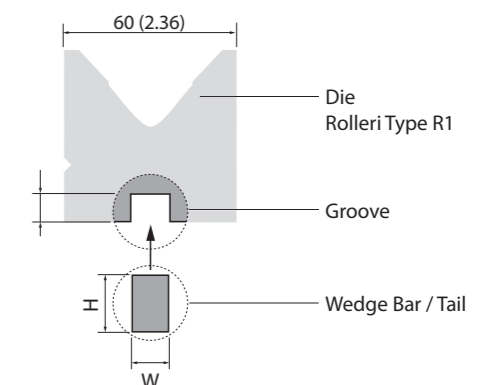


### Modification: Wedge Bar / Tail

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

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

### Mounting example



Specific information and prizes are found in the Roller Service / Modifications Chapter (see page 252)

# R1 ROLLERI TYPE R1

## 2-V Dies 90°

**M26.90.03** 1000 kN/m max.

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

**NEW**

C45: 560-710 N/mm²

**M26.90.01** 1000 kN/m max.

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

C45: 560-710 N/mm²

**M26.90.02** 1000 kN/m max.

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

C45: 560-710 N/mm²

Die Holders for 2-V Dies see page 43

**12300** 700 kN/m max.

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

**NEW**

C45: 560-710 N/mm²

**12400** 800 kN/m max.

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

**NEW**

C45: 560-710 N/mm²

# R1 ROLLERI TYPE R1

## 2-V Dies 88°



**M26.88.05** 1000 kN/m max.

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

C45: 560-710 N/mm²

Take advantage of our adapters on pages 218-221 when using dies Roller Type R1.

**12306** 700 kN/m max.

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

**NEW**

C45: 560-710 N/mm²

**12406** 800 kN/m max.

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

**NEW**

C45: 560-710 N/mm²

**12500** 1000 kN/m max.

835 mm	32.87 in	7.7 kg
415 mm	16.34 in	3.8 kg

**NEW**

C45: 560-710 N/mm²

**12600** 1000 kN/m max.

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

**NEW**

C45: 560-710 N/mm²

## 2-V Dies 88°

**M26.88.01** 1000 kN/m max.

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

C45: 560-710 N/mm²

**M26.88.02** 1000 kN/m max.

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

C45: 560-710 N/mm²

**M26.88.03** 1000 kN/m max.

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

C45: 560-710 N/mm²

**M26.88.04** 1000 kN/m max.

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

C45: 560-710 N/mm²



**12700** 700 kN/m max.

835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.4 kg

**NEW**

C45: 560-710 N/mm²

**31400** 1000 kN/m max.

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

**NEW**

C45: 560-710 N/mm²

# R1 ROLLERI TYPE R1

## 2-V Dies 60°

**M26.60.01** 600 kN/m max.

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

**M26.60.02** 800 kN/m max.

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

**M26.60.03** 800 kN/m max.

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

**M26.60.05** 800 kN/m max.

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

## 2-V Dies 35°

**M31.35.01** 300 kN/m max.

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

**M31.35.02** 300 kN/m max.

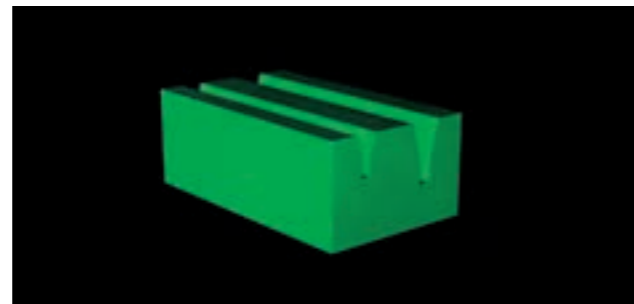
835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg

## 2-V Dies 30°

**33700** 300 kN/m max.

**NEW**

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



# R1 ROLLERI TYPE R1

## Die Holders for 2-V Dies



**SU034**

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

for all 2-V Dies pages 40-42

**SU055**

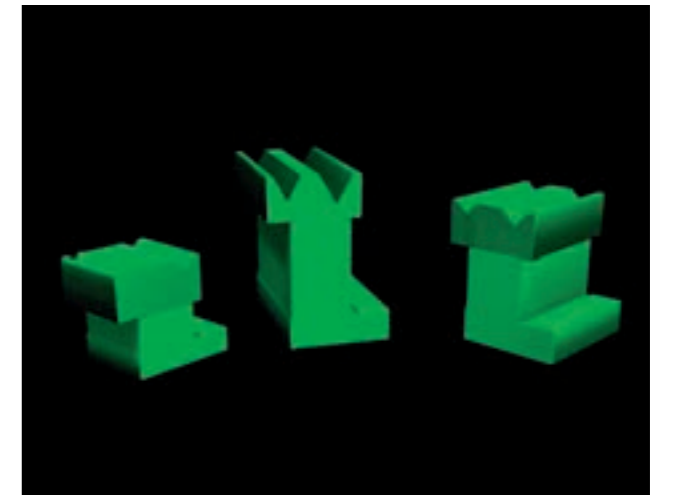
830 mm	32.68 in	14.5 kg
410 mm	16.14 in	7.2 kg

for all 2-V Dies pages 40-42

**SU075**

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

for all 2-V Dies pages 40-42



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



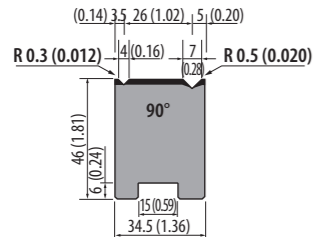
**Rolleri Videos**

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


# R1 ROLLERI TYPE R1

## Self Centering 2-V Dies 90°

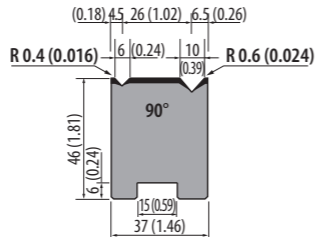
**46-10** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

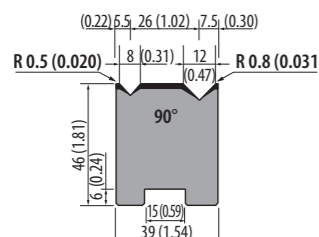
**46-11** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

**46-12** 800 kN/m max.

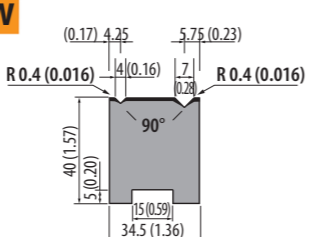


835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.6 kg


C45: 800-850 N/mm<sup>2</sup> 

**50190** 600 kN/m max.

**NEW**

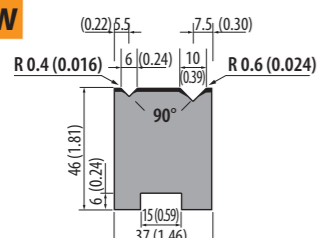


835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
795 mm segmented	31.29 in segmented	9.2 kg
805 mm segmented	31.69 in segmented	9.4 kg


C45: 800-850 N/mm<sup>2</sup> 

**50290** 700 kN/m max.

**NEW**



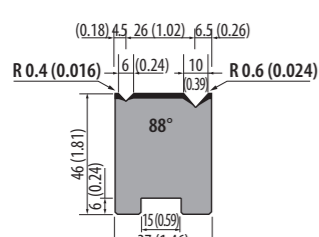
835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.69 in segmented	10.1 kg

C45: 800-850 N/mm<sup>2</sup> 




## Self Centering 2-V Dies 88°

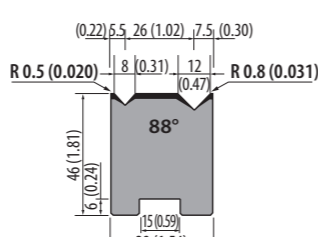
**46.11.88** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

**46.13** 800 kN/m max.



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

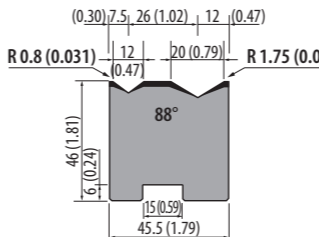
C45: 800-850 N/mm<sup>2</sup> 

# R1 ROLLERI TYPE R1


## Self Centering 2-V Dies 88°



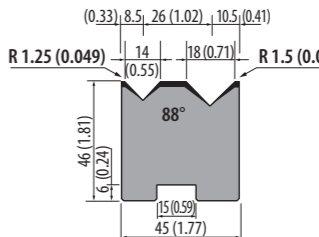
**46.14** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

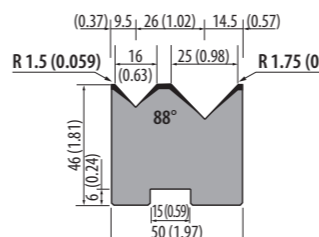
**46.15** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

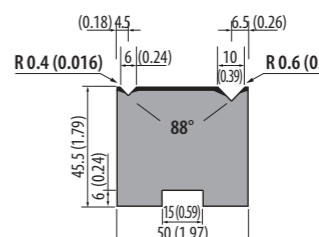
**46.16** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

**30247** 700 kN/m max.

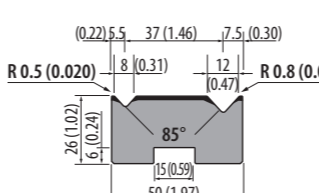


835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg


C45: 800-850 N/mm<sup>2</sup> 

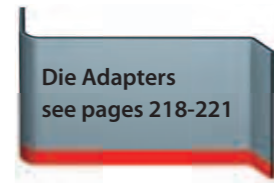
## Self Centering 2-V Dies 85°

**M26.85.02** 1000 kN/m max.



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

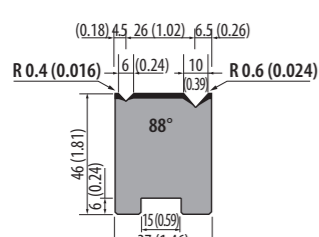
42Cr: 900-1150 N/mm<sup>2</sup> 




## Self Centering 2-V Dies 88°

## Self Centering 2-V Dies 30°

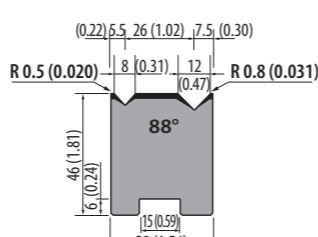
**46.11.88** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

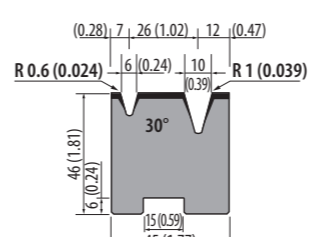
**46.13** 800 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

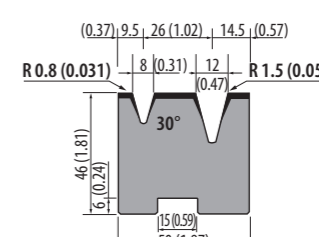
**46.17** 400 kN/m max.




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

C45: 800-850 N/mm<sup>2</sup> 

**46.18** 400 kN/m max.

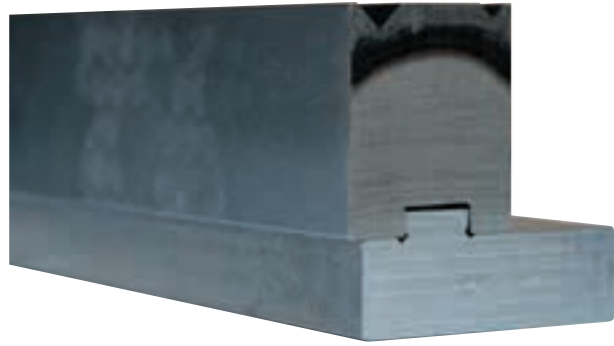


835 mm	32.87 in	13.2 kg
415 mm	16.34 in	6.6 kg
795 mm segmented	31.29 in segmented	12.6 kg
805 mm segmented	31.69 in segmented	12.7 kg

C45: 800-850 N/mm<sup>2</sup> 

# R1 ROLLERI TYPE R1

## Die Holders for Self Centering 2-V Dies



**PM60** 1000 kN/m max.

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

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

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

**PM50** 1000 kN/m max.

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

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

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

**PM50.20** 1000 kN/m max.

**NEW**

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

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

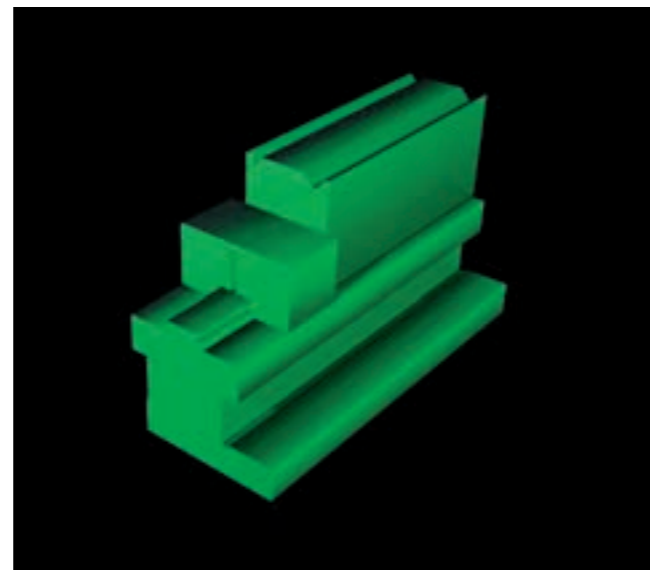
C45: 800-850 N/mm<sup>2</sup>

## Clamping Piece for Self Centering 2-V Dies

**PB60**

pair	0.2 kg
------	--------

Fe37



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

# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 90°



**32000** 950 kN/m max.

**NEW**

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

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

**32100** 950 kN/m max.

**NEW**

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

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

**32300** 950 kN/m max.

**NEW**

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

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

**07000** 950 kN/m max.

**NEW**

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

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

**07100** 950 kN/m max.

**NEW**

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

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

**07300** 950 kN/m max.

**NEW**

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

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

## Self Centering 1-V Dies 88°

**32006** 950 kN/m max.

**NEW**

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

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

**32106** 950 kN/m max.

**NEW**

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

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

**32200** 950 kN/m max.

**NEW**

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

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

**32400** 1000 kN/m max.

**NEW**

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

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



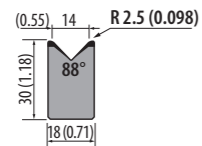
# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 88°

32500

1000 kN/m max.

**NEW**



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

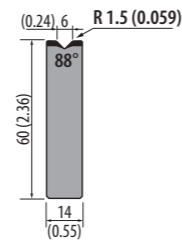
C45: 560-710 N/mm<sup>2</sup>



07006

950 kN/m max.

**NEW**



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

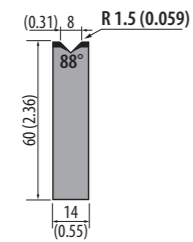
C45: 560-710 N/mm<sup>2</sup>



07106

950 kN/m max.

**NEW**



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

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

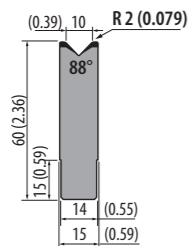


Compatible Die Holders  
for bolted 1-V Dies  
see page 52,  
Article-No. 33000

07200

950 kN/m max.

**NEW**



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

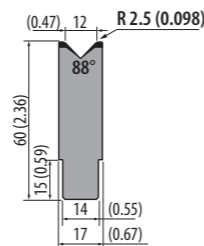
C45: 560-710 N/mm<sup>2</sup>



07400

950 kN/m max.

**NEW**



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

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



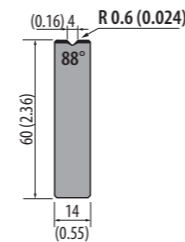
# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 88°



AMR60.04.88

1000 kN/m max.



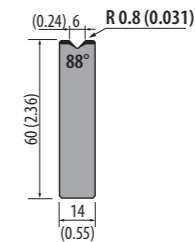
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

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



AMR60.06.88

1000 kN/m max.



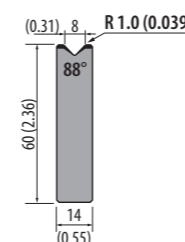
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

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



AMR60.08.88

1000 kN/m max.



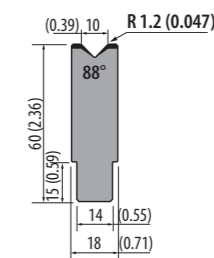
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

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



AMR60.10.88

1000 kN/m max.



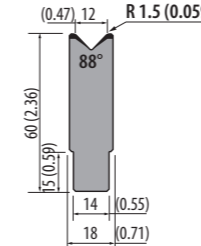
835 mm	32.87 in	5.6 kg
415 mm	16.34 in	2.8 kg
795 mm segmented	31.29 in segmented	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

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



AMR60.12.88

1000 kN/m max.



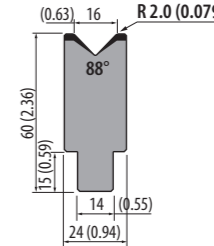
835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

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



AMR60.16.88

1000 kN/m max.



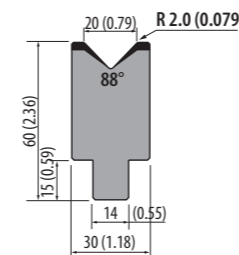
835 mm	32.87 in	7.1 kg
415 mm	16.34 in	3.5 kg
795 mm segmented	31.29 in segmented	6.8 kg
805 mm segmented	31.69 in segmented	6.9 kg

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



AMR60.20.88

1000 kN/m max.



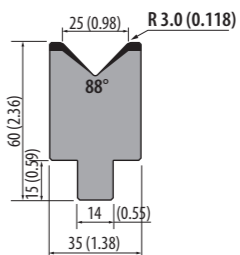
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
795 mm segmented	31.29 in segmented	7.6 kg
805 mm segmented	31.69 in segmented	7.7 kg

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



AMR60.25.88

1000 kN/m max.



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

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



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

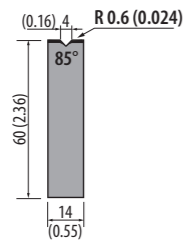
# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 85°

### AMR60.04.85

1000 kN/m max.

**NEW**



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

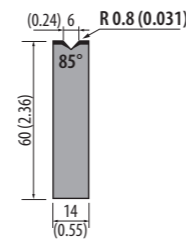
C45: 560-710 N/mm<sup>2</sup>



### AMR60.06.85

1000 kN/m max.

**NEW**



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

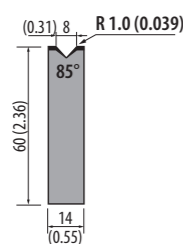
C45: 560-710 N/mm<sup>2</sup>



### AMR60.08.85

1000 kN/m max.

**NEW**



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

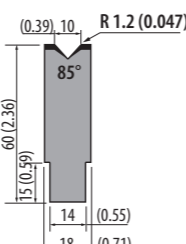
C45: 560-710 N/mm<sup>2</sup>



### AMR60.10.85

1000 kN/m max.

**NEW**



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

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



### AMR60.12.85

1000 kN/m max.

**NEW**



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

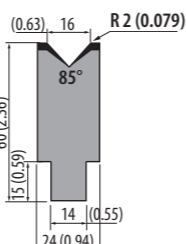
C45: 560-710 N/mm<sup>2</sup>



### AMR60.16.85

1000 kN/m max.

**NEW**



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

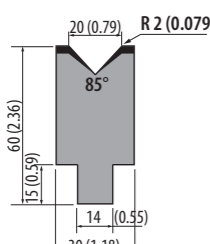
C45: 560-710 N/mm<sup>2</sup>



### AMR60.20.85

1000 kN/m max.

**NEW**



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

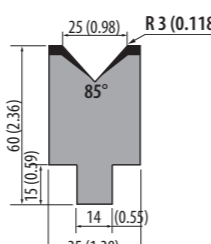
C45: 560-710 N/mm<sup>2</sup>



### AMR60.25.85

1000 kN/m max.

**NEW**



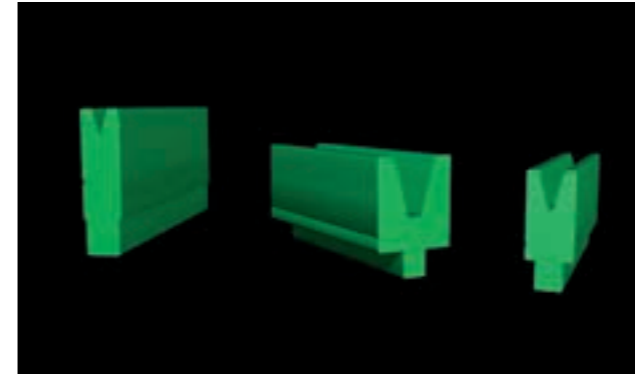
835 mm	32.87 in	9.2 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	8.8 kg
805 mm segmented	31.69 in segmented	8.9 kg

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



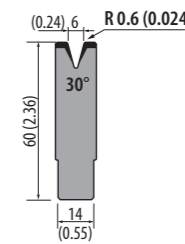
# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 30°



### AMR60.06.30

350 kN/m max.



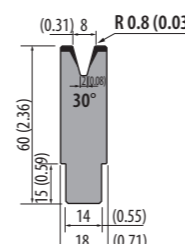
835 mm	32.87 in	5.9 kg
415 mm	16.34 in	2.9 kg
795 mm segmented	31.29 in segmented	5.6 kg
805 mm segmented	31.69 in segmented	5.7 kg

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



### AMR60.08.30

350 kN/m max.



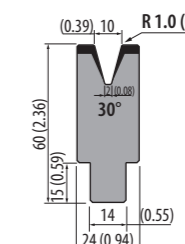
835 mm	32.87 in	6.6 kg
415 mm	16.34 in	3.3 kg
795 mm segmented	31.29 in segmented	6.3 kg
805 mm segmented	31.69 in segmented	6.4 kg

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



### AMR60.10.30

500 kN/m max.



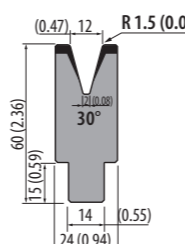
835 mm	32.87 in	7.8 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.4 kg
805 mm segmented	31.69 in segmented	7.5 kg

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



### AMR60.12.30

400 kN/m max.



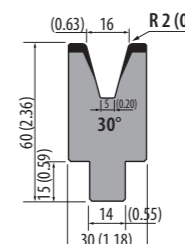
835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
805 mm segmented	31.69 in segmented	7.6 kg

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



### AMR60.16.30

450 kN/m max.



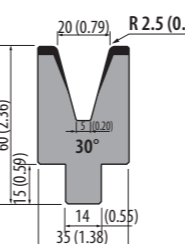
835 mm	32.87 in	8.8 kg
415 mm	16.34 in	4.7 kg
795 mm segmented	31.29 in segmented	8.4 kg
805 mm segmented	31.69 in segmented	8.5 kg

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



### AMR60.20.30

500 kN/m max.



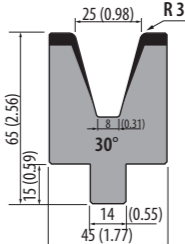
835 mm	32.87 in	15.9 kg
415 mm	16.34 in	7.9 kg
795 mm segmented	31.29 in segmented	15.1 kg
805 mm segmented	31.69 in segmented	15.3 kg

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



### AMR65.25.30

500 kN/m max.



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

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

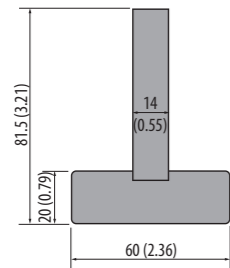


# R1 ROLLERI TYPE R1

## Die Holders for Self Centering 1-V Dies

33000

NEW



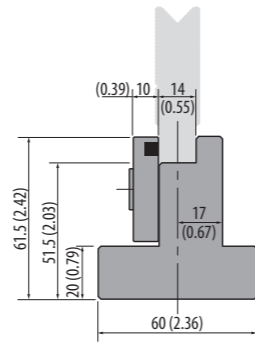
1000 kN/m max.		
835 mm	32.87 in	12.7 kg
415 mm	16.34 in	6.3 kg

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

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



SU61F



1000 kN/m max.		
835 mm	32.87 in	14.8 kg
415 mm	16.34 in	7.3 kg

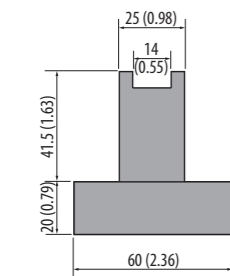
for self centering 1-V Dies, pages 49-51

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



08000

NEW



950 kN/m max.		
1050 mm	41.34 in	17.8 kg

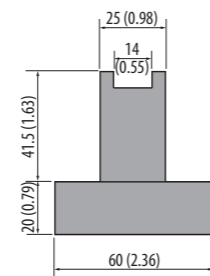
for self centering 1-V Dies, pages 47-51

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



08100

NEW



950 kN/m max.		
1260 mm	49.61 in	21.4 kg

for self centering 1-V Dies, pages 47-51

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



# R1 ROLLERI TYPE R1

## Prevention of Bending Marks



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

- Protective Sheets
- PU-Upholstery
- Synthetic Dies

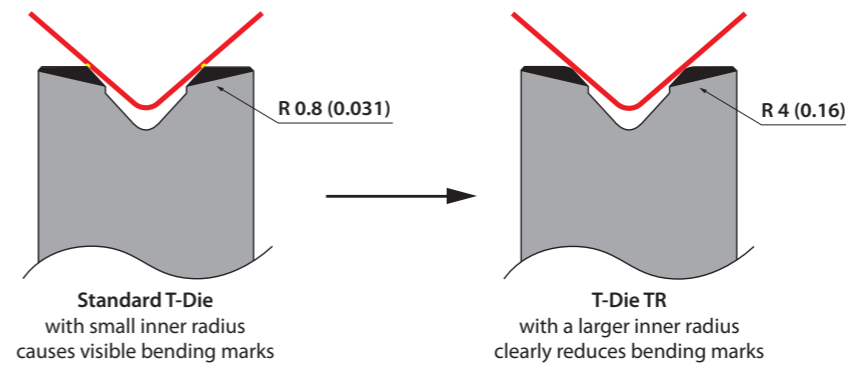
### Our Advantages – Your Convenience

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

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

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

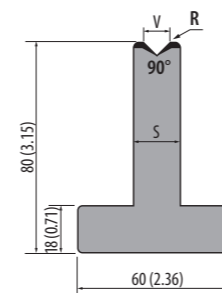
This solution is available on stock for some of our T-Dies under the Article No.: TR



Specific information for mark-free bending see pages 222-229

## T-Dies 90°, H=80 (3.15), H=120 (4.72)

### T-Dies 90°, H=80 mm (3.15 in)

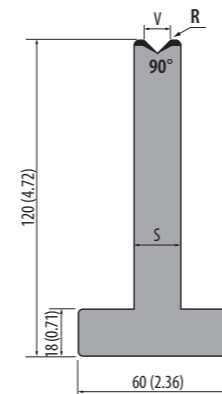


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	1000 kN/m max.				
							Weight	Weight	Weight	Weight	
T80.06.90	6	0.24	0.4	0.02	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg	14.0 kg
T80.08.90	8	0.31	0.5	0.02	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg	14.0 kg
T80.10.90	10	0.39	0.6	0.02	18	0.71	14.2 kg	7.0 kg	13.5 kg	13.7 kg	
T80.12.90	12	0.47	0.8	0.03	18	0.71	15.0 kg	7.5 kg	14.3 kg	14.5 kg	

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



### T-Dies 90°, H=120 mm (4.72 in)



Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	1000 kN/m max.				
							Weight	Weight	Weight	Weight	
T120.06.90	6	0.24	0.4	0.02	14	0.55	16.0 kg	8.0 kg	15.2 kg	15.4 kg	
T120.08.90	8	0.31	0.5	0.02	14	0.55	16.0 kg	8.0 kg	15.2 kg	15.4 kg	
T120.10.90	10	0.39	0.6	0.02	18	0.71	19.0 kg	9.0 kg	18.1 kg	18.3 kg	
T120.12.90	12	0.47	0.8	0.03	18	0.71	19.0 kg	9.0 kg	18.1 kg	18.3 kg	

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

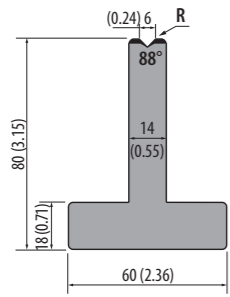


# R1 ROLLERI TYPE R1

T-Dies 88°, H=80 (3.15)

## T80.06.88 / TR80.06.88

1000 kN/m max.



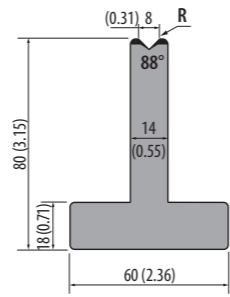
R=0.4 (0.016)			
<b>T80.06.88</b>	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=2.75 (0.108)			
<b>TR80.06.88</b>	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg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

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



## T80.08.88 / TR80.08.88

1000 kN/m max.



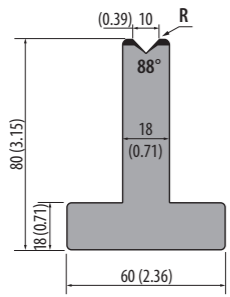
R=0.5 (0.020)			
<b>T80.08.88</b>	835 mm	32.87 in	12.6 kg
	415 mm	16.34 in	6.3 kg
	795 mm segmented	31.29 in segmented	12.0 kg
	805 mm segmented	31.69 in segmented	12.1 kg
R=2.75 (0.108)			
<b>TR80.08.88</b>	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg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

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



## T80.10.88 / TR80.10.88

1000 kN/m max.



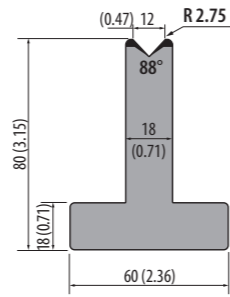
R=0.8 (0.031)			
<b>T80.10.88</b>	835 mm	32.87 in	14.2 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.5 kg
	805 mm segmented	31.69 in segmented	13.7 kg
R=2.75 (0.108)			
<b>TR80.10.88</b>	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg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

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



## T80.12.88

1000 kN/m max.



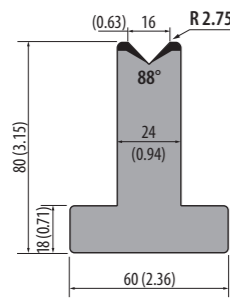
	835 mm	32.87 in	14.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.3 kg
	805 mm segmented	31.69 in segmented	13.5 kg

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



## T80.16.88

1000 kN/m max.



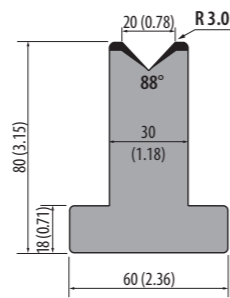
	835 mm	32.87 in	16.6 kg
	415 mm	16.34 in	8.3 kg
	795 mm segmented	31.29 in segmented	15.8 kg
	805 mm segmented	31.69 in segmented	16.0 kg

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



## T80.20.88

1000 kN/m max.



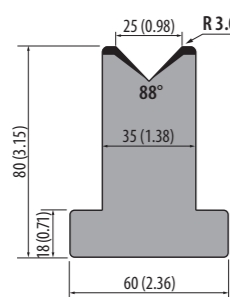
	835 mm	32.87 in	18.5 kg
	415 mm	16.34 in	9.2 kg
	795 mm segmented	31.29 in segmented	17.6 kg
	805 mm segmented	31.69 in segmented	17.8 kg

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



## T80.25.88

1000 kN/m max.



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

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



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



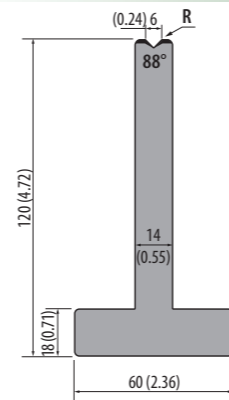
# R1 ROLLERI TYPE R1

T-Dies 88°, H=120 (4.72)



## T120.06.88 / TR120.06.88

1000 kN/m max.



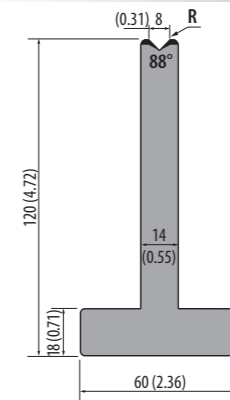
R=0.4 (0.016)			
<b>T120.06.88</b>	835 mm	32.87 in	16.5 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.7 kg
	805 mm segmented	31.69 in segmented	16.0 kg
R=2.75 (0.108)			
<b>TR120.06.88</b>	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg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

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



## T120.08.88 / TR120.08.88

1000 kN/m max.



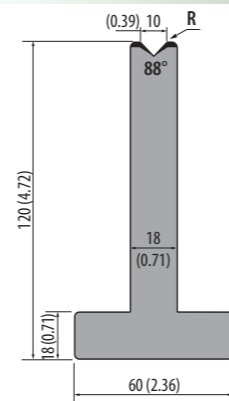
R=0.5 (0.020)			
<b>T120.08.88</b>	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
R=2.75 (0.108)			
<b>TR120.08.88</b>	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg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

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



## T120.10.88 / TR120.10.88

1000 kN/m max.



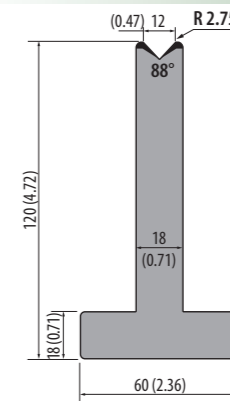
R=0.8 (0.031)			
<b>T120.10.88</b>	835 mm	32.87 in	19.0 kg
	415 mm	16.34 in	9.5 kg
	795 mm segmented	31.29 in segmented	18.0 kg
	805 mm segmented	31.69 in segmented	18.3 kg
R=2.75 (0.108)			
<b>TR120.10.88</b>	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg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

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



## T120.12.88

1000 kN/m max.



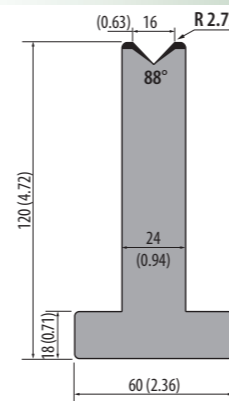
	835 mm	32.87 in	19.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	18.0 kg
	805 mm segmented	31.69 in segmented	18.3 kg

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



## T120.16.88

1000 kN/m max.



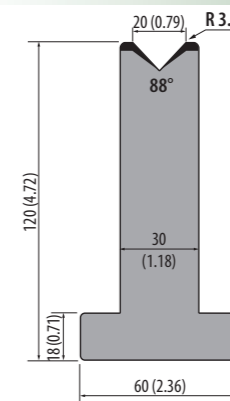
	835 mm	32.87 in	22.0 kg
	415 mm	16.34 in	11.0 kg
	795 mm segmented	31.29 in segmented	20.9 kg
	805 mm segmented	31.69 in segmented	21.2 kg

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



## T120.20.88

1000 kN/m max.



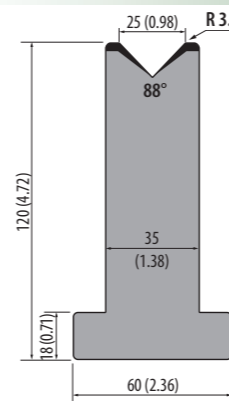
	835 mm	32.87 in	27.0 kg
	415 mm	16.34 in	13.5 kg
	795 mm segmented	31.29 in segmented	25.7 kg
	805 mm segmented	31.69 in segmented	26.0 kg

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



## T120.25.88

1000 kN/m max.



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

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

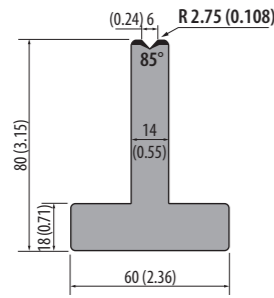


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# R1 ROLLERI TYPE R1

T-Dies 85°, H=80 (3.15)

**T80.06.85** 1000 kN/m max.

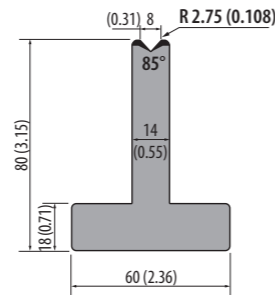


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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



**T80.08.85** 1000 kN/m max.

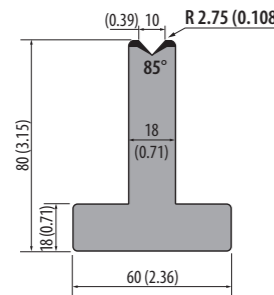


835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.2 kg
795 mm segmented	31.29 in segmented	12.0 kg
805 mm segmented	31.69 in segmented	12.1 kg

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



**T80.10.85** 1000 kN/m max.

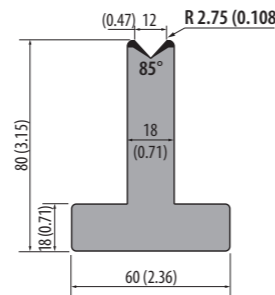


835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

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



**T80.12.85** 1000 kN/m max.

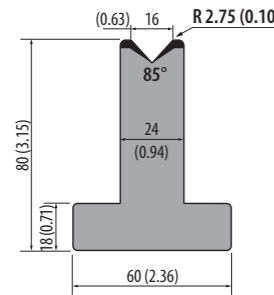


835 mm	32.87 in	14.1 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.4 kg
805 mm segmented	31.69 in segmented	13.6 kg

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



**T80.16.85** 1000 kN/m max.

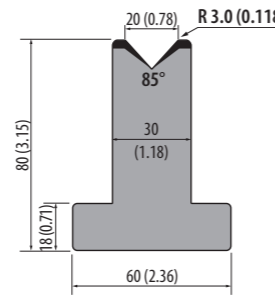


835 mm	32.87 in	16.4 kg
415 mm	16.34 in	8.2 kg
795 mm segmented	31.29 in segmented	15.6 kg
805 mm segmented	31.69 in segmented	15.8 kg

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



**T80.20.85** 1000 kN/m max.

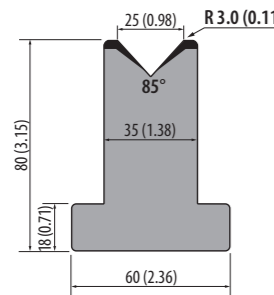


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

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



**T80.25.85** 1000 kN/m max.



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

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



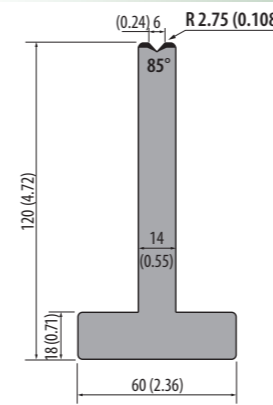
Do you have queries about delivery times, operational areas, and other possibilities? Give us a call!

# R1 ROLLERI TYPE R1

T-Dies 85°, H=120 (4.72)



**T120.06.85** 1000 kN/m max.

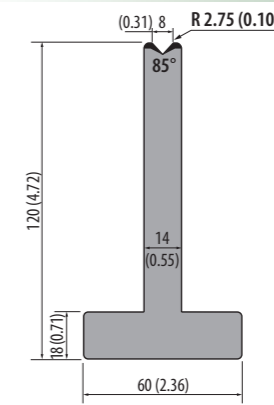


835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

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



**T120.08.85** 1000 kN/m max.

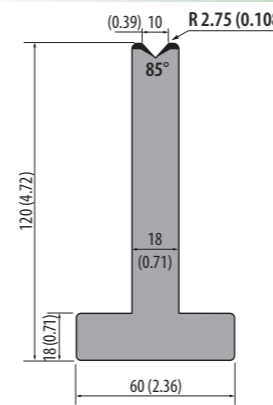


835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

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



**T120.10.85** 1000 kN/m max.

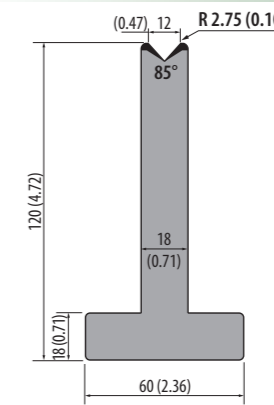


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

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



**T120.12.85** 1000 kN/m max.

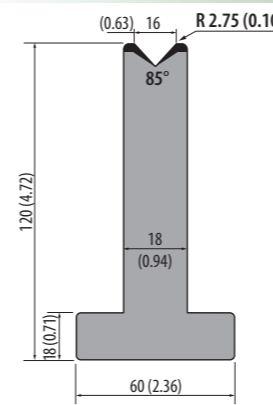


835 mm	32.87 in	18.9 kg
415 mm	16.34 in	9.4 kg
795 mm segmented	31.29 in segmented	18.0 kg
805 mm segmented	31.69 in segmented	18.2 kg

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



**T120.16.85** 1000 kN/m max.

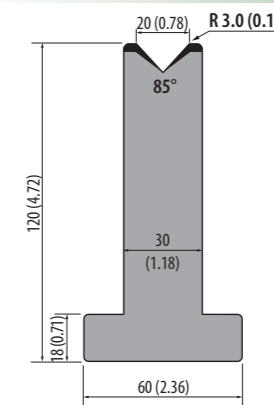


835 mm	32.87 in	22.7 kg
415 mm	16.34 in	11.3 kg
795 mm segmented	31.29 in segmented	21.7 kg
805 mm segmented	31.69 in segmented	21.9 kg

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



**T120.20.85** 1000 kN/m max.

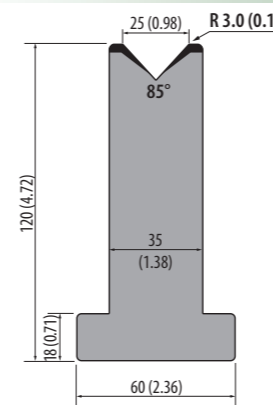


835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

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



**T120.25.85** 1000 kN/m max.



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

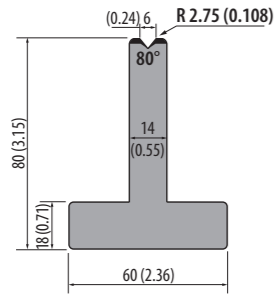
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

T-Dies 80°, H=80 (3.15)

**T80.06.80** 950 kN/m max.

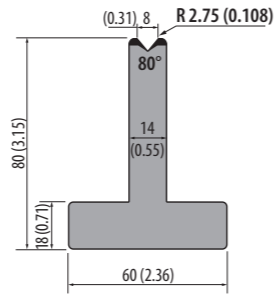


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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



**T80.08.80** 950 kN/m max.

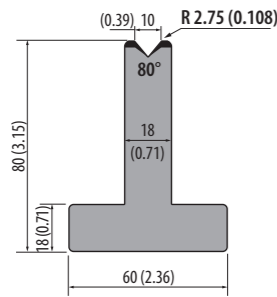


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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



**T80.10.80** 950 kN/m max.

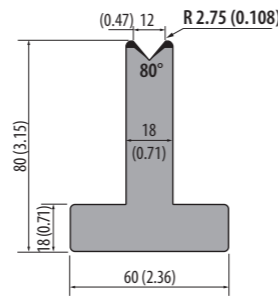


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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



**T80.12.80** 950 kN/m max.

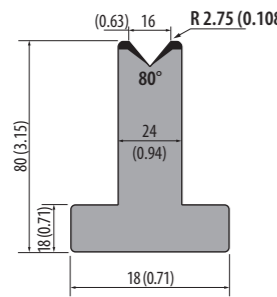


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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



**T80.16.80** 950 kN/m max.

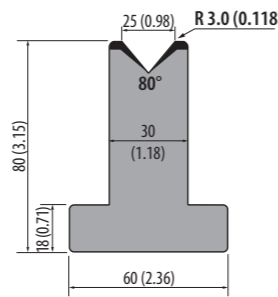


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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



**T80.20.80** 950 kN/m max.

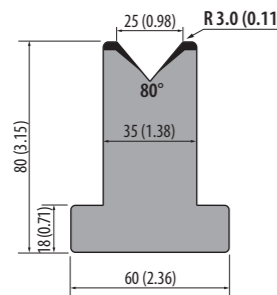


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

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



**T80.25.80** 950 kN/m max.



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

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



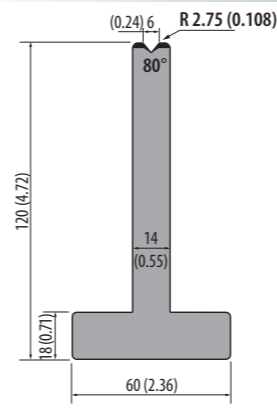
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# R1 ROLLERI TYPE R1

T-Dies 80°, H=120 (4.72)



**T120.06.80** 950 kN/m max.

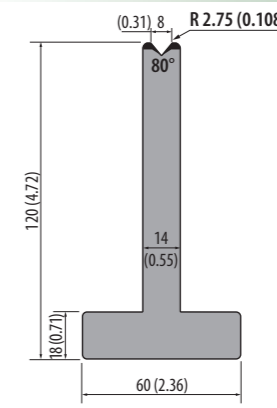


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

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



**T120.08.80** 950 kN/m max.

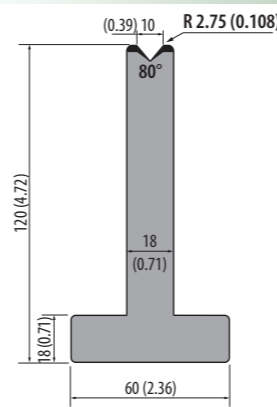


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

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



**T120.10.80** 950 kN/m max.

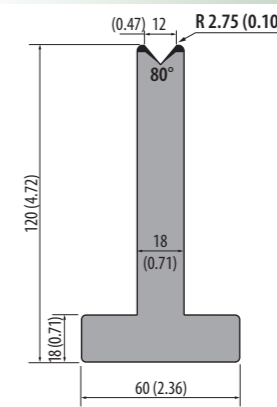


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

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



**T120.12.80** 950 kN/m max.

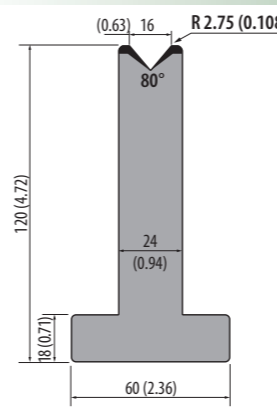


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

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



**T120.16.80** 950 kN/m max.

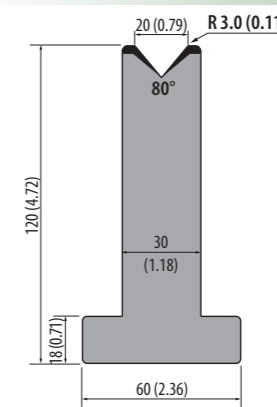


835 mm	32.87 in	18.8 kg
415 mm	16.34 in	9.3 kg
795 mm segmented	31.29 in segmented	17.9 kg
805 mm segmented	31.69 in segmented	18.1 kg

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



**T120.20.80** 950 kN/m max.

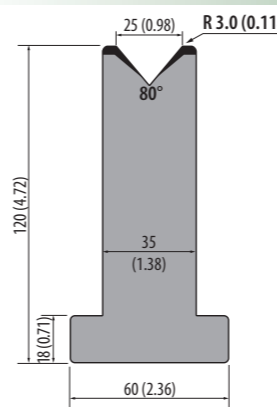


835 mm	32.87 in	26.3 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	25.0 kg
805 mm segmented	31.69 in segmented	25.4 kg

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



**T120.25.80** 950 kN/m max.



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

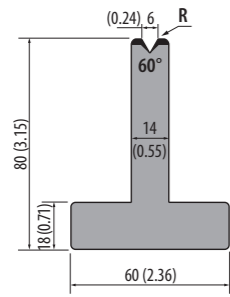
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

T-Dies 60°, H=80 (3.15)

**T80.06.60 / TR80.06.60** 600 kN/m max.

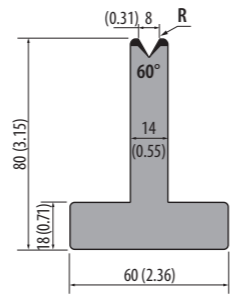


R=0.5 (0.020)			
<b>T80.06.60</b>	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=1.5 (0.059)			
<b>TR80.06.60</b>	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
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

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



**T80.08.60 / TR80.08.60** 600 kN/m max.

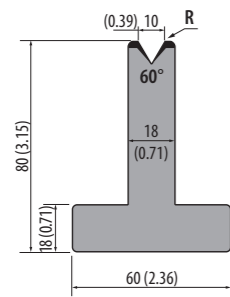


R=0.8 (0.031)			
<b>T80.08.60</b>	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=1.5 (0.059)			
<b>TR80.08.60</b>	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
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

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



**T80.10.60 / TR80.10.60** 600 kN/m max.

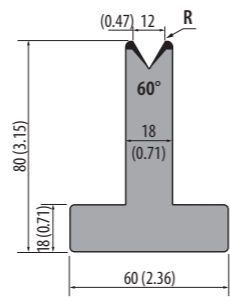


R=0.8 (0.031)			
<b>T80.10.60</b>	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
R=2.75 (0.108)			
<b>TR80.10.60</b>	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg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

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



**T80.12.60 / TR80.12.60** 600 kN/m max.

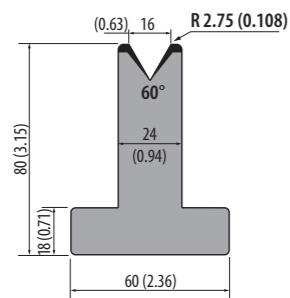


R=0.8 (0.031)			
<b>T80.12.60</b>	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
R=2.75 (0.108)			
<b>TR80.12.60</b>	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg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

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



**T80.16.60** 600 kN/m max.

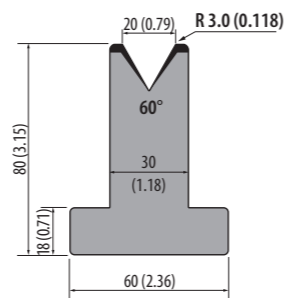


	835 mm	32.87 in	15.6 kg
	415 mm	16.34 in	8.7 kg
	795 mm segmented	31.29 in segmented	14.8 kg
	805 mm segmented	31.69 in segmented	15.0 kg

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



**T80.20.60** 600 kN/m max.

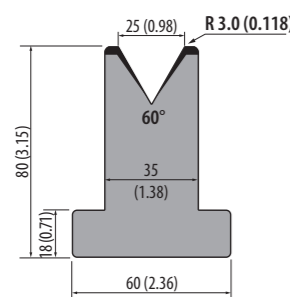


	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.5 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg

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



**T80.25.60** 600 kN/m max.



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

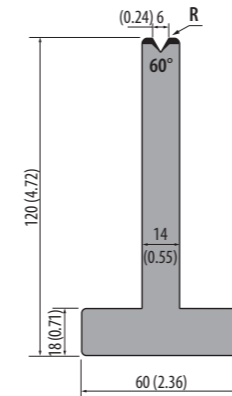
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

T-Dies 60°, H=120 (4.72)

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

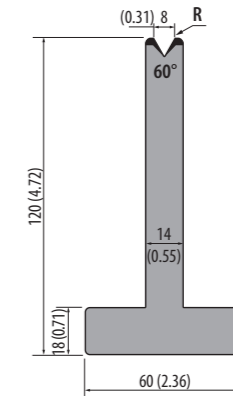


R=0.5 (0.020)			
<b>T120.06.60</b>	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
R=1.5 (0.059)			
<b>TR120.06.60</b>	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg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

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



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

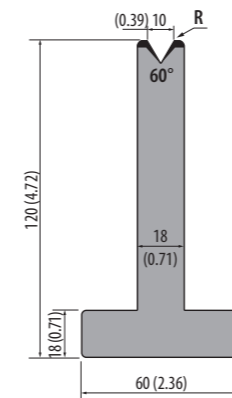


R=0.8 (0.031)			
<b>T120.08.60</b>	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
R=1.5 (0.059)			
<b>TR120.08.60</b>	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg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

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



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

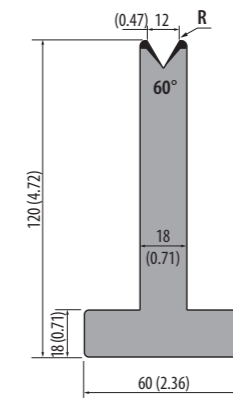


R=0.8 (0.031)			
<b>T120.10.60</b>	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
R=2.75 (0.108)			
<b>TR120.10.60</b>	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg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

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



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

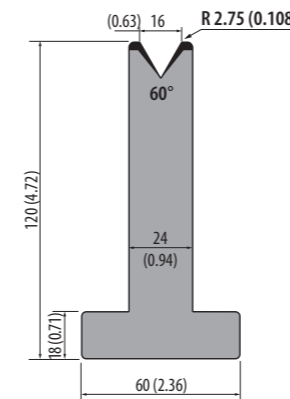


R=0.8 (0.031)			
<b>T120.12.60</b>	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
R=2.75 (0.108)			
<b>TR120.12.60</b>	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg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

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



**T120.16.60** 600 kN/m max.

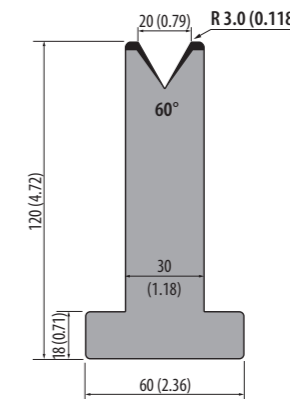


	835 mm	32.87 in	22.4 kg
	415 mm	16.34 in	11.1 kg
	795 mm segmented	31.29 in segmented	21.3 kg
	805 mm segmented	31.69 in segmented	21.6 kg

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



**T120.20.60** 600 kN/m max.

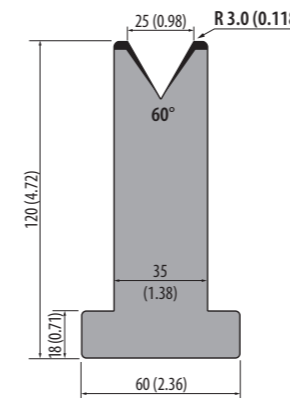


	835 mm	32.87 in	26.0 kg
	415 mm	16.34 in	13.0 kg
	795 mm segmented	31.29 in segmented	24.8 kg
	805 mm segmented	31.69 in segmented	25.0 kg

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



**T120.25.60** 600 kN/m max.



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

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



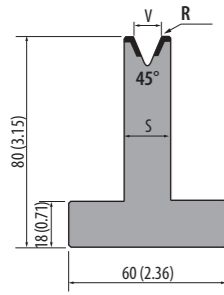
For modifications on dies see pages 250-253

# R1 ROLLERI TYPE R1

T-Dies 45°, H=80 (3.15), H=120 (4.72)

## T-Dies 45°, H=80 mm (3.15 in)

500 kN/m max.



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

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

# R1 ROLLERI TYPE R1

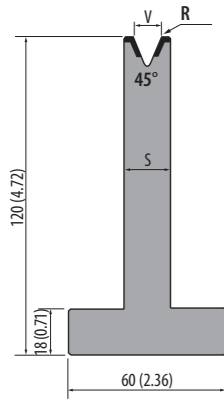
T-Dies 35°, H=80 (3.15), H=120 (4.72)



2  
R1

## T-Dies 45°, H=120 mm (4.72 in)

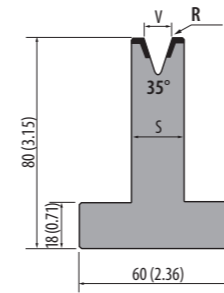
500 kN/m max.



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

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

## T-Dies 35°, H=80 mm (3.15 in)

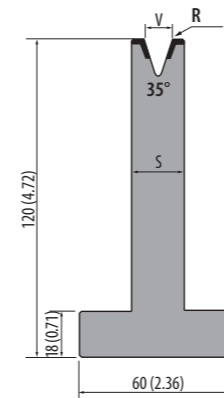


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	Weight	Weight	Weight	Weight
T80.06.35	6	0.24	0.8	0.03	14	0.55	350	12.5 kg	6.5 kg	11.9 kg	12.0 kg
T80.08.35	8	0.31	1.0	0.04	16	0.63	350	13.0 kg	7.0 kg	12.4 kg	12.6 kg
T80.10.35	10	0.39	1.2	0.05	20	0.79	400	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.12.35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

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



## T-Dies 35°, H=120 mm (4.72 in)



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

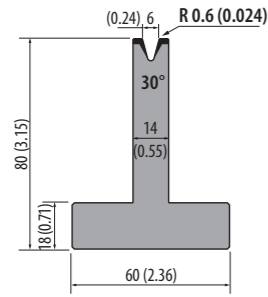
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

T-Dies 30°, H=80 (3.15)

**T80.06.30** 350 kN/m max.

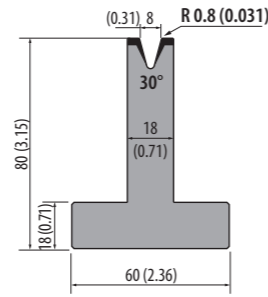


835 mm	32.87 in	12.4 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	11.8 kg
805 mm segmented	31.69 in segmented	12.0 kg

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



**T80.08.30** 350 kN/m max.

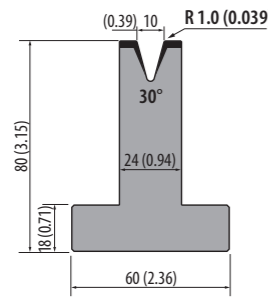


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.6 kg

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



**T80.10.30** 500 kN/m max.

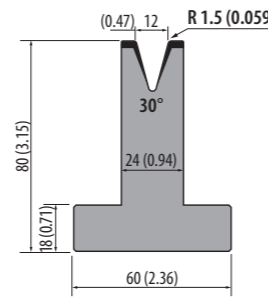


835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

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



**T80.12.30** 400 kN/m max.

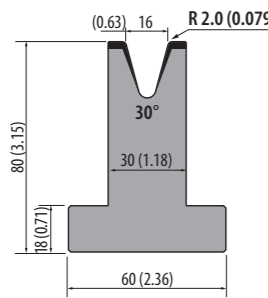


835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

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



**T80.16.30** 450 kN/m max.

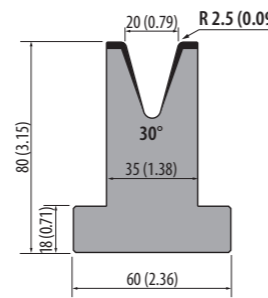


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

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



**T80.20.30** 500 kN/m max.

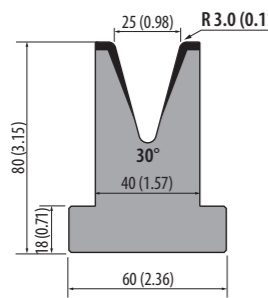


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

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



**T80.25.30** 500 kN/m max.



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

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



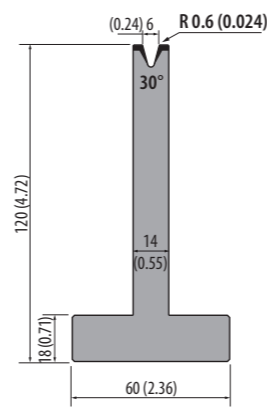
Articles on stock – Please note that delivery time varies according to your location.

# R1 ROLLERI TYPE R1

T-Dies 30°, H=120 (4.72)



**T120.06.30** 350 kN/m max.

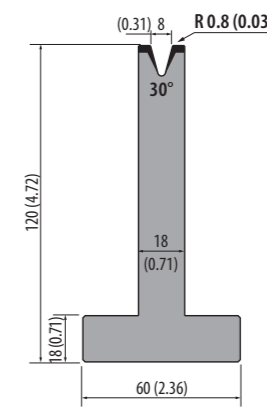


835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

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



**T120.08.30** 350 kN/m max.

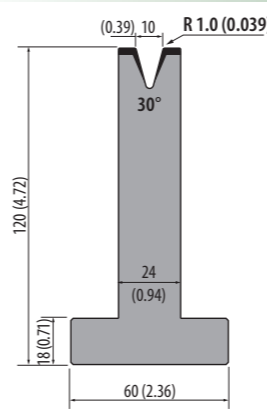


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

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



**T120.10.30** 500 kN/m max.

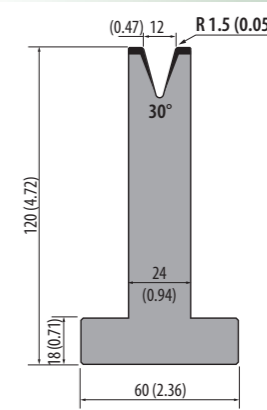


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.9 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

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



**T120.12.30** 400 kN/m max.

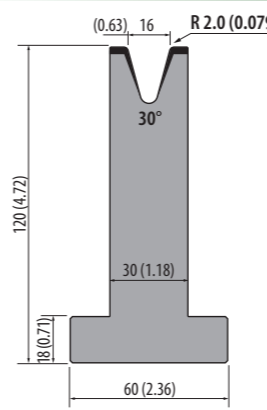


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

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



**T120.16.30** 450 kN/m max.

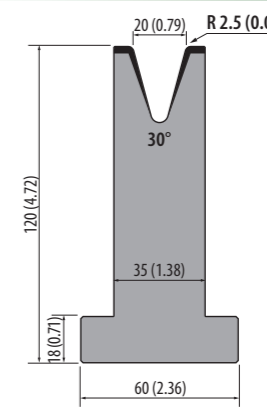


835 mm	32.87 in	25.8 kg
415 mm	16.34 in	12.8 kg
795 mm segmented	31.29 in segmented	24.6 kg
805 mm segmented	31.69 in segmented	24.9 kg

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



**T120.20.30** 500 kN/m max.

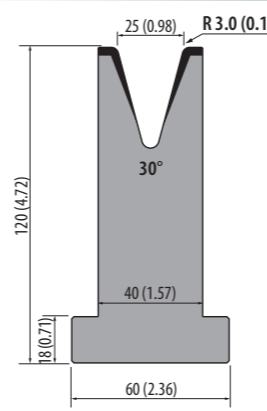


835 mm	32.87 in	28.0 kg
415 mm	16.34 in	14.0 kg
795 mm segmented	31.29 in segmented	26.7 kg
805 mm segmented	31.69 in segmented	27.0 kg

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



**T120.25.30** 500 kN/m max.



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

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



# R1 ROLLERI TYPE R1

T-Dies 26°, H=80 (3.15)



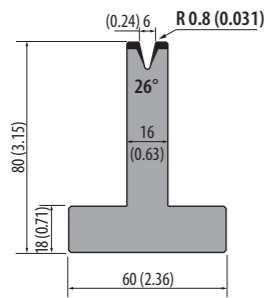
# R1 ROLLERI TYPE R1

T-Dies 26°, H=120 (4.72)



2  
R1

**T80.06.26** 200 kN/m max.

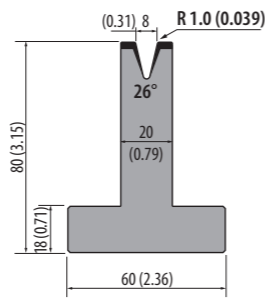


835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

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



**T80.08.26** 200 kN/m max.

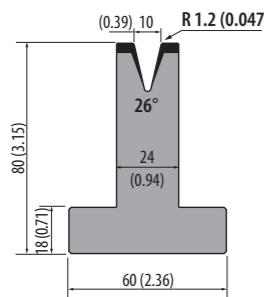


835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	14.5 kg

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



**T80.10.26** 200 kN/m max.

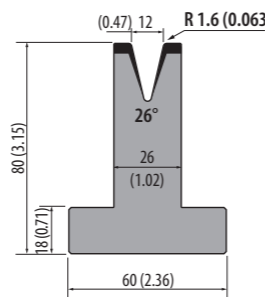


835 mm	32.87 in	15.5 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	14.9 kg

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



**T80.12.26** 200 kN/m max.

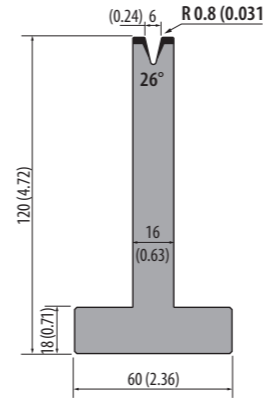


835 mm	32.87 in	16.6 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	15.8 kg
805 mm segmented	31.69 in segmented	16.0 kg

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



**T120.06.26** 200 kN/m max.

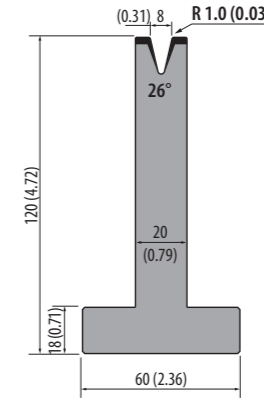


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

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



**T120.08.26** 200 kN/m max.

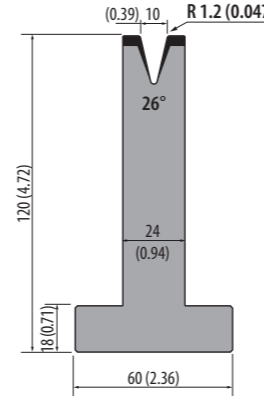


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

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



**T120.10.26** 200 kN/m max.

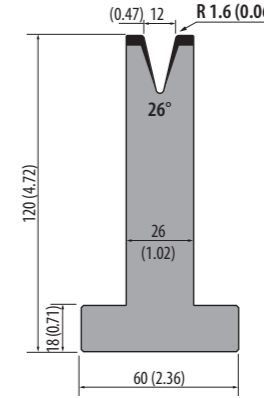


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

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

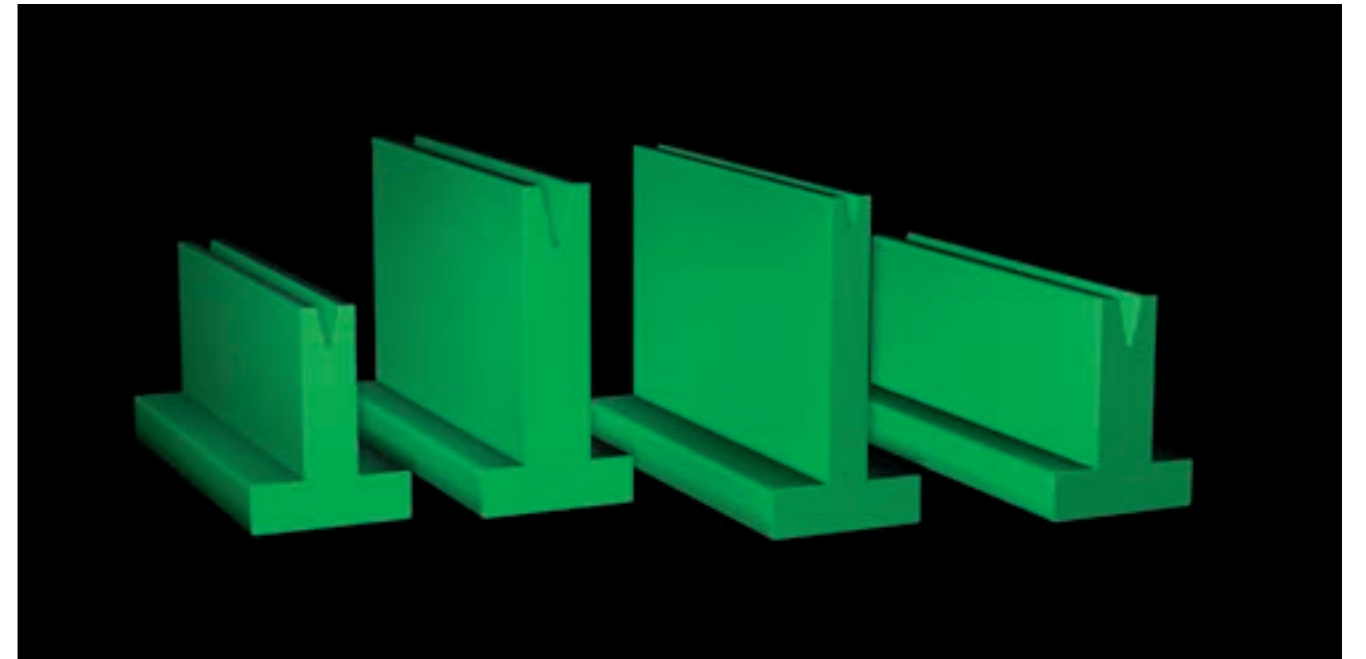


**T120.12.26** 200 kN/m max.



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

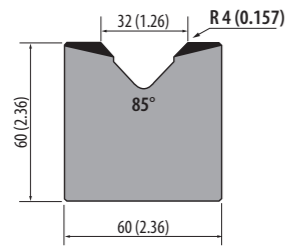
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

1-V Dies, 85°

**M60.85.32** 1000 kN/m max.

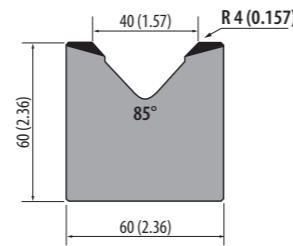


835 mm	32.87 in	21.6 kg
415 mm	16.34 in	10.7 kg
795 mm segmented	31.29 in segmented	20.6 kg
805 mm segmented	31.69 in segmented	20.8 kg

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



**M60.85.40** 1000 kN/m max.

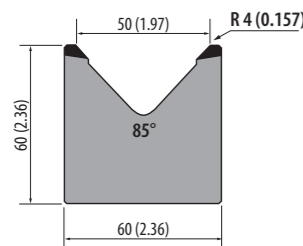


835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

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



**M60.85.50** 1000 kN/m max.

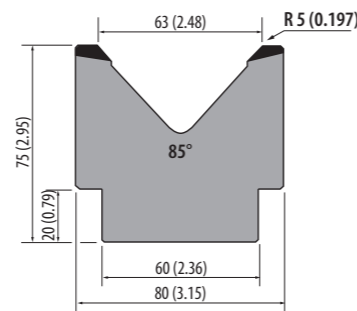


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

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



**M75.85.63** 1000 kN/m max.

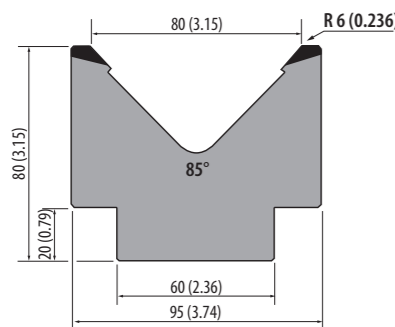


835 mm	32.87 in	29.2 kg
415 mm	16.34 in	14.5 kg
795 mm segmented	31.29 in segmented	27.8 kg
805 mm segmented	31.69 in segmented	28.0 kg

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

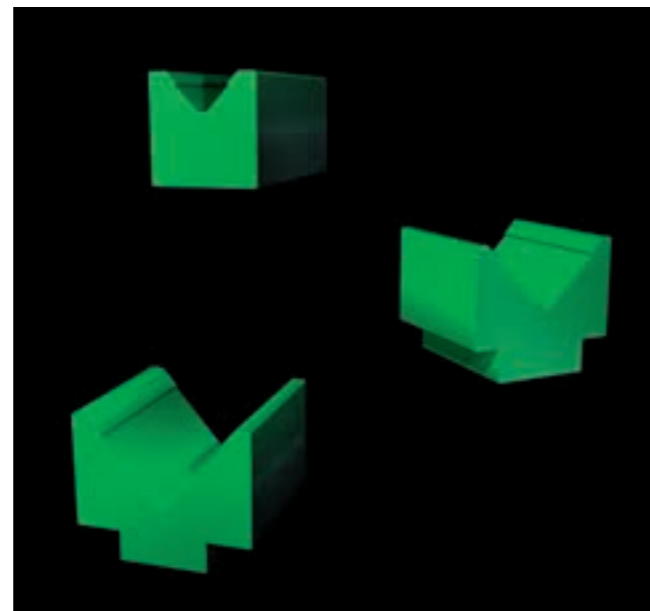


**M80.85.80** 1000 kN/m max.



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

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

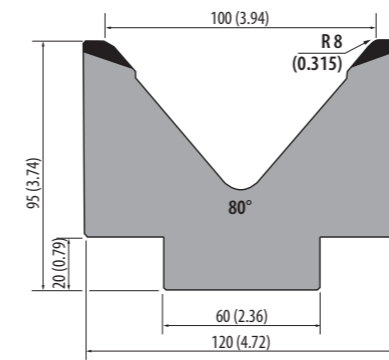


# R1 ROLLERI TYPE R1

1-V Dies, 80°

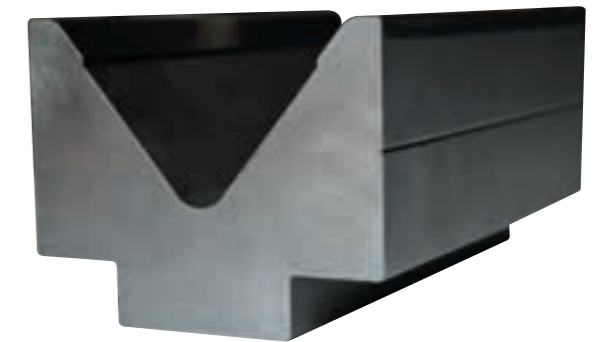


**M95.80.100** 1000 kN/m max.

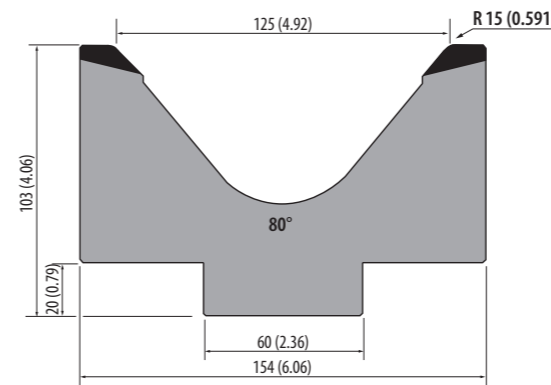


835 mm	32.87 in	46.2 kg
415 mm	16.34 in	22.9 kg
795 mm segmented	31.29 in segmented	44.0 kg
805 mm segmented	31.69 in segmented	44.5 kg

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



**MK103.80.125** 700 kN/m max.

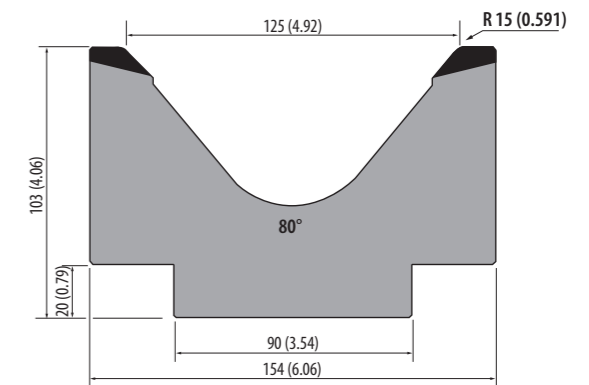


835 mm	32.87 in	62.0 kg
415 mm	16.34 in	31.0 kg
795 mm segmented	31.29 in segmented	59.0 kg
805 mm segmented	31.69 in segmented	59.8 kg



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

**M103.80.125** 1000 kN/m max.

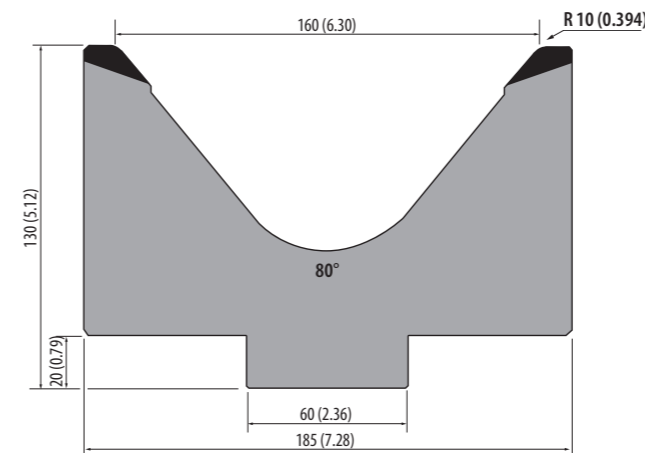


835 mm	32.87 in	64.9 kg
415 mm	16.34 in	32.2 kg
795 mm segmented	31.29 in segmented	61.4 kg
805 mm segmented	31.69 in segmented	62.5 kg



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

**MK130.80.160** 700 kN/m max.

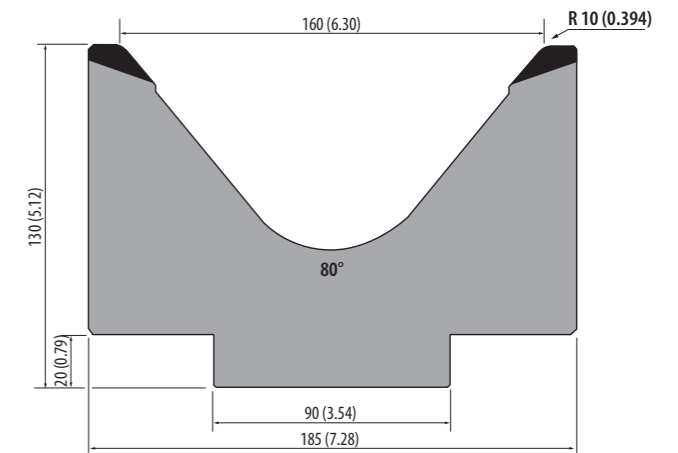


835 mm	32.87 in	93.0 kg
415 mm	16.34 in	46.5 kg
795 mm segmented	31.29 in segmented	88.5 kg
805 mm segmented	31.69 in segmented	89.7 kg



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

**M130.80.160** 1000 kN/m max.



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

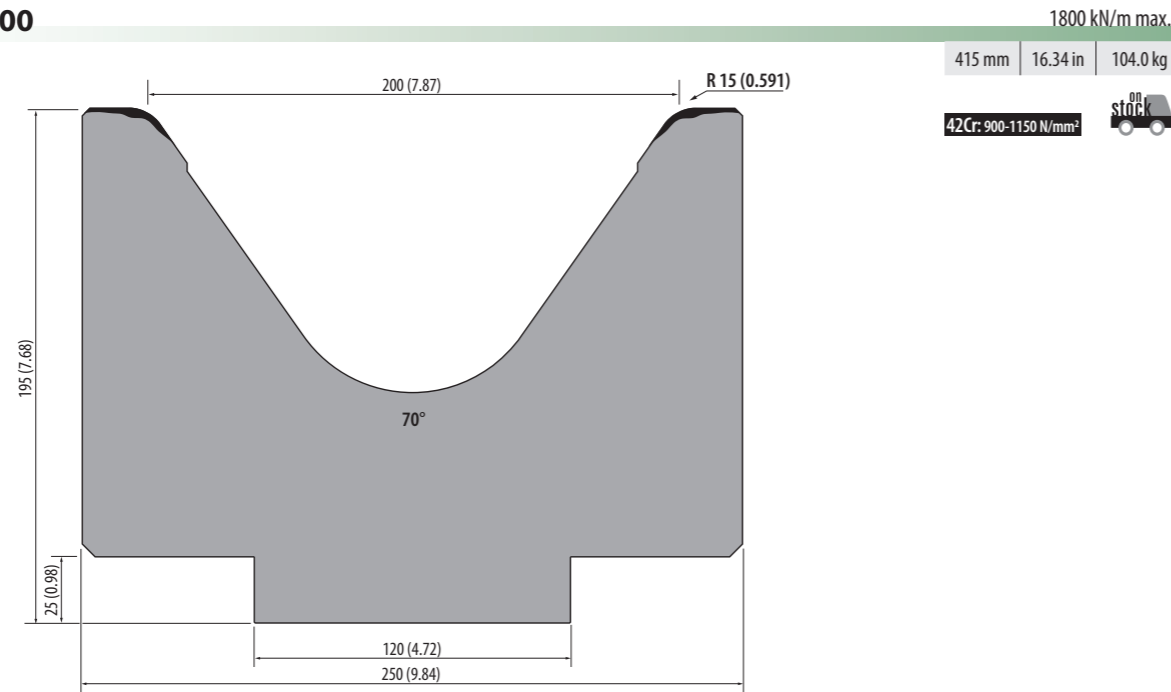


C45: 560-710 N/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

1-V Dies, 70°

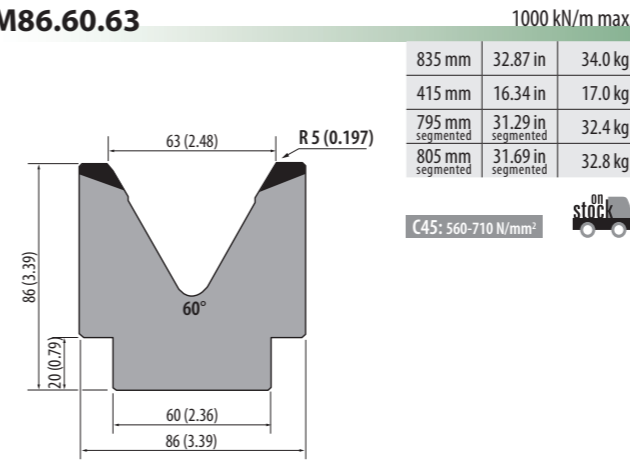
M195.70.200



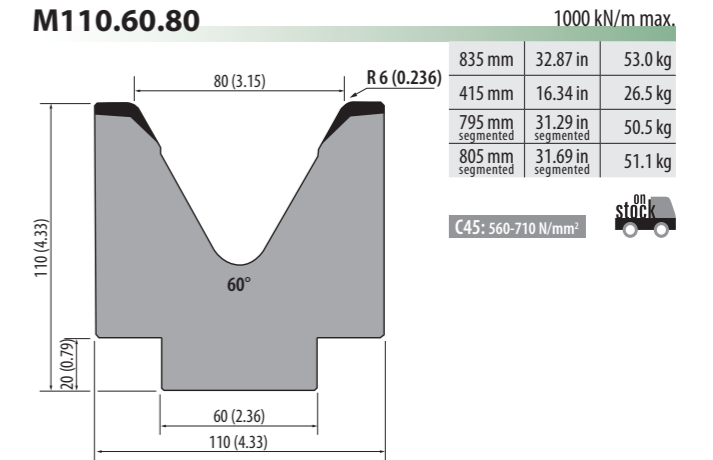
# R1 ROLLERI TYPE R1

1-V Dies, 60°

M86.60.63

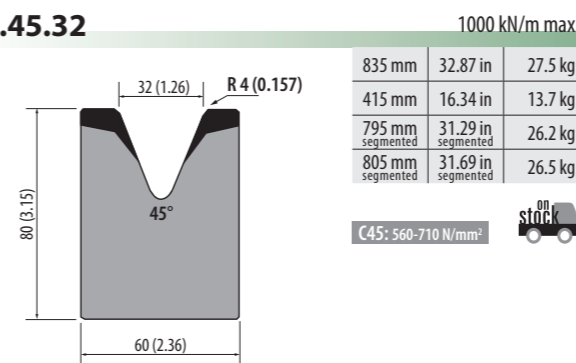


M110.60.80

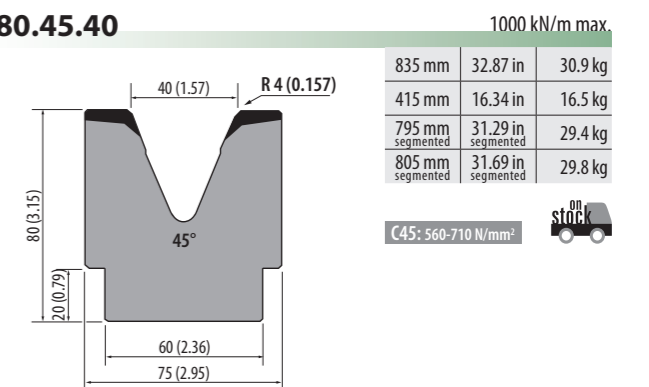


# 1-V Dies, 45°

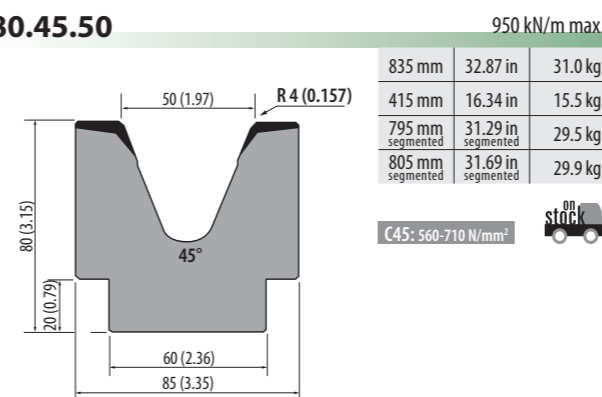
M80.45.32



M80.45.40



M80.45.50



For the application of dies Roller Type R1 use the adapters on pages 218-221

### M60.90.01

1000 kN/m max.

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

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

### M60.90.02

800 kN/m max.

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

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

### M.360.R

1000 kN/m max.

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

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

### M.460.R

800 kN/m max.

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

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

### M.460

800 kN/m max.

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

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

### M.460.60

600 kN/m max.

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

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

### M.490

1000 kN/m max.

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

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

### M.490.70

600 kN/m max.

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

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

### T70-88

1000 kN/m max.

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

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

### T70-60

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

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

V (mm)	6	8	10	12	16	20
kN/m max.	600	600	600	600	800	800

### T70-45

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

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

V (mm)	6	8	10	12	16	20
kN/m max.	400	400	500	500	700	700

### T70-35

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

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

V (mm)	6	8	10	12	16	20
kN/m max.	300	350	450	450	500	500

### SU-T70

525 mm	20.67 in	12.4 kg
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C45: 560-710 N/mm<sup>2</sup>

### PB-T70

20 mm	0.79 in	0.2 kg
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per pair

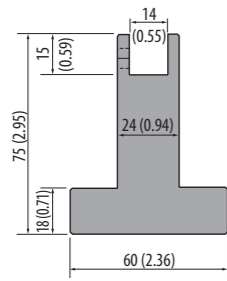
Fe37

Special Punches and Dies see pages 236-241

# R1 ROLLERI TYPE R1

## Synthetic Dies

### TN80.14

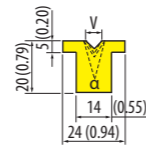


1000 kN/m max.		
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg

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



### INS14...



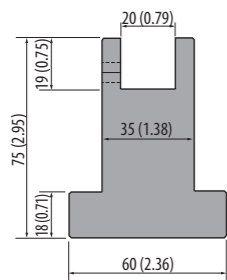
200 kN/m max.		
835 mm	32.87 in	0.30 kg
415 mm	16.34 in	0.15 kg



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

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

### TN80.20

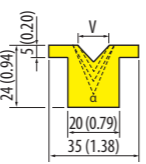


1000 kN/m max.		
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg

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



### INS20...



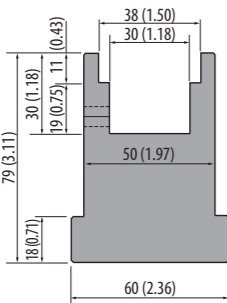
200 kN/m max.		
835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg



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

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

### TN80.30

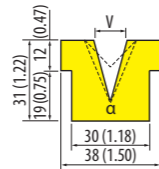


1000 kN/m max.		
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

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



### INS30...



200 kN/m max.		
835 mm	32.87 in	0.50 kg
415 mm	16.34 in	0.25 kg



Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.98
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16	0.63
INS30.20.60	60°	20	0.79

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

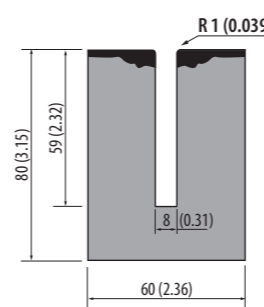
For advantages and mounting examples see Mark-Free bending Chapter on pages 228-229

# R1 ROLLERI TYPE R1

## Hemming Dies



### TOP.SM-134.28.8 / TOP.SM-134.24.8

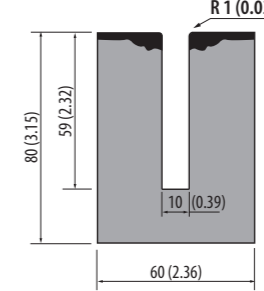


525 mm	20.67 in	17.5 kg
495 mm segmented	19.49 in segmented	16.5 kg

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



### TOP.SM-134.24.10

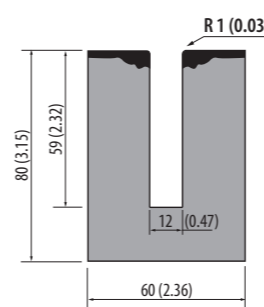


525 mm	20.67 in	18.0 kg
495 mm segmented	19.49 in segmented	16.9 kg

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



### TOP.SM-134.24.12



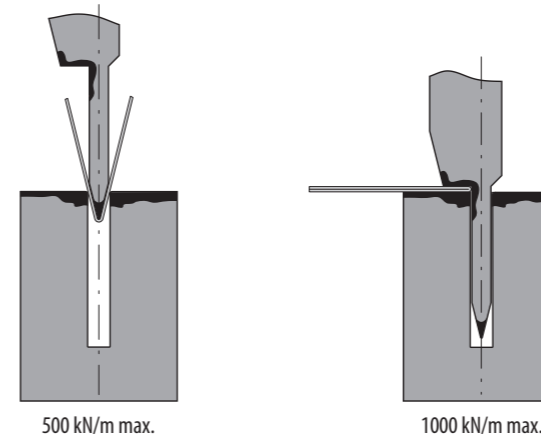
525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.9 kg

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



Compatible Hemming Punches see page 28

### Example of application



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

# R1 ROLLERI TYPE R1

## Spring-loaded Hemming Dies

**S101.35.06** 600 kN/m max.

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

C45: 800-850 N/mm<sup>2</sup>

**S101.35.08** 600 kN/m max.

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

C45: 800-850 N/mm<sup>2</sup>

**S101.35.10** 600 kN/m max.

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

C45: 800-850 N/mm<sup>2</sup>

**S110.30.08** 800 kN/m max.

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

C45: 800-850 N/mm<sup>2</sup>

**S135.26.08** 400 kN/m max.

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

C45: 800-850 N/mm<sup>2</sup>

**S135.26.10** 1000 kN/m max.

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

C45: 800-850 N/mm<sup>2</sup>

**SA135.26.12** 1000 kN/m max.

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

C45: 800-850 N/mm<sup>2</sup>

### Our Advantage – Your Convenience

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



### Rolleri Videos

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



# R1 ROLLERI TYPE R1

## Pneumatic Hemming Dies



**KPN** per piece 1.0 kg

Accessories for pneumatic hemming dies

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

**S101PN.35.06** 600 kN/m max.

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

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

**S101PN.35.08** 600 kN/m max.

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

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

**S101PN.35.10** 600 kN/m max.

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

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

**S135PN.26.08** 400 kN/m max.

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

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

**S135PN.26.10** 1000 kN/m max.

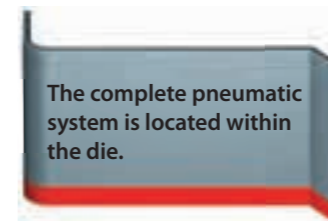
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

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

**SA135PN.26.12** 1000 kN/m max.

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

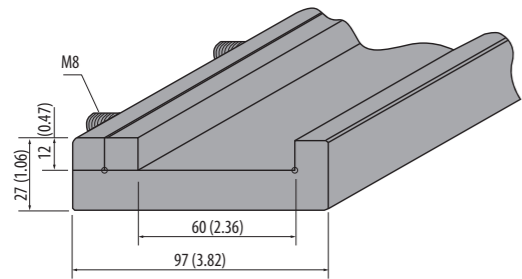
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

Adpater Rails for Dies

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



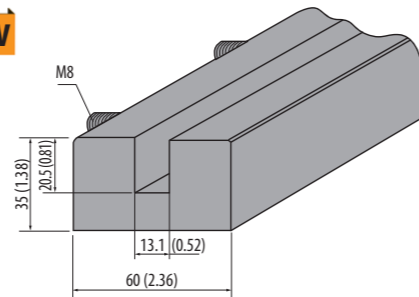
Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



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

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

**NEW**

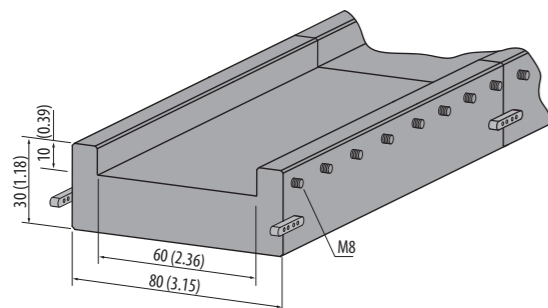


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



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

## C 1050/R

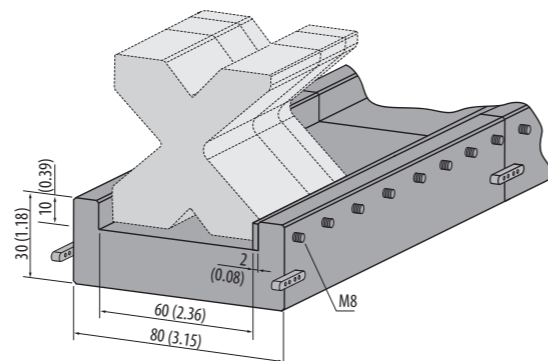


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg



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

## C 1050/RS

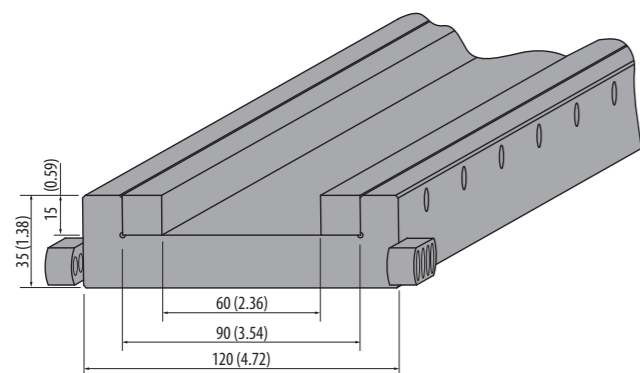


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



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

## C 1050-90



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



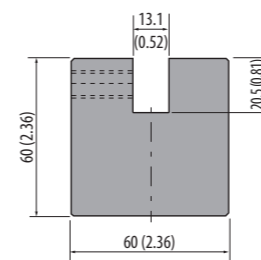
C45: 560-710 N/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

Die Adapters



## AD5



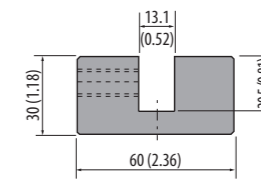
1000 kN/m max.		
1000 mm	39.37 in	26.1 kg
500 mm	19.68 in	13.0 kg

Rolleri Type R1  
→ Rolleri Type R2/R3

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



## AD6



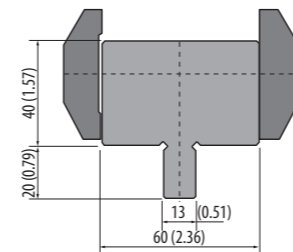
1000 kN/m max.		
1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1  
→ Rolleri Type R2/R3

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



## AD7



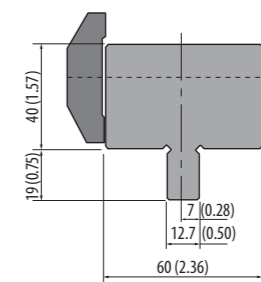
1000 kN/m max.		
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3  
→ Rolleri Type R1

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



## AD9-12.7



1000 kN/m max.		
835 mm	32.87 in	19.6 kg
415 mm	16.34 in	9.7 kg

Rolleri Type RX LVD  
→ Rolleri Type R1

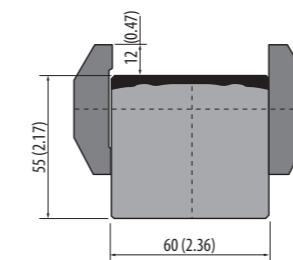
C45: 560-710 N/mm<sup>2</sup>



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

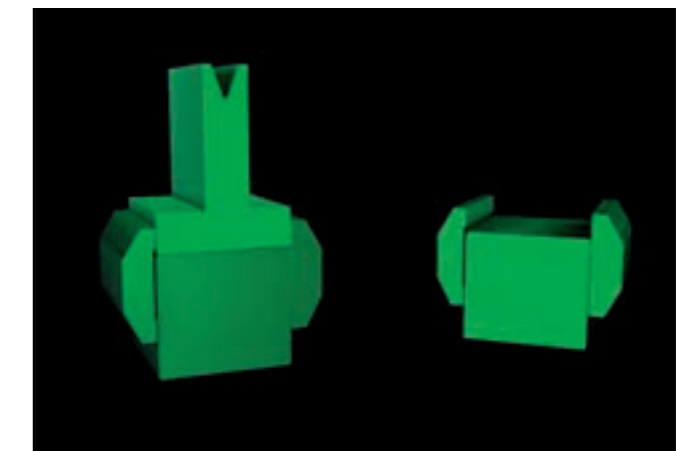
## Die Extensions

### CTS60



1000 kN/m max.		
835 mm	32.87 in	29.0 kg
415 mm	16.34 in	14.5 kg

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





## PUNCHES ROLLERI TYPE R2

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

### Compatibility

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

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

### Compatibility

Punches Roller Type R2 are:

- compatible with press brake machines from: Bystronic-Hämmerle, LVD, Trumpf or on press brake machines with System NSCL (New Standard Clamping)
- also applicable on all other press brake machines with adapter-systems (see page 214).

### Material

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

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

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

### Tang

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

- QuickLock ↓
- Safety Pins ↔
- ROL-System ↑

#### ATTENTION:

##### QuickLock

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

##### Safety Pins

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

##### ROL1-System

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

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

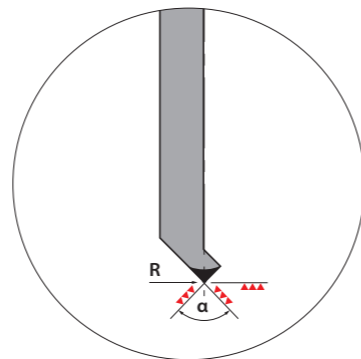
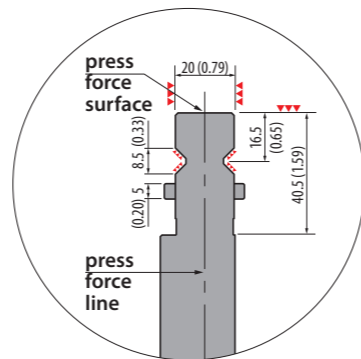
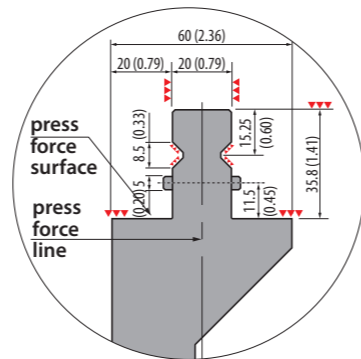
Depending on each type, the punches are either head-bearing or shoulder-bearing.

Indications of precision ground surfaces:



### Our Advantages – Your Convenience

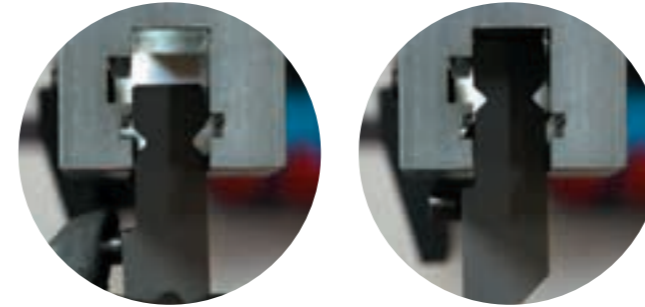
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 248-249)
- very large stock availability



### Clamping Systems

#### QuickLock (Standard)

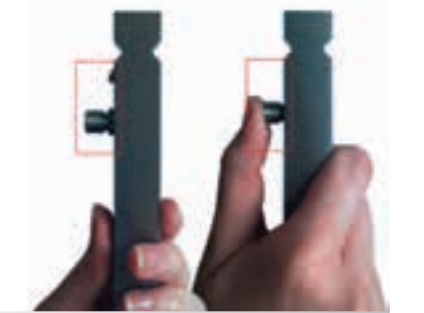
- vertical tool exchange
- easy handling
- substantial savings on equipment costs
- applicable on tools < 12.0 kg
- applicable on tools > 12.0 kg through special sectioning possible



#### Rolleri Videos

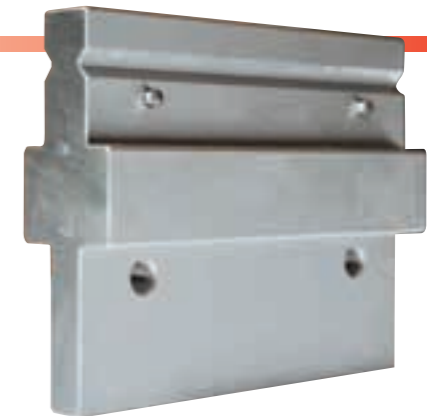
QuickLock System:  
[www.rolleritools.com/videos/quicklock](http://www.rolleritools.com/videos/quicklock)

## QuickLock



#### Safety Pins (Standard)

- horizontal tool exchange



#### ROL1-System

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



### Tool Lengths and Sectioning

Standard

More lengths and sectionings are possible upon request.

500 mm (19.68 in)

515 mm (20.28 in)

525 mm (20.67 in)

#### Sectioning FA

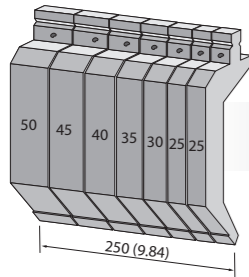
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

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

#### Sectioning FB

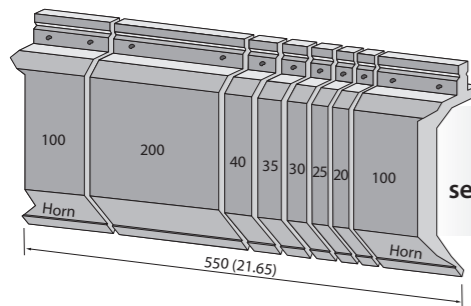
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

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

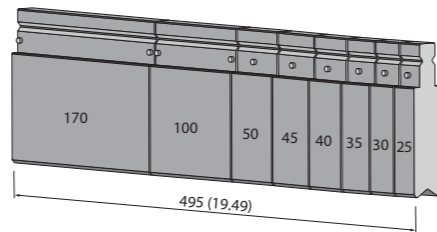


250 mm (9.84 in) segmented / FC (7 segments)

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

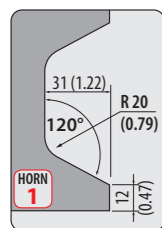


550 mm (21.65 in) segmented / FW (8 segments)

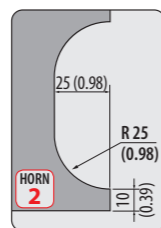


495 mm (19.49 in) segmented / F (8 segments)

### Horn Types



**Horn 1**  
Standard for all segmented Punches Roller Type R2

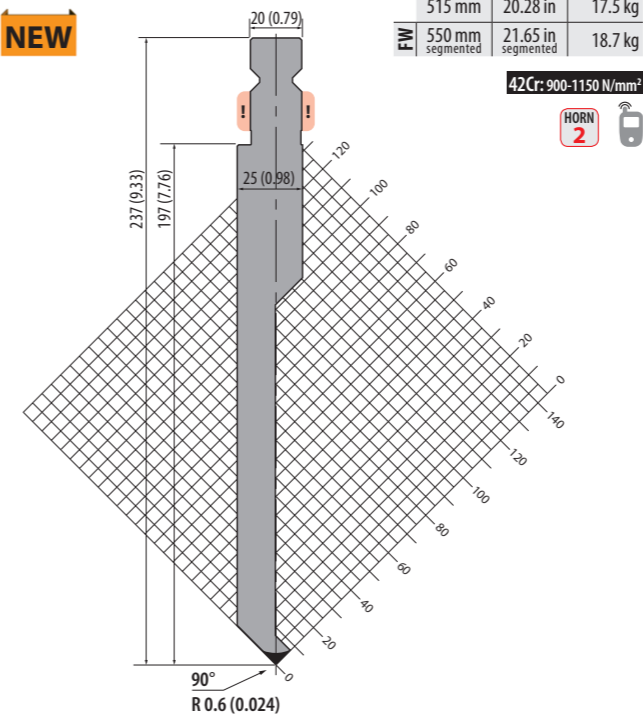


**Horn 2**  
for all segmented Punches Roller Type R2 of Length 550 mm (21.65 in)

### TPR237.90.R06

600 kN/m max.

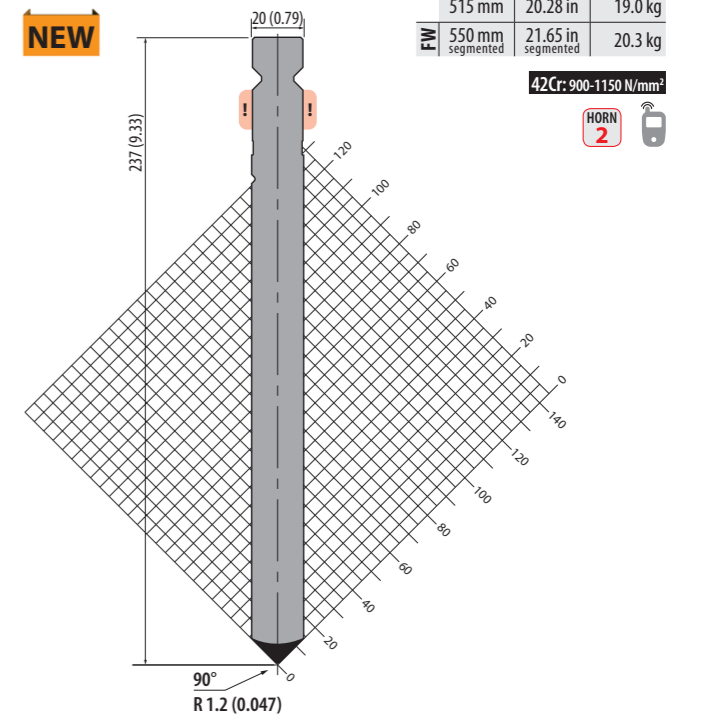
NEW



### TPR237.90.R12

1000 kN/m max.

NEW

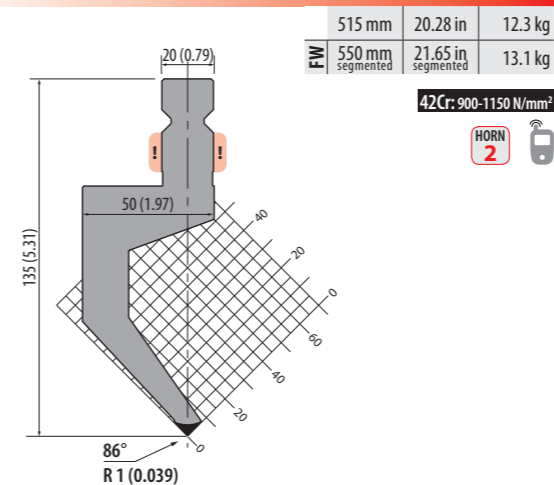


### 86° Punches

### TPR135.86.R1

650 kN/m max.

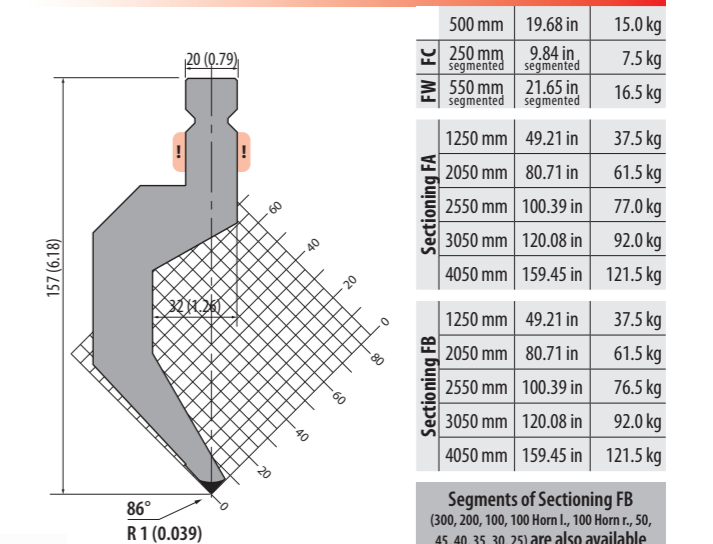
NEW



### TPR157.86.R1

800 kN/m max.

NEW



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

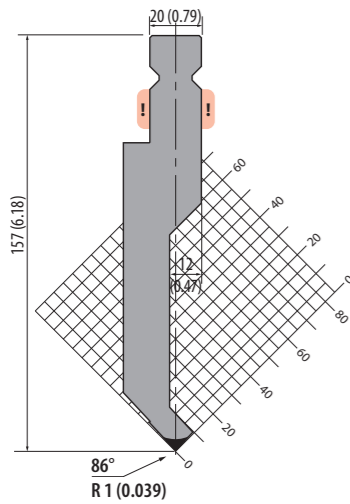
42Cr: 900-1150 N/mm<sup>2</sup>  
HORN 1  
HORN 2 only for 550 mm (21.65 in) segm.

# R2 ROLLERI TYPE R2

## 86° Punches

TPR157.86.R1-A

800 kN/m max.



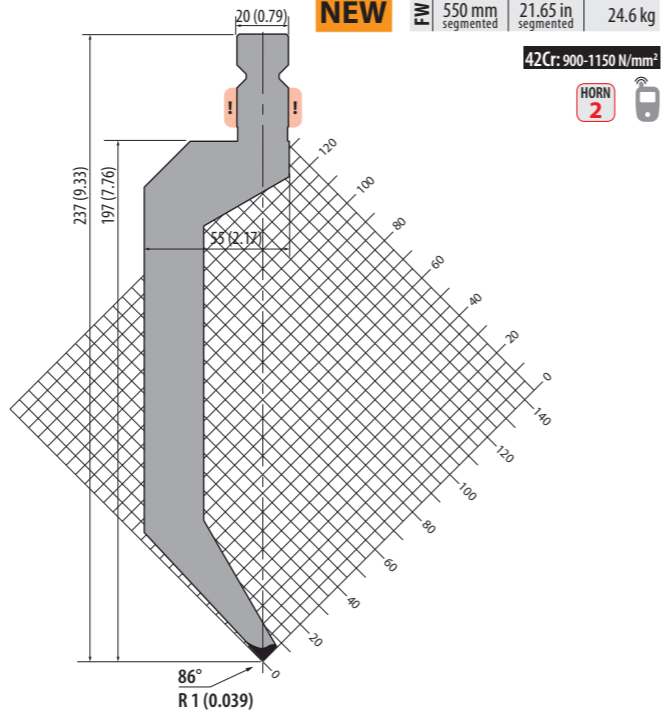
	500 mm	19.68 in	12.5 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
	FW 550 mm segmented	21.65 in segmented	13.8 kg
Sectioning FA	1250 mm	49.21 in	31.3 kg
	2050 mm	80.71 in	51.3 kg
	2550 mm	100.39 in	63.8 kg
	3050 mm	120.08 in	76.3 kg
	4050 mm	159.45 in	101.3 kg
Sectioning FB	1250 mm	49.21 in	31.3 kg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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

TPR237.86.R1

500 kN/m max.



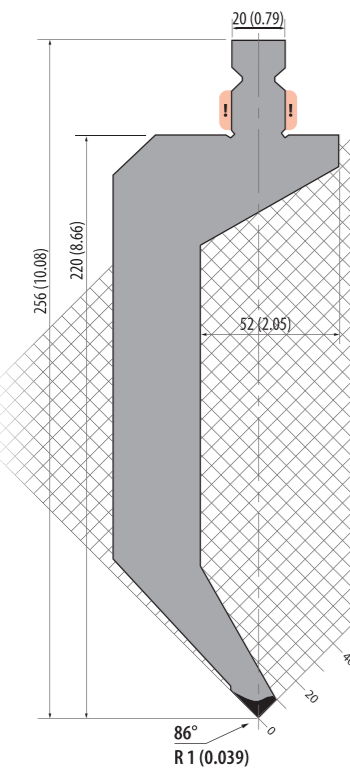
**NEW**

	515 mm	20.28 in	23.0 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
	FW 550 mm segmented	21.65 in segmented	24.6 kg

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

TPR256.86.R1

800 kN/m max.



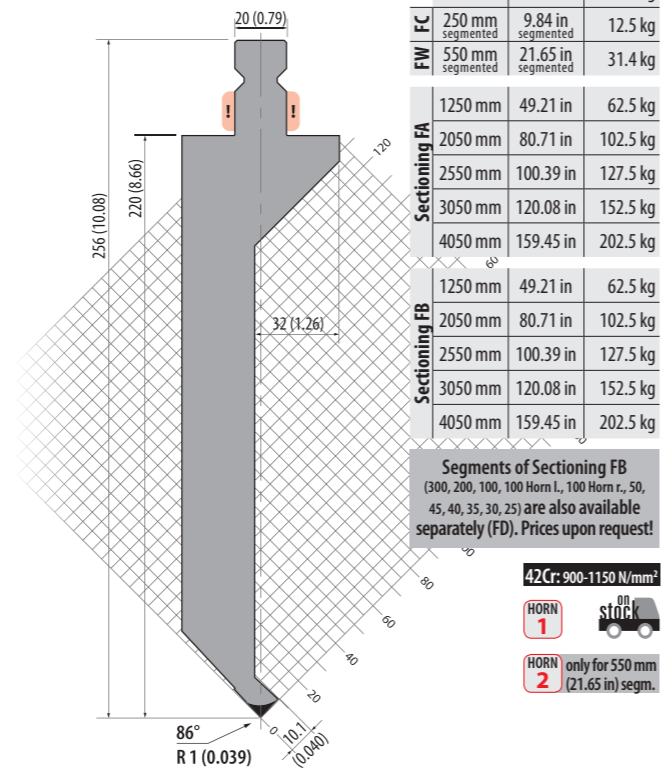
	500 mm	19.68 in	33.0 kg
FC	250 mm segmented	9.84 in segmented	16.5 kg
	FW 550 mm segmented	21.65 in segmented	36.3 kg
Sectioning FA	1250 mm	49.21 in	82.5 kg
	2050 mm	80.71 in	136.0 kg
	2550 mm	100.39 in	189.0 kg
	3050 mm	120.08 in	202.0 kg
	4050 mm	159.45 in	268.0 kg
Sectioning FB	1250 mm	49.21 in	82.5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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

TPR256.86.R1-A

800 kN/m max.



	500 mm	19.68 in	28.5 kg
FC	250 mm segmented	9.84 in segmented	12.5 kg
	FW 550 mm segmented	21.65 in segmented	31.4 kg
Sectioning FA	1250 mm	49.21 in	62.5 kg
	2050 mm	80.71 in	102.5 kg
	2550 mm	100.39 in	127.5 kg
	3050 mm	120.08 in	152.5 kg
	4050 mm	159.45 in	202.5 kg
Sectioning FB	1250 mm	49.21 in	62.5 kg
	2050 mm	80.71 in	102.5 kg
	2550 mm	100.39 in	127.5 kg
	3050 mm	120.08 in	152.5 kg
	4050 mm	159.45 in	202.5 kg

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

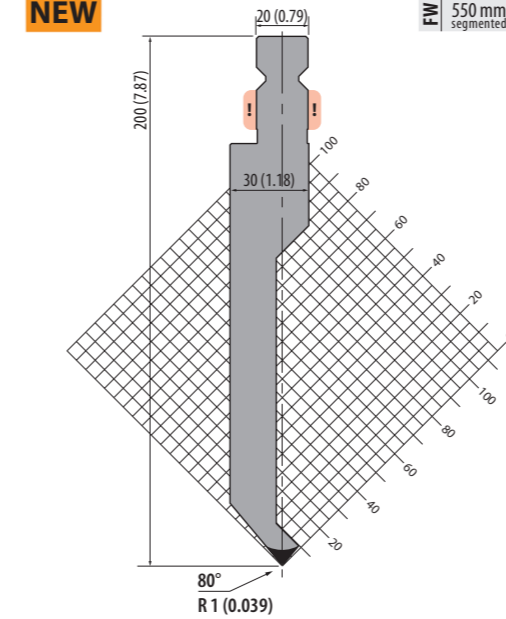
# R2 ROLLERI TYPE R2

## 80° Punches



TPR200.80.R1

800 kN/m max.



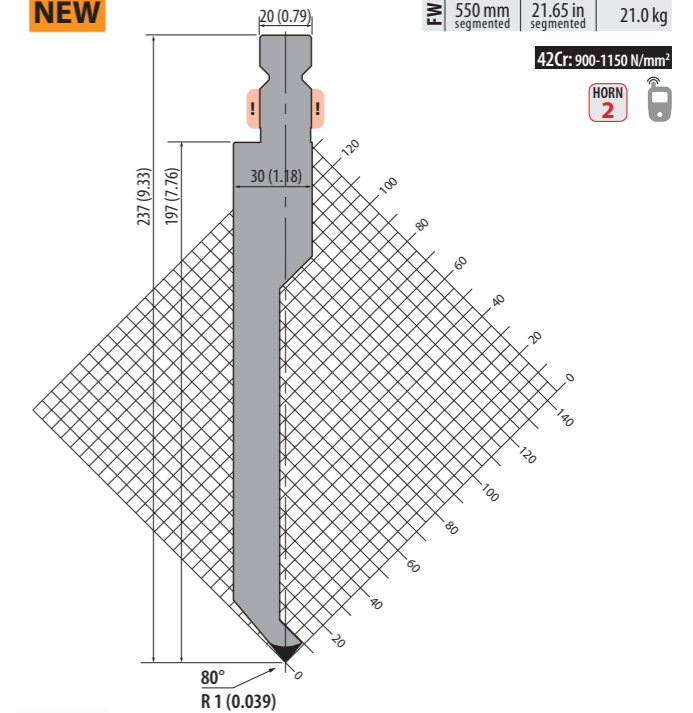
**NEW**

	515 mm	20.28 in	19.0 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
	FW 550 mm segmented	21.65 in segmented	20.3 kg

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

TPR237.80.R1

800 kN/m max.



**NEW**

	515 mm	20.28 in	19.7 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
	FW 550 mm segmented	21.65 in segmented	21.0 kg

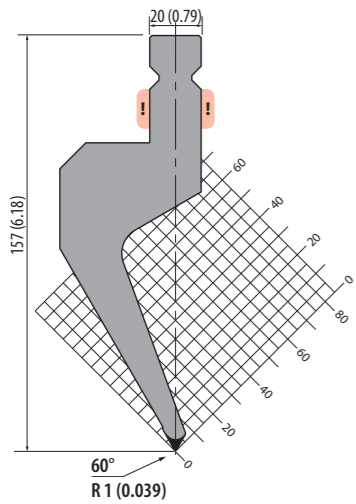
42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 2**

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



### TPR157.60.R1

700 kN/m max.



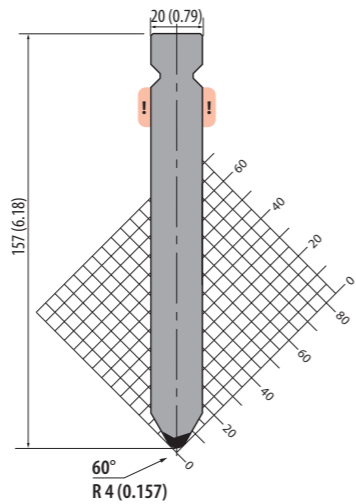
FW	FC	FA	FB
500 mm	19.68 in	15.0 kg	
250 mm segmented	9.84 in segmented	7.5 kg	
550 mm segmented	21.65 in segmented	16.5 kg	
<b>Sectioning FA</b>			
1250 mm	49.21 in	37.5 kg	
2050 mm	80.71 in	61.5 kg	
2550 mm	100.39 in	77.0 kg	
3050 mm	120.08 in	92.0 kg	
4050 mm	159.45 in	121.5 kg	
<b>Sectioning FB</b>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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

### TPR157.60.R4

1300 kN/m max.



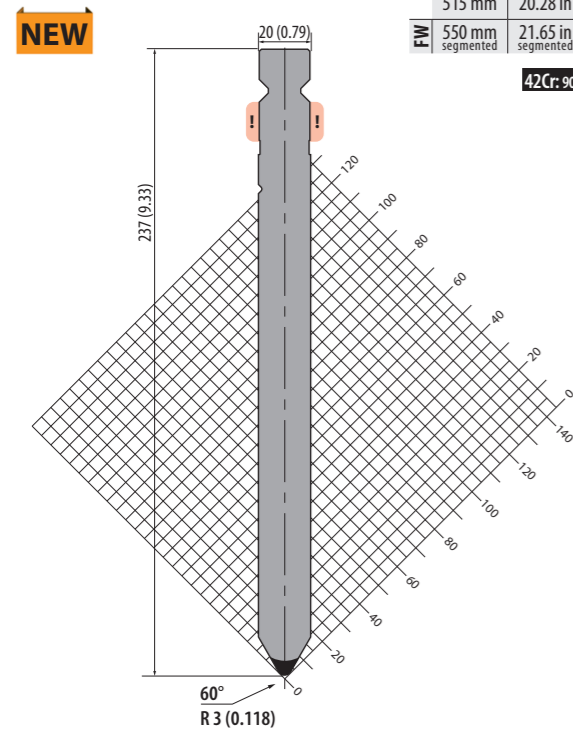
FW	FC	FA	FB
500 mm	19.68 in	12.0 kg	
250 mm segmented	9.84 in segmented	6.0 kg	
550 mm segmented	21.65 in segmented	13.2 kg	
<b>Sectioning FA</b>			
1250 mm	49.21 in	30.0 kg	
2050 mm	80.71 in	49.2 kg	
2550 mm	100.39 in	61.2 kg	
3050 mm	120.08 in	73.2 kg	
4050 mm	159.45 in	97.2 kg	
<b>Sectioning FB</b>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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

### TPR237.60.R3

1300 kN/m max.

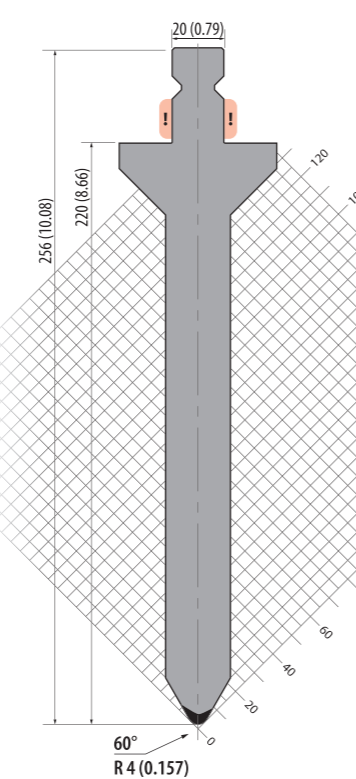


FW	FC	FB
515 mm	20.28 in	18.8 kg
550 mm segmented	21.65 in segmented	20.1 kg

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

### TPR256.60.R4

1300 kN/m max.



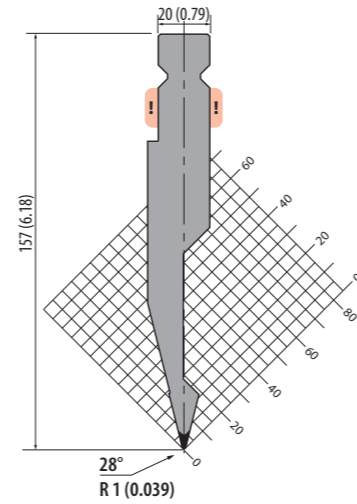
FW	FC	FA	FB
500 mm	19.68 in	26.1 kg	
250 mm segmented	9.84 in segmented	13.5 kg	
550 mm segmented	21.65 in segmented	28.7 kg	
<b>Sectioning FA</b>			
1250 mm	49.21 in	68.0 kg	
2050 mm	80.71 in	111.0 kg	
2550 mm	100.39 in	138.0 kg	
3050 mm	120.08 in	165.0 kg	
4050 mm	159.45 in	219.0 kg	
<b>Sectioning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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

### TPR157.28.R1

600 kN/m max.



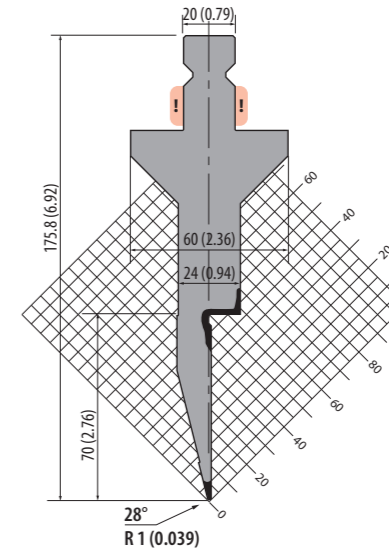
FW	FC	FA	FB
500 mm	19.68 in	10.0 kg	
250 mm segmented	9.84 in segmented	5.0 kg	
550 mm segmented	21.65 in segmented	11.0 kg	
<b>Sectioning FA</b>			
1250 mm	49.21 in	25.0 kg	
2050 mm	80.71 in	41.0 kg	
2550 mm	100.39 in	51.0 kg	
3050 mm	120.08 in	61.0 kg	
4050 mm	159.45 in	81.0 kg	
<b>Sectioning FB</b>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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

### TPR176.28.R1

400 kN/m max.



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

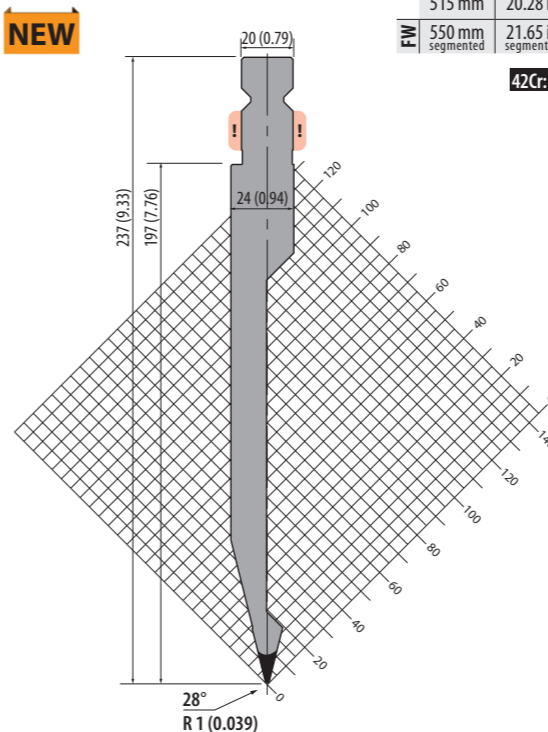
Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

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

### TPR237.28.R1

600 kN/m max.

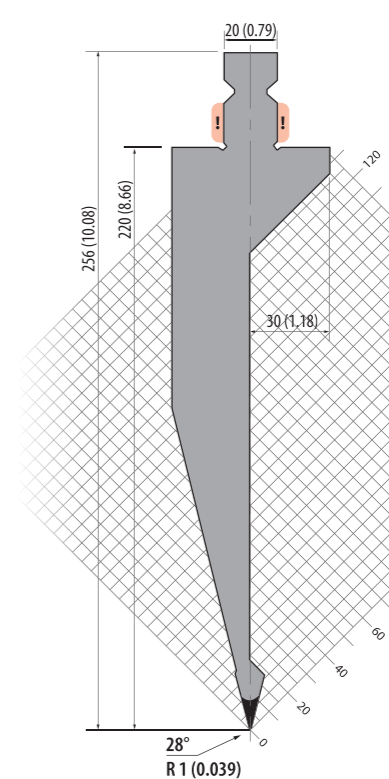


FW	FC	FB
515 mm	20.28 in	15.0 kg
550 mm segmented	21.65 in segmented	16.0 kg

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

### TPR256.28.R1

600 kN/m max.



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

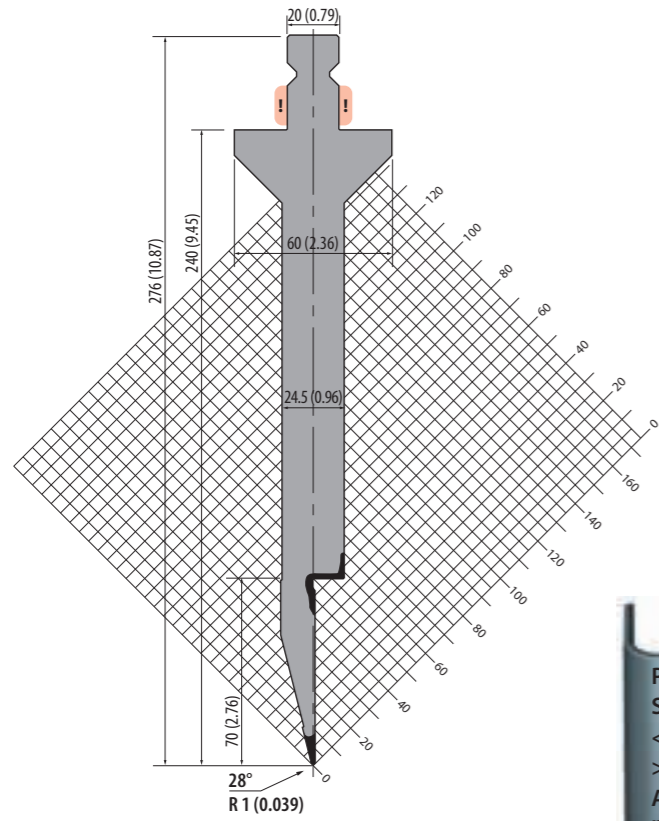
Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

# R2 ROLLERI TYPE R2

28° Punches

TPR276.28.R1



400 kN/m max.

FW   FC	mm	in	kg
250 mm segmented	19.68	0.77	12.0
550 mm segmented	21.65	0.85	26.4
Sectioning FA			
1250 mm	49.21	1.94	60.0
2050 mm	80.71	3.18	98.4
2550 mm	100.39	3.95	122.4
3050 mm	120.08	4.73	146.4
4050 mm	159.45	6.28	194.4
Sectioning FB			
1250 mm	49.21	1.94	60.0
2050 mm	80.71	3.18	98.4
2550 mm	100.39	3.95	122.4
3050 mm	120.08	4.73	146.4
4050 mm	159.45	6.28	194.4

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

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



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

# R2 ROLLERI TYPE R2

28°/24° Hemming Punches



TPR.SP.195.28.8

FW   FC	mm	in	kg
525 mm	20.67	0.81	9.4
495 mm segmented	19.49	0.77	8.9

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

TPR.SP.195.24.8

**NEW**

FW   FC	mm	in	kg
525 mm	20.67	0.81	9.4
495 mm segmented	19.49	0.77	8.9

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

TPR.SP.195.24.10

FW   FC	mm	in	kg
525 mm	20.67	0.81	15.5
495 mm segmented	19.49	0.77	9.3

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

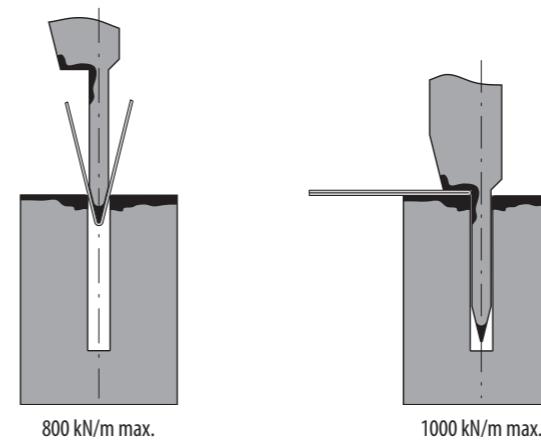
Only for thin material!  
 Hemming Dies see page 118

TPR.SP.195.24.12

FW   FC	mm	in	kg
525 mm	20.67	0.81	15.5
495 mm segmented	19.49	0.77	9.5

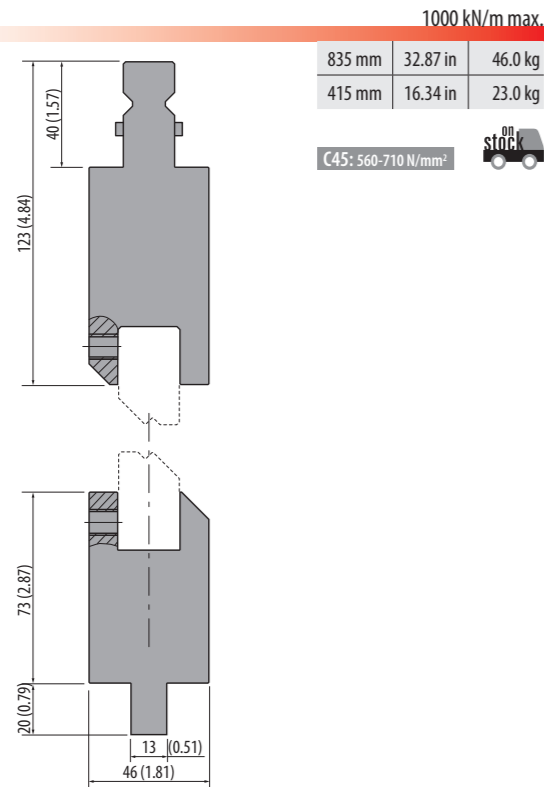
42Cr: 900-1150 N/mm<sup>2</sup>

## Example of application



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

### TPZ

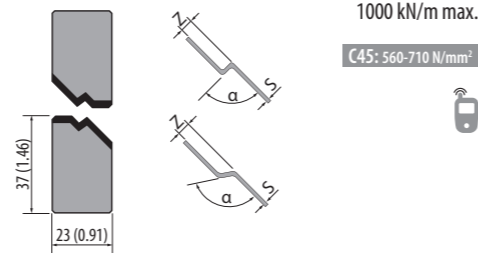


1000 kN/m max.

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

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

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



1000 kN/m max.

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

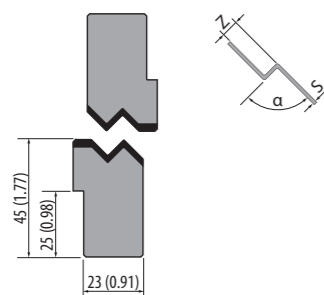
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°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

835 mm / 32.87 in      415 mm / 16.34 in

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

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

### Z-Profile Tool Inserts 90°



1000 kN/m max.

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

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

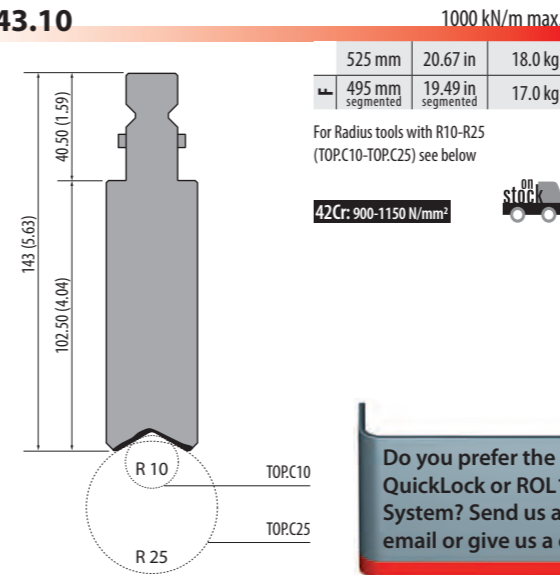
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	6.5 kg
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	6.5 kg
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	6.5 kg
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	6.5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

835 mm / 32.87 in      415 mm / 16.34 in

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



### TPR143.10



1000 kN/m max.

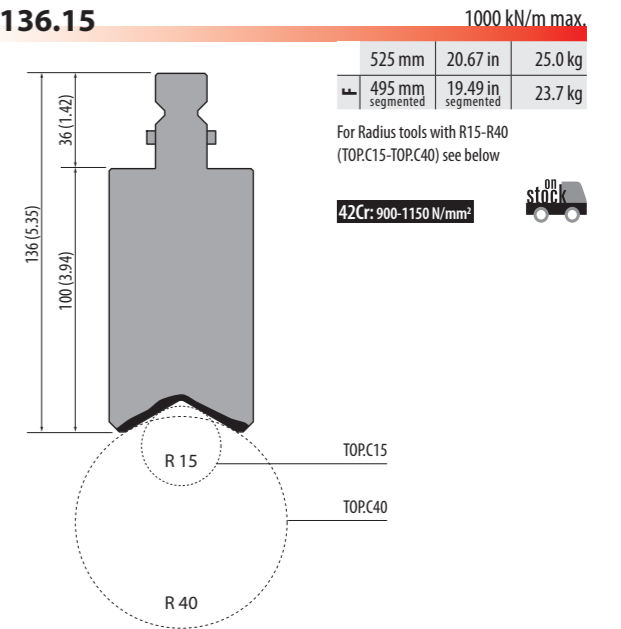
525 mm	20.67 in	18.0 kg
495 mm segmented	19.49 in segmented	17.0 kg

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

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

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

### TPR136.15



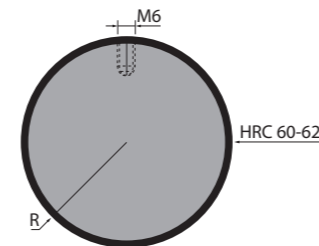
1000 kN/m max.

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

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

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

### Radius punches: R10-40



Material C53 induction hardened 60-62HRC

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

1000 kN/m max.

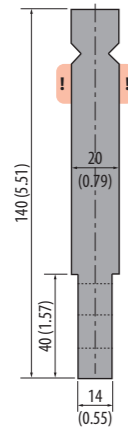
Model	R mm	R in	Weight	Weight
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C40	40	1.57	20.7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

525 mm / 20.67 in      495 mm / 19.49 in segmented

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



### TPR140-14 800 kN/m max.

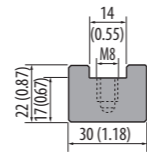


830 mm	32.68 in	17.0 kg
412 mm	16.22 in	9.0 kg

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

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

### E30.22 800 kN/m max.

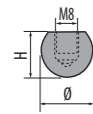


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

Hemming tool

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

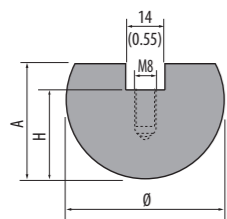
### Radius Tool: Ø 16-20 mm (0.63-0.79 in)



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

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

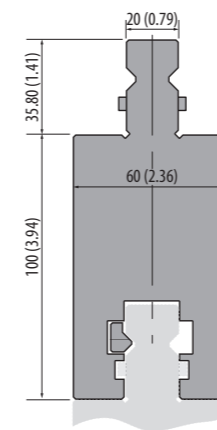
### Radius Tool: Ø 25-100 mm (0.98-3.94)



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

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

### AD21 1500 kN/m max.

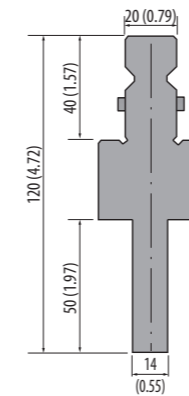


150 mm	5.91 in	7.0 kg
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42Cr: 900-1150 N/mm<sup>2</sup>

### Punch Adapters

### AD11 1000 kN/m max.

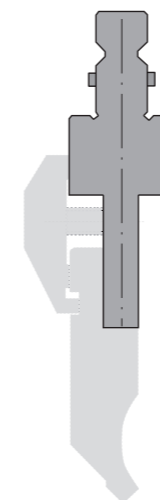


150 mm	5.91 in	3.0 kg
--------	---------	--------

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



### Example of application



For more Adapters see pages 212-217



## DIES ROLLERI TYPE R2

Content Explanation	98 - 99
Dies H=55 (2.17) - 85 (3.35)	100
Dies 90°, H=100 (3.94)	101
Dies 86°, H=100 (3.94)	101 - 103
Dies 84°, H=100 (3.94)	103 - 104
Dies 80°, H=100 (3.94)	105
Dies 60°, H=120 (4.72)	106
Dies 30°, H=100 (3.94)	106 - 108
Dies 86°, H=150 (5.91)	109 - 110
Dies 84°, H=150 (5.91)	110 - 111
Dies 80°, H=150 (5.91)	112
Dies 30°, H=150 (5.91)	113 - 114
Die Adapters	115
Synthetic Dies, H=100 (3.94)	116
Hemming Dies	118 - 119

### Compatibility

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

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

### Compatibility

Dies Roller Type R2 are:

- compatible with press brake machines with a table groove for pins 13 x 20 mm (0.51 x 0.79 in): Bystronic-Hämmerle, Trumpf
- also applicable on all other press brake machines with **Adapter-Systems and Adapter Rails** (see pages 218-221).

### Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 250-253)
- very large stock availability

### Material

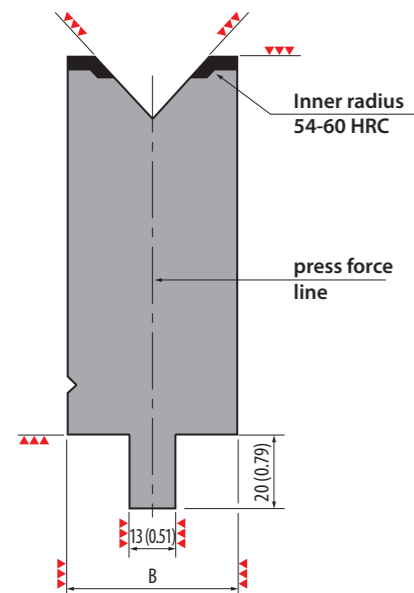
The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

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

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

### Tang

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



Indications of precision ground surfaces:

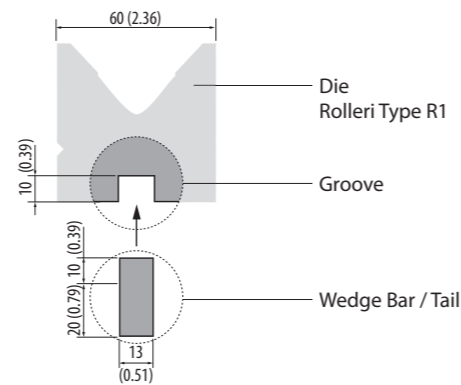


### Modification: Wedge Bar / Tail

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

For more specific information and prices go to page 252 in the Service Chapter.

### A30 (Mounting example)



### Tool lengths and sectioning

Standard

More lengths and sectionings are possible upon request.

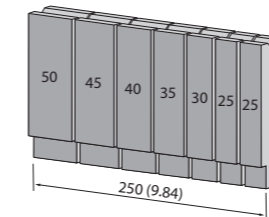
- 500 mm (19.68 in)
- 515 mm (20.28 in)
- 525 mm (20.67 in)
- 1000 mm (39.37 in)

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

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

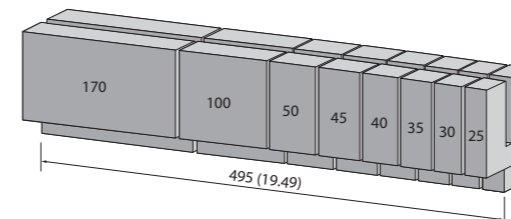
Sectioning FB  
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

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

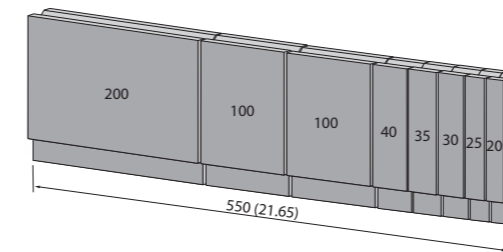


250 mm (9.84 in) segmented / FC (7 segments)

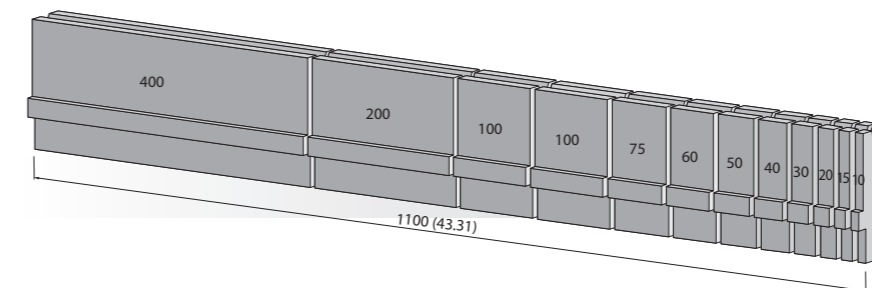
Segmented tools are delivered in complete sets. Single pieces are also available!



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



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

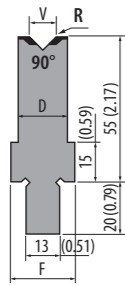


1100 mm (43.31 in) segmented (12 segments)

# R2 ROLLERI TYPE R2

Dies, H=55 (2.17) / H=60 (2.36) / H=65 (2.56) / H=70 (2.76) / H=85 (3.35)

## 90° Dies, H=55 (2.17)

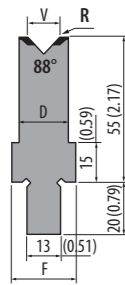


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.06.90	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg
BMR55.08.90	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg
BMR55.10.90	10	0.39	1.0	0.04	20	0.79	25	0.98	1100	10.5 kg	5.2 kg	10.0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

Individual drawings see pages 138-142

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

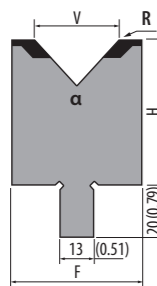
## 88° Dies, H=55 (2.17)



Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.10.88	10	0.39	1.0	0.04	20	0.79	25	0.98	1100	11.0 kg	5.0 kg	12.0 kg
BMR55.12.88	12	0.47	1.5	0.06	20	0.79	25	0.98	1200	10.5 kg	5.2 kg	10.0 kg
BMR55.16.88	16	0.63	2.0	0.08	30	1.18	30	1.18	1200	14.5 kg	7.2 kg	14.0 kg
BMR55.20.88	20	0.79	2.0	0.08	30	1.18	30	1.18	1100	14.5 kg	7.2 kg	14.0 kg
BMR55.24.88	24	0.94	3.0	0.12	40	1.57	40	1.57	1200	18.5 kg	9.2 kg	18.0 kg

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

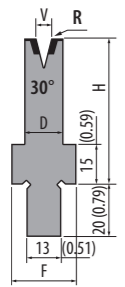
## 85° / 80° / 60° Dies, H=55 (2.17) / H=65 (2.56) / H=85 (3.35)



Model	α	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.32.85	85	32	1.26	4.0	0.16	55	2.17	50	1.97	1200	21.0 kg	10.5 kg	20.5 kg
BMR55.40.85	85	40	1.57	4.0	0.16	55	2.17	55	2.17	1200	21.5 kg	10.7 kg	25.0 kg
BMR65.80.80	80	80	3.15	10.0	0.39	65	2.56	100	3.94	1700	39.0 kg	20.0 kg	43.0 kg
BMR85.100.80	80	100	3.94	12.0	0.47	85	3.35	125	4.92	2300	62.0 kg	31.0 kg	69.0 kg
BMR55.40.60	60	40	1.57	5.0	0.20	55	2.17	55	2.17	1300	20.3 kg	10.5 kg	22.3 kg
BMR55.50.60	60	50	1.97	5.0	0.20	55	2.17	70	2.76	1200	25.0 kg	12.0 kg	21.0 kg
BMR65.60.60	60	60	2.36	7.0	0.28	65	2.56	80	3.15	1100	31.0 kg	15.5 kg	34.1 kg

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

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



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

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

# R2 ROLLERI TYPE R2

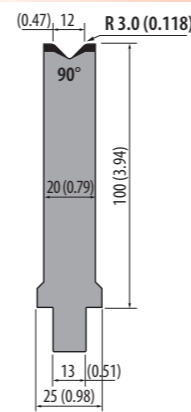
Dies 90°, H=100 (3.94)



## WMR100.12.90

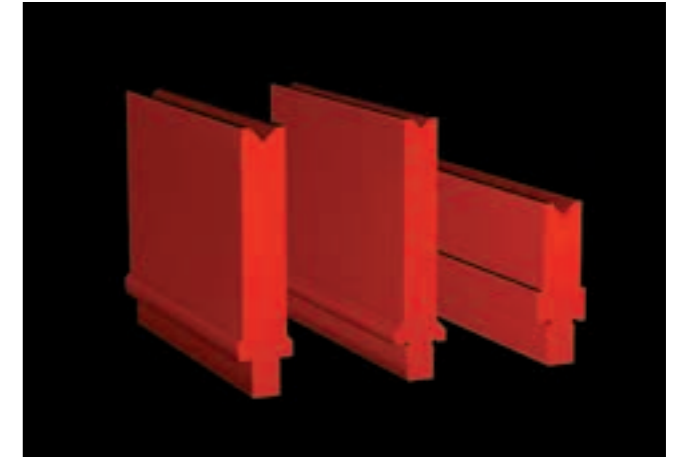
1200 kN/m max.

NEW



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

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

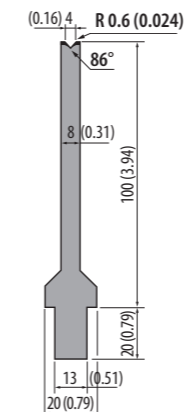


## Dies 86°, H=100 (3.94)

### TMR100.04.86

250 kN/m max.

NEW



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

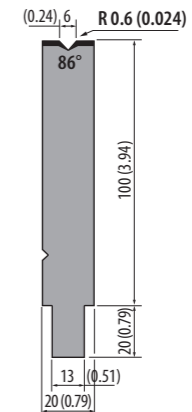
Sectioning FA	1250 mm	49.21 in	11.3 kg
2050 mm	80.71 in	18.5 kg	
2550 mm	100.39 in	23.0 kg	
3050 mm	120.08 in	27.5 kg	
4050 mm	159.45 in	36.5 kg	
Sectioning FB	1250 mm	49.21 in	11.3 kg
2050 mm	80.71 in	18.5 kg	
2550 mm	100.39 in	23.0 kg	
3050 mm	120.08 in	27.5 kg	
4050 mm	159.45 in	36.5 kg	

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

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

### TMR100.06.86

1200 kN/m max.



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

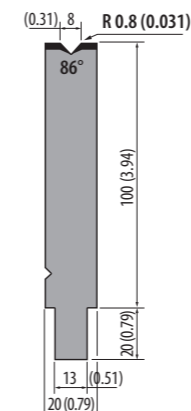
Sectioning FA	1250 mm	49.21 in	12.5 kg
2050 mm	80.71 in	20.5 kg	
2550 mm	100.39 in	25.5 kg	
3050 mm	120.08 in	30.5 kg	
4050 mm	159.45 in	40.5 kg	
Sectioning FB	1250 mm	49.21 in	12.5 kg
2050 mm	80.71 in	20.5 kg	
2550 mm	100.39 in	25.5 kg	
3050 mm	120.08 in	30.5 kg	
4050 mm	159.45 in	40.5 kg	

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

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

### TMR100.08.86

1150 kN/m max.



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

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

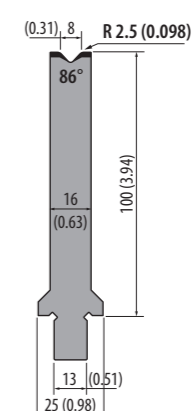
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

### WMR100.08.86

400 kN/m max.

NEW



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

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

# R2 ROLLERI TYPE R2

Dies 86°, H=100 (3.94)

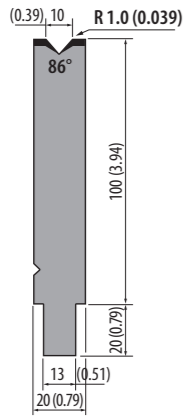
# R2 ROLLERI TYPE R2

Dies 86°, H=100 (3.94)



## TMR100.10.86

1100 kN/m max.



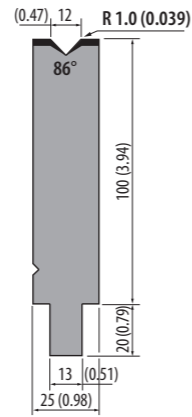
	500 mm	19.68 in	8.7 kg
FW FC	250 mm segmented	9.84 in segmented	4.4 kg
	550 mm segmented	21.65 in segmented	9.6 kg
Sectioning FA	1250 mm	49.21 in	21.8 kg
	2050 mm	80.71 in	35.7 kg
	2550 mm	100.39 in	44.4 kg
	3050 mm	120.08 in	53.1 kg
	4050 mm	159.45 in	70.5 kg
Sectioning FB	1250 mm	49.21 in	21.8 kg
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

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

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

## TMR100.12.86

1200 kN/m max.



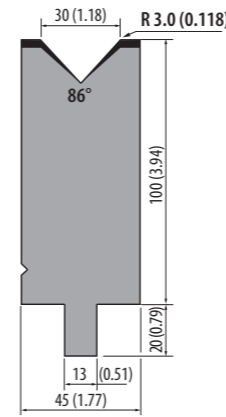
	500 mm	19.68 in	10.0 kg
FW FC	250 mm segmented	9.84 in segmented	5.0 kg
	550 mm segmented	21.65 in segmented	11.0 kg
Sectioning FA	1250 mm	49.21 in	26.6 kg
	2050 mm	80.71 in	43.7 kg
	2550 mm	100.39 in	54.3 kg
	3050 mm	120.08 in	65.0 kg
	4050 mm	159.45 in	86.3 kg
Sectioning FB	1250 mm	49.21 in	26.6 kg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

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

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

## TMR100.30.86

1200 kN/m max.



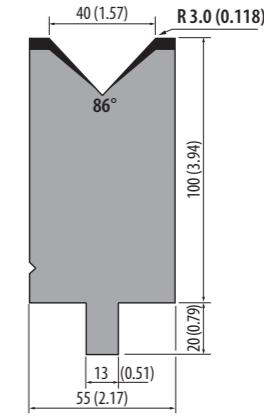
	500 mm	19.68 in	17.6 kg
FW FC	250 mm segmented	9.84 in segmented	9.0 kg
	550 mm segmented	21.65 in segmented	19.4 kg
Sectioning FA	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	74.0 kg
	2550 mm	100.39 in	92.0 kg
	3050 mm	120.08 in	110.0 kg
	4050 mm	159.45 in	146.0 kg
Sectioning FB	1250 mm	49.21 in	45.0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

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

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

## TMR100.40.86

1200 kN/m max.



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

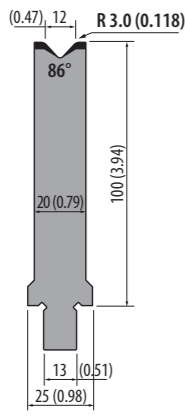
**Segments of Sectioning FB**  
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)  
are also available separately (FD).  
Prices upon request!

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

## WMR100.12.86

1200 kN/m max.

**NEW**

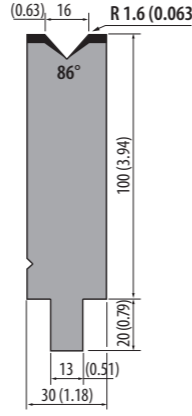


	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

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

## TMR100.16.86

1200 kN/m max.



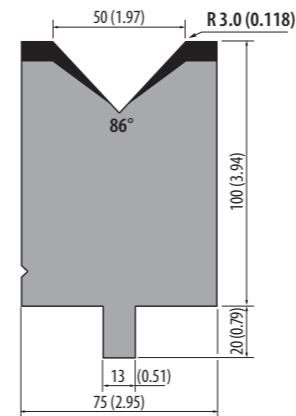
	500 mm	19.68 in	12.5 kg
FW FC	250 mm segmented	9.84 in segmented	5.5 kg
	550 mm segmented	21.65 in segmented	13.8 kg
Sectioning FA	1250 mm	49.21 in	27.5 kg
	2050 mm	80.71 in	45.0 kg
	2550 mm	100.39 in	56.0 kg
	3050 mm	120.08 in	67.0 kg
	4050 mm	159.45 in	89.0 kg
Sectioning FB	1250 mm	49.21 in	27.5 kg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

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

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

## TMR100.50.86

1500 kN/m max.



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

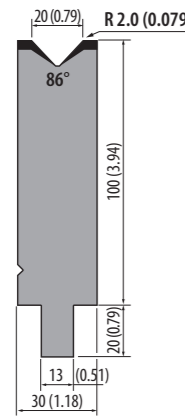
**Segments of Sectioning FB**  
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)  
are also available separately (FD).  
Prices upon request!

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

Die Adapters see pages 218-221

## TMR100.20.86

1150 kN/m max.



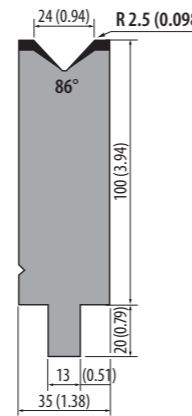
	500 mm	19.68 in	12.2 kg
FW FC	250 mm segmented	9.84 in segmented	6.0 kg
	550 mm segmented	21.65 in segmented	13.4 kg
Sectioning FA	1250 mm	49.21 in	30.5 kg
	2050 mm	80.71 in	50.0 kg
	2550 mm	100.39 in	62.2 kg
	3050 mm	120.08 in	74.4 kg
	4050 mm	159.45 in	98.8 kg
Sectioning FB	1250 mm	49.21 in	30.5 kg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

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

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

## TMR100.24.86

1200 kN/m max.



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

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

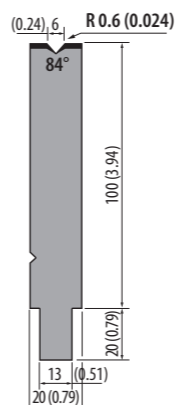
42Cr: 900-1150 N/mm<sup>2</sup>

# Dies 84°, H=100 (3.94)

## TMR100.06.84

1200 kN/m max.

**NEW**



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

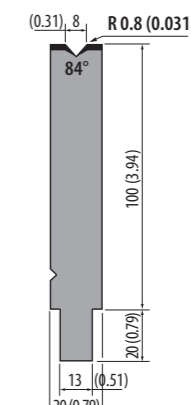
**Segments of Sectioning FB**  
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)  
are also available separately (FD).  
Prices upon request!

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

## TMR100.08.84

1150 kN/m max.

**NEW**



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

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

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

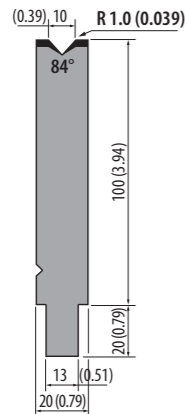
# R2 ROLLERI TYPE R2

Dies 84°, H=100 (3.94)

## TMR100.10.84

1100 kN/m max.

**NEW**



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



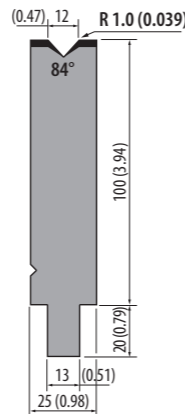
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR100.12.84

1200 kN/m max.

**NEW**



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



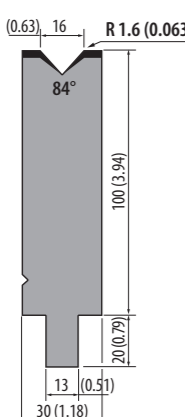
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR100.16.84

1200 kN/m max.

**NEW**



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



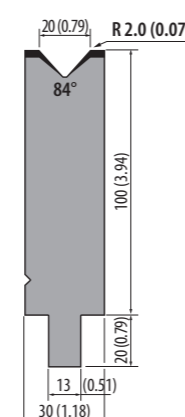
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR100.20.84

1150 kN/m max.

**NEW**



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



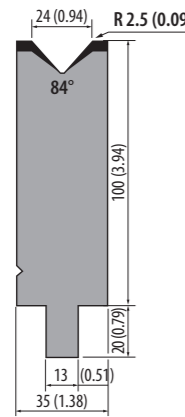
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR100.24.84

1200 kN/m max.

**NEW**



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



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

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

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

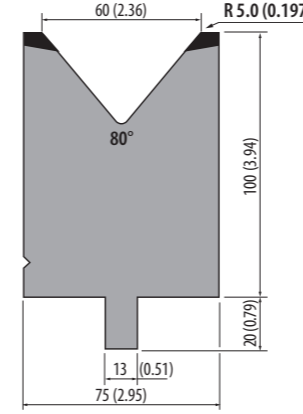
# R2 ROLLERI TYPE R2

Dies 80°, H=100 (3.94)



## TMR100.60.80

1500 kN/m max.



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

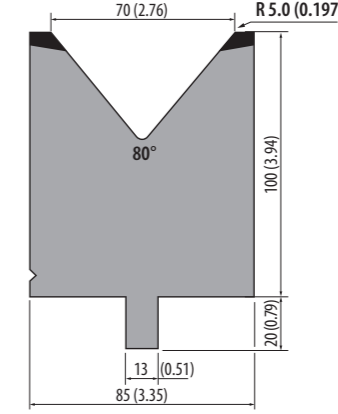


Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR100.70.80

1500 kN/m max.



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

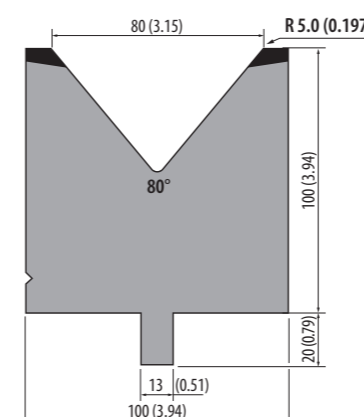


Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR100.80.80

1500 kN/m max.



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



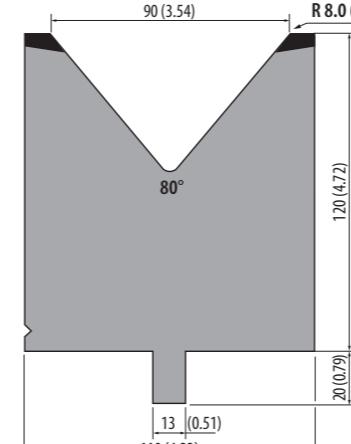
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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



## TMR120.90.80

1500 kN/m max.



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

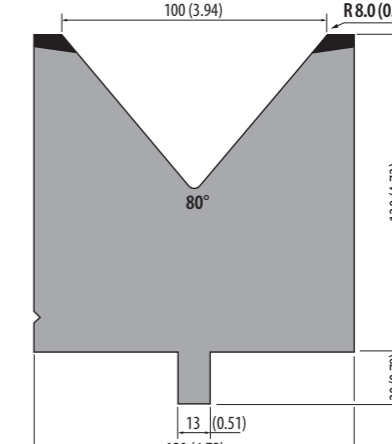


Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR120.100.80

1500 kN/m max.



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



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

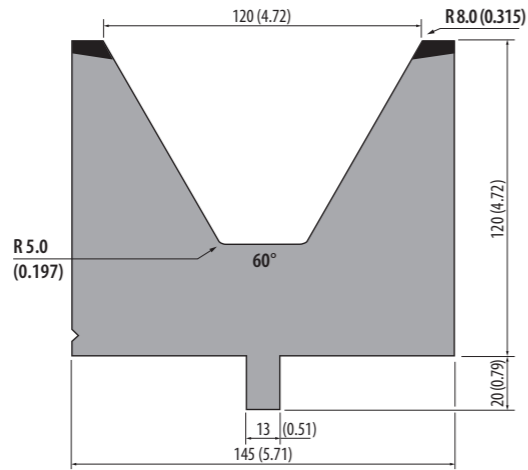
42Cr: 900-1150 N/mm<sup>2</sup>

# R2 ROLLERI TYPE R2

Dies 60°, H=120 (4.72)

## TMR120.120.60

**NEW**



1600 kN/m max.

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

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

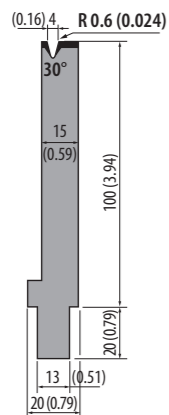
42Cr: 900-1150 N/mm<sup>2</sup>

**Rolleri Videos**  
find updated and helpful videos at:  
[www.rolleritools.com/videos/overview](http://www.rolleritools.com/videos/overview)

## Dies 30°, H=100 (3.94)

## TMR100.04.30

**NEW**



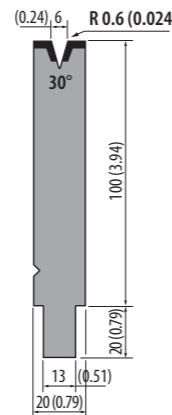
150 kN/m max.

500 mm	19.68 in	7.0 kg
<b>FW FC</b>		
250 mm segmented	9.84 in segmented	3.5 kg
550 mm segmented	21.65 in segmented	7.7 kg
<b>Sectioning FA</b>		
1250 mm	49.21 in	17.5 kg
2050 mm	80.71 in	28.7 kg
2550 mm	100.39 in	35.7 kg
3050 mm	120.08 in	42.7 kg
4050 mm	159.45 in	56.7 kg
<b>Sectioning FB</b>		
1250 mm	49.21 in	17.5 kg
2050 mm	80.71 in	28.7 kg
2550 mm	100.39 in	35.7 kg
3050 mm	120.08 in	42.7 kg
4050 mm	159.45 in	56.7 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.06.30



400 kN/m max.

500 mm	19.68 in	8.7 kg
<b>FW FC</b>		
250 mm segmented	9.84 in segmented	4.3 kg
550 mm segmented	21.65 in segmented	9.6 kg
<b>Sectioning FA</b>		
1250 mm	49.21 in	21.8 kg
2050 mm	80.71 in	34.9 kg
2550 mm	100.39 in	43.4 kg
3050 mm	120.08 in	51.9 kg
4050 mm	159.45 in	68.9 kg
<b>Sectioning FB</b>		
1250 mm	49.21 in	21.8 kg
2050 mm	80.71 in	34.9 kg
2550 mm	100.39 in	43.4 kg
3050 mm	120.08 in	51.9 kg
4050 mm	159.45 in	68.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

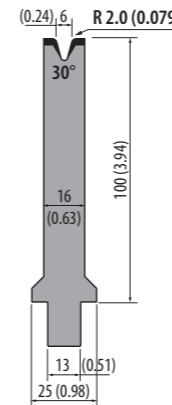
42Cr: 900-1150 N/mm<sup>2</sup>

# R2 ROLLERI TYPE R2

Dies 30°, H=100 (3.94)

## WMR100.06.30

**NEW**

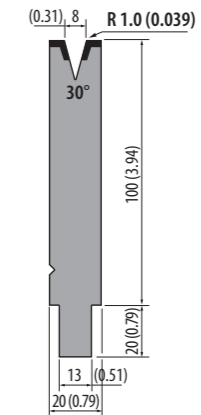


400 kN/m max.

515 mm	20.28 in	7.7 kg
<b>FW</b>		
550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.08.30



400 kN/m max.

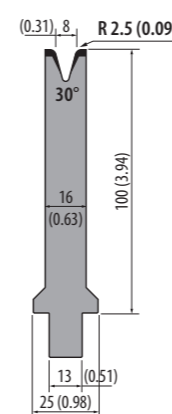
500 mm	19.68 in	8.5 kg
<b>FW FC</b>		
250 mm segmented	9.84 in segmented	4.3 kg
550 mm segmented	21.65 in segmented	9.4 kg
<b>Sectioning FA</b>		
1250 mm	49.21 in	21.3 kg
2050 mm	80.71 in	34.9 kg
2550 mm	100.39 in	43.4 kg
3050 mm	120.08 in	51.9 kg
4050 mm	159.45 in	68.9 kg
<b>Sectioning FB</b>		
1250 mm	49.21 in	21.3 kg
2050 mm	80.71 in	34.9 kg
2550 mm	100.39 in	43.4 kg
3050 mm	120.08 in	51.9 kg
4050 mm	159.45 in	68.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## WMR100.08.30

**NEW**

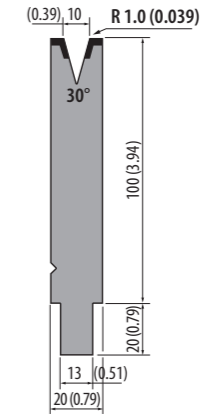


400 kN/m max.

515 mm	20.28 in	7.7 kg
<b>FW</b>		
550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.10.30



400 kN/m max.

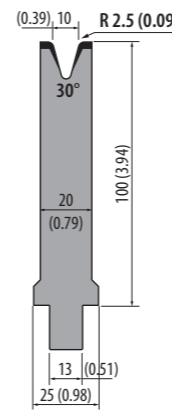
500 mm	19.68 in	8.5 kg
<b>FW FC</b>		
250 mm segmented	9.84 in segmented	3.5 kg
550 mm segmented	21.65 in segmented	9.4 kg
<b>Sectioning FA</b>		
1250 mm	49.21 in	17.5 kg
2050 mm	80.71 in	28.7 kg
2550 mm	100.39 in	35.7 kg
3050 mm	120.08 in	42.7 kg
4050 mm	159.45 in	56.7 kg
<b>Sectioning FB</b>		
1250 mm	49.21 in	17.5 kg
2050 mm	80.71 in	28.7 kg
2550 mm	100.39 in	35.7 kg
3050 mm	120.08 in	42.7 kg
4050 mm	159.45 in	56.7 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## WMR100.10.30

**NEW**

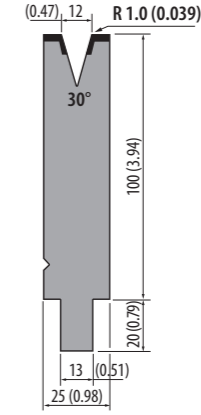


400 kN/m max.

515 mm	20.28 in	9.0 kg
<b>FW</b>		
550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.12.30



400 kN/m max.

500 mm	19.68 in	10.3 kg
<b>FW FC</b>		
250 mm segmented	9.84 in segmented	5.3 kg
550 mm segmented	21.65 in segmented	11.3 kg
<b>Sectioning FA</b>		
1250 mm	49.21 in	26.3 kg
2050 mm	80.71 in	43.1 kg
2550 mm	100.39 in	53.6 kg
3050 mm	120.08 in	64.1 kg
4050 mm	159.45 in	85.1 kg
<b>Sectioning FB</b>		
1250 mm	49.21 in	26.3 kg
2050 mm	80.71 in	43.1 kg
2550 mm	100.39 in	53.6 kg
3050 mm	120.08 in	64.1 kg
4050 mm	159.45 in	85.1 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

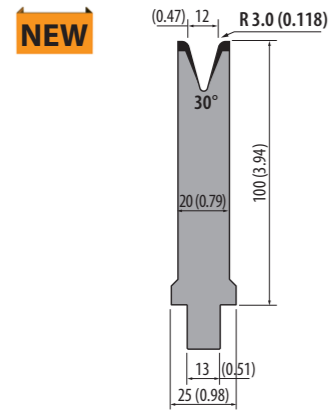
# R2 ROLLERI TYPE R2

Dies 30°, H=100 (3.94)



## WMR100.12.30

400 kN/m max.

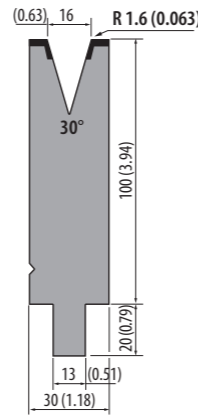


FW	515 mm	20.28 in	8.9 kg
FC	550 mm segmented	21.65 in segmented	9.5 kg

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.16.30

500 kN/m max.



FW	500 mm	19.68 in	11.8 kg
FC	250 mm segmented	9.84 in segmented	6.0 kg
FC	550 mm segmented	21.65 in segmented	12.9 kg

Sectioning FA	1250 mm	49.21 in	29.5 kg
	2050 mm	80.71 in	48.4 kg
	2550 mm	100.39 in	60.2 kg
	3050 mm	120.08 in	72.0 kg
Sectioning FB	1250 mm	49.21 in	29.5 kg
	2050 mm	80.71 in	48.4 kg
	2550 mm	100.39 in	60.2 kg
	3050 mm	120.08 in	72.0 kg

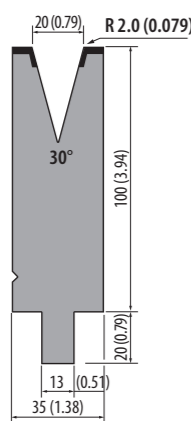
Sectioning FB	1250 mm	49.21 in	29.5 kg
	2050 mm	80.71 in	48.4 kg
	2550 mm	100.39 in	60.2 kg
	3050 mm	120.08 in	72.0 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.20.30

600 kN/m max.



FW	500 mm	19.68 in	13.0 kg
FC	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg

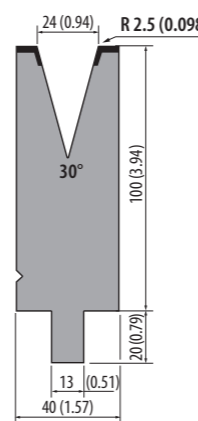
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.24.30

650 kN/m max.



FW	500 mm	19.68 in	15.0 kg
FC	250 mm segmented	9.84 in segmented	7.5 kg
FC	550 mm segmented	21.65 in segmented	16.5 kg

Sectioning FA	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg
Sectioning FB	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg

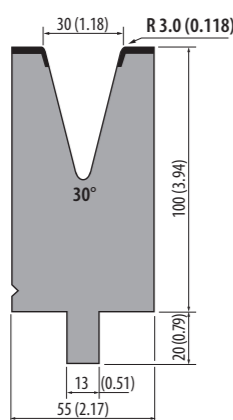
Sectioning FB	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.30.30

900 kN/m max.



FW	500 mm	19.68 in	19.0 kg
FC	250 mm segmented	9.84 in segmented	9.5 kg
FC	550 mm segmented	21.65 in segmented	20.9 kg

Sectioning FA	1250 mm	49.21 in	47.5 kg
	2050 mm	80.71 in	80.0 kg
	2550 mm	100.39 in	96.9 kg
	3050 mm	120.08 in	116.0 kg
Sectioning FB	1250 mm	49.21 in	47.5 kg
	2050 mm	80.71 in	80.0 kg
	2550 mm	100.39 in	96.9 kg
	3050 mm	120.08 in	116.0 kg

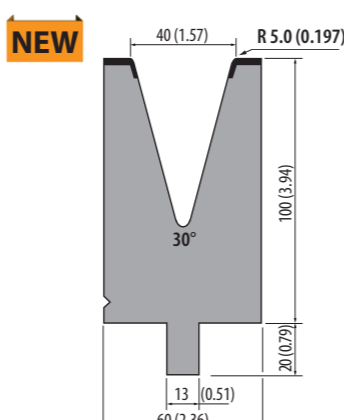
Sectioning FB	1250 mm	49.21 in	47.5 kg
	2050 mm	80.71 in	80.0 kg
	2550 mm	100.39 in	96.9 kg
	3050 mm	120.08 in	116.0 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR100.40.30

900 kN/m max.



FW	500 mm	19.68 in	18.5 kg
FC	250 mm segmented	9.84 in segmented	9.3 kg
FC	550 mm segmented	21.65 in segmented	20.4 kg

Sectioning FA	1250 mm	49.21 in	46.3 kg
	2050 mm	80.71 in	75.9 kg
	2550 mm	100.39 in	94.4 kg
	3050 mm	120.08 in	112.9 kg
Sectioning FB	1250 mm	49.21 in	46.3 kg
	2050 mm	80.71 in	75.9 kg
	2550 mm	100.39 in	94.4 kg
	3050 mm	120.08 in	112.9 kg

Sectioning FB	1250 mm	49.21 in	46.3 kg
	2050 mm	80.71 in	75.9 kg
	2550 mm	100.39 in	94.4 kg
	3050 mm	120.08 in	112.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

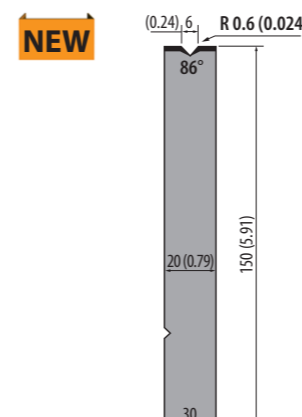
42Cr: 900-1150 N/mm<sup>2</sup>

# R2 ROLLERI TYPE R2

Dies 86°, H=150 (5.91)

## TMR150.06.86

400 kN/m max.



FW	500 mm	19.68 in	13.0 kg
FC	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg

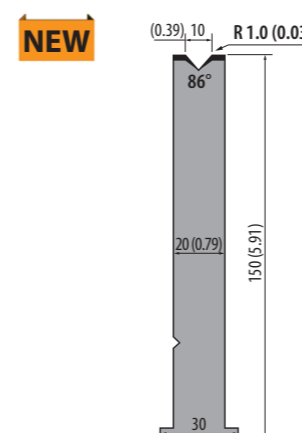
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.10.86

500 kN/m max.



FW	500 mm	19.68 in	13.0 kg
FC	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg

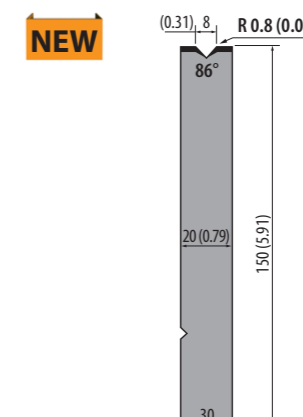
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.08.86

400 kN/m max.



FW	500 mm	19.68 in	13.1 kg
FC	250 mm segmented	9.84 in segmented	6.6 kg
FC	550 mm segmented	21.65 in segmented	14.4 kg

Sectioning FA	1250 mm	49.21 in	32.8 kg
	2050 mm	80.71 in	53.7 kg
	2550 mm	100.39 in	66.8 kg
	3050 mm	120.08 in	79.9 kg
Sectioning FB	1250 mm	49.21 in	32.8 kg
	2050 mm	80.71 in	53.7 kg
	2550 mm	100.39 in	66.8 kg
	3050 mm	120.08 in	79.9 kg

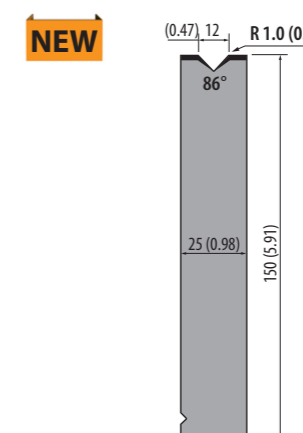
Sectioning FB	1250 mm	49.21 in	32.8 kg
	2050 mm	80.71 in	53.7 kg
	2550 mm	100.39 in	66.8 kg
	3050 mm	120.08 in	79.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.12.86

500 kN/m max.



FW	500 mm	19.68 in	15.5 kg
FC	250 mm segmented	9.84 in segmented	7.8 kg
FC	550 mm segmented	21.65 in segmented	17.0 kg

Sectioning FA	1250 mm	49.21 in	38.8 kg
	2050 mm	80.71 in	63.6 kg
	2550 mm	100.39 in	79.1 kg
	3050 mm	120.08 in	94.6 kg
Sectioning FB	1250 mm	49.21 in	38.8 kg
	2050 mm	80.71 in	63.6 kg
	2550 mm	100.39 in	79.1 kg
	3050 mm	120.08 in	94.6 kg

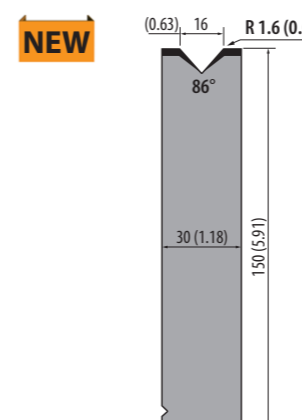
Sectioning FB	1250 mm	49.21 in	38.8 kg
	2050 mm	80.71 in	63.6 kg
	2550 mm	100.39 in	79.1 kg
	3050 mm	120.08 in	94.6 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.16.86

700 kN/m max.



FW	500 mm	19.68 in	18.0 kg
FC	250 mm segmented	9.84 in segmented	9.0 kg
FC	550 mm segmented	21.65 in segmented	19.8 kg

Sectioning FA	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	73.8 kg
	2550 mm	100.39 in	91.8 kg
	3050 mm	120.08 in	109.8 kg
Sectioning FB	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	73.8 kg
	2550 mm	100.39 in	91.8 kg
	3050 mm	120.08 in	109.8 kg

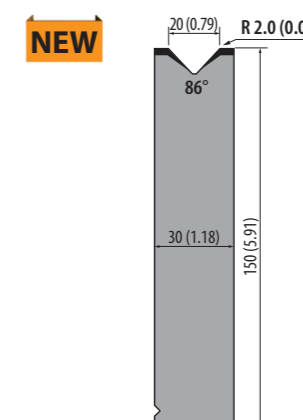
Sectioning FB	1250 mm	49.21 in	45.0 kg
	2050 mm	80.71 in	73.8 kg
	2550 mm	100.39 in	91.8 kg
	3050 mm	120.08 in	109.8 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.20.86

700 kN/m max.

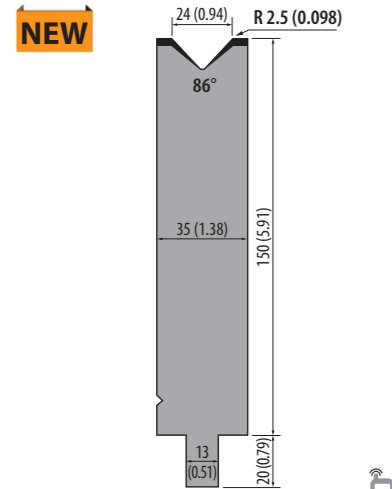


# R2 ROLLERI TYPE R2

Dies 86°, H=150 (5.91)

## TMR150.24.86

700 kN/m max.



FW / FC	500 mm	19.68 in	20.8 kg
250 mm segmented	9.84 in	10.4 kg	
550 mm segmented	21.65 in	22.9 kg	
Sectioning FA	1250 mm	49.21 in	52.0 kg
2050 mm	80.71 in	85.3 kg	
2550 mm	100.39 in	106.0 kg	
3050 mm	120.08 in	129.9 kg	
4050 mm	159.45 in	168.5 kg	
Sectioning FB	1250 mm	49.21 in	52.0 kg
2050 mm	80.71 in	85.3 kg	
2550 mm	100.39 in	106.0 kg	
3050 mm	120.08 in	129.9 kg	
4050 mm	159.45 in	168.5 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

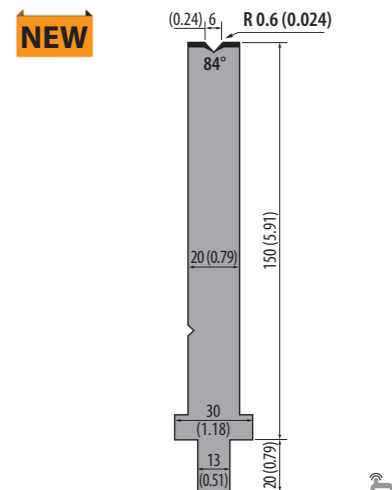


**Rolleri Videos**  
find updated and helpful videos at:  
[www.rolleritools.com/videos/overview](http://www.rolleritools.com/videos/overview)

# Dies 84°, H=150 (5.91)

## TMR150.06.84

400 kN/m max.



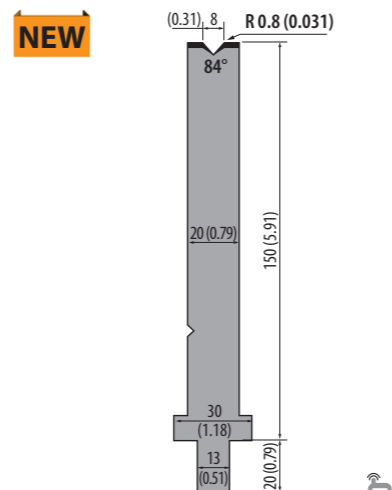
FW / FC	500 mm	19.68 in	13.0 kg
250 mm segmented	9.84 in	6.5 kg	
550 mm segmented	21.65 in	14.3 kg	
Sectioning FA	1250 mm	49.21 in	32.5 kg
2050 mm	80.71 in	53.3 kg	
2550 mm	100.39 in	66.3 kg	
3050 mm	120.08 in	79.3 kg	
4050 mm	159.45 in	105.3 kg	
Sectioning FB	1250 mm	49.21 in	32.5 kg
2050 mm	80.71 in	53.3 kg	
2550 mm	100.39 in	66.3 kg	
3050 mm	120.08 in	79.3 kg	
4050 mm	159.45 in	105.3 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.08.84

400 kN/m max.



FW / FC	500 mm	19.68 in	13.0 kg
250 mm segmented	9.84 in	6.5 kg	
550 mm segmented	21.65 in	14.3 kg	
Sectioning FA	1250 mm	49.21 in	32.5 kg
2050 mm	80.71 in	53.3 kg	
2550 mm	100.39 in	66.3 kg	
3050 mm	120.08 in	79.3 kg	
4050 mm	159.45 in	105.3 kg	
Sectioning FB	1250 mm	49.21 in	32.5 kg
2050 mm	80.71 in	53.3 kg	
2550 mm	100.39 in	66.3 kg	
3050 mm	120.08 in	79.3 kg	
4050 mm	159.45 in	105.3 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

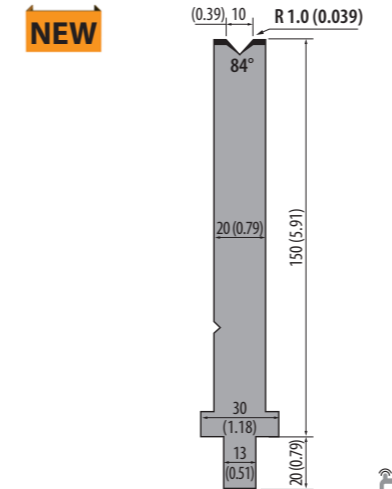
42Cr: 900-1150 N/mm<sup>2</sup>

# R2 ROLLERI TYPE R2

Dies 84°, H=150 (5.91)

## TMR150.10.84

500 kN/m max.



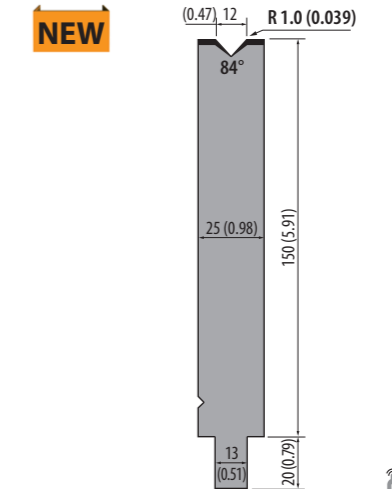
FW / FC	500 mm	19.68 in	13.0 kg
250 mm segmented	9.84 in	6.5 kg	
550 mm segmented	21.65 in	14.3 kg	
Sectioning FA	1250 mm	49.21 in	32.5 kg
2050 mm	80.71 in	53.3 kg	
2550 mm	100.39 in	66.3 kg	
3050 mm	120.08 in	79.3 kg	
4050 mm	159.45 in	105.3 kg	
Sectioning FB	1250 mm	49.21 in	32.5 kg
2050 mm	80.71 in	53.3 kg	
2550 mm	100.39 in	66.3 kg	
3050 mm	120.08 in	79.3 kg	
4050 mm	159.45 in	105.3 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.12.84

500 kN/m max.



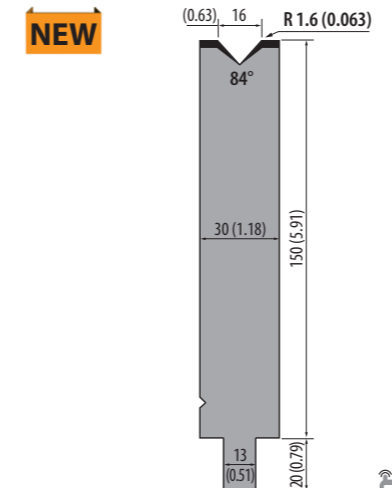
FW / FC	500 mm	19.68 in	15.5 kg
250 mm segmented	9.84 in	7.8 kg	
550 mm segmented	21.65 in	17.0 kg	
Sectioning FA	1250 mm	49.21 in	38.8 kg
2050 mm	80.71 in	63.6 kg	
2550 mm	100.39 in	79.1 kg	
3050 mm	120.08 in	94.6 kg	
4050 mm	159.45 in	125.6 kg	
Sectioning FB	1250 mm	49.21 in	38.8 kg
2050 mm	80.71 in	63.6 kg	
2550 mm	100.39 in	79.1 kg	
3050 mm	120.08 in	94.6 kg	
4050 mm	159.45 in	125.6 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.16.84

700 kN/m max.



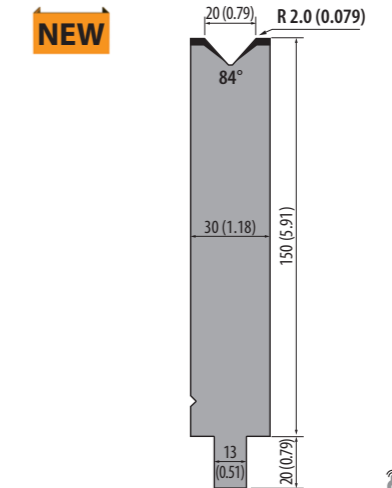
FW / FC	500 mm	19.68 in	18.0 kg
250 mm segmented	9.84 in	9.0 kg	
550 mm segmented	21.65 in	19.8 kg	
Sectioning FA	1250 mm	49.21 in	45.0 kg
2050 mm	80.71 in	73.8 kg	
2550 mm	100.39 in	91.8 kg	
3050 mm	120.08 in	109.8 kg	
4050 mm	159.45 in	145.8 kg	
Sectioning FB	1250 mm	49.21 in	45.0 kg
2050 mm	80.71 in	73.8 kg	
2550 mm	100.39 in	91.8 kg	
3050 mm	120.08 in	109.8 kg	
4050 mm	159.45 in	145.8 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.20.84

700 kN/m max.



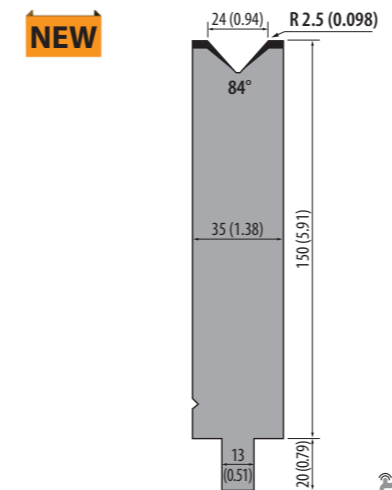
FW / FC	500 mm	19.68 in	18.2 kg
250 mm segmented	9.84 in	9.1 kg	
550 mm segmented	21.65 in	20.0 kg	
Sectioning FA	1250 mm	49.21 in	45.5 kg
2050 mm	80.71 in	74.6 kg	
2550 mm	100.39 in	92.8 kg	
3050 mm	120.08 in	111.0 kg	
4050 mm	159.45 in	147.4 kg	
Sectioning FB	1250 mm	49.21 in	45.5 kg
2050 mm	80.71 in	74.6 kg	
2550 mm	100.39 in	92.8 kg	
3050 mm	120.08 in	111.0 kg	
4050 mm	159.45 in	147.4 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.24.84

700 kN/m max.



FW / FC	500 mm	19.68 in	20.8 kg
250 mm segmented	9.84 in	10.4 kg	
550 mm segmented	21.65 in	22.9 kg	
Sectioning FA	1250 mm	49.21 in	52.0 kg
2050 mm	80.71 in	85.3 kg	
2550 mm	100.39 in	106.0 kg	
3050 mm	120.08 in	129.9 kg	
4050 mm	159.45 in	168.5 kg	
Sectioning FB	1250 mm	49.21 in	52.0 kg
2050 mm	80.71 in	85.3 kg	
2550 mm	100.39 in	106.0 kg	
3050 mm	120.08 in	129.9 kg	
4050 mm	159.45 in	168.5 kg	

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>



# R2 ROLLERI TYPE R2

Dies 80°, H=150 (5.91)



## TMR150.24.80 700 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	20.8 kg
		250 mm segmented	9.84 in segmented	10.4 kg
		550 mm segmented	21.65 in segmented	22.9 kg
Sectioning FA		1250 mm	49.21 in	52.0 kg
		2050 mm	80.71 in	85.3 kg
		2550 mm	100.39 in	106.0 kg
		3050 mm	120.08 in	129.9 kg
Sectioning FB		1250 mm	49.21 in	52.0 kg
		2050 mm	80.71 in	85.3 kg
		2550 mm	100.39 in	106.0 kg
		3050 mm	120.08 in	129.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.30.80 900 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	26.0 kg
		250 mm segmented	9.84 in segmented	13.0 kg
		550 mm segmented	21.65 in segmented	28.6 kg
Sectioning FA		1250 mm	49.21 in	65.0 kg
		2050 mm	80.71 in	106.6 kg
		2550 mm	100.39 in	132.6 kg
		3050 mm	120.08 in	158.6 kg
Sectioning FB		1250 mm	49.21 in	65.0 kg
		2050 mm	80.71 in	106.6 kg
		2550 mm	100.39 in	132.6 kg
		3050 mm	120.08 in	158.6 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.40.80 1200 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	31.0 kg
		250 mm segmented	9.84 in segmented	15.5 kg
		550 mm segmented	21.65 in segmented	34.1 kg
Sectioning FA		1250 mm	49.21 in	77.5 kg
		2050 mm	80.71 in	127.1 kg
		2550 mm	100.39 in	158.1 kg
		3050 mm	120.08 in	189.1 kg
Sectioning FB		1250 mm	49.21 in	77.5 kg
		2050 mm	80.71 in	127.1 kg
		2550 mm	100.39 in	158.1 kg
		3050 mm	120.08 in	189.1 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.50.80 1500 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	36.0 kg
		250 mm segmented	9.84 in segmented	18.0 kg
		550 mm segmented	21.65 in segmented	39.6 kg
Sectioning FA		1250 mm	49.21 in	90.0 kg
		2050 mm	80.71 in	147.6 kg
		2550 mm	100.39 in	183.6 kg
		3050 mm	120.08 in	219.6 kg
Sectioning FB		1250 mm	49.21 in	90.0 kg
		2050 mm	80.71 in	147.6 kg
		2550 mm	100.39 in	183.6 kg
		3050 mm	120.08 in	219.6 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

# R2 ROLLERI TYPE R2

Dies 30°, H=150 (5.91)

## TMR150.06.30 400 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	12.8 kg
		250 mm segmented	9.84 in segmented	6.4 kg
		550 mm segmented	21.65 in segmented	14.0 kg
Sectioning FA		1250 mm	49.21 in	32.0 kg
		2050 mm	80.71 in	52.5 kg
		2550 mm	100.39 in	65.3 kg
		3050 mm	120.08 in	78.1 kg
Sectioning FB		1250 mm	49.21 in	32.0 kg
		2050 mm	80.71 in	52.5 kg
		2550 mm	100.39 in	65.3 kg
		3050 mm	120.08 in	78.1 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.08.30 400 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	12.7 kg
		250 mm segmented	9.84 in segmented	6.4 kg
		550 mm segmented	21.65 in segmented	13.9 kg
Sectioning FA		1250 mm	49.21 in	31.8 kg
		2050 mm	80.71 in	52.1 kg
		2550 mm	100.39 in	64.8 kg
		3050 mm	120.08 in	77.5 kg
Sectioning FB		1250 mm	49.21 in	31.8 kg
		2050 mm	80.71 in	52.1 kg
		2550 mm	100.39 in	64.8 kg
		3050 mm	120.08 in	77.5 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.10.30 400 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	12.6 kg
		250 mm segmented	9.84 in segmented	6.3 kg
		550 mm segmented	21.65 in segmented	13.9 kg
Sectioning FA		1250 mm	49.21 in	31.5 kg
		2050 mm	80.71 in	51.7 kg
		2550 mm	100.39 in	64.3 kg
		3050 mm	120.08 in	76.9 kg
Sectioning FB		1250 mm	49.21 in	31.5 kg
		2050 mm	80.71 in	51.7 kg
		2550 mm	100.39 in	64.3 kg
		3050 mm	120.08 in	76.9 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.12.30 400 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	15.2 kg
		250 mm segmented	9.84 in segmented	7.6 kg
		550 mm segmented	21.65 in segmented	16.7 kg
Sectioning FA		1250 mm	49.21 in	38.0 kg
		2050 mm	80.71 in	62.3 kg
		2550 mm	100.39 in	77.5 kg
		3050 mm	120.08 in	92.7 kg
Sectioning FB		1250 mm	49.21 in	38.0 kg
		2050 mm	80.71 in	62.3 kg
		2550 mm	100.39 in	77.5 kg
		3050 mm	120.08 in	92.7 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.16.30 500 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	17.7 kg
		250 mm segmented	9.84 in segmented	8.9 kg
		550 mm segmented	21.65 in segmented	19.5 kg
Sectioning FA		1250 mm	49.21 in	44.3 kg
		2050 mm	80.71 in	72.6 kg
		2550 mm	100.39 in	90.3 kg
		3050 mm	120.08 in	108.0 kg
Sectioning FB		1250 mm	49.21 in	44.3 kg
		2050 mm	80.71 in	72.6 kg
		2550 mm	100.39 in	90.3 kg
		3050 mm	120.08 in	108.0 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

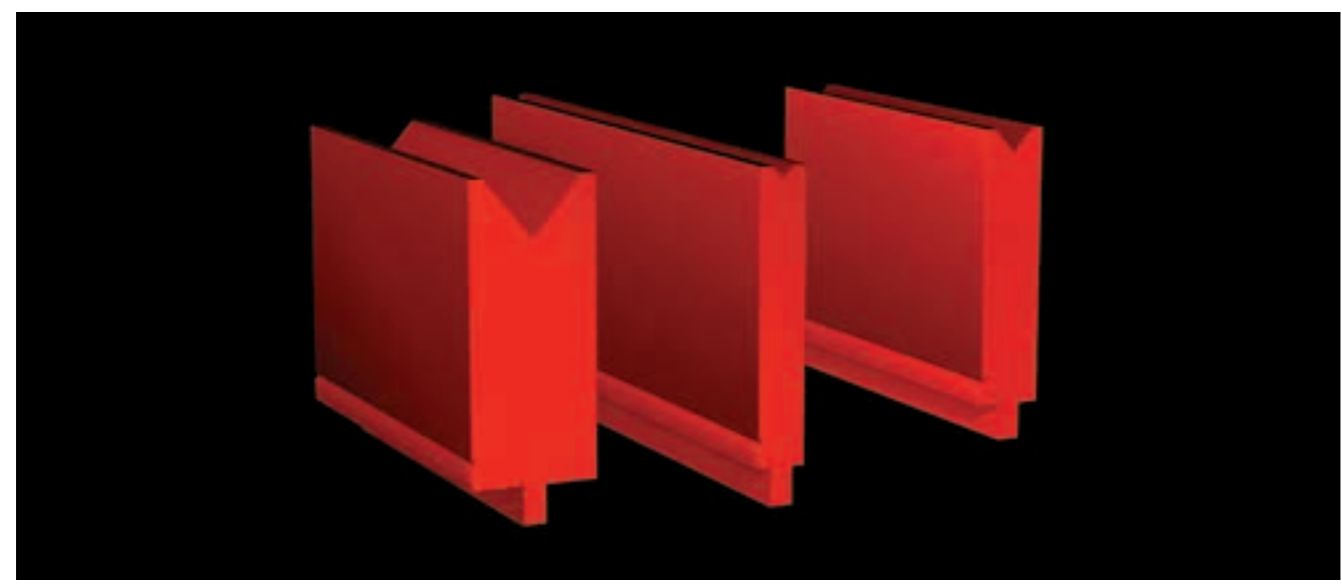
## TMR150.20.30 600 kN/m max.

**NEW**

FW	FC	500 mm	19.68 in	20.0 kg
		250 mm segmented	9.84 in segmented	10.0 kg
		550 mm segmented	21.65 in segmented	22.0 kg
Sectioning FA		1250 mm	49.21 in	50.0 kg
		2050 mm	80.71 in	82.0 kg
		2550 mm	100.39 in	102.0 kg
		3050 mm	120.08 in	122.0 kg
Sectioning FB		1250 mm	49.21 in	50.0 kg
		2050 mm	80.71 in	82.0 kg
		2550 mm	100.39 in	102.0 kg
		3050 mm	120.08 in	122.0 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>



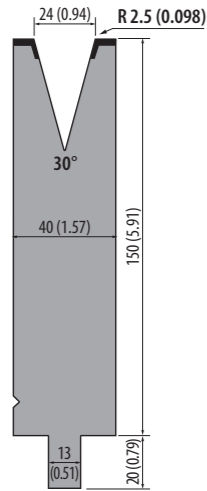
# R2 ROLLERI TYPE R2

Dies 30°, H=150 (5.91)

## TMR150.24.30

650 kN/m max.

**NEW**



FW / FC	mm	in	kg
250 mm segmented	9.84	0.39	12.3
550 mm segmented	21.65	0.85	27.0
<b>Sectioning FA</b>			
1250 mm	49.21	1.94	61.5
2050 mm	80.71	3.18	100.9
2550 mm	100.39	3.95	125.5
3050 mm	120.08	4.73	150.1
4050 mm	159.45	6.27	199.3
<b>Sectioning FB</b>			
1250 mm	49.21	1.94	61.5
2050 mm	80.71	3.18	100.9
2550 mm	100.39	3.95	125.5
3050 mm	120.08	4.73	150.1
4050 mm	159.45	6.27	199.3

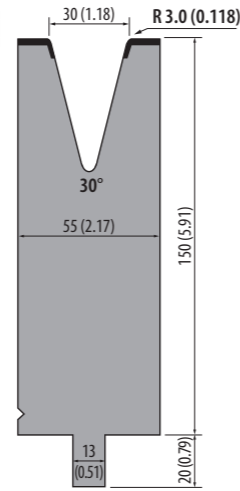
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.30.30

900 kN/m max.

**NEW**



FW / FC	mm	in	kg
250 mm segmented	9.84	0.39	12.3
550 mm segmented	21.65	0.85	27.0
<b>Sectioning FA</b>			
1250 mm	49.21	1.94	61.5
2050 mm	80.71	3.18	100.9
2550 mm	100.39	3.95	125.5
3050 mm	120.08	4.73	150.1
4050 mm	159.45	6.27	199.3
<b>Sectioning FB</b>			
1250 mm	49.21	1.94	61.5
2050 mm	80.71	3.18	100.9
2550 mm	100.39	3.95	125.5
3050 mm	120.08	4.73	150.1
4050 mm	159.45	6.27	199.3

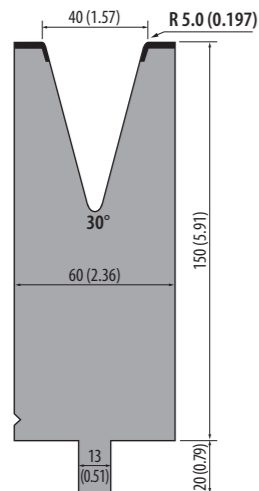
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>

## TMR150.40.30

900 kN/m max.

**NEW**



FW / FC	mm	in	kg
250 mm segmented	9.84	0.39	12.7
550 mm segmented	21.65	0.85	27.8
<b>Sectioning FA</b>			
1250 mm	49.21	1.94	63.3
2050 mm	80.71	3.18	103.7
2550 mm	100.39	3.95	129.0
3050 mm	120.08	4.73	154.3
4050 mm	159.45	6.27	204.9
<b>Sectioning FB</b>			
1250 mm	49.21	1.94	63.3
2050 mm	80.71	3.18	103.7
2550 mm	100.39	3.95	129.0
3050 mm	120.08	4.73	154.3
4050 mm	159.45	6.27	204.9

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm<sup>2</sup>



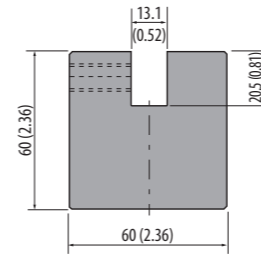
# R2 ROLLERI TYPE R2

Die adapters



## AD5

1000 kN/m max.



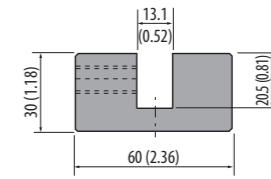
Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



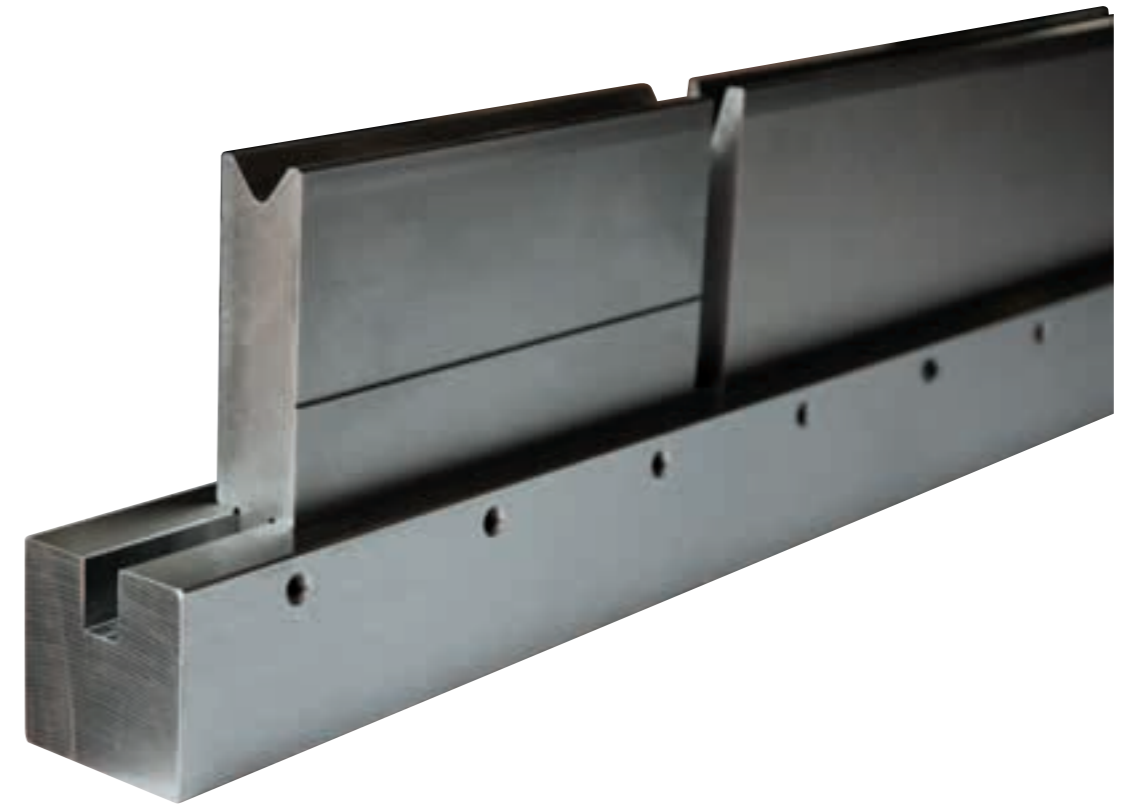
## AD6

1000 kN/m max.



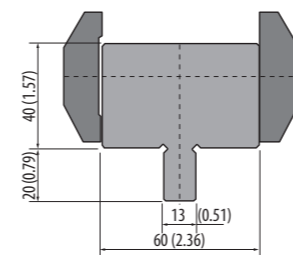
Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



## AD7

1000 kN/m max.



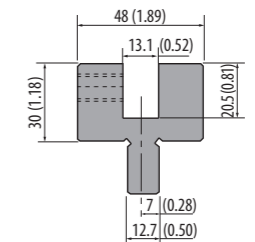
Rolleri Type R2/R3  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



## AD8-12.7

1000 kN/m max.



Rolleri Type RX LVD  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



# R2 ROLLERI TYPE R2

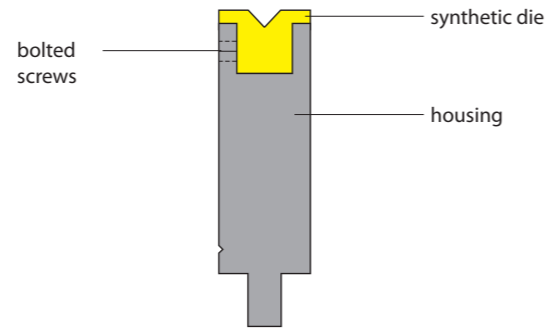
Synthetic dies, H=100 (3.94)

## Our Advantages – Your Convenience

- easy handling
- faster and easier exchange
- preventing bending marks
- decrease of post-processing of bended profiles
- higher product quality

## Mounting example

Synthetic dies will be adjusted into the housing and secured with bolted screws.

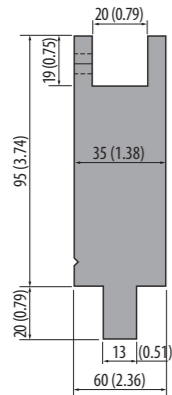


### TMN95.20

1000 kN/m max.

835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

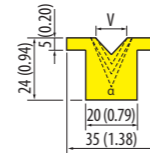
C45: 560-710 N/mm<sup>2</sup>



### INS20...

200 kN/m max.

835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg



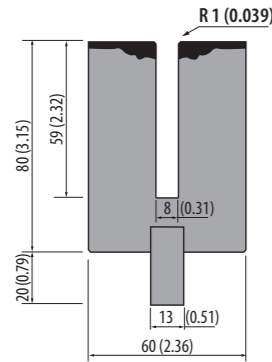
Model	$\alpha$	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	$\alpha$	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

More mark-free bending available see pages 222-229



### TPR.SM.195.28.8 / TPR.SM.195.24.8

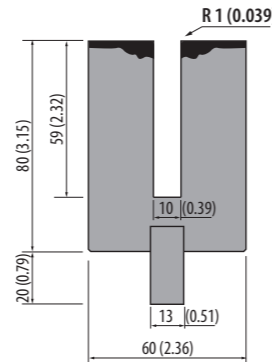


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.4 kg

42Cr: 900-1150 N/mm<sup>2</sup>



### TPR.SM.195.24.10

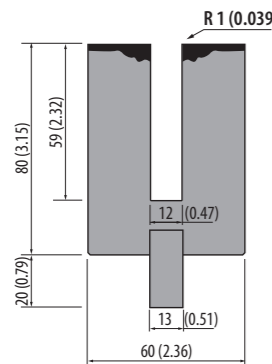


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm<sup>2</sup>



### TPR.SM.195.24.12



525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

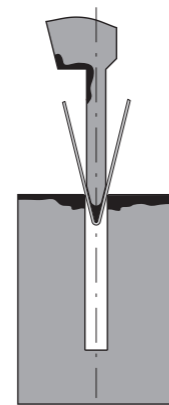


Only for thin material!  
Hemming punches  
see page 91

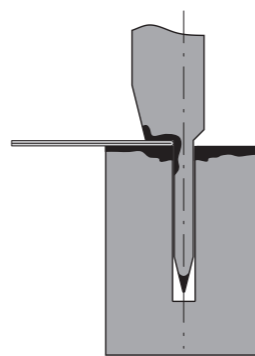
### Example of application



S mm	S in	A mm	A in	R.45 Kg/mm <sup>2</sup>	R.70 Kg/mm <sup>2</sup>	S mm	S in	A mm	A in	R.45 Kg/mm <sup>2</sup>	R.70 Kg/mm <sup>2</sup>
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80



500 kN/m max.



1000 kN/m max.

### Application

- movable table necessary
- used flexibly
- easy mounting

Hemming punches  
see page 91

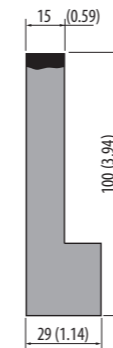
### TMI100



	500 mm	19.68 in	5.0 kg
FW FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg
	1250 mm	49.21 in	12.5 kg
Sectioning FA	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

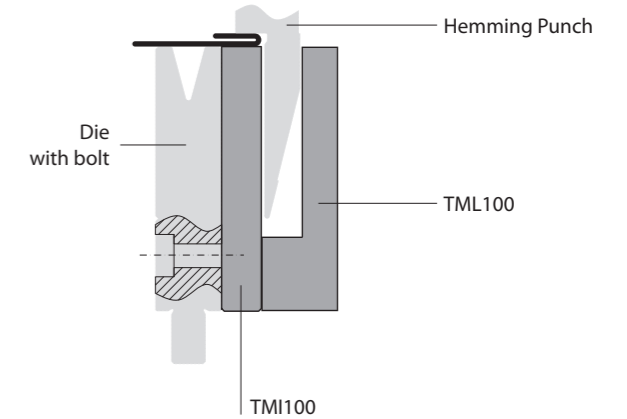
### TML100



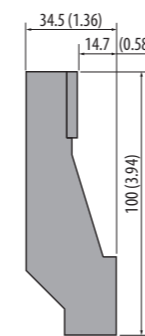
	500 mm	19.68 in	5.0 kg
FW FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg
	1250 mm	49.21 in	12.5 kg
Sectioning FA	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

### Example of application TMI100 + TML100



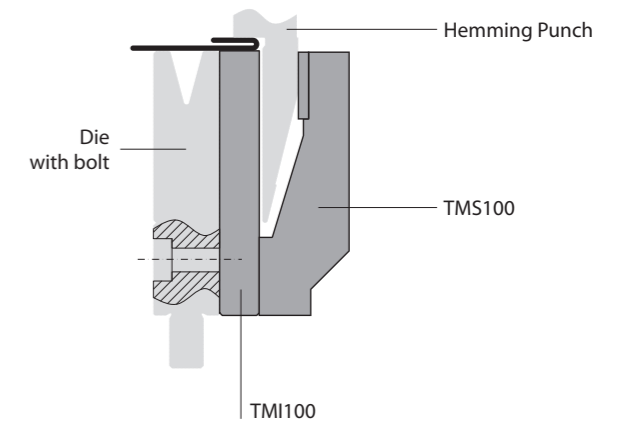
### TMS100



	500 mm	19.68 in	5.0 kg
FW FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg
	1250 mm	49.21 in	12.5 kg
Sectioning FA	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg

Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

### Example of application TMI100 + TMS100



## PUNCHES ROLLERI TYPE R3

Content Explanation	122 - 123
Punches Bystronic-Beyeler RFA	124 - 125
Punches Bystronic-Beyeler RF	125
Hemming Punches Bystronic-Beyeler RFA	126
Punches Bystronic-Beyeler R	127
Punches Bystronic-Beyeler S	128
Punch adapters	129
Z-Profile Tools	130 - 131
Radius Tools	132 - 133

### Compatibility

Punches Roller Type R3 are compatible with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

With Adapter-Systems the punches Roller Type R3 are also applicable on all other press brake machines.

### Compatibility

Punches Roller Type R3 are:

- compatible with press brake machines from:
  - Bystronic-Beyeler RFA
  - Bystronic-Beyeler RF
  - Bystronic-Beyeler R
  - Bystronic-Beyeler S

### Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 248-249)
- very large stock availability

### Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm <sup>2</sup>	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

### Tang

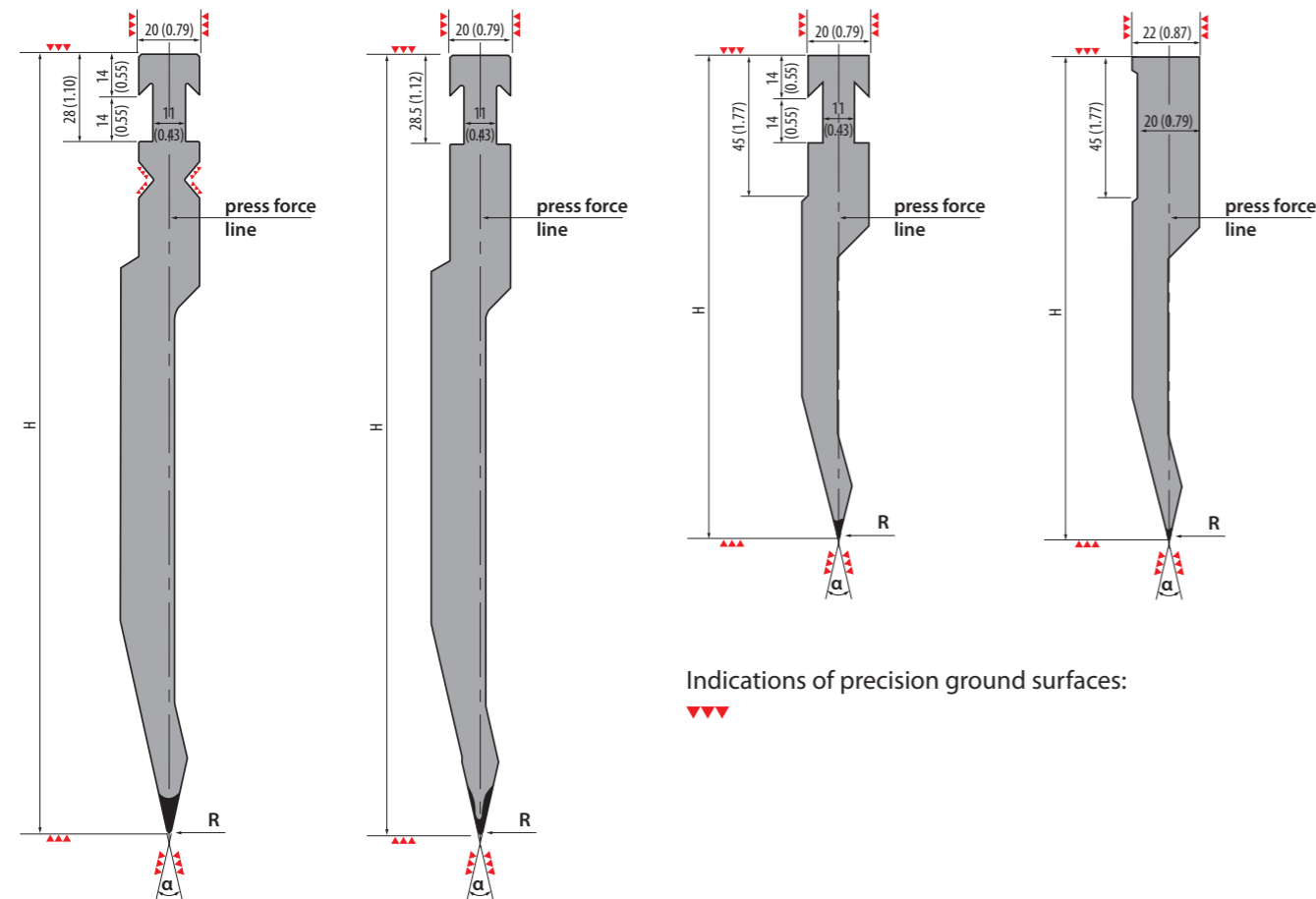
Punches Roller Type R3 have the following tangs:

Bystronic-Beyeler RFA

Bystronic-Beyeler RF

Bystronic-Beyeler R

Bystronic-Beyeler S

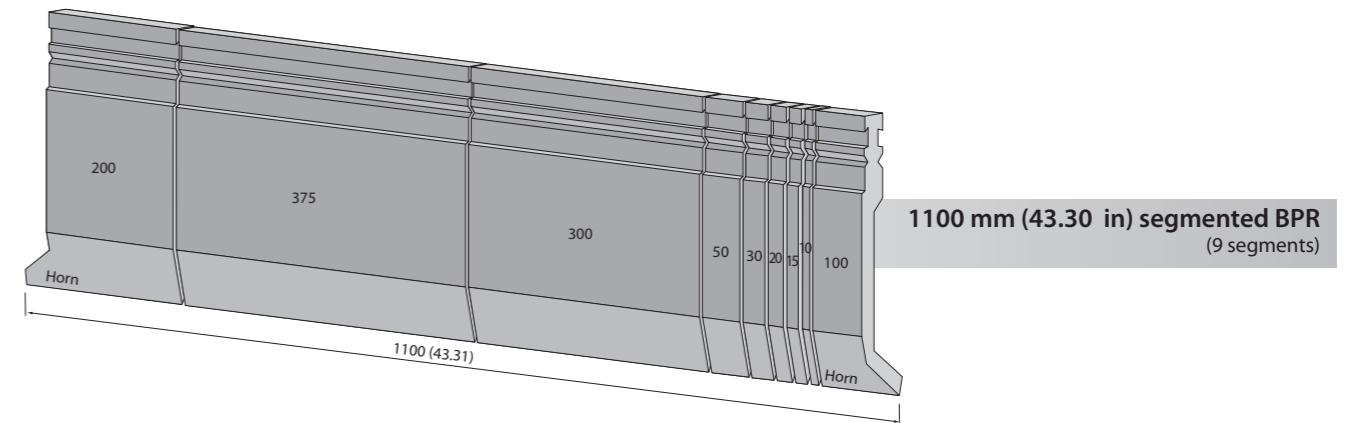
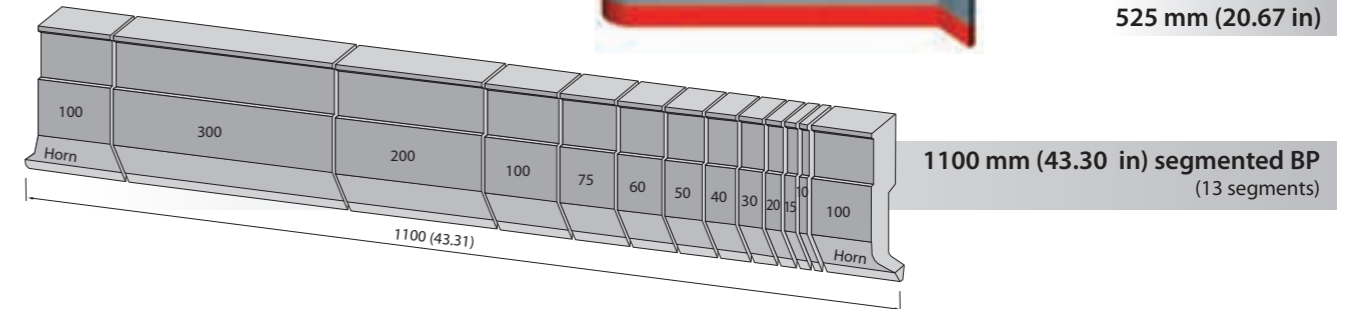


### Tool lengths and sectioning

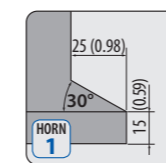
Standard

Segmented tools are delivered in complete sets. Single pieces are also available!  
More lengths and sectionings are possible upon request.

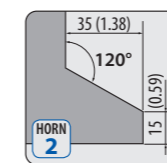
- 1000 mm (39.36 in)
- 500 mm (19.68 in)
- 508 mm (20.00 in)
- 525 mm (20.67 in)



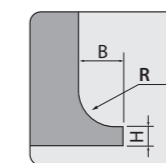
### Horn Types



**Horn 1**  
Standard BP  
for all segm.  
Punches BP  
Rolleri Type R3



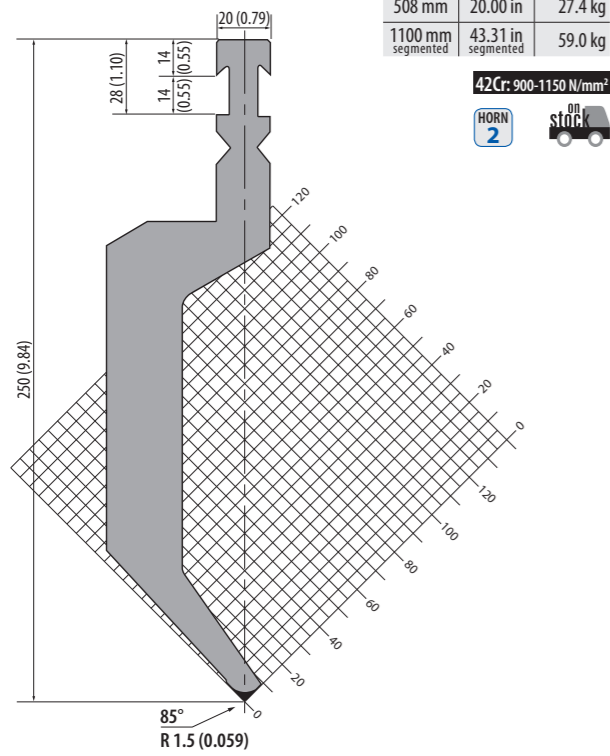
**Horn 2**  
Standard BPR  
for all segm.  
Punches BPR  
Rolleri Type R3



**Individual Horn**  
production  
according  
to your  
specifications

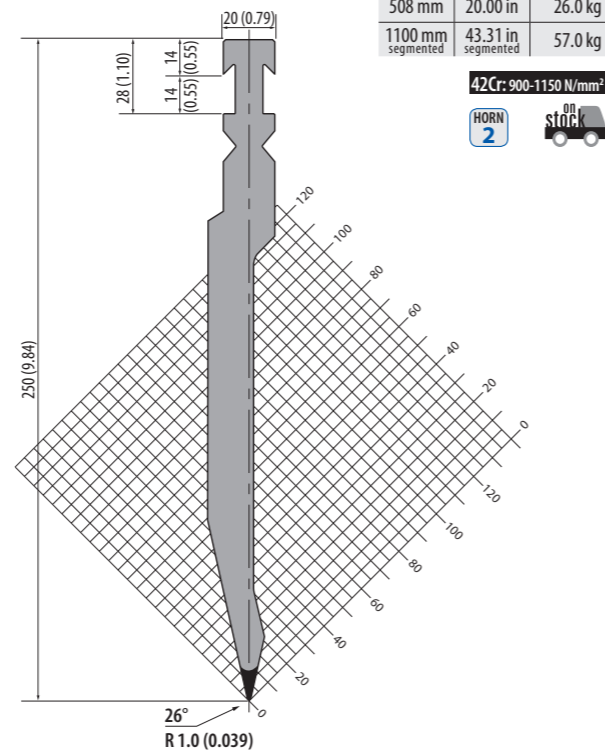
**BPR250.P4-RFA**

900 kN/m max.



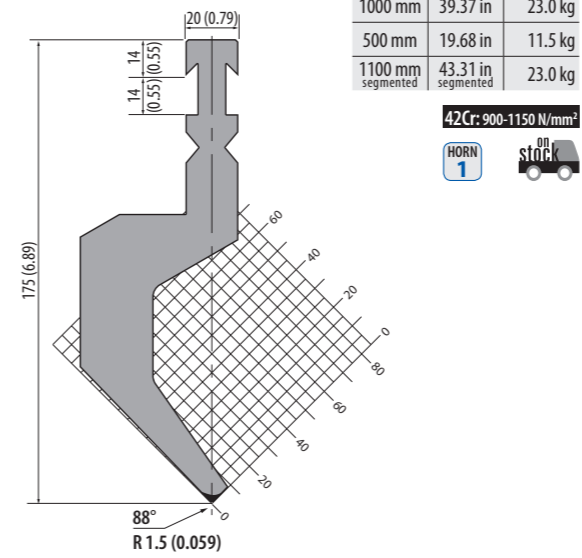
**BPR250.P5-RFA**

1000 kN/m max.



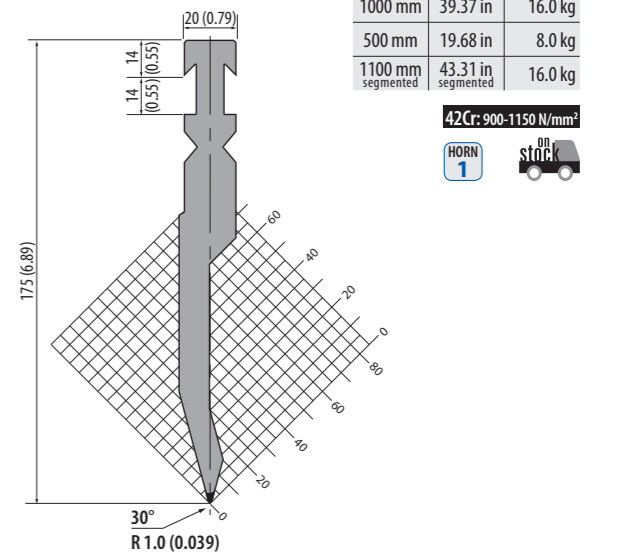
**BP175.88.R15-RFA**

500 kN/m max.



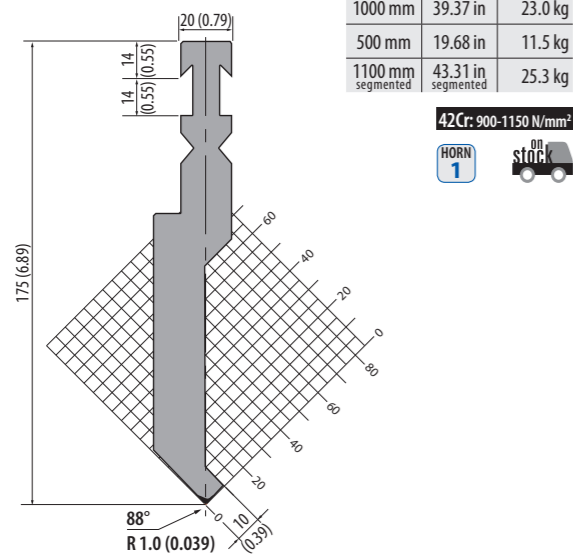
**BP175.30.R1-RFA**

800 kN/m max.



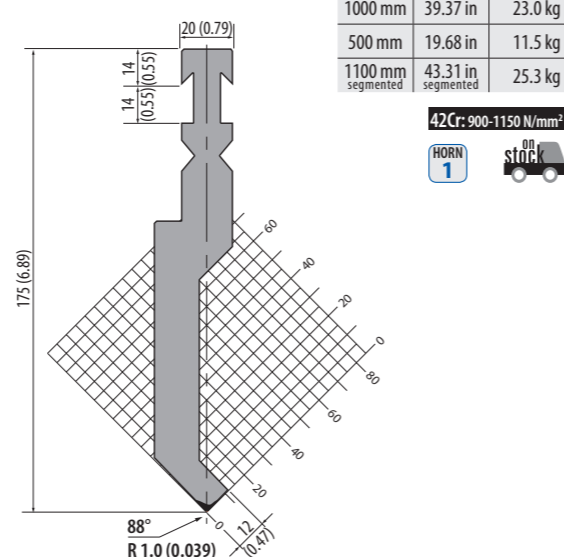
**BP175.88.R1-A-RFA**

1000 kN/m max.



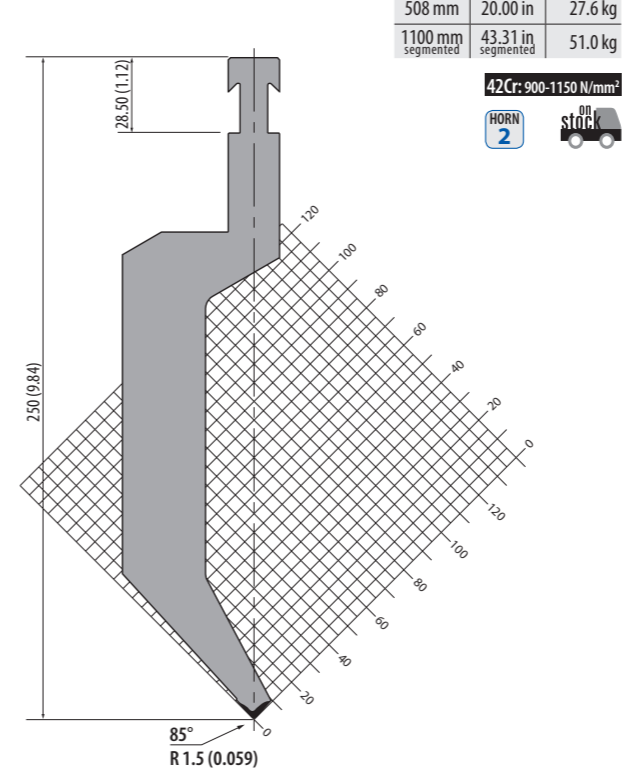
**BP175.88.R1-B-RFA**

1000 kN/m max.



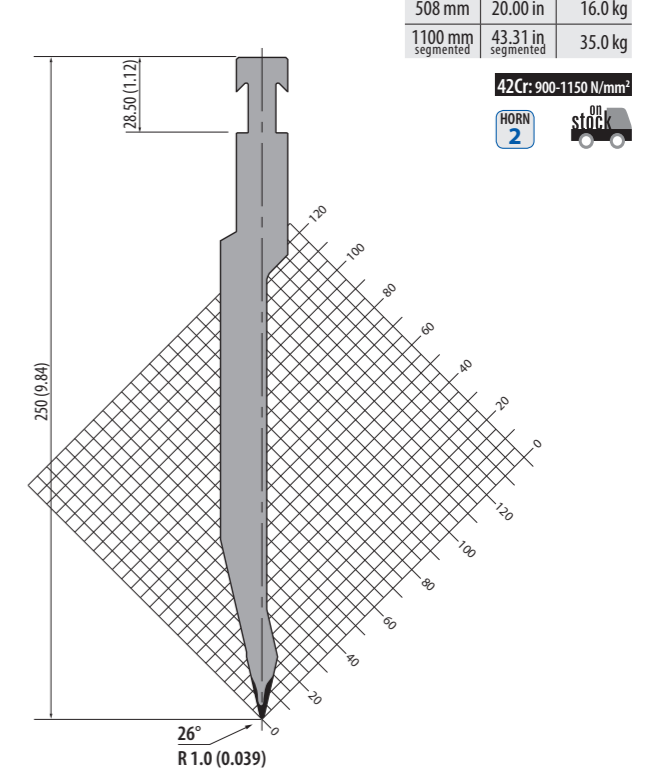
**BPR250.P4-RF**

1000 kN/m max.

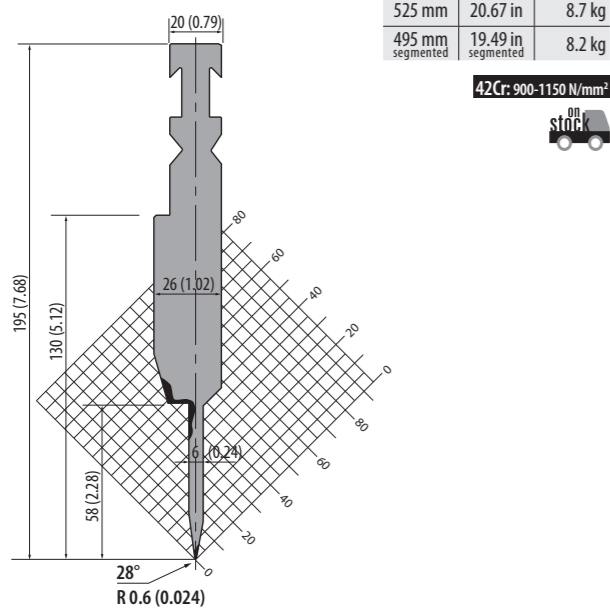


**BPR250.P5-RF**

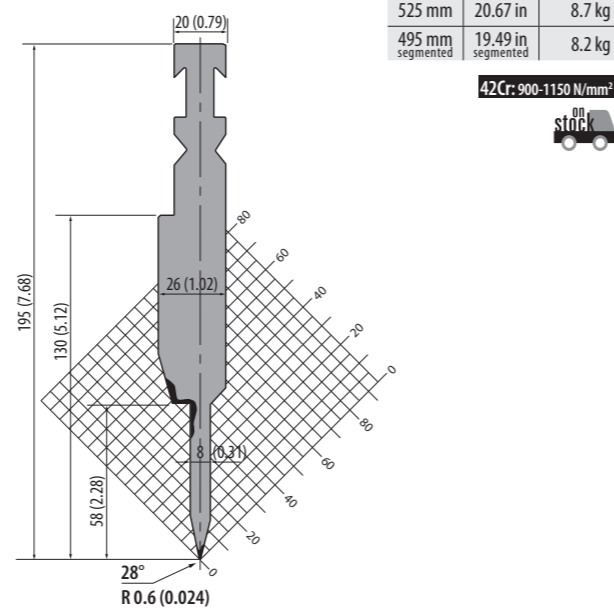
900 kN/m max.



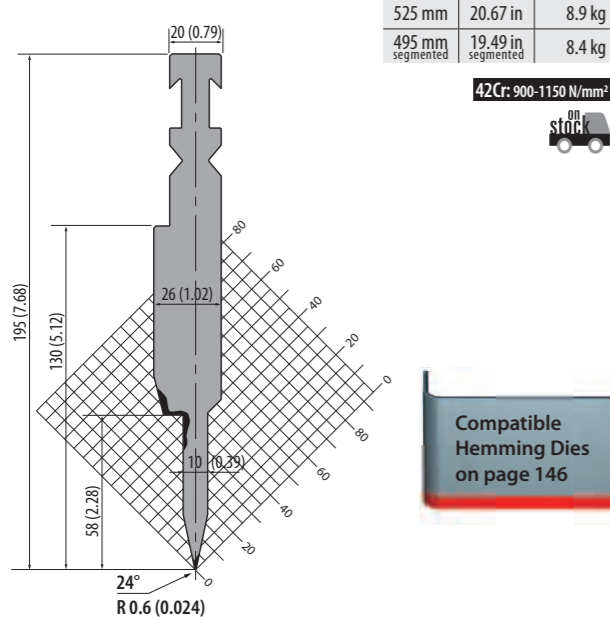
**BPR.SP-195.28.6** 500 kN/m max.



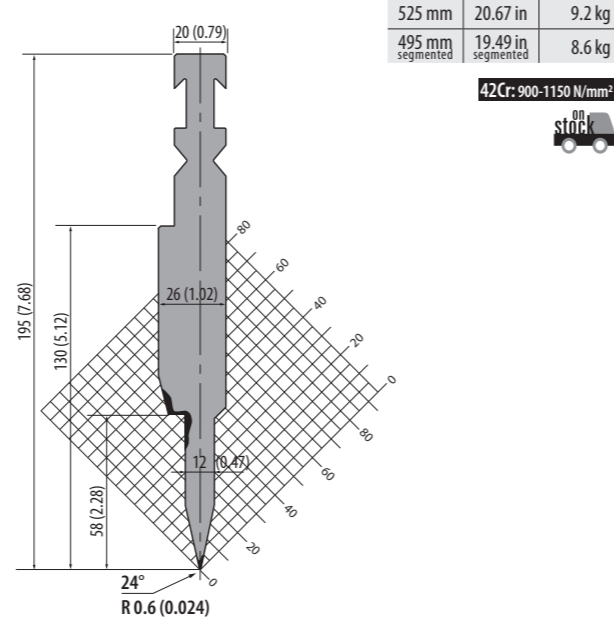
**BPR.SP-195.28.8** 500 kN/m max.



**BPR.SP-195.24.10** 500 kN/m max.

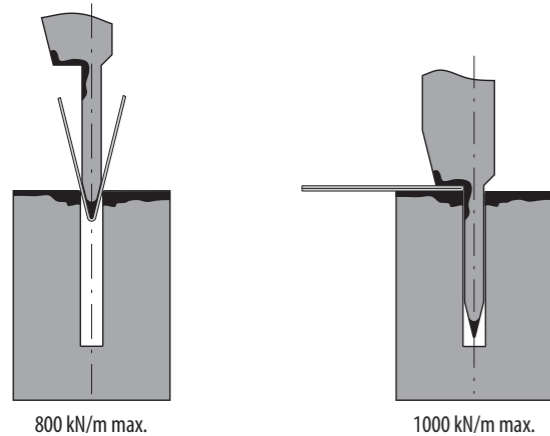


**BPR.SP-195.24.12** 500 kN/m max.



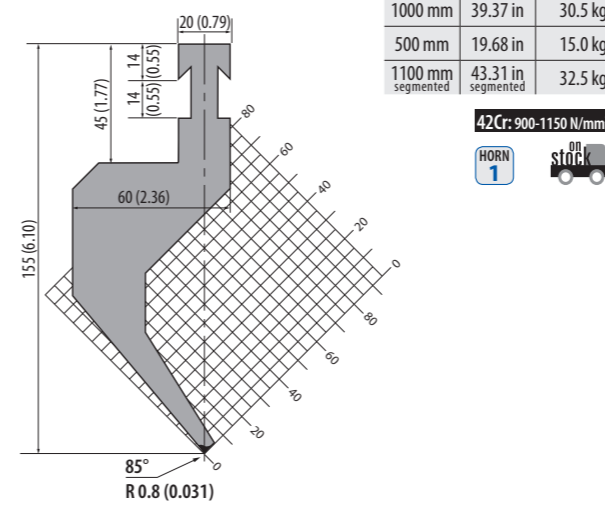
Compatible Hemming Dies on page 146

**Example of Application**

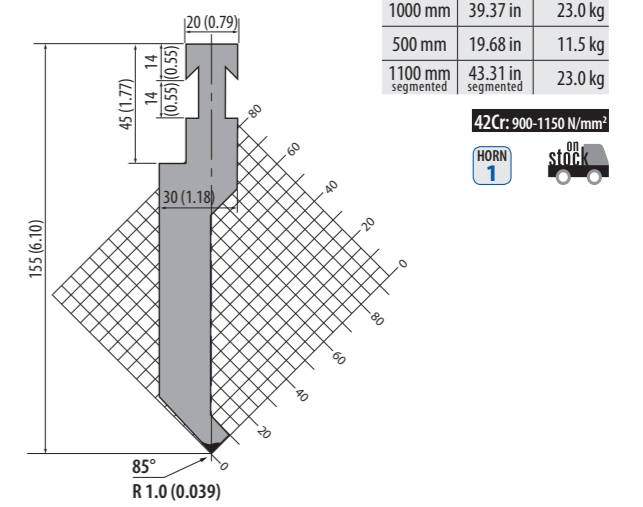


S	S	A	A	R.45	R.70	S	S	A	A	R.45	R.70
mm	in	mm	in	Kgf/mm <sup>2</sup>	Kgf/mm <sup>2</sup>	mm	in	mm	in	Kgf/mm <sup>2</sup>	Kgf/mm <sup>2</sup>
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

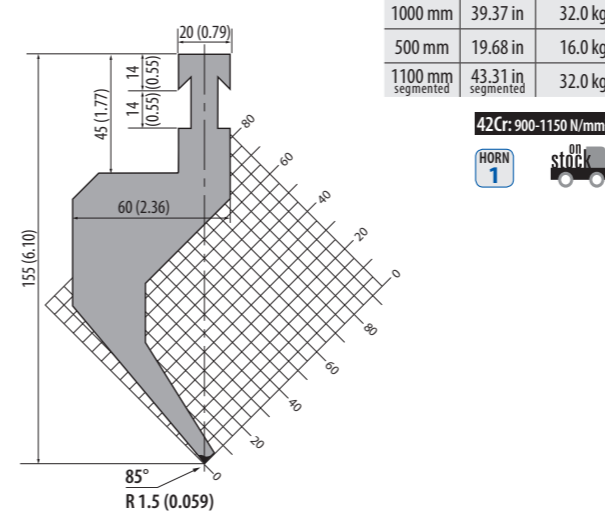
**BP155.85.R08-R** 500 kN/m max.



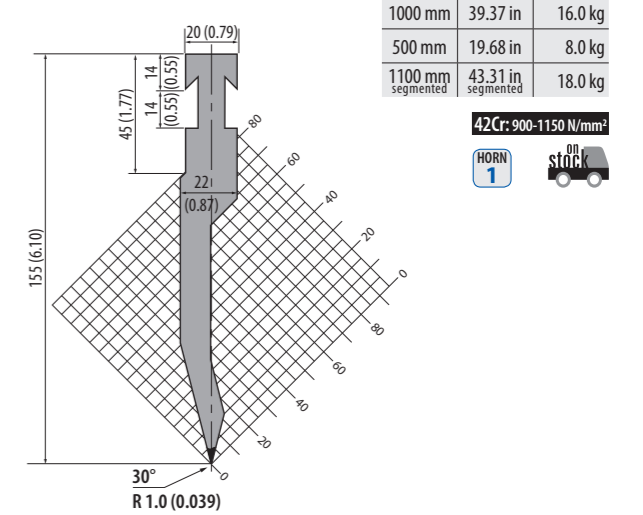
**BP155.85.R1-R** 1000 kN/m max.



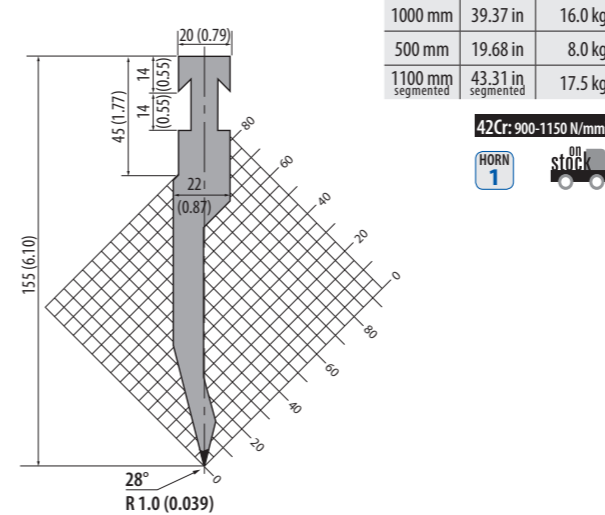
**BP155.85.R15-R** 500 kN/m max.



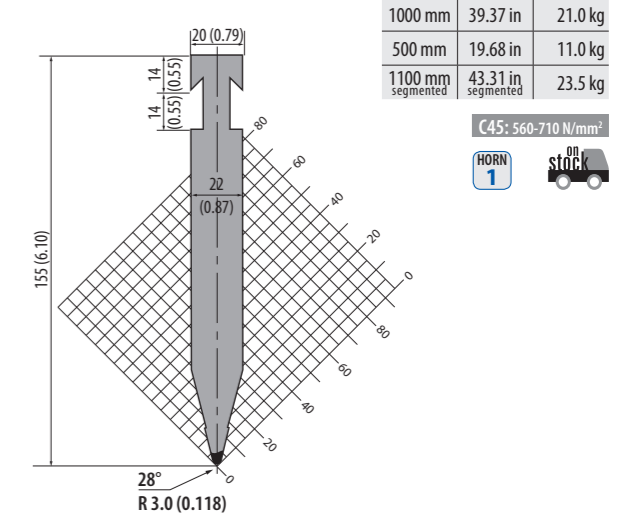
**BP155.30.R1-R** 800 kN/m max.



**BP155.28.R1-R** 800 kN/m max.

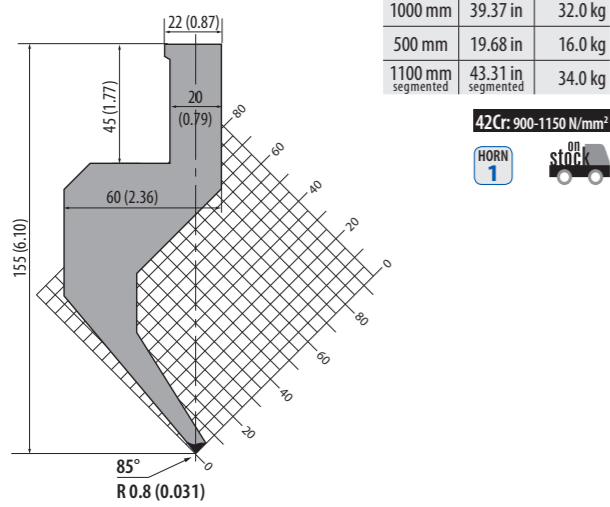


**BP155.28.R3-R** 1000 kN/m max.

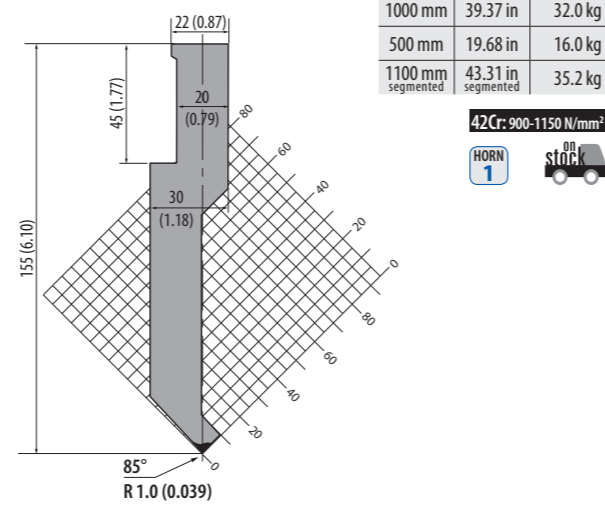




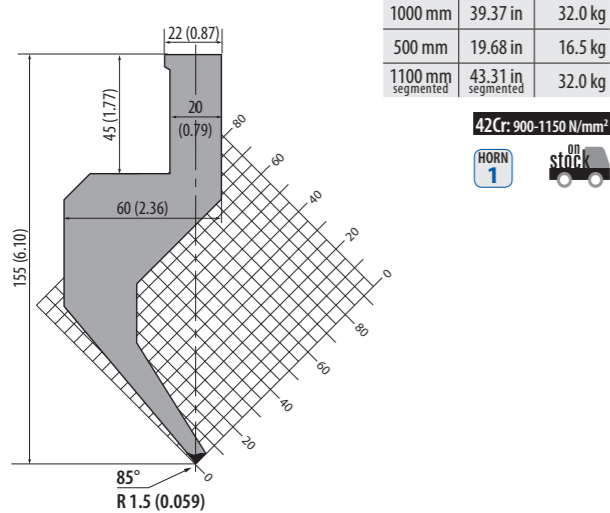
**BP155.85.R08-S** 500 kN/m max.



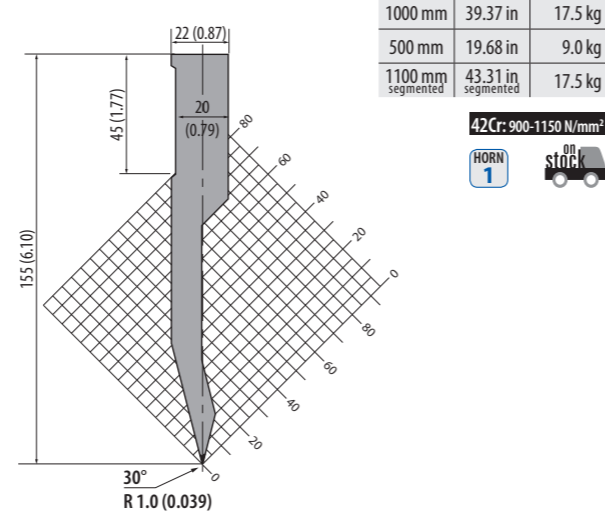
**BP155.85.R1-S** 1000 kN/m max.



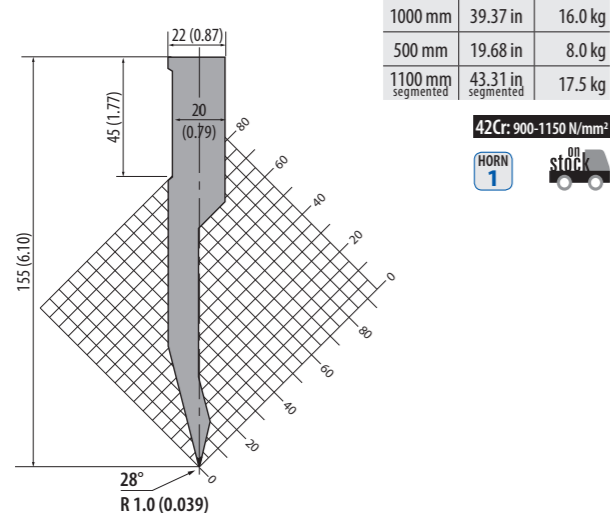
**BP155.85.R15-S** 500 kN/m max.



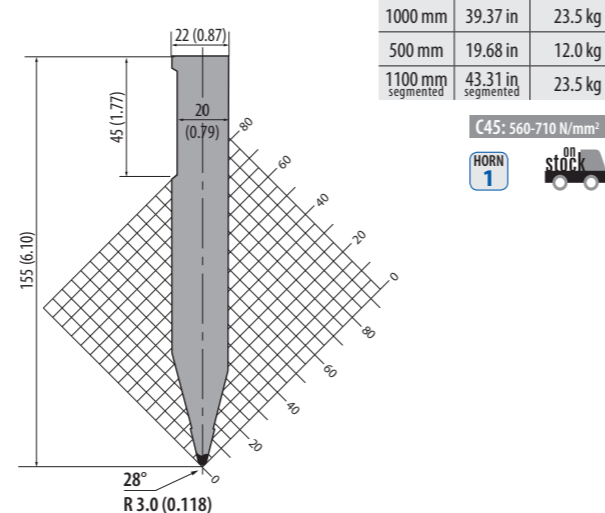
**BP155.30.R1-S** 800 kN/m max.



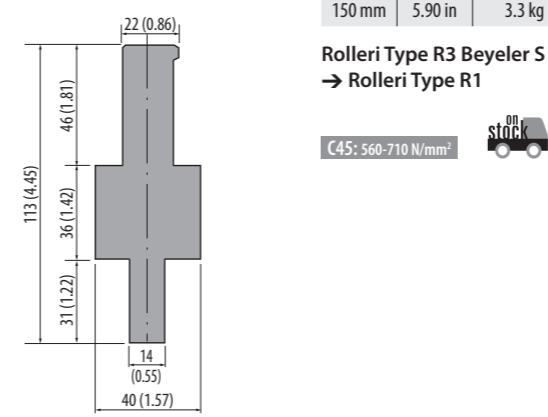
**BP155.28.R1-S** 800 kN/m max.



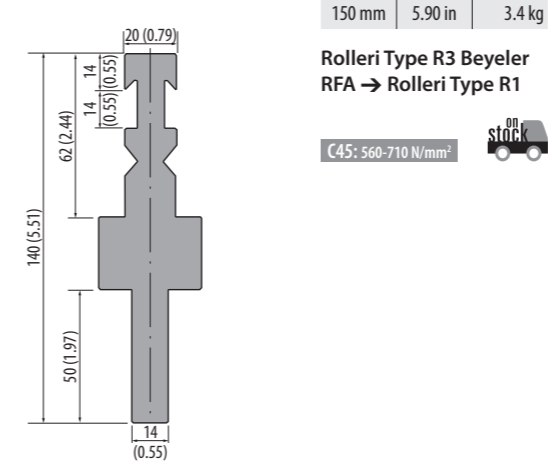
**BP155.28.R3-S** 1000 kN/m max.



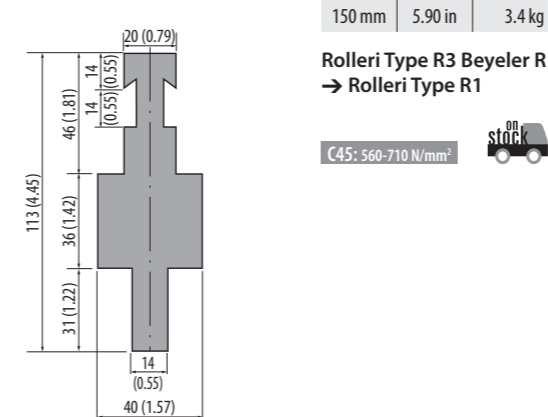
**AD3** 1000 kN/m max.



**AD10** 1000 kN/m max.



**AD22** 1000 kN/m max.



Articles on stock – Please note that delivery time varies according to your location.

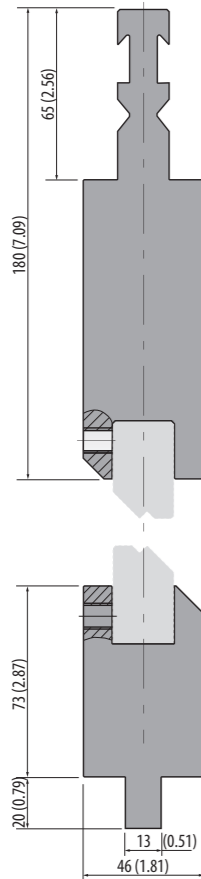


**BPZ-RFA**

1000 kN/m max.

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.7 kg

C45: 560-710 N/mm<sup>2</sup>



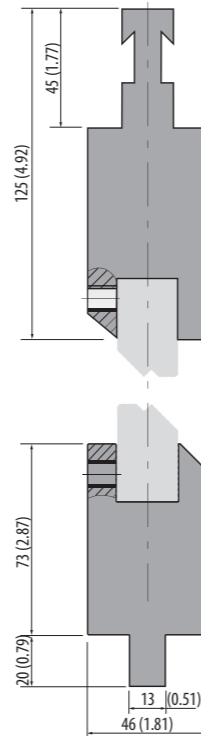
**BPZ-R**

1000 kN/m max.

**NEW**

835 mm	32.87 in	24.7 kg
415 mm	16.34 in	12.3 kg

C45: 560-710 N/mm<sup>2</sup>



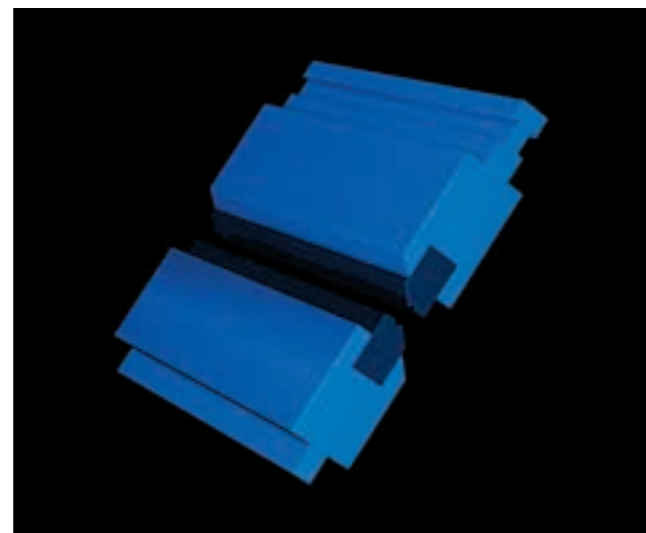
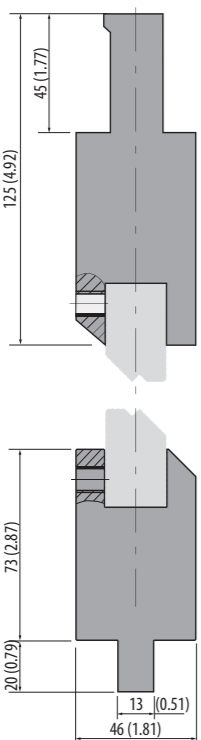
**BPZ-S**

1000 kN/m max.

**NEW**

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.5 kg

C45: 560-710 N/mm<sup>2</sup>



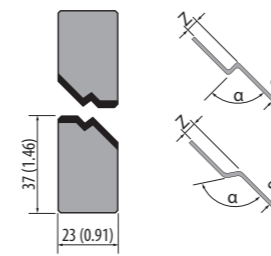
**Rolleri Videos**

find updated and helpful videos at:  
[www.rolleritools.com/videos/overview](http://www.rolleritools.com/videos/overview)



**Z-Tool Inserts 160° / 150° / 140° / 90°**

1000 kN/m max.



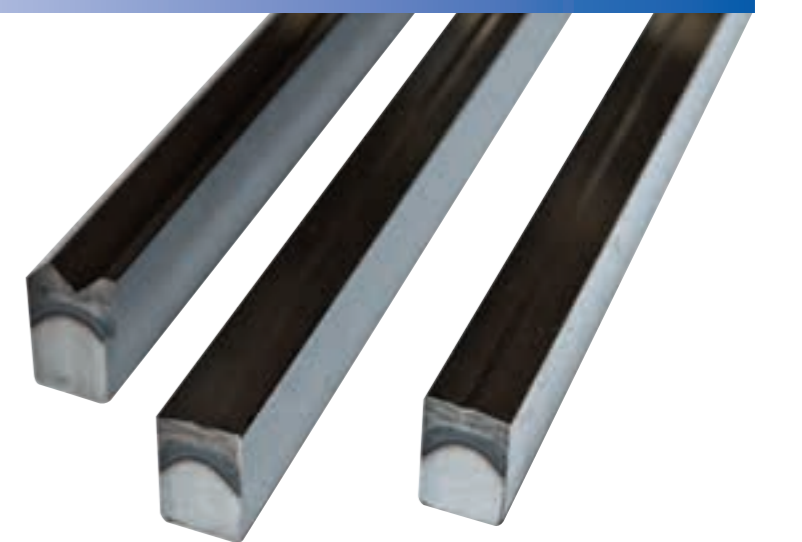
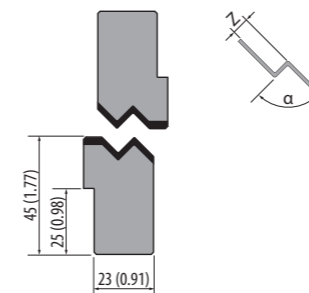
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02	11.0 kg	5.5 kg
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02	11.0 kg	5.5 kg
CEZ 3.0	3.0	0.12	90°	1.0	0.04	10.3 kg	5.1 kg
CEZ 3.5	3.5	0.14	90°	1.0	0.04	10.0 kg	5.0 kg
CEZ 4.0	4.0	0.16	90°	1.2	0.05	10.0 kg	5.0 kg
CEZ 4.5	4.5	0.18	90°	1.2	0.05	10.0 kg	5.0 kg
CEZ 5.0	5.0	0.20	90°	1.3	0.05	10.0 kg	5.0 kg
CEZ 5.5	5.5	0.22	90°	1.4	0.06	10.0 kg	5.0 kg
CEZ 6.0	6.0	0.24	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 6.5	6.5	0.26	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 7.0	7.0	0.28	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 7.5	7.5	0.30	90°	1.6	0.06	10.0 kg	5.0 kg
CEZ 8.0	8.0	0.31	90°	1.6	0.06	10.0 kg	5.0 kg

C45: 560-710 N/mm<sup>2</sup>

\* Fe Rmax = 42 Kg/mm<sup>2</sup>

**Z-Profile Inserts 90°**

1000 kN/m max.



Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	6.5 kg
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	6.5 kg
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	6.5 kg
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	6.5 kg
CEZ 15.0	15	0.59	90°	2.3	0.09	13.5 kg	6.5 kg



C45: 560-710 N/mm<sup>2</sup>

\* Fe Rmax = 42 Kg/mm<sup>2</sup>

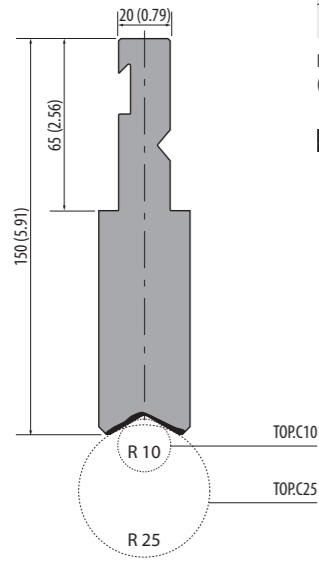
### BPR150.P10.10-RFA

1000 kN/m max.

522 mm	20.55 in	16.5 kg
495 mm segmented	19.49 in segmented	16.0 kg

For Radius tools with R10-R25 (TOP.C10-TOP.C25) see below

42Cr: 900-1150 N/mm<sup>2</sup>



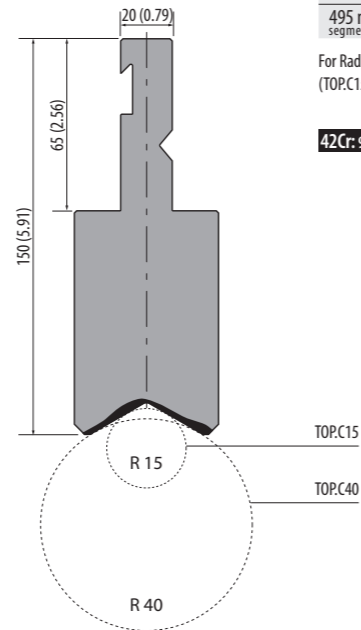
### BPR150.P10.15-RFA

1000 kN/m max.

522 mm	20.55 in	23.0 kg
495 mm segmented	19.49 in segmented	21.7 kg

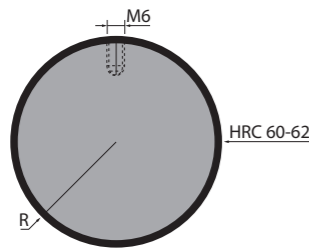
For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm<sup>2</sup>



### Radius Tools: R10-40

1000 kN/m max.



Material: C53 induction hardened 60-62HRC

C53: 610-760 N/mm<sup>2</sup>



Model	R mm	R in	Weight	Weight
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg

Articles on stock – Please note that delivery time varies according to your location.

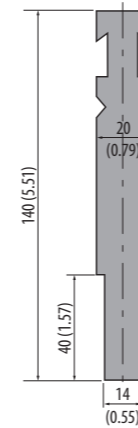


### BPU-RFA

800 kN/m max.

830 mm	32.68 in	15.3 kg
410 mm	16.14 in	7.6 kg

C45: 560-710 N/mm<sup>2</sup>

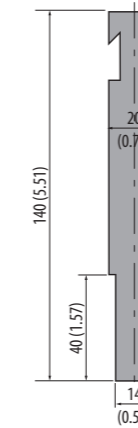


### BPU-R

800 kN/m max.

830 mm	32.68 in	15.8 kg
410 mm	16.14 in	7.8 kg

C45: 560-710 N/mm<sup>2</sup>

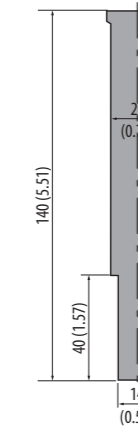


### BPU-S

800 kN/m max.

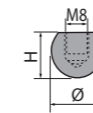
830 mm	32.68 in	16.8 kg
410 mm	16.14 in	8.3 kg

C45: 560-710 N/mm<sup>2</sup>



### Radius Tool: Ø 16-20 mm (0.63-0.79 in)

800 kN/m max.

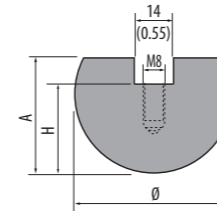


C45: 560-710 N/mm<sup>2</sup>

Model	Ø mm	Ø in	H mm	H in	Weight	Weight
C13.08	16	0.63	13	0.51	2.00 kg	1.00 kg
C13.09	18	0.71	16	0.63	2.00 kg	1.00 kg
C16.10	20	0.79	16	0.63	2.00 kg	1.00 kg

### Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.



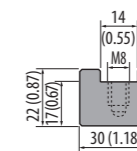
C45: 560-710 N/mm<sup>2</sup>

Model	Ø mm	Ø in	H mm	H in	A mm	A in	Weight	Weight
C17.12	25	0.98	17	0.67	22	0.87	2.5 kg	1.2 kg
C20.15	30	1.18	20	0.79	27	1.06	3.7 kg	1.8 kg
C22.17	35	1.38	22	0.87	32	1.26	5.0 kg	2.4 kg
C24.20	40	1.57	24	0.94	34	1.34	7.0 kg	3.5 kg
C29.25	50	1.97	29	1.14	39	1.54	10.0 kg	4.7 kg
C34.30	60	2.36	34	1.34	44	1.73	13.5 kg	6.7 kg
C45.35	70	2.76	45	1.77	55	2.17	20.3 kg	10.0 kg
C45.40	80	3.15	45	1.77	55	2.17	23.0 kg	11.5 kg
C60.45	90	3.54	60	2.36	70	2.76	34.0 kg	17.0 kg
C70.50	100	3.94	70	2.76	80	3.15	43.5 kg	21.7 kg



### E30.22

800 kN/m max.



835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

C45: 560-710 N/mm<sup>2</sup>



## DIES ROLLERI TYPE R3

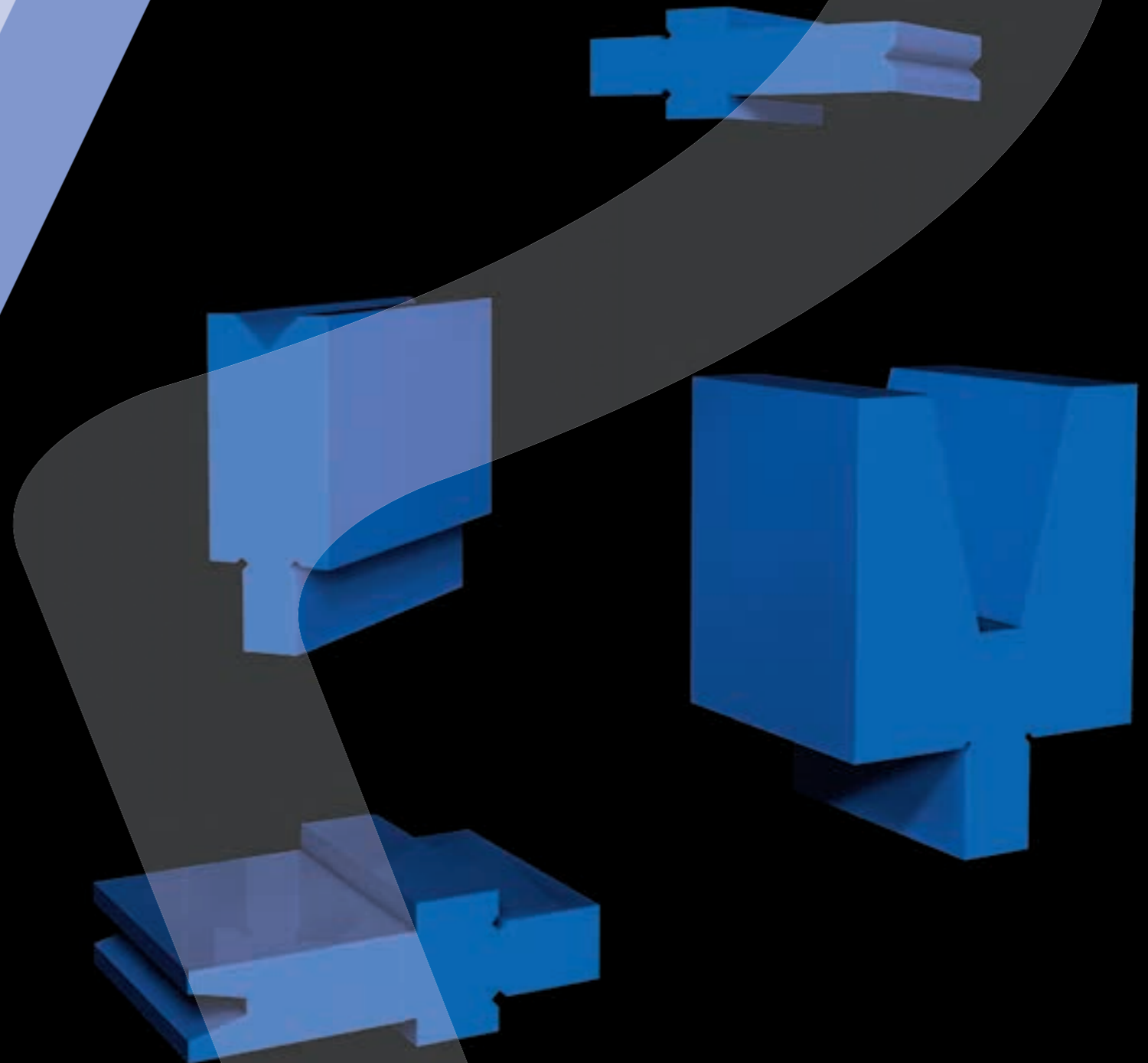
Content Explanation	136 - 137
Dies 90°, H=55 (2.17)	138
Dies 88°, H=55 (2.17)	139
Dies 85°, H=55 (2.17)	139
Dies 80°, H=65 (2.56) / H=85 (3.35)	140
Dies 60°, H=55 (2.17) / H=65 (2.56)	140
Dies 30°, H=55 (2.17) / H=60 (2.36)	141
Dies 30°, H=70 (2.76)	142
Dies, H=100 (3.94) / H=120 (4.72) / H=150 (5.91)	143 - 145
Hemming Dies	146
Synthetic Dies, H=100 (3.94)	147
Die Adapters	147

### Compatibility

Dies Rolleri Type R3 are compatible with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

With Adapter-Systems the dies Rolleri Type R3 are also applicable on all other press brake machines.



### Compatibility

Dies Roller Type R3 are:

- compatible with press brake machines with a table groove for pins 13 x 20 mm (0.51 x 0.79 in): Bystronic-Beyeler, Bystronic-Hämmerle, Safan, SMD, Trumpf
- also applicable on all other press brake machines with **Adapter-Systems and Adapter Rails** (see pages 218-221).

### Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

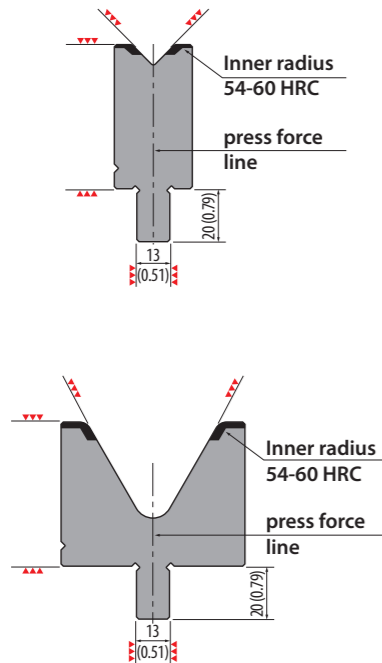
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm <sup>2</sup>	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

### Tang

All dies Roller Type R3 are by default equipped with a **13 x 20 mm (0.51 x 0.79 in) tail**.

Indications of precision ground surfaces:



### Our Advantages – Your Convenience

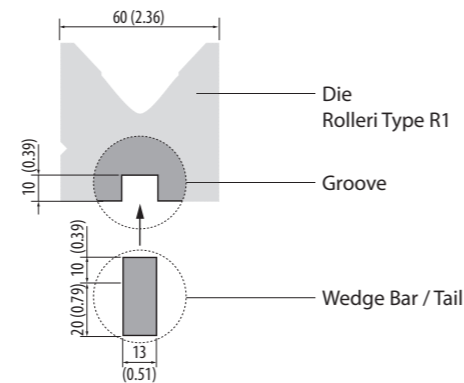
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 250-253)
- very large stock availability

### Modification: Wedge Bar / Tail

In order to also use Roller Type R1 Dies, a 10 mm (0.39 in) groove is milled and a percise grounded wedge bar / tail in 13 x 30 mm (0.51 x 1.18 in) is inserted.

For more specific information and prices go to page 252 in the Service Chapter.

### Example of Application



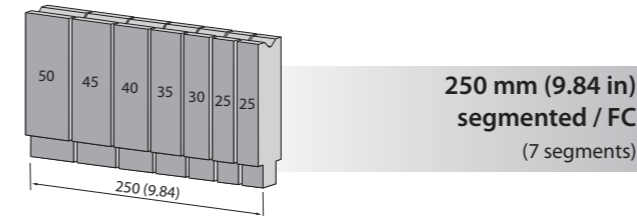
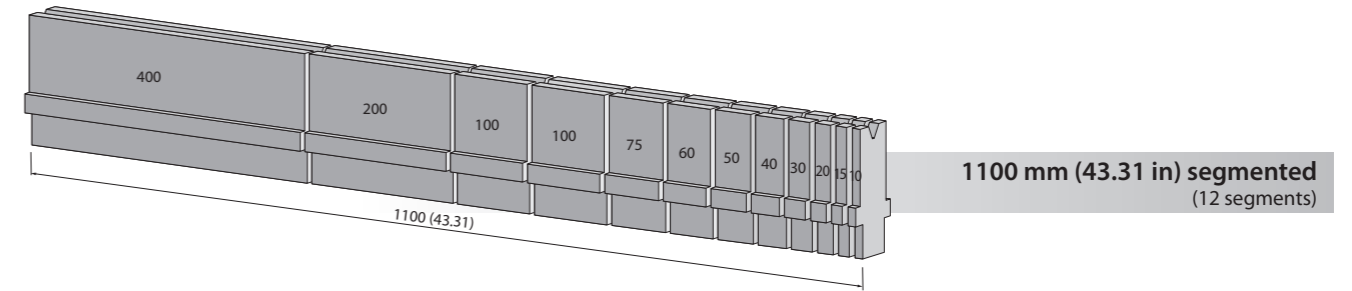
### Tool lengths and sectioning

Standard

1000 mm (39.37 in)

500 mm (19.68 in)

525 mm (20.67 in)



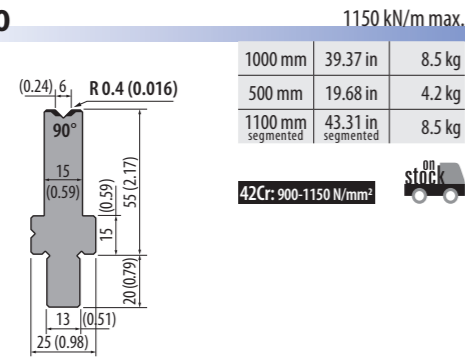
Segmented tools are delivered in complete sets. Single pieces are also available! More lengths and sectionings are possible upon request.



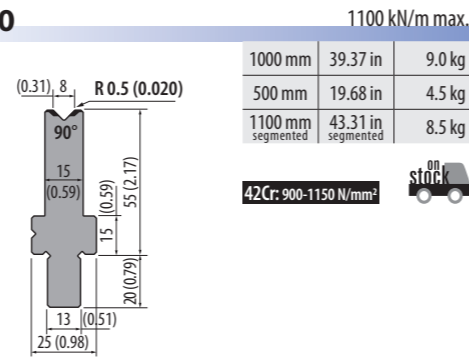
# R3 ROLLERI TYPE R3

Dies 90°, H=55 (2.17)

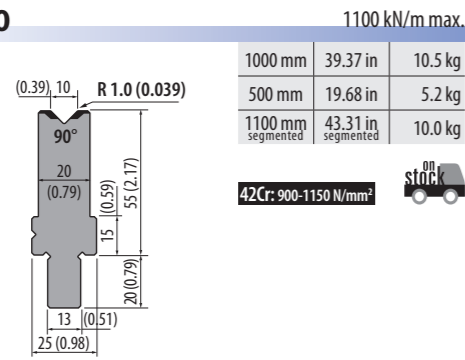
## BMR55.06.90



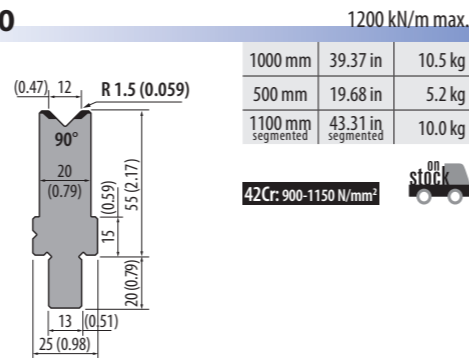
## BMR55.08.90



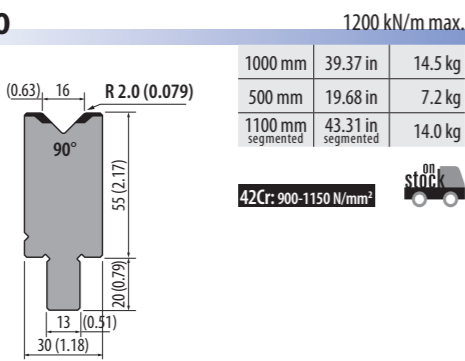
## BMR55.10.90



## BMR55.12.90



## BMR55.16.90

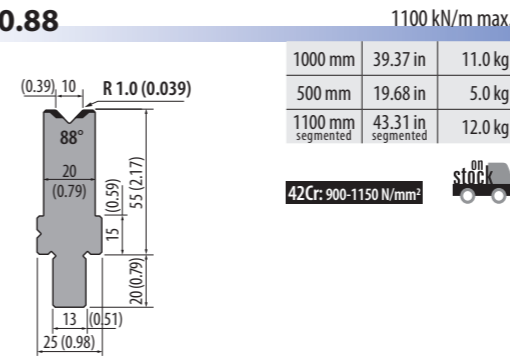


# R3 ROLLERI TYPE R3

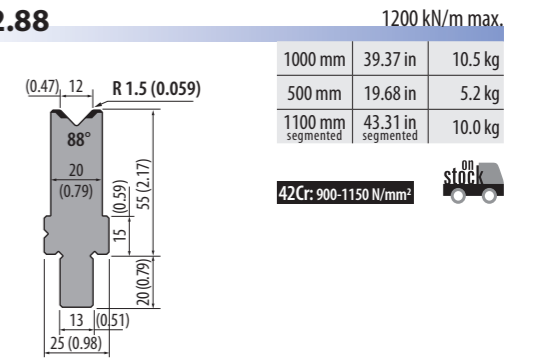
Dies 88°, H=55 (2.17)



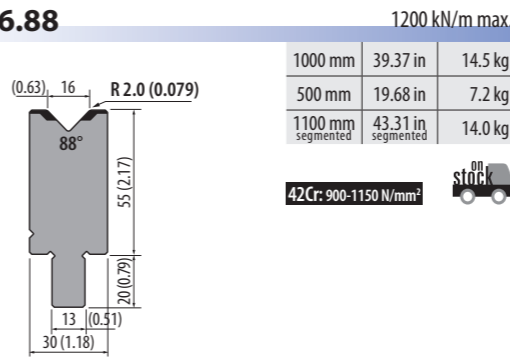
## BMR55.10.88



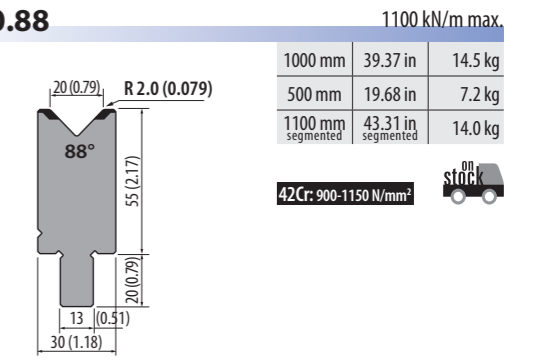
## BMR55.12.88



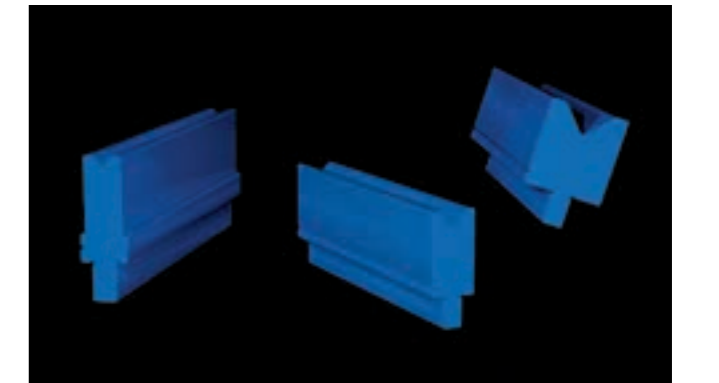
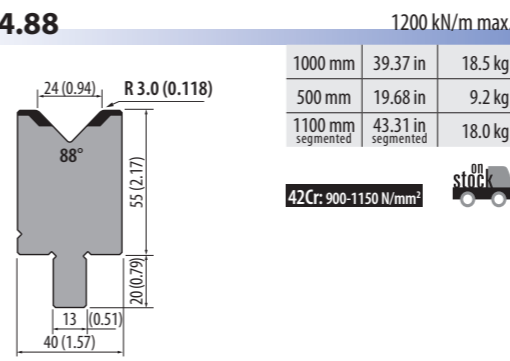
## BMR55.16.88



## BMR55.20.88

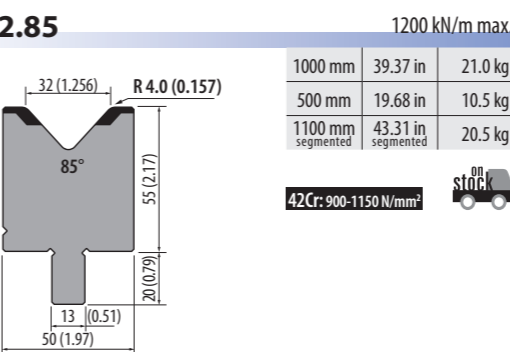


## BMR55.24.88

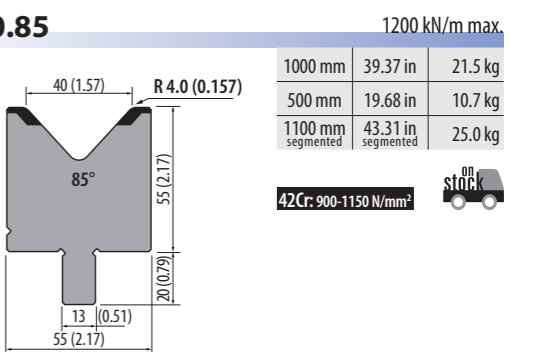


# Dies 85°, H=55 (2.17)

## BMR55.32.85



## BMR55.40.85

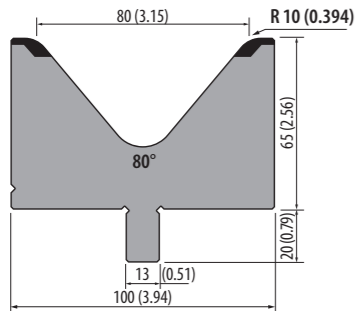


# R3 ROLLERI TYPE R3

Dies 80°, H=65 (2.56) / H=85 (3.35)

## BMR65.80.80

1700 kN/m max.



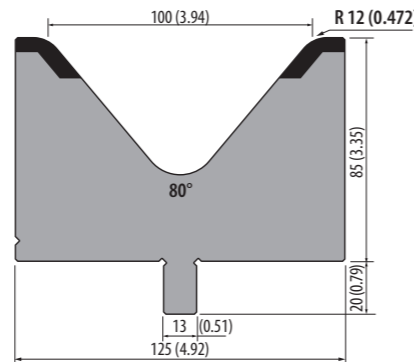
1000 mm	39.37 in	39.0 kg
500 mm	19.68 in	20.0 kg
1100 mm segmented	43.31 in segmented	43.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR85.100.80

2300 kN/m max.



1000 mm	39.37 in	62.0 kg
500 mm	19.68 in	31.0 kg
1100 mm segmented	43.31 in segmented	69.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



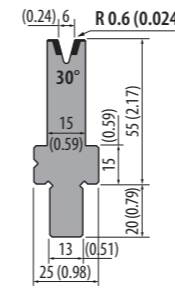
# R3 ROLLERI TYPE R3

Dies 30°, H=55 (2.17), H=60 (2.36)



## BMR55.06.30

350 kN/m max.



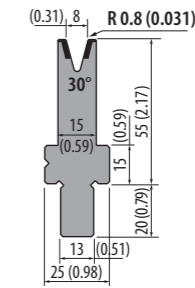
1000 mm	39.37 in	8.0 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	9.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.08.30

200 kN/m max.



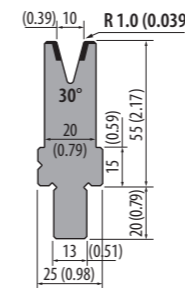
1000 mm	39.37 in	9.2 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	10.1 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.10.30

350 kN/m max.



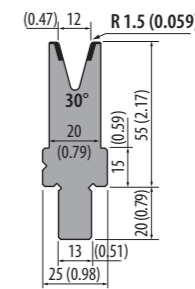
1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.12.30

300 kN/m max.



1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

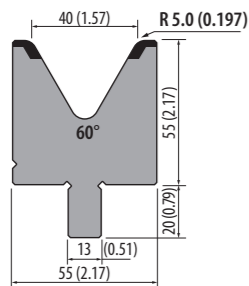
42Cr: 900-1150 N/mm<sup>2</sup>



# Dies 60°, H=55 (2.17), H=65 (2.56)

## BMR55.40.60

1300 kN/m max.



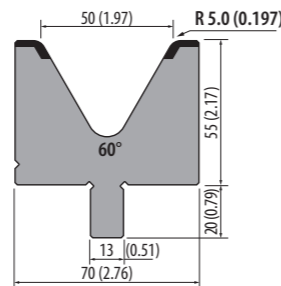
1000 mm	39.37 in	20.3 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	22.3 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.50.60

1200 kN/m max.



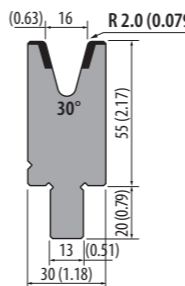
1000 mm	39.37 in	25.0 kg
500 mm	19.68 in	12.0 kg
1100 mm segmented	43.31 in segmented	21.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.16.30

450 kN/m max.



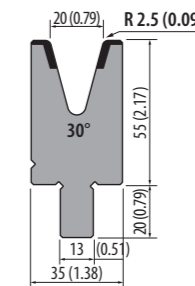
1000 mm	39.37 in	13.5 kg
500 mm	19.68 in	6.7 kg
1100 mm segmented	43.31 in segmented	14.9 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.20.30

500 kN/m max.



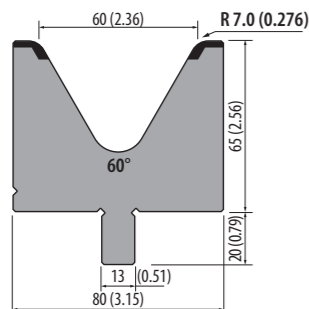
1000 mm	39.37 in	14.0 kg
500 mm	19.68 in	7.0 kg
1100 mm segmented	43.31 in segmented	13.5 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR65.60.60

1100 kN/m max.



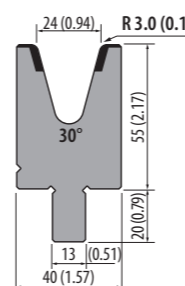
1000 mm	39.37 in	31.0 kg
500 mm	19.68 in	15.5 kg
1100 mm segmented	43.31 in segmented	34.1 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.24.30

550 kN/m max.



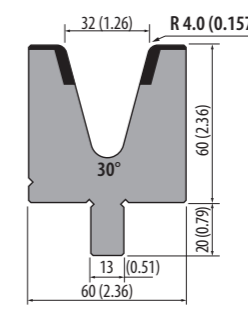
1000 mm	39.37 in	15.5 kg
500 mm	19.68 in	7.8 kg
1100 mm segmented	43.31 in segmented	17.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR60.32.30

650 kN/m max.



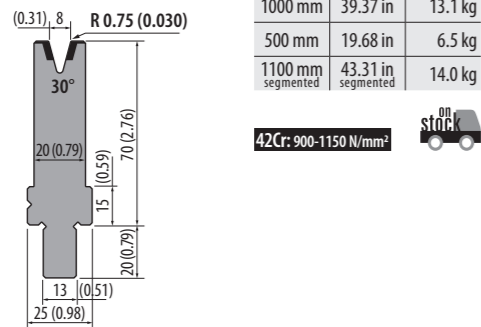
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	22.5 kg

42Cr: 900-1150 N/mm<sup>2</sup>



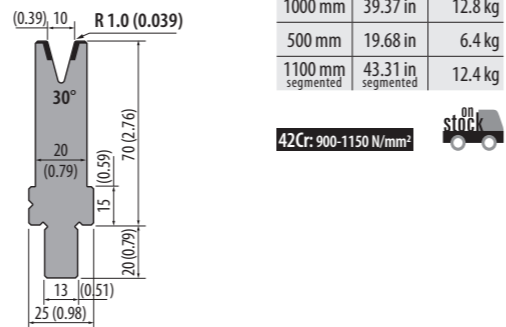
## BMR70.08.30

200 kN/m max.



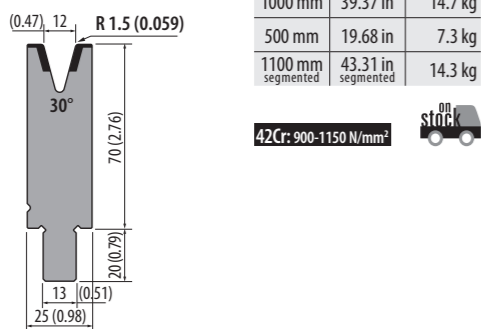
## BMR70.10.30

350 kN/m max.



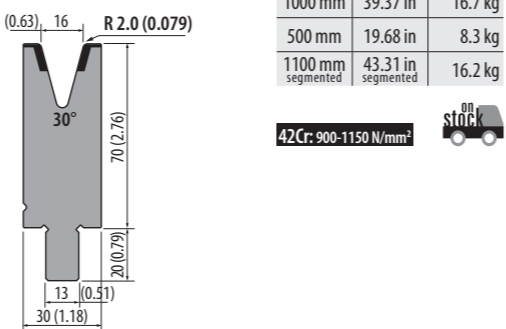
## BMR70.12.30

300 kN/m max.

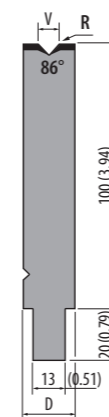


## BMR70.16.30

450 kN/m max.



## 86° Dies, H=100 (3.94)

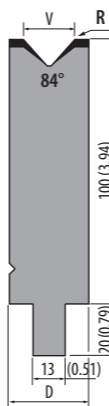


Individual drawings, available lengths and prices see pages 101-103

42Cr: 900-1150 N/mm<sup>2</sup>

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.86	4	0.16	0.6	0.02	20	0.79	450
TMR100.06.86	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.86	8	0.31	0.8	0.03	20	0.79	1150
WMR100.08.86	8	0.31	2.5	0.10	25	0.98	400
TMR100.10.86	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.86	12	0.47	1.0	0.04	25	0.98	1200
WMR100.12.86	12	0.47	2.5	0.10	25	0.98	500
TMR100.16.86	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.86	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.86	24	0.94	2.5	0.10	35	1.38	1200
TMR100.30.86	30	1.18	3.0	0.12	45	1.77	1200
TMR100.40.86	40	1.57	3.0	0.12	55	2.17	1200
TMR100.50.86	50	1.97	3.0	0.12	75	2.95	1500

## 84° Dies, H=100 (3.94)

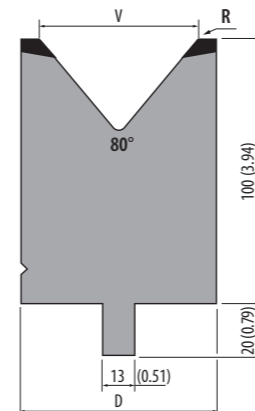


Individual drawings, available lengths and prices see pages 103-104

42Cr: 900-1150 N/mm<sup>2</sup>

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.06.84	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.84	8	0.31	0.8	0.03	20	0.79	1150
TMR100.10.84	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.84	12	0.47	1.0	0.04	25	0.98	1200
TMR100.16.84	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.84	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.84	24	0.94	2.5	0.10	35	1.38	1200

## 80° Dies, H=100 (3.94) / H=120 (4.72)



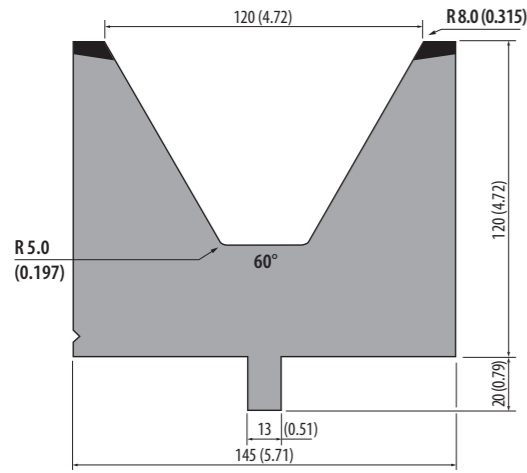
Individual drawings, available lengths and prices see page 105

42Cr: 900-1150 N/mm<sup>2</sup>

Model	V (mm)	V (in)	H (mm)	H (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.60.80	60	2.36	100	3.94	5.0	0.20	75	2.95	1500
TMR100.70.80	70	2.76	100	3.94	5.0	0.20	85	3.35	1500
TMR100.80.80	80	3.15	100	3.94	5.0	0.20	100	3.94	1500
TMR120.90.80	90	3.54	120	4.72	8.0	0.31	110	4.33	1500
TMR120.100.80	100	3.94	120	4.72	8.0	0.31	120	4.72	1500



## 60° Die, H=120 (4.72)

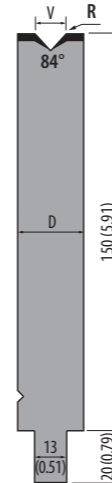


Individual drawings, available lengths and prices see page 106

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR120.120.60	120	4.72	8.0	0.31	145	5.71	1000

42Cr: 900-1150 N/mm<sup>2</sup>

## 84° Dies, H=150 (5.91)

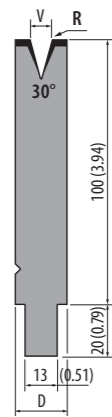


Individual drawings, available lengths and prices see pages 110-111

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.84	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.84	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.84	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.84	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.84	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.84	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.84	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm<sup>2</sup>

## 30° Dies, H=100 (3.94)

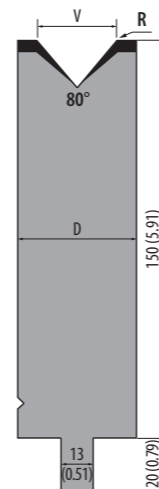


Individual drawings, available lengths and prices see pages 106-108

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.30	4	0.16	0.6	0.02	20	0.79	150
TMR100.06.30	6	0.24	0.6	0.02	20	0.79	400
WMR100.06.30	6	0.24	2.0	0.08	20	0.79	400
TMR100.08.30	8	0.31	1.0	0.04	20	0.79	400
WMR100.08.30	8	0.31	2.5	0.10	20	0.79	400
TMR100.10.30	10	0.39	1.0	0.04	20	0.79	400
WMR100.10.30	10	0.39	2.5	0.10	25	0.98	400
TMR100.12.30	12	0.47	1.0	0.04	25	0.98	400
WMR100.12.30	12	0.47	3.0	0.12	25	0.98	400
TMR100.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR100.20.30	20	0.79	2.0	0.08	30	1.18	600
TMR100.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR100.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR100.40.30	40	1.57	5.0	0.20	60	2.36	900

42Cr: 900-1150 N/mm<sup>2</sup>

## 80° Dies, H=150 (5.91)

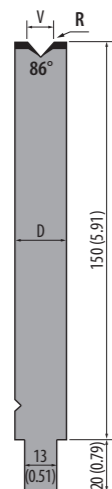


Individual drawings, available lengths and prices see page 112

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.24.80	24	0.94	2.5	0.10	35	1.38	700
TMR150.30.80	30	1.18	5.0	0.20	45	1.77	900
TMR150.40.80	40	1.57	5.0	0.20	55	2.17	1200
TMR150.50.80	50	1.97	5.0	0.20	65	2.56	1500

42Cr: 900-1150 N/mm<sup>2</sup>

## 86° Dies, H=150 (5.91)

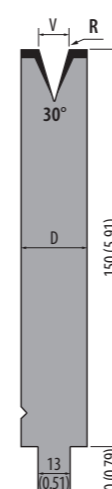


Individual drawings, available lengths and prices see pages 109-110

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.86	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.86	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.86	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.86	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.86	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.86	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.86	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm<sup>2</sup>

## 30° Dies, H=150 (5.91)

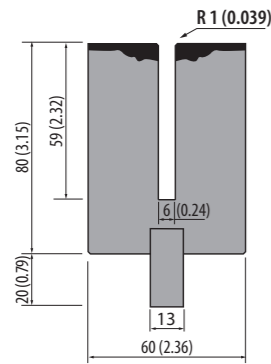


Individual drawings, available lengths and prices see pages 113-114

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.30	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.30	8	0.31	1.0	0.04	20	0.79	400
TMR150.10.30	10	0.39	1.0	0.04	20	0.79	400
TMR150.12.30	12	0.47	1.0	0.04	25	0.98	400
TMR150.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR150.20.30	20	0.79	2.0	0.08	35	1.38	600
TMR150.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR150.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR150.40.30	40	1.57	5.0	0.20	55	2.17	900

42Cr: 900-1150 N/mm<sup>2</sup>

### BPR.SM.195.28.6



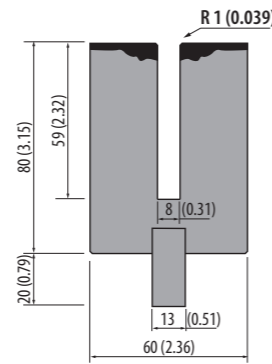
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



Only for thin material!  
Hemming punches  
see page 126

### BPR.SM.195.28.8

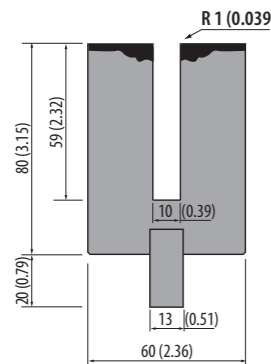


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



### BPR.SM.195.24.10

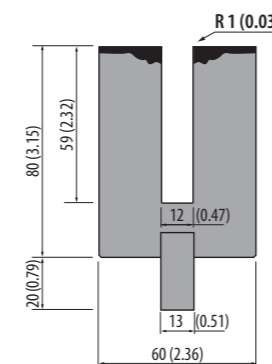


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm<sup>2</sup>



### BPR.SM.195.24.12



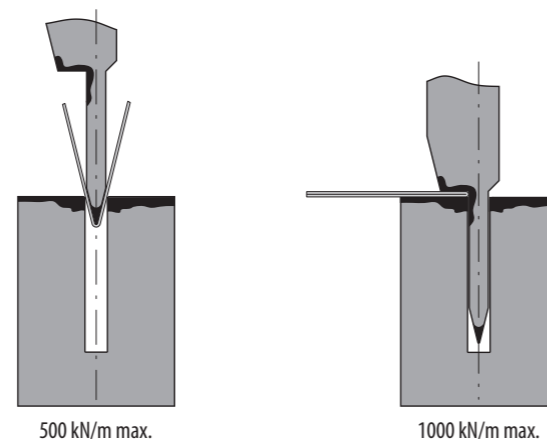
525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	10.8 kg

42Cr: 900-1150 N/mm<sup>2</sup>



### Example of Application

S mm	S in	A mm	A in	R.45 Kg/mm <sup>2</sup> t/m	R.70 Kg/mm <sup>2</sup> t/m	S mm	S in	A mm	A in	R.45 Kg/mm <sup>2</sup> t/m	R.70 Kg/mm <sup>2</sup> t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

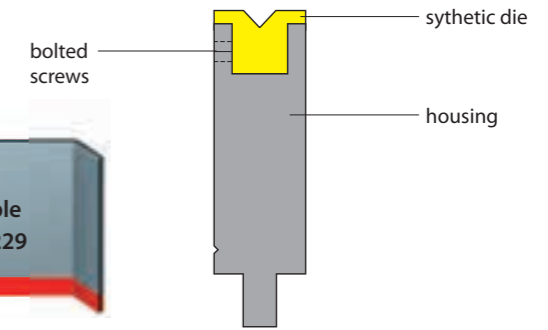


### Our Advantages – Your Convenience

- easy handling
- faster and easier exchange
- preventing bending marks
- decrease of post-processing of bended profiles
- no contact of materials
- higher product quality

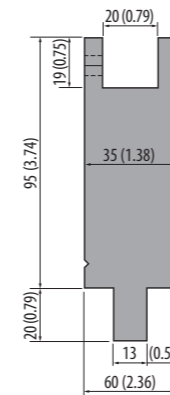
### Mounting example

Synthetic dies will be adjusted into the housing and secured with bolted screws.



More mark-free bending available  
see pages 222-229

### TMN95.20

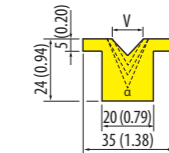


1000 kN/m max.		
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

C45: 560-710 N/mm<sup>2</sup>



### INS20...



200 kN/m max.		
835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg

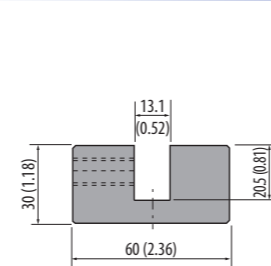


Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

### Die Adapters

#### AD6



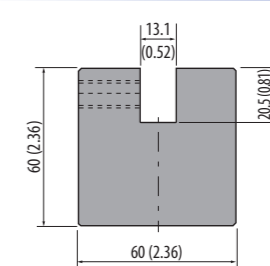
1000 kN/m max.		
1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



#### AD5



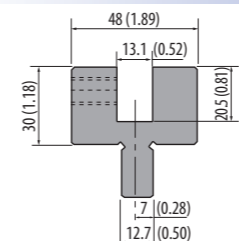
1000 kN/m max.		
1000 mm	39.37 in	26.1 kg
500 mm	19.68 in	13.0 kg

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



#### AD8-12.7



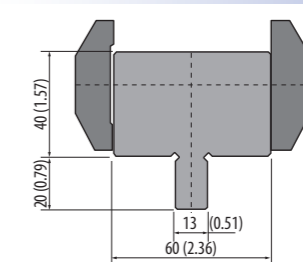
1000 kN/m max.		
1000 mm	39.37 in	15.0 kg
500 mm	19.68 in	7.5 kg

Rolleri Type RX LVD  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



#### AD7



1000 kN/m max.		
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



## TOOLS ROLLERI TYPE RX

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### Compatibility

Tools Roller Type RX are **compatible** with press brake machines from: EHT, Weinbrenner, American, Gasparini, Ajial-Axial, Colgar, LVD, Colly, Hämmerle-Bystronic, etc.

With **Adapter-Systems** the tools Roller Type RX are also applicable on all other press brake machines.



### Compatibility

Tools Rolleri Type RX are:

- compatible with press brake machines from: EHT, Weinbrenner, American, Gasparini, Ajial-Axial, Colgar, LVD, Colly, Hämmerle-Bystronic, etc.
- with Adapter-Systems (see pages 210-221) also applicable on all other press brake machines.

### Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modification possible (see pages 248-253)
- very large stock availability

### Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

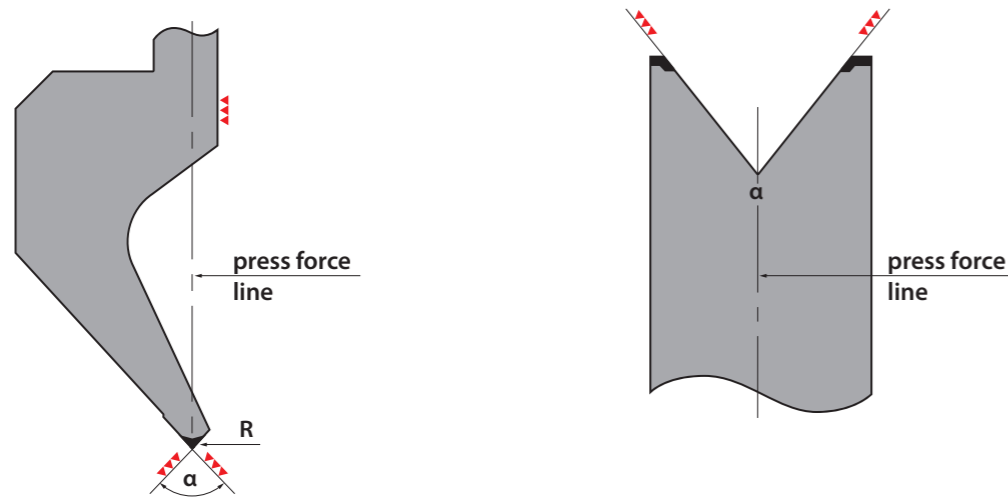
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm <sup>2</sup>	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

### Tang

Punches Rolleri R Type have various tangs.

Indications of precision ground areas:

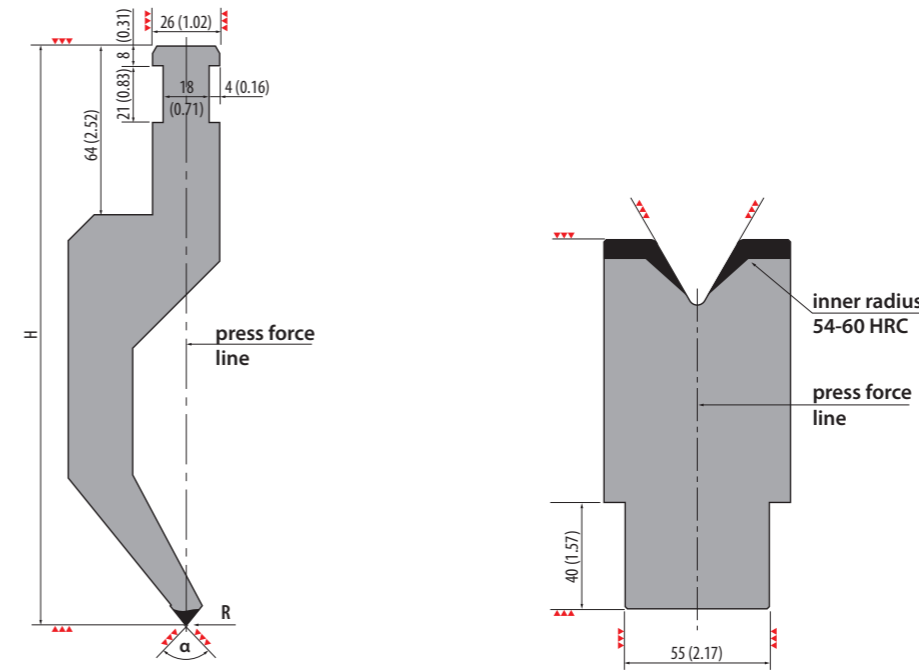


### Tool lengths, sectionings and horn types

- tools Rolleri type RX are available in any length
- customized sectioning available upon your measurements
- customized horn pieces available upon request

### Explanation

We produce for you the Tools Rolleri Type RX EHT in a vast variety – custom, fast, economic and with precision.

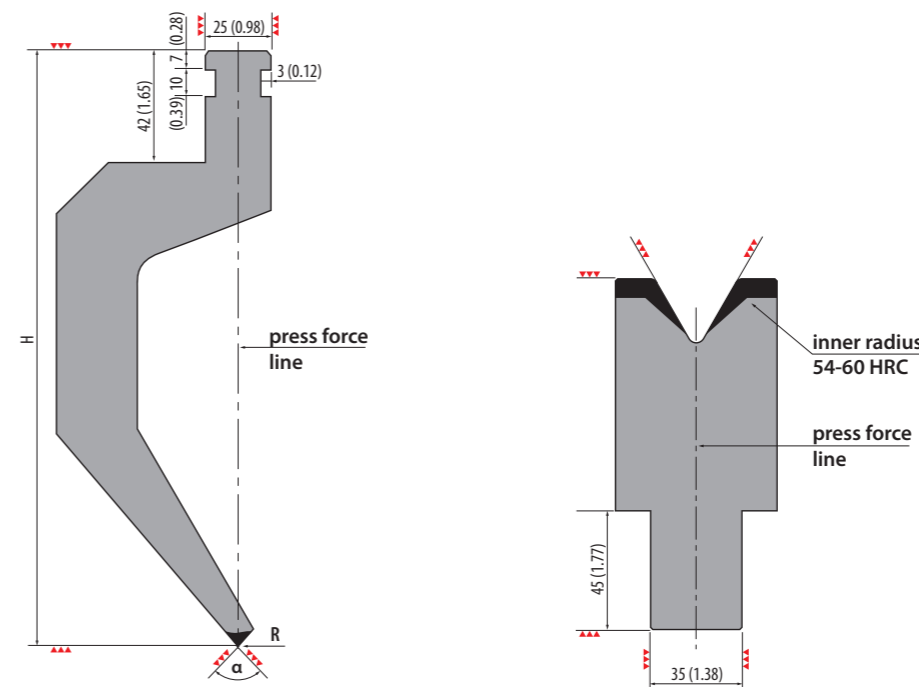


Adapters for Rolleri Type RX EHT see pages 213-220

## Weinbrenner

### Explanation

We produce for you the Tools Rolleri Type RX Weinbrenner in a vast variety – custom, fast, economic and with precision.



Adapters for Rolleri Type RX Weinbrenner see pages 213-221

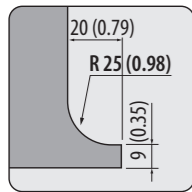
**Tool lengths, sectionings and horn types**

**Punches:**

- 838 mm (33 in)
- 415 mm (16.34 in)
- 805 mm (31.69 in) segmented  
9 segments (100 Horn left, 100, 50, 40, 20, 15, 10, 370, 100 Horn right)

**Dies:**

- 838 mm (33 in)
- 415 mm (16.34 in)
- 805 mm (31.69 in) segmented  
8 segments (200, 50, 40, 20, 15, 10, 370, 100)



**Standard-Horn Type**  
for all segmented  
Punches Rolleri  
Type RX American

**Punches American**

**ASP-135** 900 kN/m max.

<b>ASP-135-16</b>		H=125 (4.92) / R=0.4 (0.016)
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
<b>ASP-135-31</b>		H=125 (4.92) / R=0.8 (0.031)
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
<b>ASP-135-62</b>		H=124.5 (4.90) / R=1.6 (0.062)
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
<b>ASP-135-125</b>		H=123.8 (4.87) / R=3.2 (0.125)
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg

C45: 560-710 N/mm<sup>2</sup>

**ASP-24** 700 kN/m max.

<b>ASP-24-16</b>		H=127 (5.00) / R=0.4 (0.016)
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
<b>ASP-24-31</b>		H=127 (5.00) / R=0.8 (0.031)
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
<b>ASP-24-62</b>		H=126.5 (4.98) / R=1.6 (0.062)
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
<b>ASP-24-125</b>		H=125.9 (4.96) / R=3.2 (0.125)
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

Please find the  
Punch Adapters in  
the adapter chapter  
on page 215

**ASP-9** 660 kN/m max.

<b>ASP-9-16</b>		H=96 (3.78) / R=0.4 (0.016)
838 mm	33.00 in	12.8 kg
415 mm	16.34 in	6.2 kg
805 mm segmented	31.69 in segmented	12.1 kg
<b>ASP-9-31</b>		H=96 (3.78) / R=0.8 (0.031)
838 mm	33.00 in	12.8 kg
415 mm	16.34 in	6.2 kg
805 mm segmented	31.69 in segmented	12.1 kg
<b>ASP-9-63</b>		H=95.5 (3.76) / R=1.6 (0.062)
838 mm	33.00 in	12.8 kg
415 mm	16.34 in	6.2 kg
805 mm segmented	31.69 in segmented	12.1 kg
<b>ASP-9-125</b>		H=94.8 (3.73) / R=3.2 (0.125)
838 mm	33.00 in	12.8 kg
415 mm	16.34 in	6.2 kg
805 mm segmented	31.69 in segmented	12.1 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**ASP-15** 1000 kN/m max.

<b>ASP-15-16</b>		H=95.9 (3.78) / R=0.4 (0.016)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg
<b>ASP-15-31</b>		H=95.9 (3.78) / R=0.8 (0.031)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg
<b>ASP-15-63</b>		H=95.9 (3.78) / R=1.6 (0.063)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg
<b>ASP-15-98</b>		H=95.9 (3.78) / R=2.5 (0.098)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg
<b>ASP-15-125</b>		H=96 (3.78) / R=3.2 (0.125)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**ASP-14** 1000 kN/m max.

<b>ASP-14-16</b>		H=127 (5.00) / R=0.4 (0.016)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg
<b>ASP-14-31</b>		H=127 (5.00) / R=0.8 (0.031)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg
<b>ASP-14-62</b>		H=126.5 (4.98) / R=1.6 (0.062)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg
<b>ASP-14-125</b>		H=126 (4.96) / R=3.2 (0.125)
838 mm	33.00 in	13.4 kg
415 mm	16.34 in	6.6 kg
805 mm segmented	31.69 in segmented	12.9 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**ASP-18** 1000 kN/m max.

<b>ASP-18-31</b>		H=96 (3.78) / R=0.8 (0.031)
838 mm	33.00 in	10.9 kg
415 mm	16.34 in	5.4 kg
805 mm segmented	31.69 in segmented	10.5 kg
<b>ASP-18-62</b>		H=93.4 (3.68) / R=1.6 (0.062)
838 mm	33.00 in	10.9 kg
415 mm	16.34 in	5.4 kg
805 mm segmented	31.69 in segmented	10.5 kg
<b>ASP-18-125</b>		H=87.5 (3.44) / R=3.2 (0.125)
838 mm	33.00 in	10.9 kg
415 mm	16.34 in	5.4 kg
805 mm segmented	31.69 in segmented	10.5 kg

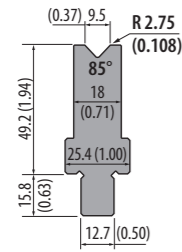
42Cr: 900-1150 N/mm<sup>2</sup>

**ASP-19** 860 kN/m max.

<b>ASP-19-31</b>		H=127 (5.00) / R=0.8 (0.031)
838 mm	33.00 in	13.8 kg
415 mm	16.34 in	6.8 kg
805 mm segmented	31.69 in segmented	13.3 kg
<b>ASP-19-62</b>		H=124.5 (4.90) / R=1.6 (0.062)
838 mm	33.00 in	13.8 kg
415 mm	16.34 in	6.8 kg
805 mm segmented	31.69 in segmented	13.3 kg
<b>ASP-19-125</b>		H=118.5 (4.67) / R=3.2 (0.125)
838 mm	33.00 in	13.8 kg
415 mm	16.34 in	6.8 kg
805 mm segmented	31.69 in segmented	13.3 kg

42Cr: 900-1150 N/mm<sup>2</sup>

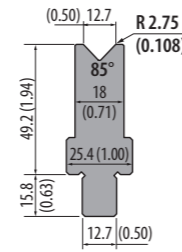
**ASD-85-375** 1000 kN/m max.



838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

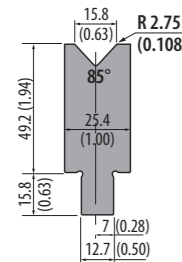
**ASD-85-500** 1000 kN/m max.



838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

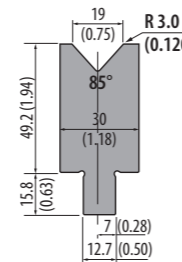
**ASD-85-625** 1000 kN/m max.



838 mm	33.00 in	9.2 kg
415 mm	16.34 in	4.6 kg
805 mm segmented	31.69 in segmented	8.9 kg

42Cr: 900-1150 N/mm<sup>2</sup>

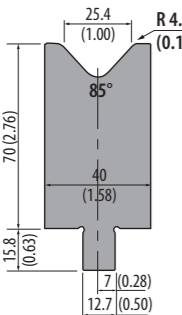
**ASD-85-750** 1080 kN/m max.



838 mm	33.00 in	10.5 kg
415 mm	16.34 in	5.2 kg
805 mm segmented	31.69 in segmented	10.1 kg

42Cr: 900-1150 N/mm<sup>2</sup>

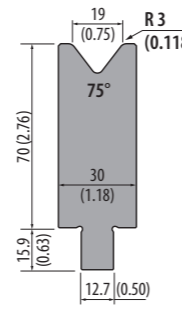
**ASD-85-100** 950 kN/m max.



838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	19.9 kg

42Cr: 900-1150 N/mm<sup>2</sup>

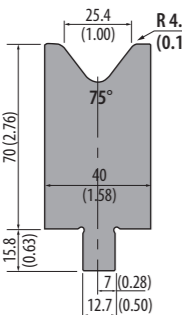
**ASD-75-750** 1000 kN/m max.



838 mm	33.00 in	14.7 kg
415 mm	16.34 in	7.3 kg
805 mm segmented	31.69 in segmented	14.1 kg

C45: 560-710 N/mm<sup>2</sup>

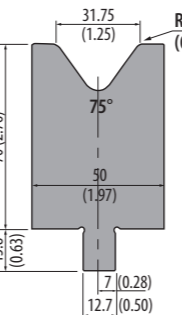
**ASD-75-100** 950 kN/m max.



838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

C45: 560-710 N/mm<sup>2</sup>

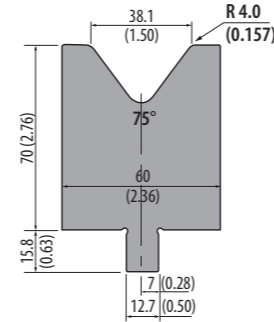
**ASD-75-125** 1000 kN/m max.



838 mm	33.00 in	22.2 kg
415 mm	16.34 in	11.0 kg
805 mm segmented	31.69 in segmented	21.3 kg

C45: 560-710 N/mm<sup>2</sup>

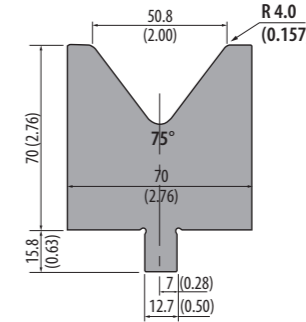
**ASD-75-150** 1000 kN/m max.



838 mm	33.00 in	25.6 kg
415 mm	16.34 in	12.7 kg
805 mm segmented	31.69 in segmented	24.6 kg

C45: 560-710 N/mm<sup>2</sup>

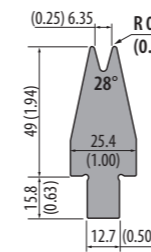
**ASD-75-200** 1000 kN/m max.



838 mm	33.00 in	27.7 kg
415 mm	16.34 in	13.7 kg
805 mm segmented	31.69 in segmented	25.6 kg

C45: 560-710 N/mm<sup>2</sup>

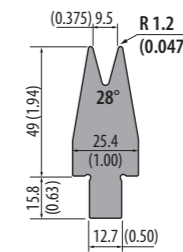
**ASD-28-250** 450 kN/m max.



838 mm	33.00 in	7.2 kg
415 mm	16.34 in	3.6 kg
805 mm segmented	31.69 in segmented	6.9 kg

42Cr: 900-1150 N/mm<sup>2</sup>

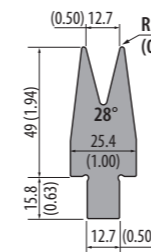
**ASD-28-375** 600 kN/m max.



838 mm	33.00 in	7.8 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.5 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**ASD-28-500** 860 kN/m max.



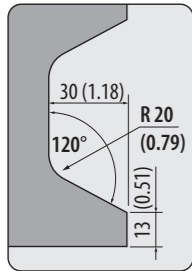
838 mm	33.00 in	8.4 kg
415 mm	16.34 in	4.2 kg
805 mm segmented	31.69 in segmented	8.1 kg

42Cr: 900-1150 N/mm<sup>2</sup>

## Tool lengths, sectionings and horn types

### Punches:

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented  
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 500 mm (19.68 in) segmented  
3 segments (100 Horn left, 300, 100 Horn right)



Standard-Horn Type  
for all segmented  
Punches Rolleri  
Type RX Gasparini

### Radius Tools Holder:

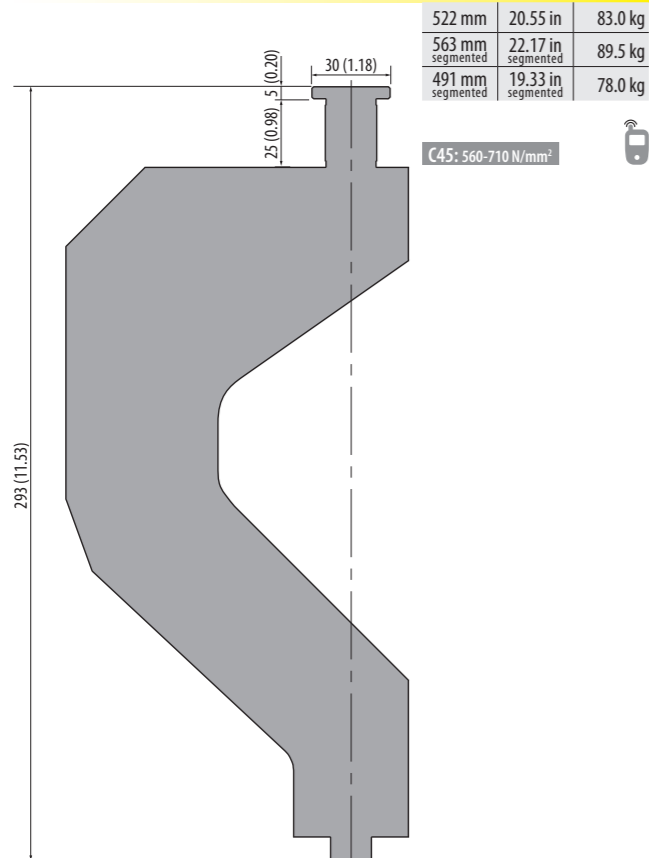
- 522 mm (20.55 in)
- 563 mm (22.17 in) segmented  
9 segments (42, 47, 52, 57, 62, 67, 72, 77, 87)
- 491 mm (19.33 in) segmented  
3 segments (97, 297, 97)

### Radius Tools:

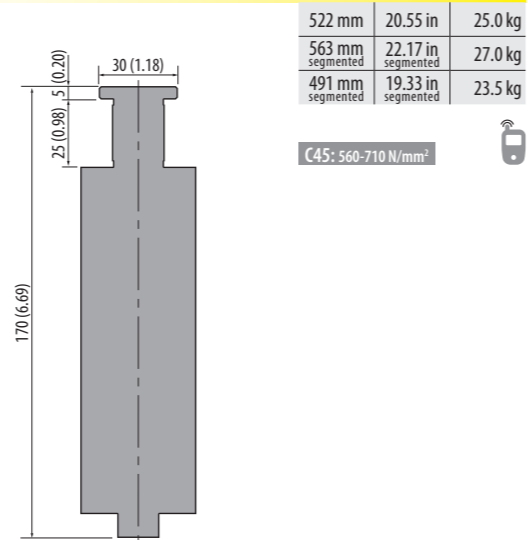
- 525 mm (20.67 in)
- 590 mm (23.23 in) segmented  
9 segments (45, 50, 55, 60, 65, 70, 75, 80, 90)
- 500 mm (19.68 in) segmented  
3 segments (100, 300, 100)

## Radius Tools Gasparini

### GASP293-16 1000 kN/m max.



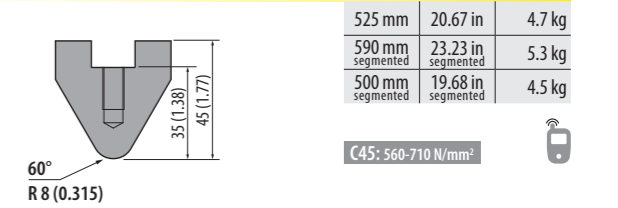
### GASP170-16 1800 kN/m max.



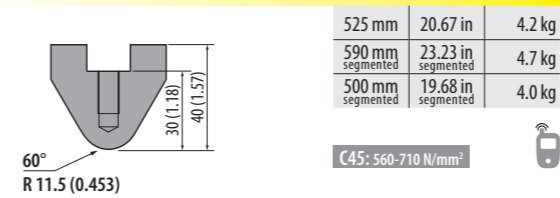
### GASP40.60.03 1000 kN/m max.



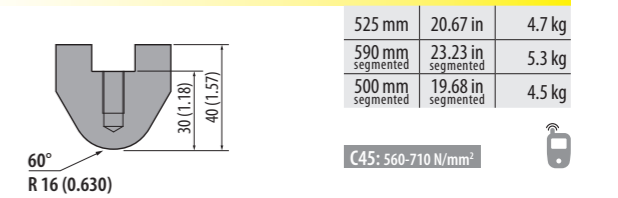
### GASP35.60.08 1000 kN/m max.



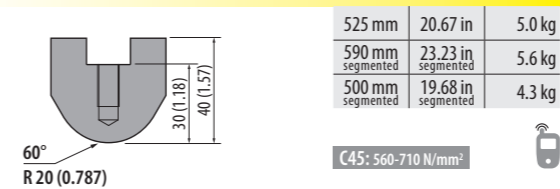
### GASP30.60.11.5 1000 kN/m max.



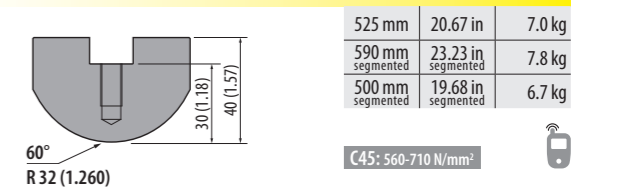
### GASP30.60.16 1000 kN/m max.



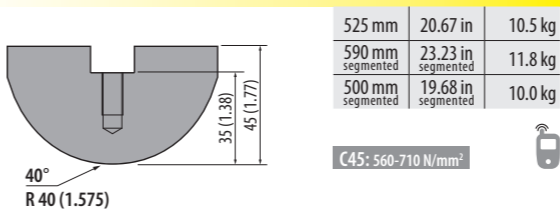
### GASP30.60.20 1000 kN/m max.



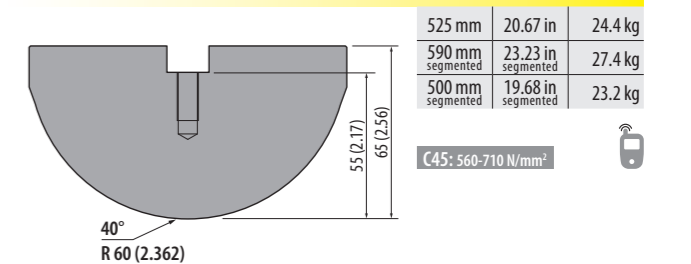
### GASP30.60.32 1000 kN/m max.



### GASP35.40.40 1500 kN/m max.



### GASP55.40.60 1800 kN/m max.

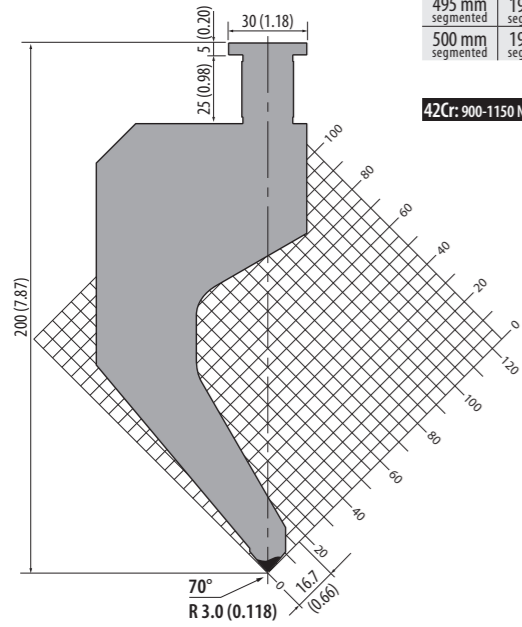


### GASP200.70.R3-30

1000 kN/m max.

525 mm	20.67 in	31.8 kg
495 mm segmented	19.49 in segmented	30.0 kg
500 mm segmented	19.68 in segmented	30.3 kg

42Cr: 900-1150 N/mm<sup>2</sup>



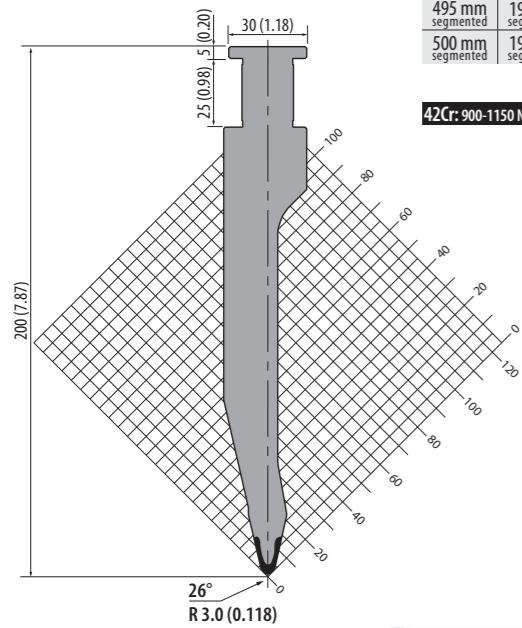
Many more tools available for Heavy Duty on pages 234-235

### GASP200.26.R3-30

1300 kN/m max.

525 mm	20.67 in	16.9 kg
495 mm segmented	19.49 in segmented	10.6 kg
500 mm segmented	19.68 in segmented	10.7 kg

42Cr: 900-1150 N/mm<sup>2</sup>

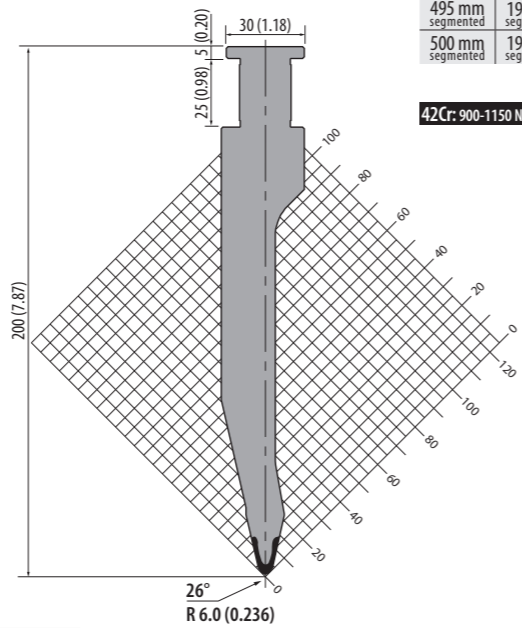


### GASP200.26.R6-30

1300 kN/m max.

525 mm	20.67 in	16.9 kg
495 mm segmented	19.49 in segmented	10.6 kg
500 mm segmented	19.68 in segmented	10.7 kg

42Cr: 900-1150 N/mm<sup>2</sup>

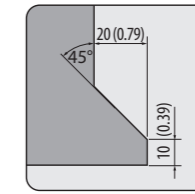


Many more tools available upon request. Compatible adapters see pages 213 and 217

### Tool lengths, sectionings and horn types

Punches:

- 1020 mm (40.16 in)
- 990 mm (38.98 in) segmented  
9 segments (100 Horn left, 500, 100, 50, 45, 40, 35, 20, 100 Horn right)



Standard-Horn Type for all segmented Punches Rolleri Type RX Ajial-Axial

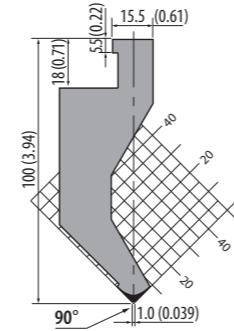
### Punches Ajial-Axial

#### AXP.100.90.1

1000 kN/m max.

1020 mm	40.16 in	16.3 kg
990 mm segmented	38.98 in segmented	15.8 kg

C45: 560-710 N/mm<sup>2</sup>

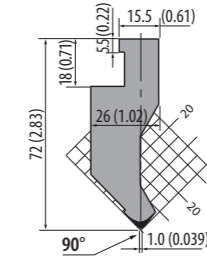


#### AXP.72.90.1

1000 kN/m max.

1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm<sup>2</sup>

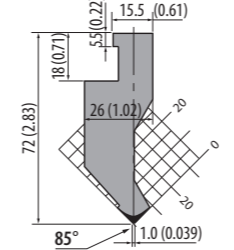


#### AXP.72.85.1

1000 kN/m max.

1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm<sup>2</sup>

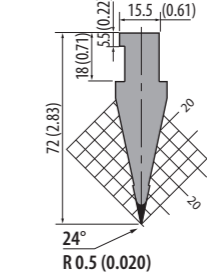


#### AXP.72.24.R05

1000 kN/m max.

1020 mm	40.16 in	7.1 kg
990 mm segmented	38.98 in segmented	6.9 kg

C45: 560-710 N/mm<sup>2</sup>



### Adapters Ajial-Axial

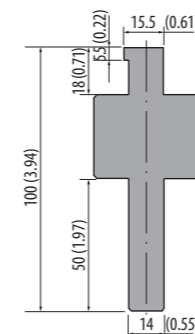
#### AD15

1000 kN/m max.

150 mm	5.91 in	4.0 kg
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Rolleri Type RX Ajial-Axial → Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



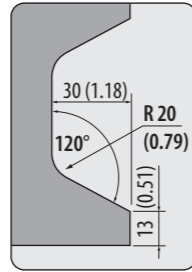
More Punches and Dies available upon request. Compatible Adapter see pages 217



**Tool lengths, sectionings and horn types**

**Punches:**

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented  
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 500 mm (19.68 in) segmented  
3 segments (100 Horn left, 300, 100 Horn right)



**Standard-Horn Type**  
for all segmented  
**Punches Rolleri**  
**Type RX Colgar**



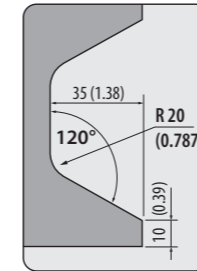
**Tool lengths, sectionings and horn types**

**Punches:**

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented  
9 segments  
(100 Horn left, 25, 30, 35, 40, 45, 50, 125, 100 Horn right)

**Dies:**

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented  
9 segments (25, 25, 30, 35, 40, 45, 50, 100, 200)



**Standard-Horn Type**  
for all segmented  
**Punches Rolleri**  
**Type RX LVD**

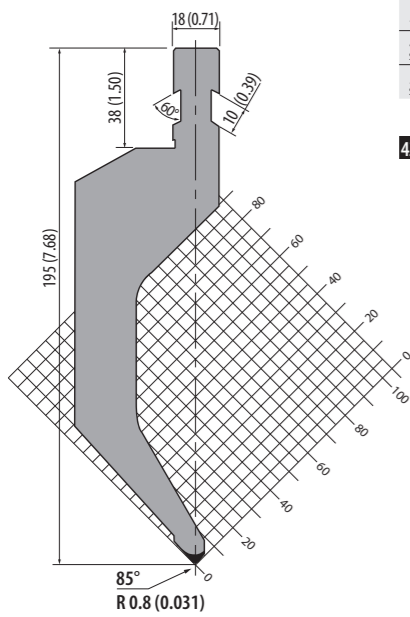
**Hemming Tools:**

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented  
8 segments (25, 30, 35, 40, 45, 50, 100, 170)

**Punches and Radius Tools Colgar**

**PAC195.85.R08**

1000 kN/m max.

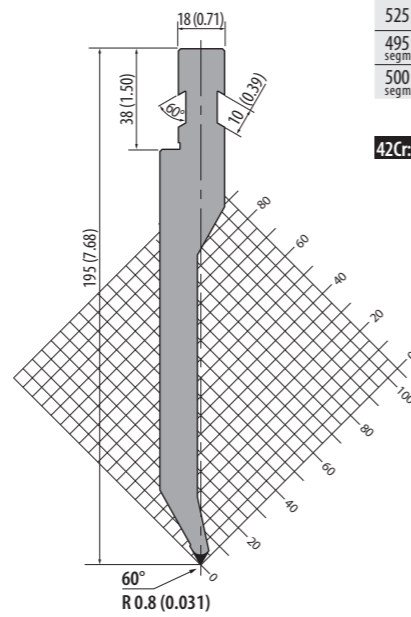


525 mm	20.67 in	20.6 kg
495 mm segmented	19.49 in segmented	19.4 kg
500 mm segmented	19.68 in segmented	19.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**PAC195.60.R08**

1000 kN/m max.

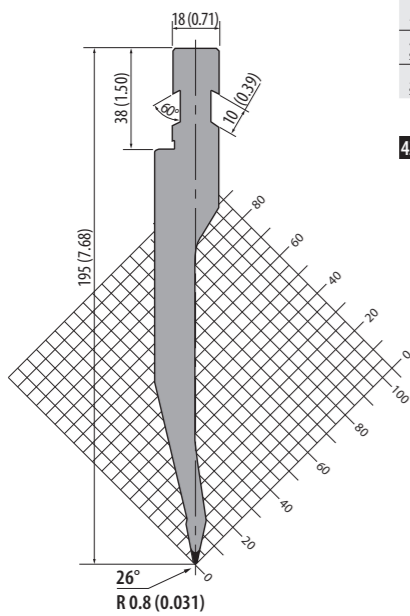


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**PAC195.26.R08**

1000 kN/m max.



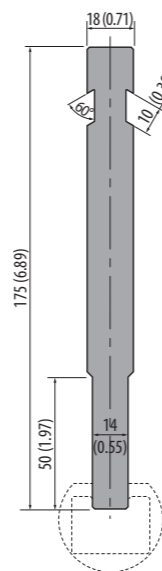
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm<sup>2</sup>

More Punches and Dies  
available upon request.  
Compatible adapter  
see pages 213, 216

**PAC175.14**

1000 kN/m max.



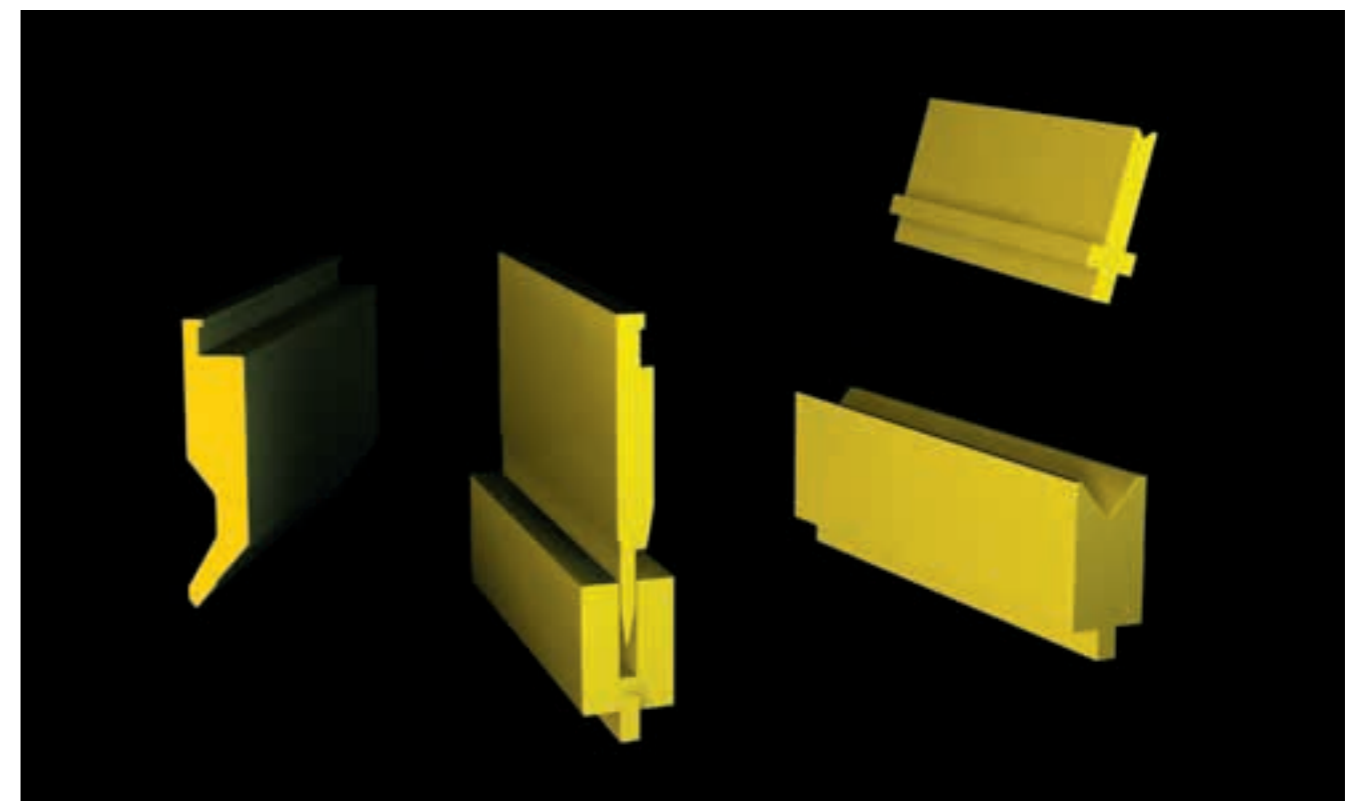
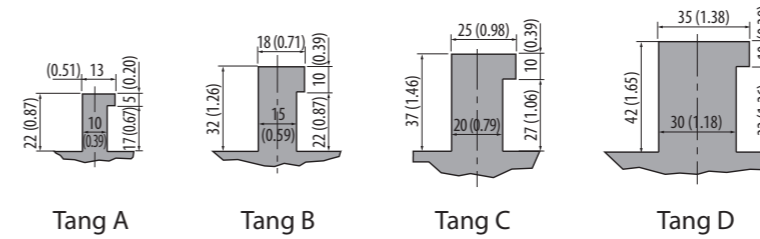
830 mm	32.68 in	18.0 kg
412 mm	16.22 in	9.0 kg

C45: 560-710 N/mm<sup>2</sup>

Compatible  
Radius holders  
see page 33

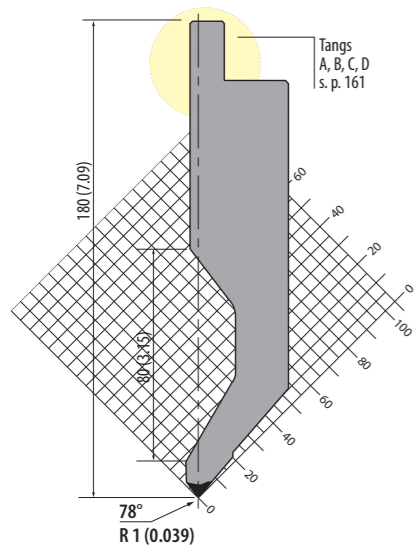
**Punch Tangs**

Punches LVD have the following  
4 different tangs



**LP180.78.R1-A**

700 kN/m max.

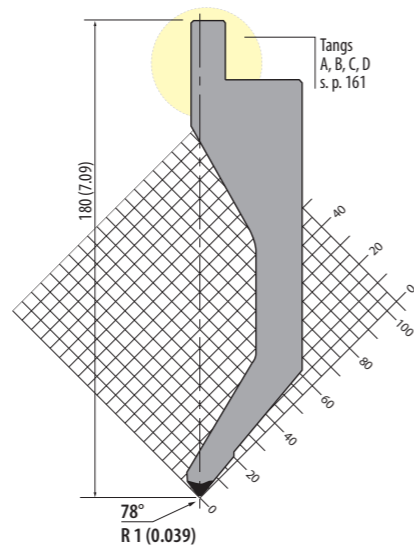


Tang A: LPA180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg
Tang B: LPB180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg
Tang C: LPC180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg
Tang D: LPD180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LP180.78.R1-B**

450 kN/m max.

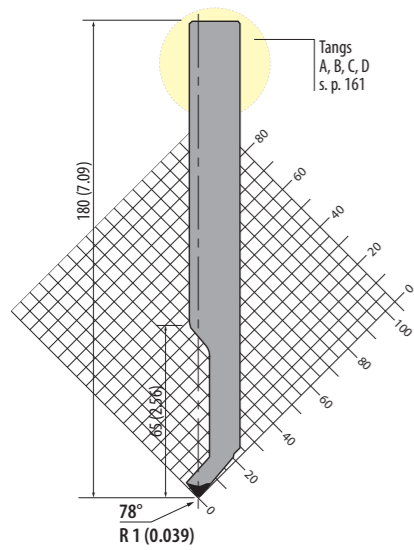


Tang A: LPA180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg
Tang B: LPB180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg
Tang C: LPC180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg
Tang D: LPD180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LP180.78.R1-C**

500 kN/m max.

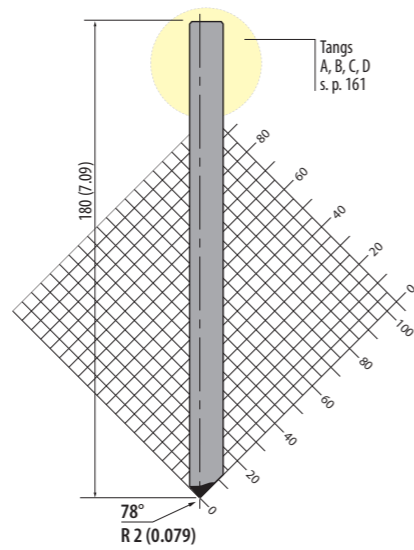


Tang A: LPA180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg
Tang B: LPB180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg
Tang C: LPC180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg
Tang D: LPD180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LP180.78-R2**

1000 kN/m max.

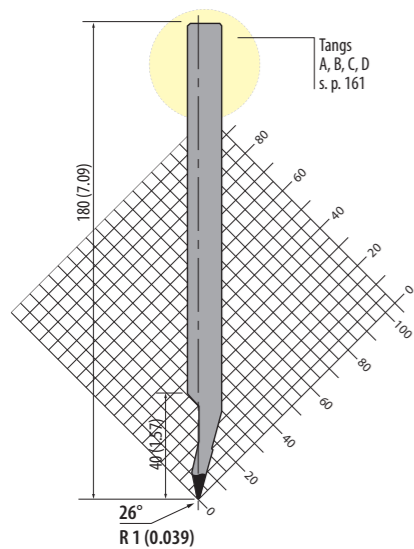


Tang A: LPA180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg
Tang B: LPB180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg
Tang C: LPC180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg
Tang D: LPD180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg

42Cr: 900-1150 N/mm<sup>2</sup>

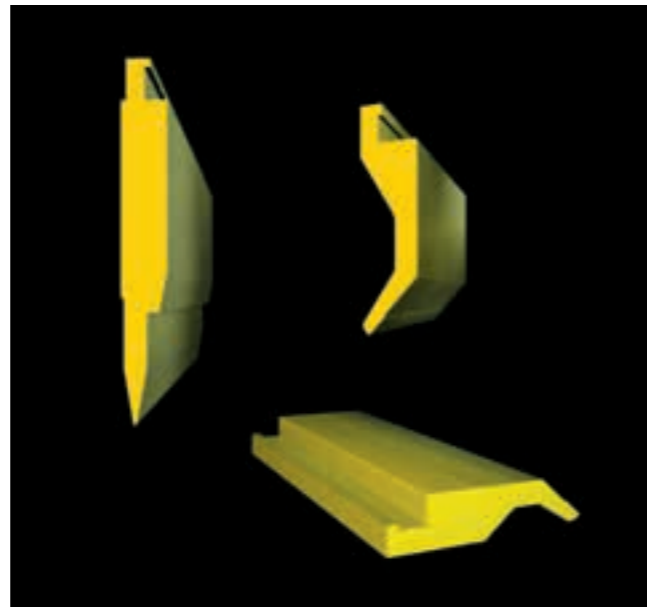
**LP180.26-R1**

500 kN/m max.

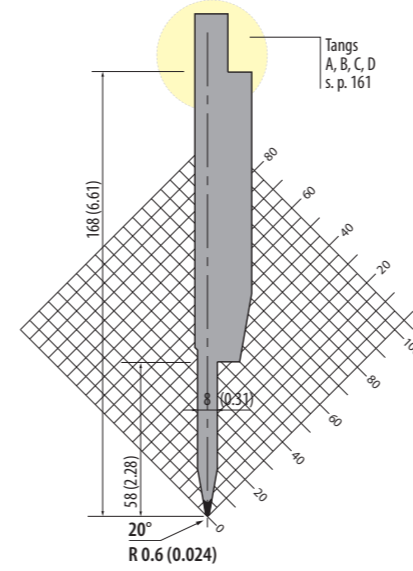


Tang A: LPA180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
Tang B: LPB180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
Tang C: LPC180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
Tang D: LPD180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>



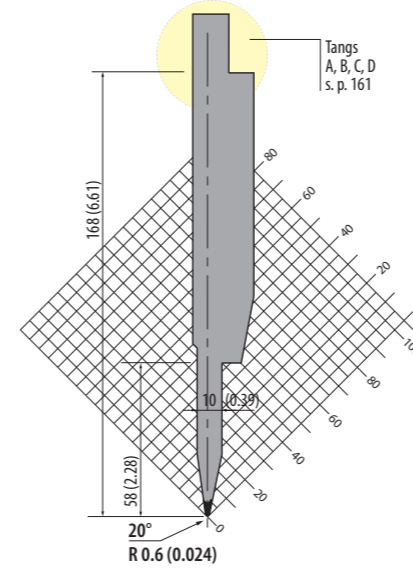
**LP.SP-190.20.8**



Tang A: LPA.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg
Tang B: LPB.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg
Tang C: LPC.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg
Tang D: LPD.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

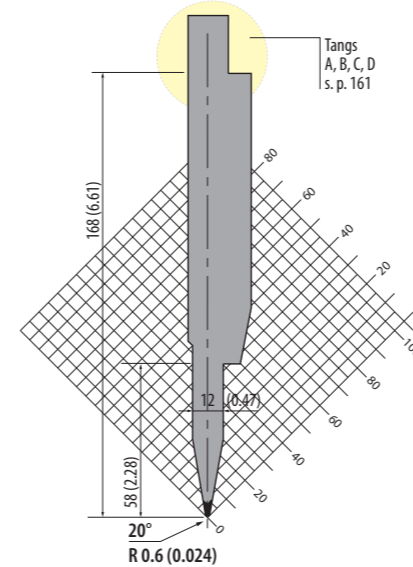
**LP.SP-190.20.10**



Tang A: LPA.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg
Tang B: LPB.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg
Tang C: LPC.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg
Tang D: LPD.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg

42Cr: 900-1150 N/mm<sup>2</sup>

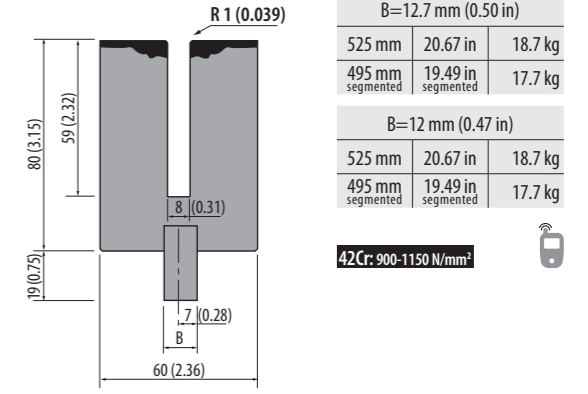
**LP.SP-190.20.12**



Tang A: LPA.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg
Tang B: LPB.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg
Tang C: LPC.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg
Tang D: LPD.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg

42Cr: 900-1150 N/mm<sup>2</sup>

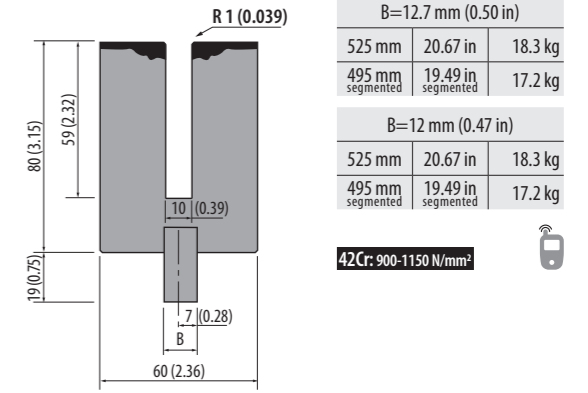
**LP.SM-190.20.8-12.7 / -12**



B=12.7 mm (0.50 in)		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg
B=12 mm (0.47 in)		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg

42Cr: 900-1150 N/mm<sup>2</sup>

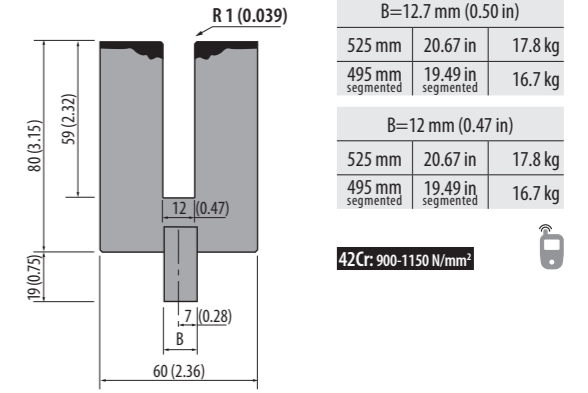
**LP.SM-190.20.10-12.7 / -12**



B=12.7 mm (0.50 in)		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg
B=12 mm (0.47 in)		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LP.SM-190.20.12-12.7 / -12**



B=12.7 mm (0.50 in)		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg
B=12 mm (0.47 in)		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg

42Cr: 900-1150 N/mm<sup>2</sup>

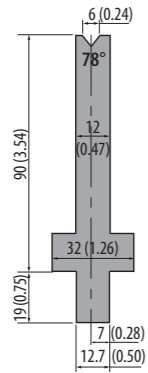
**Example of Application**

Diagram showing the application of the punch on a metal sheet. The force applied is 500 kN/m max. and 1000 kN/m max. The punch is shown in two positions, one for 500 kN/m max. and one for 1000 kN/m max. The punch is shown in two positions, one for 500 kN/m max. and one for 1000 kN/m max. The punch is shown in two positions, one for 500 kN/m max. and one for 1000 kN/m max.

S	S	A	A	R.45	R.70	S	S	A	A	R.45	R.70
mm	in	mm	in	Kgf/mm <sup>2</sup>	Kgf/mm <sup>2</sup>	mm	in	mm	in	Kgf/mm <sup>2</sup>	Kgf/mm <sup>2</sup>
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

**LM90.06.78**

400 kN/m max.

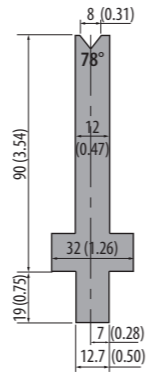


508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.08.78**

400 kN/m max.

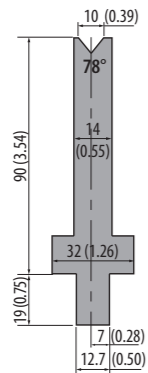


508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.10.78**

500 kN/m max.

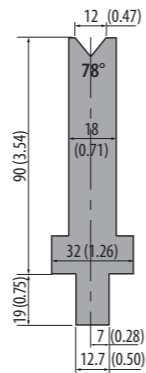


508 mm	20.00 in	7.0 kg
550 mm segmented	21.65 in segmented	7.5 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.12.78**

600 kN/m max.

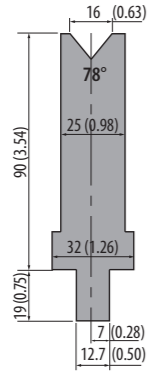


508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.7 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.16.78**

800 kN/m max.

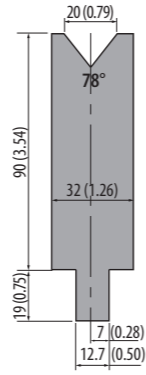


508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.20.78**

1000 kN/m max.

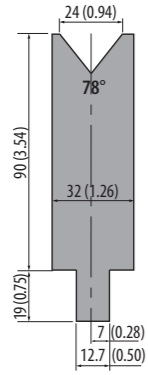


508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.8 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.24.78**

1000 kN/m max.

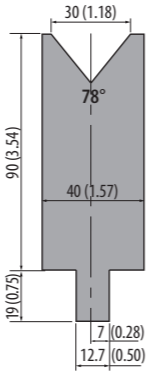


508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.30.78**

1100 kN/m max.

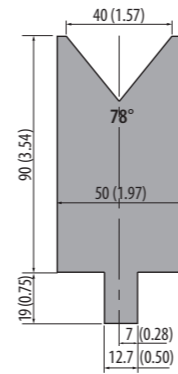


508 mm	20.00 in	12.0 kg
550 mm segmented	21.65 in segmented	13.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.40.78**

1300 kN/m max.

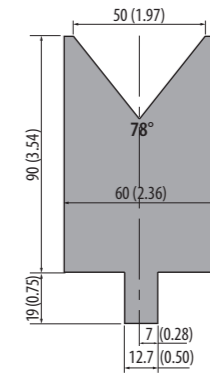


508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.50.78**

1500 kN/m max.

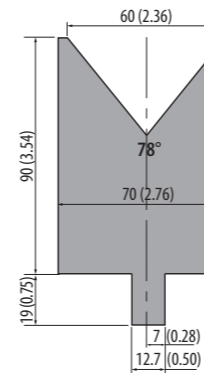


508 mm	20.00 in	19.5 kg
550 mm segmented	21.65 in segmented	21.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.60.78**

1500 kN/m max.

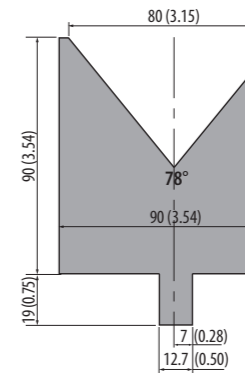


508 mm	20.00 in	23.0 kg
550 mm segmented	21.65 in segmented	24.9 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.80.78**

1500 kN/m max.

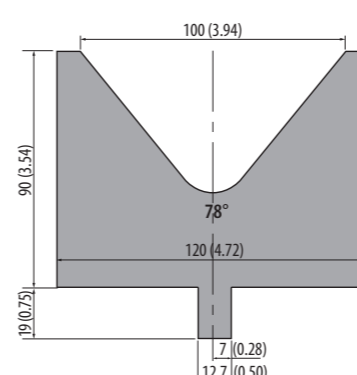


508 mm	20.00 in	25.5 kg
550 mm segmented	21.65 in segmented	27.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.100.78**

1200 kN/m max.



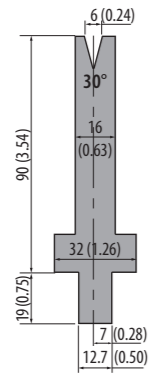
508 mm	20.00 in	31.0 kg
550 mm segmented	21.65 in segmented	33.5 kg

42Cr: 900-1150 N/mm<sup>2</sup>

**NEW**

Articles on stock – Please note that delivery time varies according to your location.

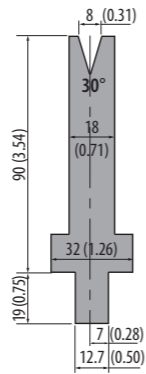
### LM90.06.30 200 kN/m max.



508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

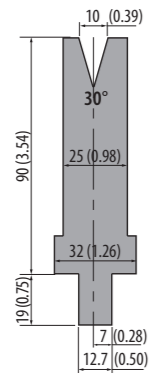
### LM90.08.30 220 kN/m max.



508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

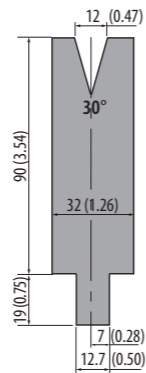
### LM90.10.30 300 kN/m max.



508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

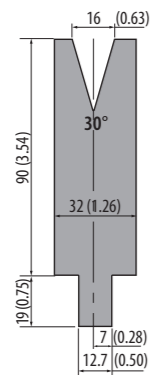
### LM90.12.30 380 kN/m max.



508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.6 kg

42Cr: 900-1150 N/mm<sup>2</sup>

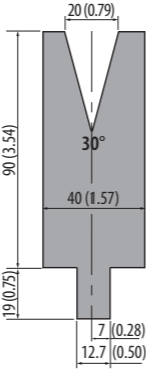
### LM90.16.30 380 kN/m max.



508 mm	20.00 in	11.5 kg
550 mm segmented	21.65 in segmented	12.4 kg

42Cr: 900-1150 N/mm<sup>2</sup>

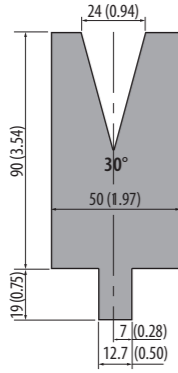
### LM90.20.30 380 kN/m max.



508 mm	20.00 in	13.8 kg
550 mm segmented	21.65 in segmented	15.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

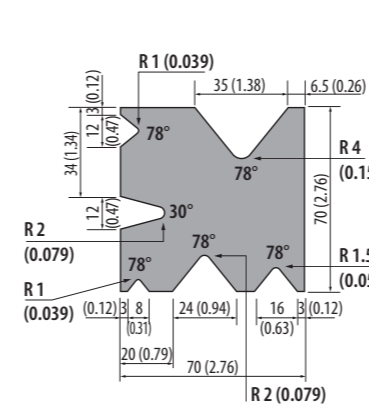
### LM90.24.30 550 kN/m max.



508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg

42Cr: 900-1150 N/mm<sup>2</sup>

### LM70

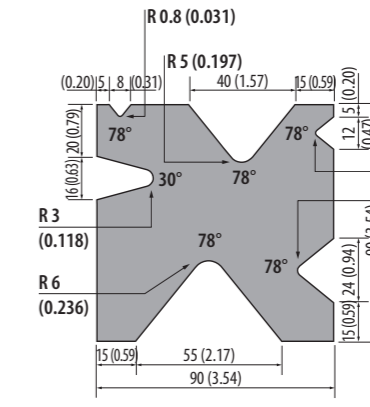


508 mm	20.00 in	16.8 kg
550 mm segmented	21.65 in segmented	18.2 kg

42Cr: 900-1150 N/mm<sup>2</sup>

	V1	V2	V3	V4	V5	V6
V mm (in)	12 (0.47)	12 (0.47)	35 (1.38)	24 (0.94)	16 (0.63)	8 (0.31)
Angle	30°	78°	78°	78°	78°	78°
kN/m max.	1300	600	1300	1200	950	500

### LM90

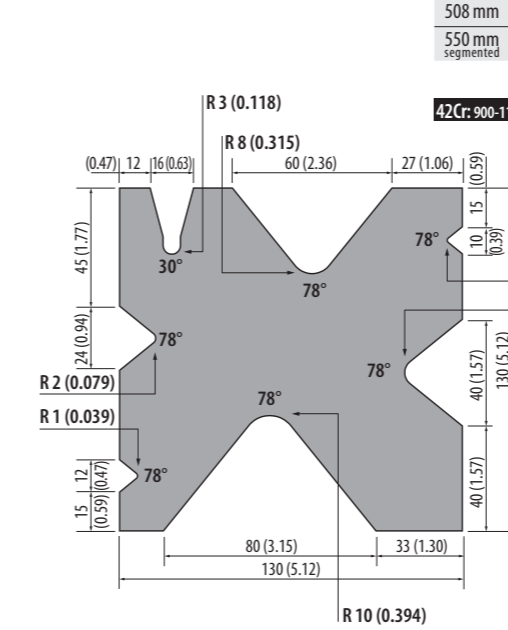


508 mm	20.00 in	25.4 kg
550 mm segmented	21.65 in segmented	27.5 kg

42Cr: 900-1150 N/mm<sup>2</sup>

	V1	V2	V3	V4	V5	V6
V mm (in)	8 (0.31)	40 (1.57)	12 (0.47)	24 (0.94)	55 (2.17)	16 (0.63)
Angle	78°	78°	78°	78°	78°	30°
kN/m max.	550	1400	550	650	1000	1000

### LM130

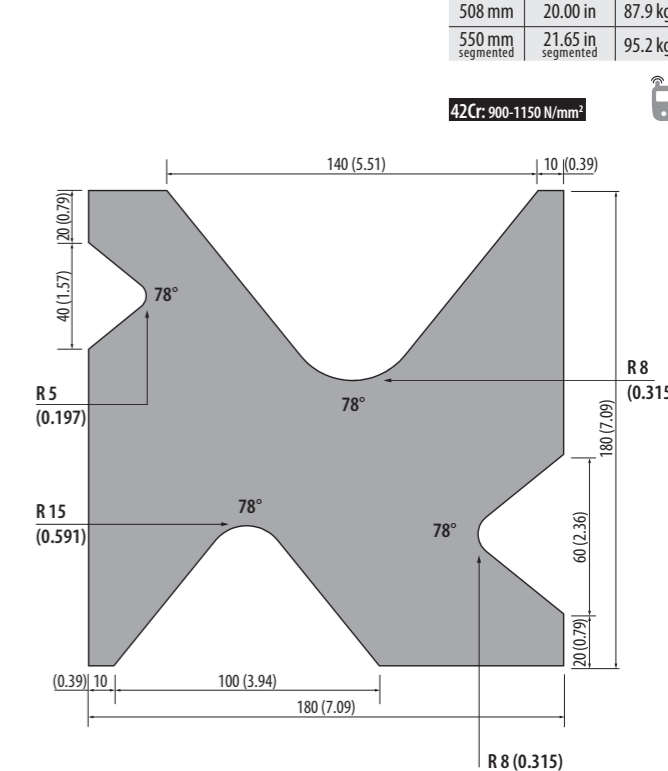


508 mm	20.00 in	51.8 kg
550 mm segmented	21.65 in segmented	56.1 kg

42Cr: 900-1150 N/mm<sup>2</sup>

	V1	V2	V3	V4	V5	V6	V7
V mm (in)	16 (0.63)	60 (2.36)	10 (0.39)	80 (3.15)	40 (1.57)	12 (0.47)	24 (0.94)
Angle	30°	78°	78°	78°	78°	78°	78°
kN/m max.	650	1500	650	1250	1500	480	1500

### LM180



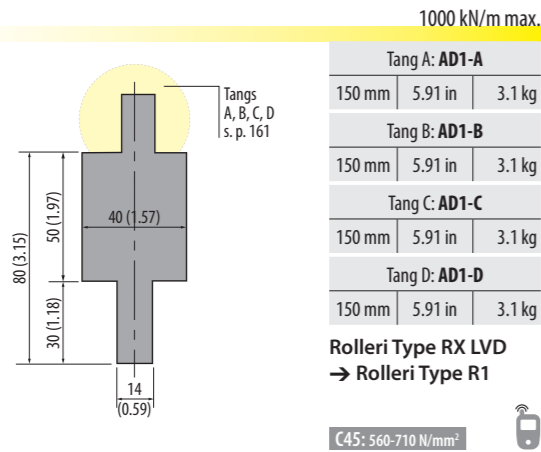
508 mm	20.00 in	87.9 kg
550 mm segmented	21.65 in segmented	95.2 kg

42Cr: 900-1150 N/mm<sup>2</sup>

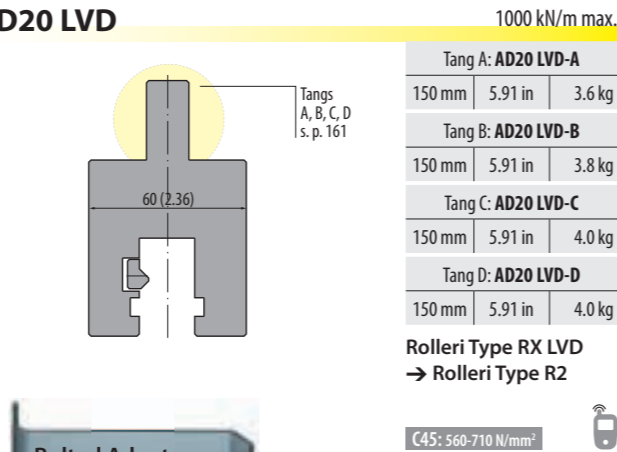
	V1	V2	V3	V4
V mm (in)	140 (5.51)	60 (2.36)	100 (3.94)	40 (1.57)
Angle	78°	78°	78°	78°
kN/m max.	550	650	700	320

7  
RX

### AD1

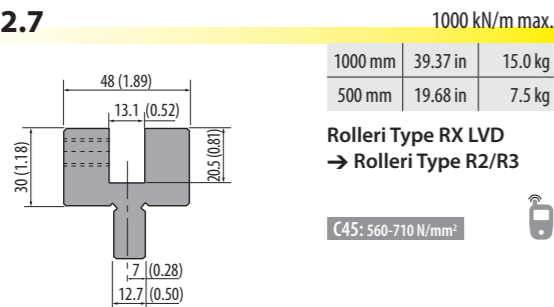


### AD20 LVD

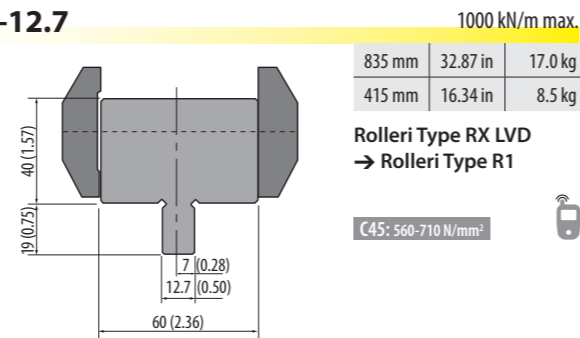


Bolted Adapters  
AW1 A-D  
see page 216

### AD8-12.7



### AD9-12.7

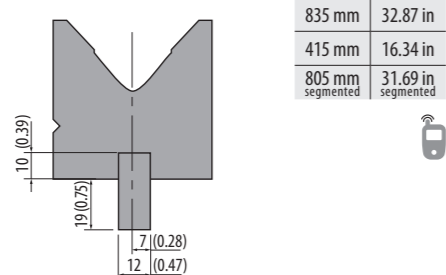


## Modification: Wedge Bar / Tail

To use Dies Rolleri Type R1, a 10 mm (0.39 in) groove is milled and polished in order to fit a wedge bar / tail of the required measurement.

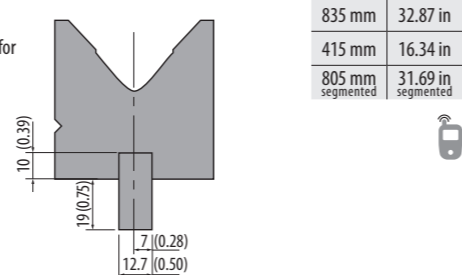
### A31

Wedge Bar / Tail:  
12 x 29 mm (0.47 x 1.14) for  
• Rolleri Type RX LVD



### A32

Wedge Bar / Tail:  
12.7 x 29 mm (0.50 x 1.14) for  
• Rolleri Type RX LVD



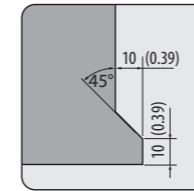
## Tool lengths, sectionings and horn types

### Punches:

- 1020 mm (40.16 in)
- 1250 mm (49.21 in) segmented  
15 segments (100 Horn left, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 100, 100 Horn right)

### Dies:

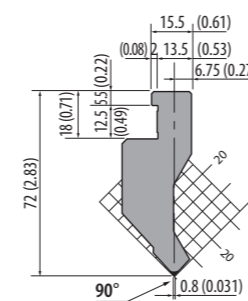
- 1020 mm (40.16 in)
- 1250 mm (49.21 in) segmented  
14 segments (100, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 200)



Standard-Horn Type  
for all segmented  
Punches Rolleri  
Type RX Colly

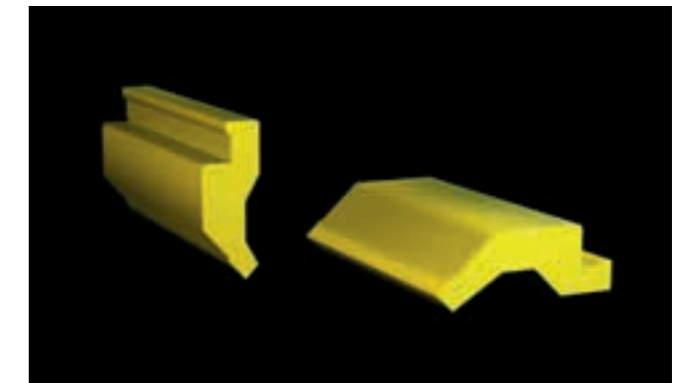
## Punches Colly

### CP72.90.08

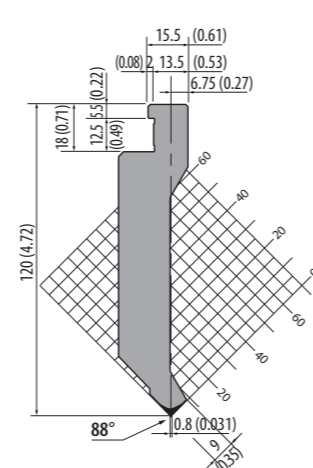


1020 mm	40.16 in	10.2 kg
1250 mm segmented	49.21 in segmented	12.5 kg

C45: 560-710 N/mm<sup>2</sup>



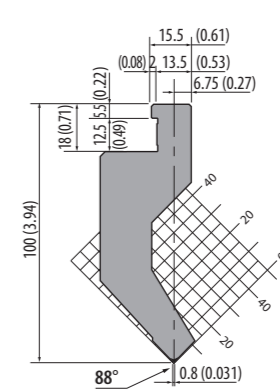
### CP120.88.08



1020 mm	40.16 in	18.5 kg
1250 mm segmented	49.21 in segmented	22.6 kg

C45: 560-710 N/mm<sup>2</sup>

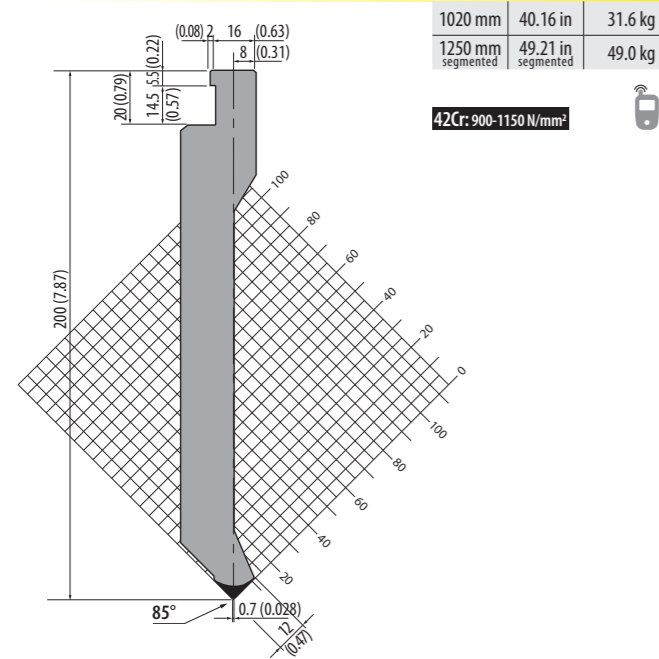
### CP100.88.08-A



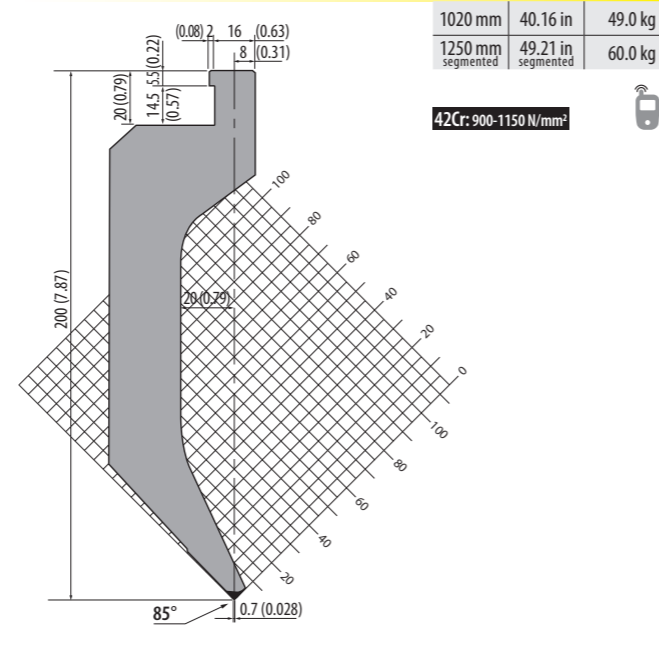
1020 mm	40.16 in	16.7 kg
1250 mm segmented	49.21 in segmented	20.4 kg

C45: 560-710 N/mm<sup>2</sup>

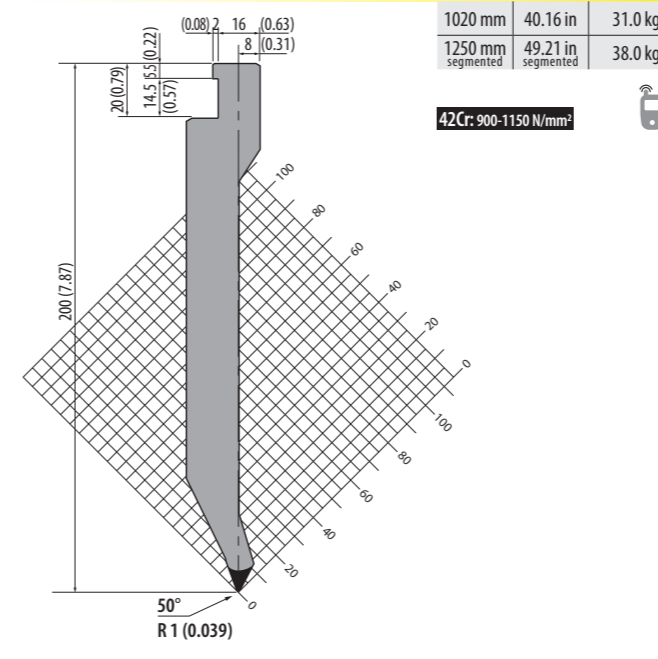
**CP200.85.07**



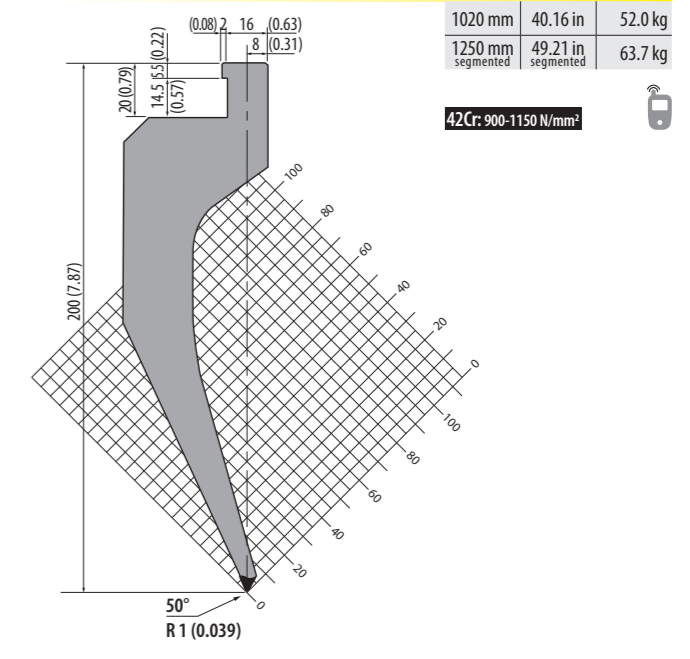
**CP200.85.07-A**



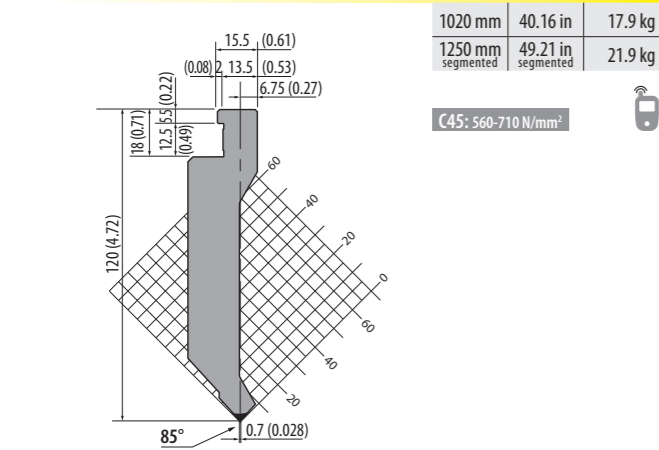
**CP200.50.R1**



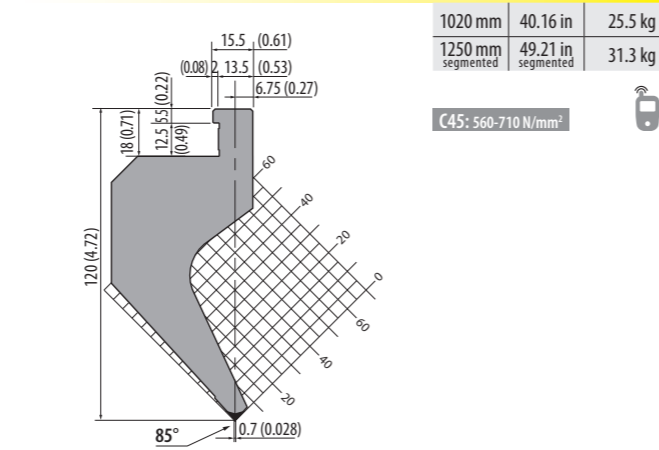
**CP200.50.R1-A**



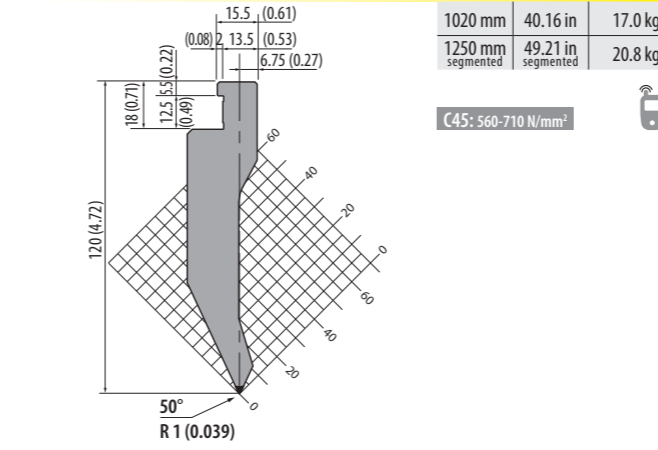
**CP120.85.07**



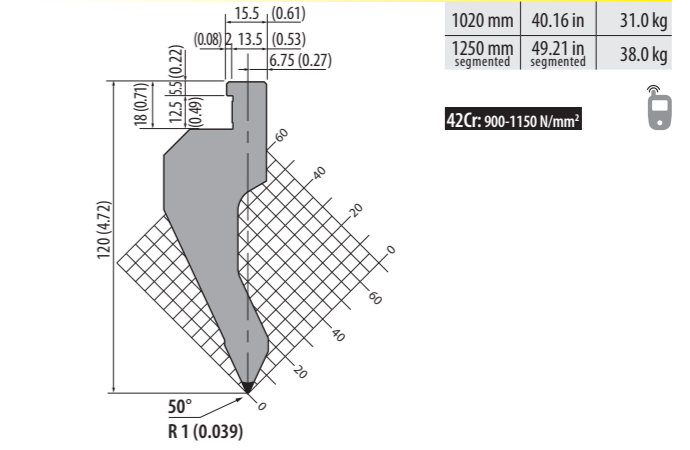
**CP120.85.07-A**



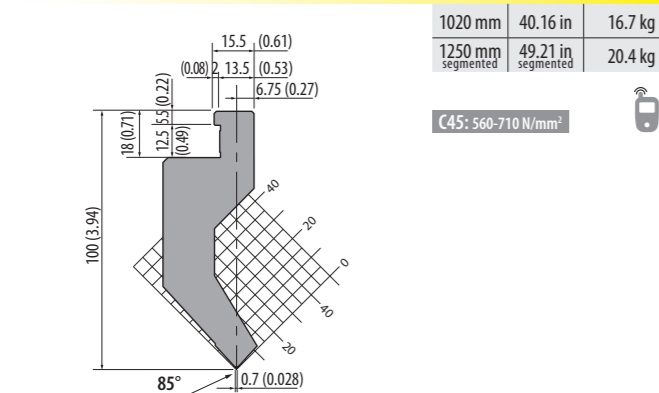
**CP120.50.R1**



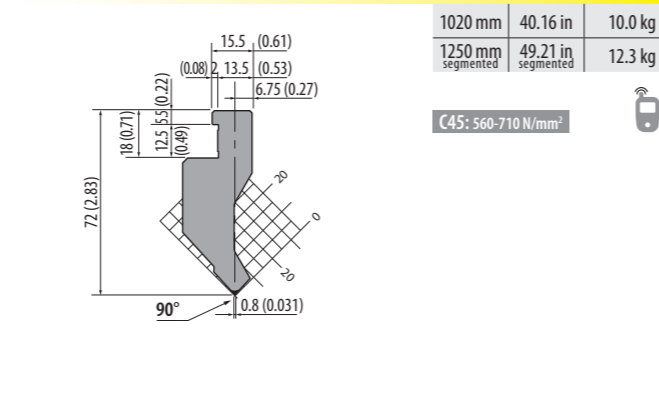
**CP120.50.R1-A**



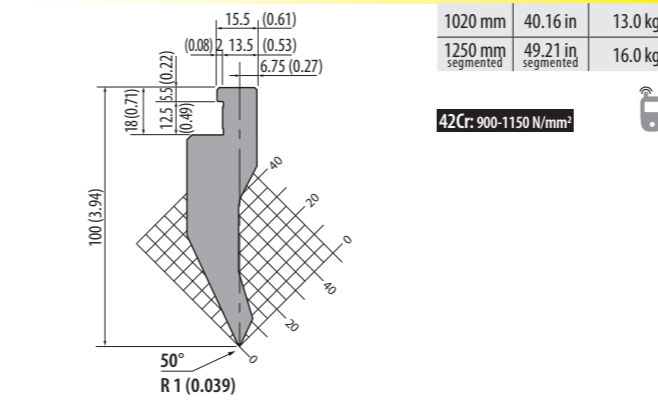
**CP100.85.07-A**



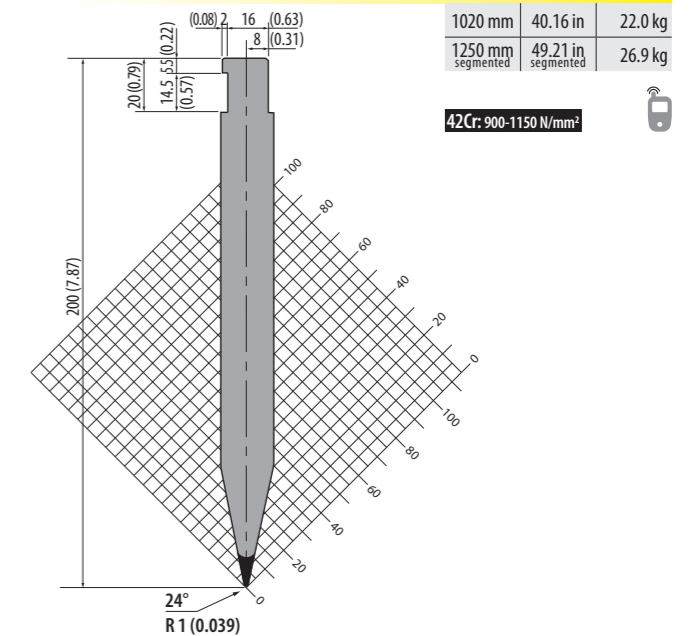
**CP72.85.07**



**CP100.50.R1**



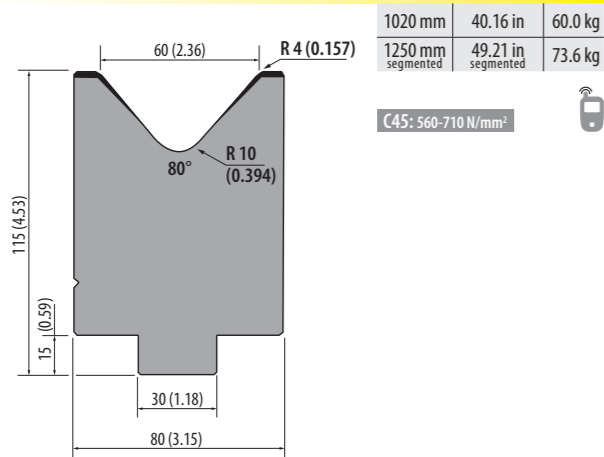
**CP200.24.R1**



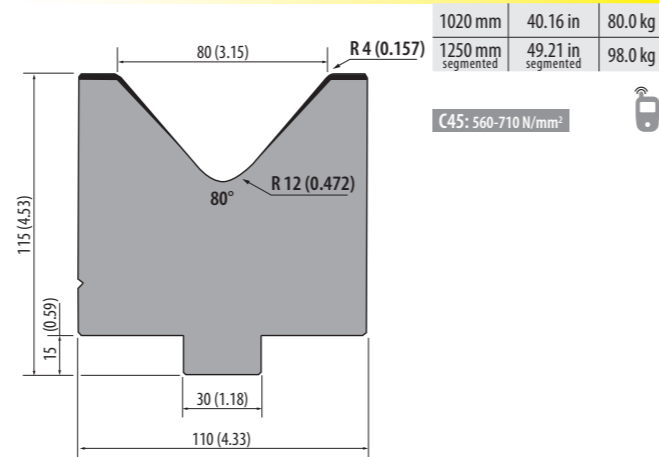
Bolted Adapters  
see page 217

7  
RX

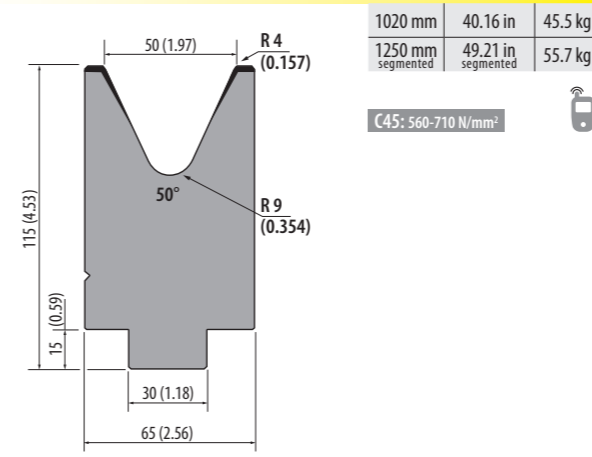
**M115.80.60**



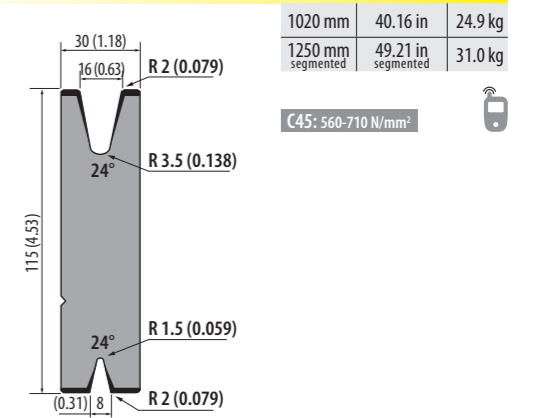
**M115.80.80**



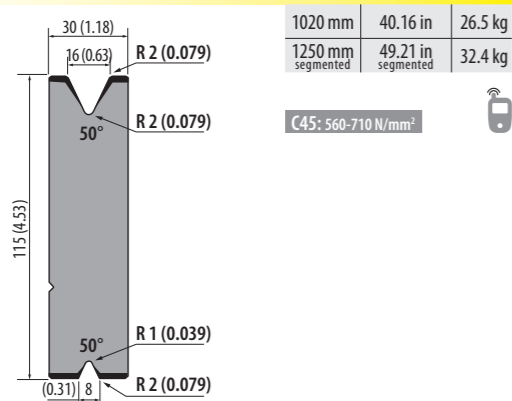
**M115.50.50**



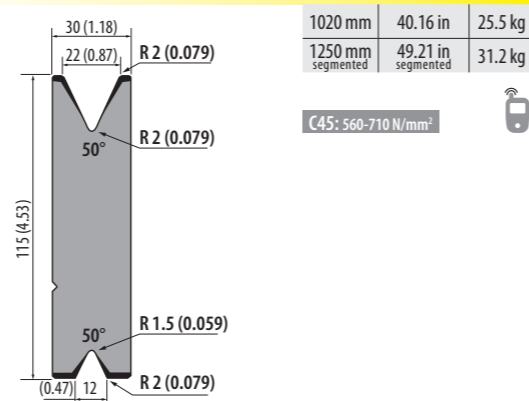
**M115.24.16**



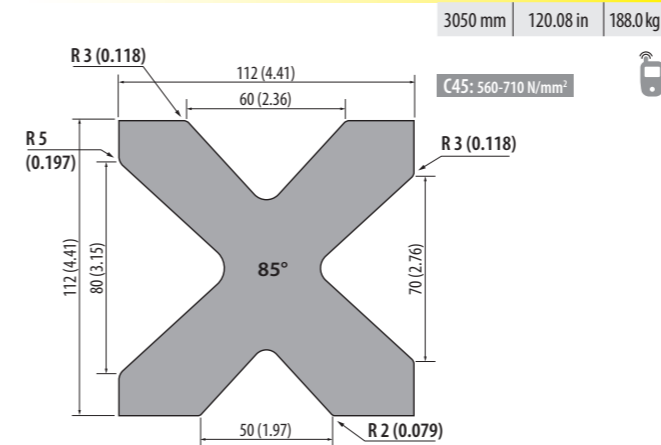
**M115.50.16**



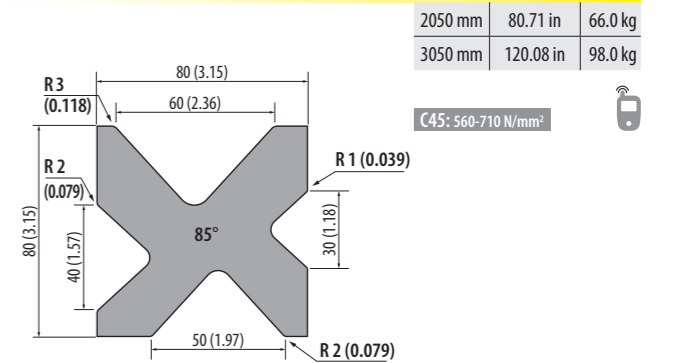
**M115.50.22**



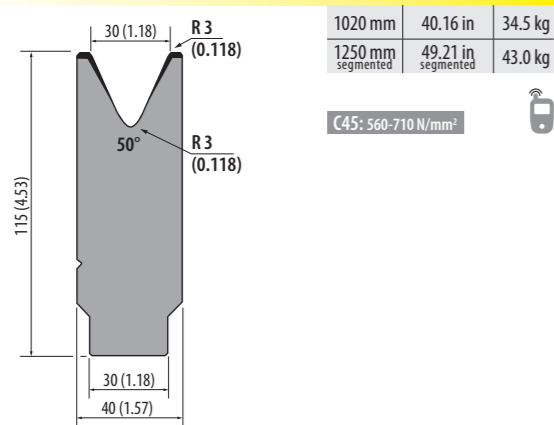
**MC112.3050**



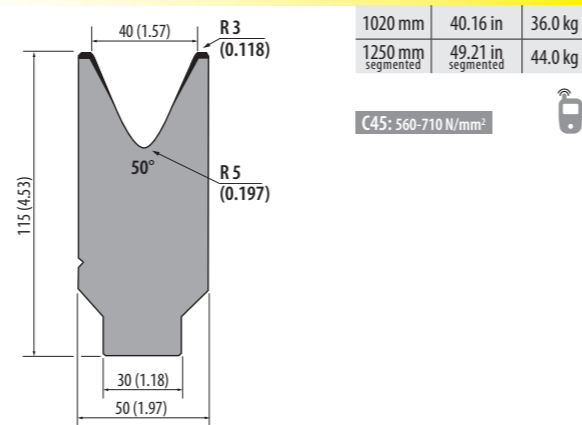
**MC80.2050 / MC80.3050**



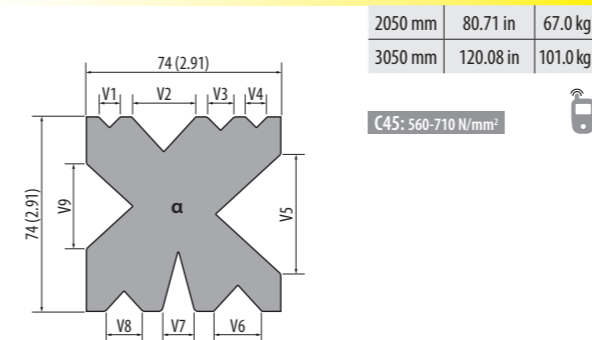
**M115.50.30**



**M115.50.40**

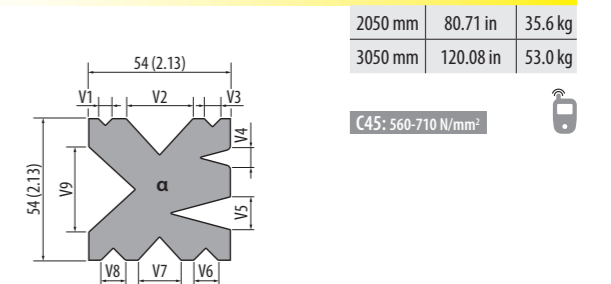


**MC74.2050 / MC74.3050**



	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm	8	24	10	8	45	18	12	14	32
(in)	(0.31)	(0.94)	(0.39)	(0.31)	(1.77)	(0.71)	(0.47)	(0.55)	(1.26)
Angle	90°	85°	90°	90°	85°	85°	30°	85°	85°
R mm	0.8	0.8	2.0	0.8	2.0	1.0	2.0	2.0	2.0
(in)	(0.031)	(0.031)	(0.079)	(0.031)	(0.079)	(0.039)	(0.079)	(0.079)	(0.079)

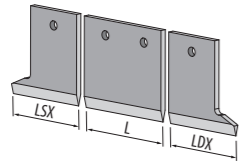
**MC54.2050 / MC54.3050**



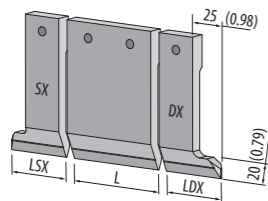
	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm	6	25	6	6	12	9	16	9	32
(in)	(0.24)	(0.98)	(0.24)	(0.24)	(0.47)	(0.35)	(0.63)	(0.35)	(1.26)
Angle	90°	85°	90°	30°	30°	90°	85°	90°	85°
R mm	0.5	1.0	0.5	2.0	0.5	1.0	0.5	1.5	1.0
(in)	(0.020)	(0.039)	(0.020)	(0.079)	(0.020)	(0.039)	(0.020)	(0.059)	(0.039)

**Tool lengths, sectionings and horn types**

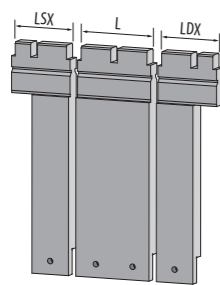
**Punches H11:**



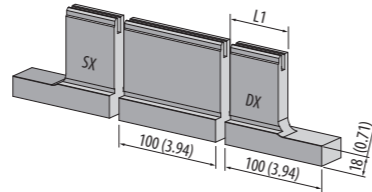
**Punches H12:**



**Punches H21:**



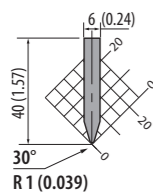
**Dies H31, H41:**



**Punches Hämmerle-Bystronic**

**H11.010.0**

600 kN/m max.

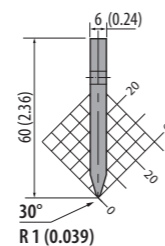


Model	Length	Weight
H11.010.01.01	100	0.17 kg
H11.010.02.01	50	0.09 kg
H11.010.02.02	55	0.09 kg
H11.010.02.03	60	0.10 kg
H11.010.02.04	65	0.11 kg
H11.010.02.05	70	0.12 kg
H11.010.02.06	75	0.13 kg
H11.010.02.07	80	0.14 kg
H11.010.02.08	85	0.14 kg
H11.010.02.09	90	0.15 kg
H11.010.02.10	95	0.16 kg
H11.010.04.01	75 DX	0.12 kg
H11.010.04.02	85 DX	0.14 kg
H11.010.04.03	95 DX	0.15 kg
H11.010.04.04	105 DX	0.17 kg
H11.010.04.05	115 DX	0.19 kg
H11.010.04.06	80 SX	0.13 kg
H11.010.05.01	75 SX	0.12 kg
H11.010.05.02	85 SX	0.14 kg
H11.010.05.03	95 SX	0.15 kg
H11.010.05.04	105 SX	0.17 kg
H11.010.05.05	115 SX	0.19 kg
H11.010.05.06	80 DX	0.13 kg

HRc 58-60

**H11.007.0**

1000 kN/m max.

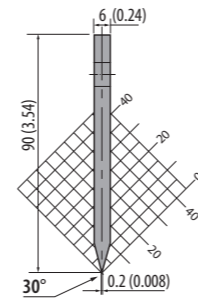


Model	Length	Weight
H11.007.01.01	100	0.26 kg
H11.007.02.01	50	0.13 kg
H11.007.02.02	55	0.14 kg
H11.007.02.03	60	0.16 kg
H11.007.02.04	65	0.17 kg
H11.007.02.05	70	0.18 kg
H11.007.02.06	75	0.20 kg
H11.007.02.07	80	0.21 kg
H11.007.02.08	85	0.22 kg
H11.007.02.09	90	0.23 kg
H11.007.02.10	95	0.25 kg
H11.007.04.01	75 DX	0.18 kg
H11.007.04.02	85 DX	0.21 kg
H11.007.04.03	95 DX	0.23 kg
H11.007.04.04	105 DX	0.25 kg
H11.007.04.05	115 DX	0.29 kg
H11.007.04.06	80 SX	0.20 kg
H11.007.05.01	75 SX	0.18 kg
H11.007.05.02	85 SX	0.21 kg
H11.007.05.03	95 SX	0.23 kg
H11.007.05.04	105 SX	0.25 kg
H11.007.05.05	115 SX	0.29 kg
H11.007.05.06	80 DX	0.20 kg

HRc 58-60

**H11.002.0**

1000 kN/m max.

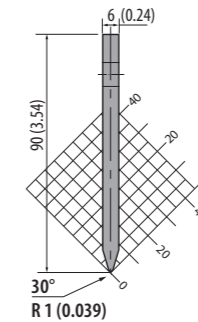


Model	Length	Weight
H11.002.01.01	100	0.40 kg
H11.002.02.01	50	0.20 kg
H11.002.02.02	55	0.22 kg
H11.002.02.03	60	0.24 kg
H11.002.02.04	65	0.26 kg
H11.002.02.05	70	0.28 kg
H11.002.02.06	75	0.30 kg
H11.002.02.07	80	0.32 kg
H11.002.02.08	85	0.34 kg
H11.002.02.09	90	0.36 kg
H11.002.02.10	95	0.38 kg
H11.002.04.01	75 DX	0.28 kg
H11.002.04.02	85 DX	0.32 kg
H11.002.04.03	95 DX	0.36 kg
H11.002.04.04	105 DX	0.38 kg
H11.002.04.05	115 DX	0.44 kg
H11.002.04.06	80 SX	0.30 kg
H11.002.05.01	75 SX	0.28 kg
H11.002.05.02	85 SX	0.32 kg
H11.002.05.03	95 SX	0.36 kg
H11.002.05.04	105 SX	0.38 kg
H11.002.05.05	115 SX	0.44 kg
H11.002.05.06	80 DX	0.30 kg

HRc 58-60

**H11.001.0**

1000 kN/m max.

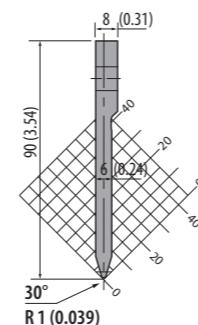


Model	Length	Weight
H11.001.01.01	100	0.40 kg
H11.001.02.01	50	0.20 kg
H11.001.02.02	55	0.22 kg
H11.001.02.03	60	0.24 kg
H11.001.02.04	65	0.26 kg
H11.001.02.05	70	0.28 kg
H11.001.02.06	75	0.30 kg
H11.001.02.07	80	0.32 kg
H11.001.02.08	85	0.34 kg
H11.001.02.09	90	0.36 kg
H11.001.02.10	95	0.38 kg
H11.001.04.01	75 DX	0.28 kg
H11.001.04.02	85 DX	0.32 kg
H11.001.04.03	95 DX	0.36 kg
H11.001.04.04	105 DX	0.38 kg
H11.001.04.05	115 DX	0.44 kg
H11.001.04.06	80 SX	0.30 kg
H11.001.05.01	75 SX	0.28 kg
H11.001.05.02	85 SX	0.32 kg
H11.001.05.03	95 SX	0.36 kg
H11.001.05.04	105 SX	0.38 kg
H11.001.05.05	115 SX	0.44 kg
H11.001.05.06	80 DX	0.30 kg

HRc 58-60

**H11.008.0**

1000 kN/m max.

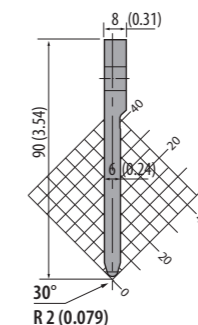


Model	Length	Weight
H11.008.01.01	100	0.44 kg
H11.008.02.01	50	0.22 kg
H11.008.02.02	55	0.24 kg
H11.008.02.03	60	0.26 kg
H11.008.02.04	65	0.29 kg
H11.008.02.05	70	0.31 kg
H11.008.02.06	75	0.33 kg
H11.008.02.07	80	0.35 kg
H11.008.02.08	85	0.37 kg
H11.008.02.09	90	0.40 kg
H11.008.02.10	95	0.42 kg
H11.008.04.01	75 DX	0.31 kg
H11.008.04.02	85 DX	0.35 kg
H11.008.04.03	95 DX	0.40 kg
H11.008.04.04	105 DX	0.46 kg
H11.008.04.05	115 DX	0.48 kg
H11.008.04.06	80 SX	0.33 kg
H11.008.05.01	75 SX	0.31 kg
H11.008.05.02	85 SX	0.35 kg
H11.008.05.03	95 SX	0.40 kg
H11.008.05.04	105 SX	0.46 kg
H11.008.05.05	115 SX	0.48 kg
H11.008.05.06	80 DX	0.33 kg

HRc 58-60

**H11.006.0**

1000 kN/m max.

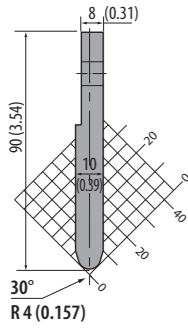


Model	Length	Weight
H11.006.01.01	100	0.44 kg
H11.006.02.01	50	0.23 kg
H11.006.02.02	55	0.25 kg
H11.006.02.03	60	0.27 kg
H11.006.02.04	65	0.29 kg
H11.006.02.05	70	0.32 kg
H11.006.02.06	75	0.34 kg
H11.006.02.07	80	0.36 kg
H11.006.02.08	85	0.38 kg
H11.006.02.09	90	0.41 kg
H11.006.02.10	95	0.43 kg
H11.006.04.01	75 DX	0.32 kg
H11.006.04.02	85 DX	0.36 kg
H11.006.04.03	95 DX	0.41 kg
H11.006.04.04	105 DX	0.44 kg
H11.006.04.05	115 DX	0.50 kg
H11.006.04.06	80 SX	0.34 kg
H11.006.05.01	75 SX	0.32 kg
H11.006.05.02	85 SX	0.36 kg
H11.006.05.03	95 SX	0.41 kg
H11.006.05.04	105 SX	0.44 kg
H11.006.05.05	115 SX	0.50 kg
H11.006.05.06	80 DX	0.34 kg

HRc 58-60



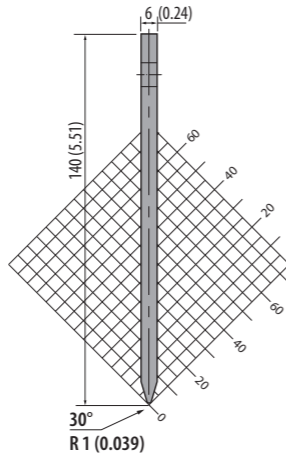
**H11.034.0** 1000 kN/m max.



Model	Length	Weight
H11.034.01.01	100	3.94
H11.034.02.01	50	1.97
H11.034.02.02	55	2.17
H11.034.02.03	60	2.36
H11.034.02.04	65	2.56
H11.034.02.05	70	2.76
H11.034.02.06	75	2.95
H11.034.02.07	80	3.15
H11.034.02.08	85	3.35
H11.034.02.09	90	3.54
H11.034.02.10	95	3.74
H11.034.04.01	75 DX	2.95 DX
H11.034.04.02	85 DX	3.35 DX
H11.034.04.03	95 DX	3.74 DX
H11.034.04.04	105 DX	4.13 DX
H11.034.04.05	115 DX	4.53 DX
H11.034.04.06	80 SX	3.15 SX
H11.034.05.01	75 SX	2.95 SX
H11.034.05.02	85 SX	3.35 SX
H11.034.05.03	95 SX	3.74 SX
H11.034.05.04	105 SX	4.13 SX
H11.034.05.05	115 SX	4.53 SX
H11.034.05.06	80 DX	3.15 DX

HRC 58-60

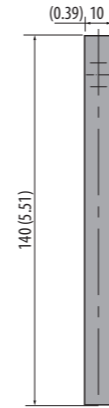
**H11.003.0** 1000 kN/m max.



Model	Length	Weight
H11.003.01.01	100	3.94
H11.003.02.01	50	1.97
H11.003.02.02	55	2.17
H11.003.02.03	60	2.36
H11.003.02.04	65	2.56
H11.003.02.05	70	2.76
H11.003.02.06	75	2.95
H11.003.02.07	80	3.15
H11.003.02.08	85	3.35
H11.003.02.09	90	3.54
H11.003.02.10	95	3.74
H11.003.04.01	75 DX	2.95 DX
H11.003.04.02	85 DX	3.35 DX
H11.003.04.03	95 DX	3.74 DX
H11.003.04.04	105 DX	4.13 DX
H11.003.04.05	115 DX	4.53 DX
H11.003.04.06	80 SX	3.15 SX
H11.003.05.01	75 SX	2.95 SX
H11.003.05.02	85 SX	3.35 SX
H11.003.05.03	95 SX	3.74 SX
H11.003.05.04	105 SX	4.13 SX
H11.003.05.05	115 SX	4.53 SX
H11.003.05.06	80 DX	3.15 DX

HRC 58-60

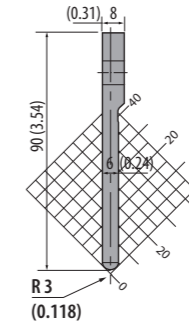
**H14.021.0** 1000 kN/m max.



Model	Length	Weight
H14.021.01.01	100	3.94
H14.021.02.01	50	1.97
H14.021.02.02	55	2.17
H14.021.02.03	60	2.36
H14.021.02.04	65	2.56
H14.021.02.05	70	2.76
H14.021.02.06	75	2.95
H14.021.02.07	80	3.15
H14.021.02.08	85	3.35
H14.021.02.09	90	3.54
H14.021.02.10	95	3.74

HRC 58-60

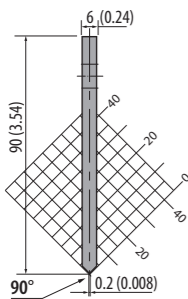
**H11.033.1** 1000 kN/m max.



Model	Length	Weight
H11.033.11.01	100	3.94
H11.033.12.01	50	1.97
H11.033.12.02	55	2.17
H11.033.12.03	60	2.36
H11.033.12.04	65	2.56
H11.033.12.05	70	2.76
H11.033.12.06	75	2.95
H11.033.12.07	80	3.15
H11.033.12.08	85	3.35
H11.033.12.09	90	3.54
H11.033.12.10	95	3.74
H11.033.14.01	75 DX	2.95 DX
H11.033.14.02	85 DX	3.35 DX
H11.033.14.03	95 DX	3.74 DX
H11.033.14.04	105 DX	4.13 DX
H11.033.14.05	115 DX	4.53 DX
H11.033.14.06	80 SX	3.15 SX
H11.033.15.01	75 SX	2.95 SX
H11.033.15.02	85 SX	3.35 SX
H11.033.15.03	95 SX	3.74 SX
H11.033.15.04	105 SX	4.13 SX
H11.033.15.05	115 SX	4.53 SX
H11.033.15.06	80 DX	3.15 DX

HRC 58-60

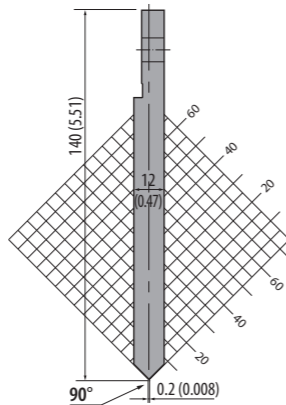
**H11.005.0** 1000 kN/m max.



Model	Length	Weight
H11.005.01.01	100	3.94
H11.005.02.01	50	1.97
H11.005.02.02	55	2.17
H11.005.02.03	60	2.36
H11.005.02.04	65	2.56
H11.005.02.05	70	2.76
H11.005.02.06	75	2.95
H11.005.02.07	80	3.15
H11.005.02.08	85	3.35
H11.005.02.09	90	3.54
H11.005.02.10	95	3.74
H11.005.04.01	75 DX	2.95 DX
H11.005.04.02	85 DX	3.35 DX
H11.005.04.03	95 DX	3.74 DX
H11.005.04.04	105 DX	4.13 DX
H11.005.04.05	115 DX	4.53 DX
H11.005.04.06	80 SX	3.15 SX
H11.005.05.01	75 SX	2.95 SX
H11.005.05.02	85 SX	3.35 SX
H11.005.05.03	95 SX	3.74 SX
H11.005.05.04	105 SX	4.13 SX
H11.005.05.05	115 SX	4.53 SX
H11.005.05.06	80 DX	3.15 DX

HRC 58-60

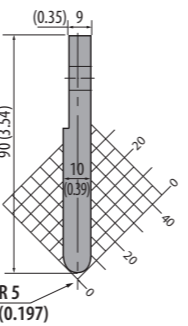
**H11.009.1** 1000 kN/m max.



Model	Length	Weight
H11.009.10.01	100	3.94
H11.009.12.01	50	1.97
H11.009.12.02	55	2.17
H11.009.12.03	60	2.36
H11.009.12.04	65	2.56
H11.009.12.05	70	2.76
H11.009.12.06	75	2.95
H11.009.12.07	80	3.15
H11.009.12.08	85	3.35
H11.009.12.09	90	3.54
H11.009.12.10	95	3.74
H11.009.14.01	75 DX	2.95 DX
H11.009.14.02	85 DX	3.35 DX
H11.009.14.03	95 DX	3.74 DX
H11.009.14.04	105 DX	4.13 DX
H11.009.14.05	115 DX	4.53 DX
H11.009.14.06	80 SX	3.15 SX
H11.009.15.01	75 SX	2.95 SX
H11.009.15.02	85 SX	3.35 SX
H11.009.15.03	95 SX	3.74 SX
H11.009.15.04	105 SX	4.13 SX
H11.009.15.05	115 SX	4.53 SX
H11.009.15.06	80 DX	3.15 DX

HRC 58-60

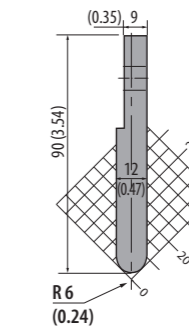
**H11.035.0** 1000 kN/m max.



Model	Length	Weight
H11.035.01.01	100	3.94
H11.035.02.01	50	1.97
H11.035.02.02	55	2.17
H11.035.02.03	60	2.36
H11.035.02.04	65	2.56
H11.035.02.05	70	2.76
H11.035.02.06	75	2.95
H11.035.02.07	80	3.15
H11.035.02.08	85	3.35
H11.035.02.09	90	3.54
H11.035.02.10	95	3.74
H11.035.04.01	75 DX	2.95 DX
H11.035.04.02	85 DX	3.35 DX
H11.035.04.03	95 DX	3.74 DX
H11.035.04.04	105 DX	4.13 DX
H11.035.04.05	115 DX	4.53 DX
H11.035.04.06	80 SX	3.15 SX
H11.035.05.01	75 SX	2.95 SX
H11.035.05.02	85 SX	3.35 SX
H11.035.05.03	95 SX	3.74 SX
H11.035.05.04	105 SX	4.13 SX
H11.035.05.05	115 SX	4.53 SX
H11.035.05.06	80 DX	3.15 DX

HRC 58-60

**H11.036.0** 1000 kN/m max.

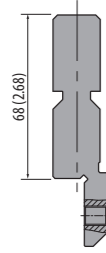


Model	Length	Weight
H11.036.01.01	100	3.94
H11.036.02.01	50	1.97
H11.036.02.02	55	2.17
H11.036.02.03	60	2.36
H11.036.02.04	65	2.56
H11.036.02.05	70	2.76
H11.036.02.06	75	2.95
H11.036.02.07	80	3.15
H11.036.02.08	85	3.35
H11.036.02.09	90	3.54
H11.036.02.10	95	3.74
H11.036.04.01	75 DX	2.95 DX
H11.036.04.02	85 DX	3.35 DX
H11.036.04.03	95 DX	3.74 DX
H11.036.04.04	105 DX	4.13 DX
H11.036.04.05	115 DX	4.53 DX
H11.036.04.06	80 SX	3.15 SX
H11.036.05.01	75 SX	2.95 SX
H11.036.05.02	85 SX	3.35 SX
H11.036.05.03	95 SX	3.74 SX
H11.036.05.04	105 SX	4.13 SX
H11.036.05.05	115 SX	4.53 SX
H11.036.05.06	80 DX	3.15 DX

HRC 58-60



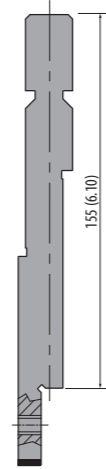
**H21.003.0** 1000 kN/m max.



Model	Length	Weight
H21.003.01.01	100	3.94
H21.003.01.03	200	7.87
H21.003.02.01	50	1.97
H21.003.02.02	55	2.17
H21.003.02.03	60	2.36
H21.003.02.04	65	2.56
H21.003.02.05	70	2.76
H21.003.02.06	75	2.95
H21.003.02.07	80	3.15
H21.003.02.08	85	3.35
H21.003.02.09	90	3.54
H21.003.02.10	95	3.74
H21.003.04.01	75 DX	2.95 DX
H21.003.04.02	85 DX	3.35 DX
H21.003.04.03	95 DX	3.74 DX
H21.003.04.04	105 DX	4.13 DX
H21.003.04.05	115 DX	4.53 DX
H21.003.04.06	80 SX	3.15 SX
H21.003.05.01	75 SX	2.95 SX
H21.003.05.02	85 SX	3.35 SX
H21.003.05.03	95 SX	3.74 SX
H21.003.05.04	105 SX	4.13 SX
H21.003.05.05	115 SX	4.53 SX
H21.003.05.06	80 DX	3.15 DX

C45: 560-710 N/mm<sup>2</sup>

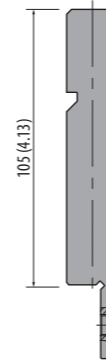
**H21.002.0** 1000 kN/m max.



Model	Length	Weight
H21.002.01.01	100	3.94
H21.002.01.03	200	7.87
H21.002.02.01	50	1.97
H21.002.02.02	55	2.17
H21.002.02.03	60	2.36
H21.002.02.04	65	2.56
H21.002.02.05	70	2.76
H21.002.02.06	75	2.95
H21.002.02.07	80	3.15
H21.002.02.08	85	3.35
H21.002.02.09	90	3.54
H21.002.02.10	95	3.74
H21.002.04.01	75 DX	2.95 DX
H21.002.04.02	85 DX	3.35 DX
H21.002.04.03	95 DX	3.74 DX
H21.002.04.04	105 DX	4.13 DX
H21.002.04.05	115 DX	4.53 DX
H21.002.04.06	80 SX	3.15 SX
H21.002.05.01	75 SX	2.95 SX
H21.002.05.02	85 SX	3.35 SX
H21.002.05.03	95 SX	3.74 SX
H21.002.05.04	105 SX	4.13 SX
H21.002.05.05	115 SX	4.53 SX
H21.002.05.06	80 DX	3.15 DX

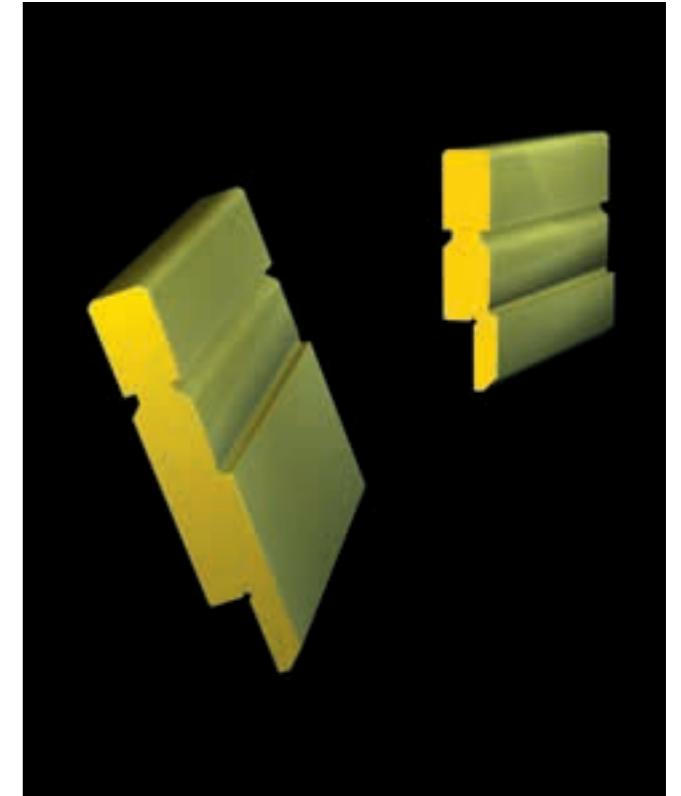
C45: 560-710 N/mm<sup>2</sup>

**H21.004.0** 1000 kN/m max.

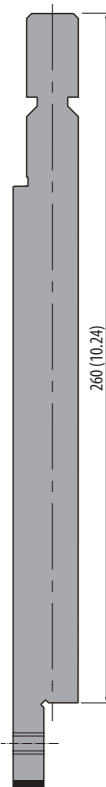


Model	Length	Weight
H21.004.01.01	100	3.94
H21.004.01.03	200	7.87
H21.004.02.01	50	1.97
H21.004.02.02	55	2.17
H21.004.02.03	60	2.36
H21.004.02.04	65	2.56
H21.004.02.05	70	2.76
H21.004.02.06	75	2.95
H21.004.02.07	80	3.15
H21.004.02.08	85	3.35
H21.004.02.09	90	3.54
H21.004.02.10	95	3.74
H21.004.04.01	75 DX	2.95 DX
H21.004.04.02	85 DX	3.35 DX
H21.004.04.03	95 DX	3.74 DX
H21.004.04.04	105 DX	4.13 DX
H21.004.04.05	115 DX	4.53 DX
H21.004.04.06	80 SX	3.15 SX
H21.004.05.01	75 SX	2.95 SX
H21.004.05.02	85 SX	3.35 SX
H21.004.05.03	95 SX	3.74 SX
H21.004.05.04	105 SX	4.13 SX
H21.004.05.05	115 SX	4.53 SX
H21.004.05.06	80 DX	3.15 DX

C45: 560-710 N/mm<sup>2</sup>



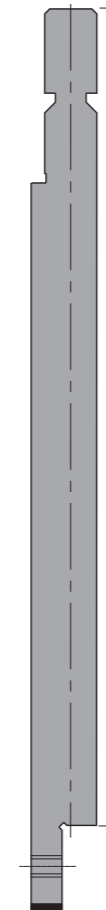
**H21.005.0** 1000 kN/m max.



Model	Length	Weight
H21.005.01.01	100	3.94
H21.005.01.03	200	7.87
H21.005.02.01	50	1.97
H21.005.02.02	55	2.17
H21.005.02.03	60	2.36
H21.005.02.04	65	2.56
H21.005.02.05	70	2.76
H21.005.02.06	75	2.95
H21.005.02.07	80	3.15
H21.005.02.08	85	3.35
H21.005.02.09	90	3.54
H21.005.02.10	95	3.74
H21.005.04.01	75 DX	2.95 DX
H21.005.04.02	85 DX	3.35 DX
H21.005.04.03	95 DX	3.74 DX
H21.005.04.04	105 DX	4.13 DX
H21.005.04.05	115 DX	4.53 DX
H21.005.04.06	80 SX	3.15 SX
H21.005.05.01	75 SX	2.95 SX
H21.005.05.02	85 SX	3.35 SX
H21.005.05.03	95 SX	3.74 SX
H21.005.05.04	105 SX	4.13 SX
H21.005.05.05	115 SX	4.53 SX
H21.005.05.06	80 DX	3.15 DX

C45: 560-710 N/mm<sup>2</sup>

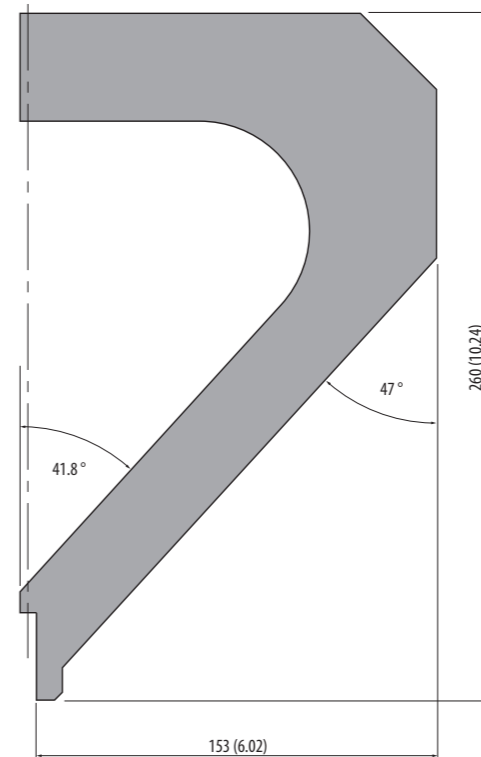
**H21.010.0** 1000 kN/m max.



Model	Length	Weight
H21.010.01.01	100	3.94
H21.010.01.03	200	7.87
H21.010.02.01	50	1.97
H21.010.02.02	55	2.17
H21.010.02.03	60	2.36
H21.010.02.04	65	2.56
H21.010.02.05	70	2.76
H21.010.02.06	75	2.95
H21.010.02.07	80	3.15
H21.010.02.08	85	3.35
H21.010.02.09	90	3.54
H21.010.02.10	95	3.74
H21.010.04.01	75 DX	2.95 DX
H21.010.04.02	85 DX	3.35 DX
H21.010.04.03	95 DX	3.74 DX
H21.010.04.04	105 DX	4.13 DX
H21.010.04.05	115 DX	4.53 DX
H21.010.04.06	80 SX	3.15 SX
H21.010.05.01	75 SX	2.95 SX
H21.010.05.02	85 SX	3.35 SX
H21.010.05.03	95 SX	3.74 SX
H21.010.05.04	105 SX	4.13 SX
H21.010.05.05	115 SX	4.53 SX
H21.010.05.06	80 DX	3.15 DX

C45: 560-710 N/mm<sup>2</sup>

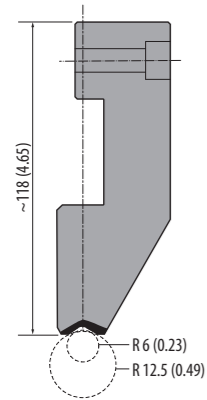
**H22.006.0** 600 kN/m max.



Model	Length	Weight
H22.006.01.01	100	3.94
H22.006.02.01	50	1.97
H22.006.02.02	55	2.17
H22.006.02.03	60	2.36
H22.006.02.04	65	2.56
H22.006.02.05	70	2.76
H22.006.02.06	75	2.95
H22.006.02.07	80	3.15
H22.006.02.08	85	3.35
H22.006.02.09	90	3.54
H22.006.02.10	95	3.74

42Cr: 900-1150 N/mm<sup>2</sup>

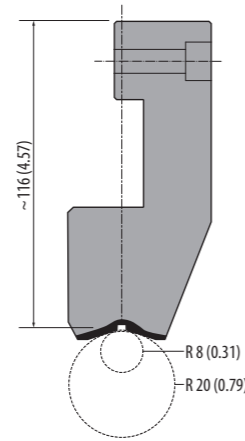
**H22.013.0** 1000 kN/m max.



Model	Length	Weight
H22.013.01.01	100	2.82 kg
H22.013.02.01	50	1.41 kg
H22.013.02.02	55	1.55 kg
H22.013.02.03	60	1.69 kg
H22.013.02.04	65	1.83 kg
H22.013.02.05	70	1.97 kg
H22.013.02.06	75	2.12 kg
H22.013.02.07	80	2.26 kg
H22.013.02.08	85	2.40 kg
H22.013.02.09	90	2.54 kg
H22.013.02.10	95	2.68 kg

C45: 560-710 N/mm<sup>2</sup>

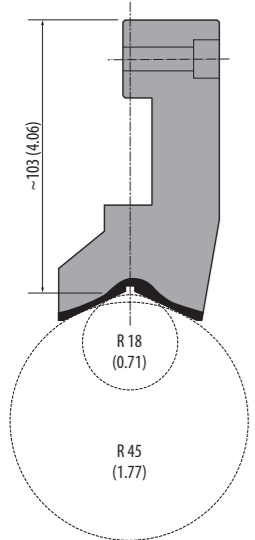
**H22.014.0** 1000 kN/m max.



Model	Length	Weight
H22.014.01.01	100	3.06 kg
H22.014.02.01	50	1.53 kg
H22.014.02.02	55	1.68 kg
H22.014.02.03	60	1.83 kg
H22.014.02.04	65	1.98 kg
H22.014.02.05	70	2.14 kg
H22.014.02.06	75	2.29 kg
H22.014.02.07	80	2.44 kg
H22.014.02.08	85	2.59 kg
H22.014.02.09	90	2.75 kg
H22.014.02.10	95	2.90 kg

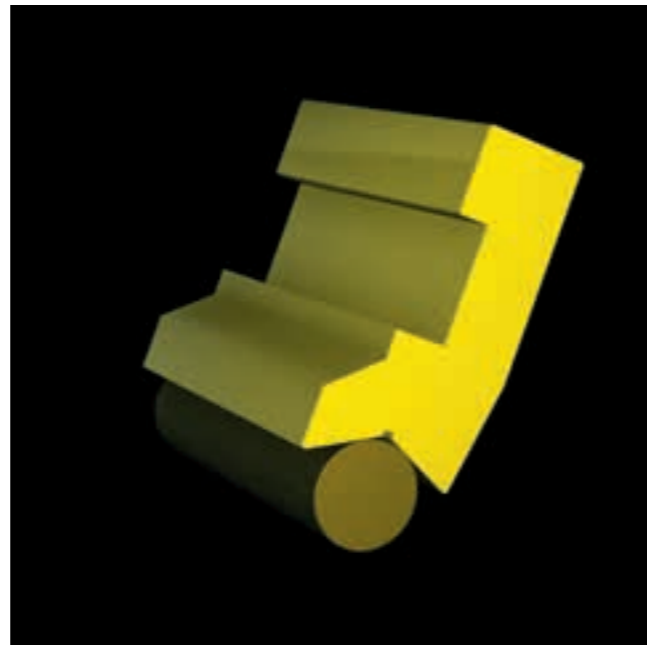
C45: 560-710 N/mm<sup>2</sup>

**H22.015.0** 1000 kN/m max.

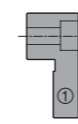


Model	Length	Weight
H22.015.01.01	100	3.28 kg
H22.015.02.01	50	1.64 kg
H22.015.02.02	55	1.80 kg
H22.015.02.03	60	1.97 kg
H22.015.02.04	65	2.13 kg
H22.015.02.05	70	2.30 kg
H22.015.02.06	75	2.46 kg
H22.015.02.07	80	2.62 kg
H22.015.02.08	85	2.79 kg
H22.015.02.09	90	2.95 kg
H22.015.02.10	95	3.12 kg

C45: 560-710 N/mm<sup>2</sup>



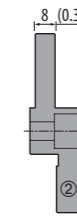
**H61.100.01 / H61.500.01**



Model	Length	Weight
H61.100.01	100	0.63 kg
H61.500.01	500	3.15 kg

C45: 560-710 N/mm<sup>2</sup>

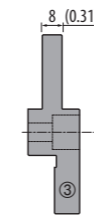
**H61.100.02 / H61.500.02**



Model	Length	Weight
H61.100.02	100	0.70 kg
H61.500.02	500	3.50 kg

C45: 560-710 N/mm<sup>2</sup>

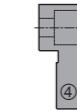
**H61.100.03 / H61.500.03**



Model	Length	Price	Weight
H61.100.03	100	3.94	0.70 kg
H61.500.03	500	19.68	3.50 kg

C45: 560-710 N/mm<sup>2</sup>

**H61.100.04 / H61.500.04**



Model	Length	Weight
H61.100.04	100	0.63 kg
H61.500.04	500	3.15 kg

C45: 560-710 N/mm<sup>2</sup>

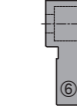
**H61.100.05 / H61.500.05**



Model	Length	Weight
H61.100.05	100	0.30 kg
H61.500.05	500	1.50 kg

C45: 560-710 N/mm<sup>2</sup>

**H61.100.06 / H61.500.06**



Model	Length	Weight
H61.100.06	100	0.63 kg
H61.500.06	500	3.15 kg

C45: 560-710 N/mm<sup>2</sup>

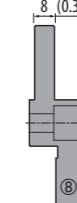
**H61.100.07**



Model	Length	Weight
H61.100.07	100	0.65 kg

C45: 560-710 N/mm<sup>2</sup>

**H61.100.08 / H61.500.08**



Model	Length	Weight
H61.100.08	100	0.70 kg
H61.500.08	500	3.50 kg

C45: 560-710 N/mm<sup>2</sup>



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videos/overview](http://www.rolleritools.com/videos/overview)





**H31.007.0** 500 kN/m max.

Model	Length	Weight
H31.007.01.01	100	3.94
H31.007.02.01	50 SX	1.97 SX
H31.007.02.02	55 DX	2.17 DX
H31.007.02.03	60 DX	2.36 DX
H31.007.02.04	65 DX	2.56 DX
H31.007.02.05	70 DX	2.76 DX
H31.007.02.06	75 DX	2.95 DX
H31.007.02.07	80 DX	3.15 DX
H31.007.02.08	85 DX	3.35 DX
H31.007.02.09	90 DX	3.54 DX
H31.007.02.10	95 DX	3.74 DX
H31.007.03.01	50 DX	1.97 DX
H31.007.03.02	55 SX	2.17 SX
H31.007.03.03	60 SX	2.36 SX
H31.007.03.04	65 SX	2.56 SX
H31.007.03.05	70 SX	2.76 SX
H31.007.03.06	75 SX	2.95 SX
H31.007.03.07	80 SX	3.15 SX
H31.007.03.08	85 SX	3.35 SX
H31.007.03.09	90 SX	3.54 SX
H31.007.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm<sup>2</sup>

**H31.007.2** 500 kN/m max.

Model	Length	Weight
H31.007.21.01	100	3.94
H31.007.22.01	50 SX	1.97 SX
H31.007.22.02	55 DX	2.17 DX
H31.007.22.03	60 DX	2.36 DX
H31.007.22.04	65 DX	2.56 DX
H31.007.22.05	70 DX	2.76 DX
H31.007.22.06	75 DX	2.95 DX
H31.007.22.07	80 DX	3.15 DX
H31.007.22.08	85 DX	3.35 DX
H31.007.22.09	90 DX	3.54 DX
H31.007.22.10	95 DX	3.74 DX
H31.007.23.01	50 DX	1.97 DX
H31.007.23.02	55 SX	2.17 SX
H31.007.23.03	60 SX	2.36 SX
H31.007.23.04	65 SX	2.56 SX
H31.007.23.05	70 SX	2.76 SX
H31.007.23.06	75 SX	2.95 SX
H31.007.23.07	80 SX	3.15 SX
H31.007.23.08	85 SX	3.35 SX
H31.007.23.09	90 SX	3.54 SX
H31.007.23.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm<sup>2</sup>

**H31.090.01.01** 1500 kN/m max.

Model	Length	Weight
H31.090.01.01	100	3.94

8.15 kg  
C45: 560-710 N/mm<sup>2</sup>

**H31.013.0** 500 kN/m max.

Model	Length	Weight
H31.013.01.01	100	3.94
H31.013.02.01	50 SX	1.97 SX
H31.013.02.02	55 DX	2.17 DX
H31.013.02.03	60 DX	2.36 DX
H31.013.02.04	65 DX	2.56 DX
H31.013.02.05	70 DX	2.76 DX
H31.013.02.06	75 DX	2.95 DX
H31.013.02.07	80 DX	3.15 DX
H31.013.02.08	85 DX	3.35 DX
H31.013.02.09	90 DX	3.54 DX
H31.013.02.10	95 DX	3.74 DX
H31.013.03.01	50 DX	1.97 DX
H31.013.03.02	55 SX	2.17 SX
H31.013.03.03	60 SX	2.36 SX
H31.013.03.04	65 SX	2.56 SX
H31.013.03.05	70 SX	2.76 SX
H31.013.03.06	75 SX	2.95 SX
H31.013.03.07	80 SX	3.15 SX
H31.013.03.08	85 SX	3.35 SX
H31.013.03.09	90 SX	3.54 SX
H31.013.03.10	95 SX	3.74 SX

C45: 560-710 N/mm<sup>2</sup>

**H31.012.0** 500 kN/m max.

Model	Length	Weight
H31.012.01.01	100	3.94
H31.012.02.01	50 SX	1.97 SX
H31.012.02.02	55 DX	2.17 DX
H31.012.02.03	60 DX	2.36 DX
H31.012.02.04	65 DX	2.56 DX
H31.012.02.05	70 DX	2.76 DX
H31.012.02.06	75 DX	2.95 DX
H31.012.02.07	80 DX	3.15 DX
H31.012.02.08	85 DX	3.35 DX
H31.012.02.09	90 DX	3.54 DX
H31.012.02.10	95 DX	3.74 DX
H31.012.03.01	50 DX	1.97 DX
H31.012.03.02	55 SX	2.17 SX
H31.012.03.03	60 SX	2.36 SX
H31.012.03.04	65 SX	2.56 SX
H31.012.03.05	70 SX	2.76 SX
H31.012.03.06	75 SX	2.95 SX
H31.012.03.07	80 SX	3.15 SX
H31.012.03.08	85 SX	3.35 SX
H31.012.03.09	90 SX	3.54 SX
H31.012.03.10	95 SX	3.74 SX

C45: 560-710 N/mm<sup>2</sup>

**H31.110.01.01** 1500 kN/m max.

Model	Length	Weight
H31.110.01.01	100	3.94

8.83 kg  
C45: 560-710 N/mm<sup>2</sup>

**H31.006.0** 350 kN/m max.

Model	Length	Weight
H31.006.01.01	100	3.94
H31.006.02.01	50 SX	1.97 SX
H31.006.02.02	55 DX	2.17 DX
H31.006.02.03	60 DX	2.36 DX
H31.006.02.04	65 DX	2.56 DX
H31.006.02.05	70 DX	2.76 DX
H31.006.02.06	75 DX	2.95 DX
H31.006.02.07	80 DX	3.15 DX
H31.006.02.08	85 DX	3.35 DX
H31.006.02.09	90 DX	3.54 DX
H31.006.02.10	95 DX	3.74 DX
H31.006.03.01	50 DX	1.97 DX
H31.006.03.02	55 SX	2.17 SX
H31.006.03.03	60 SX	2.36 SX
H31.006.03.04	65 SX	2.56 SX
H31.006.03.05	70 SX	2.76 SX
H31.006.03.06	75 SX	2.95 SX
H31.006.03.07	80 SX	3.15 SX
H31.006.03.08	85 SX	3.35 SX
H31.006.03.09	90 SX	3.54 SX
H31.006.03.10	95 SX	3.74 SX

42Cr: 900-1150 N/mm<sup>2</sup>

**H31.060.0** 1500 kN/m max.

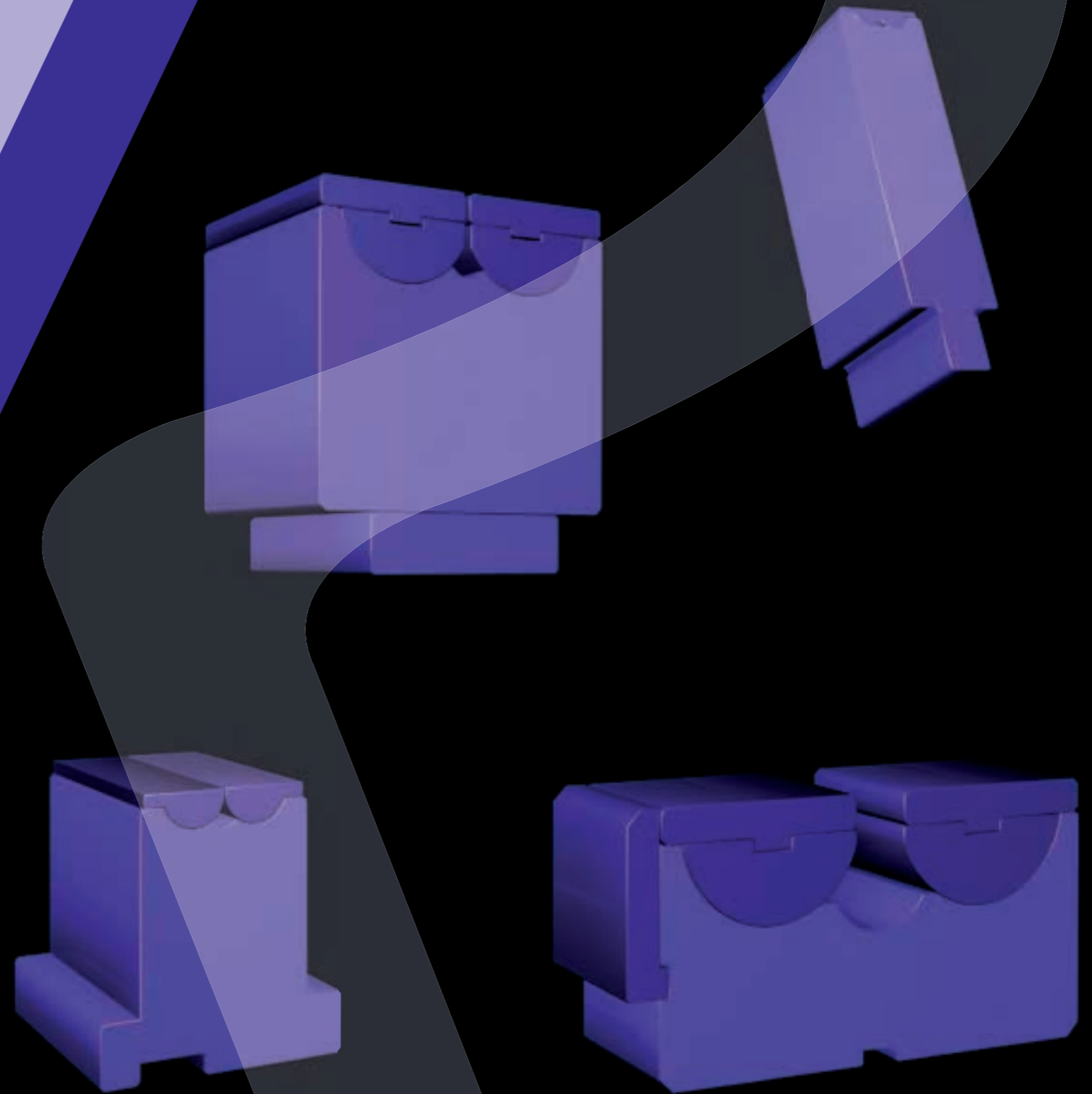
Model	Length	Weight
H31.060.01.01	100	3.94
H31.060.02.01	50 SX	1.97 SX
H31.060.02.02	55 DX	2.17 DX
H31.060.02.03	60 DX	2.36 DX
H31.060.02.04	65 DX	2.56 DX
H31.060.02.05	70 DX	2.76 DX
H31.060.02.06	75 DX	2.95 DX
H31.060.02.07	80 DX	3.15 DX
H31.060.02.08	85 DX	3.35 DX
H31.060.02.09	90 DX	3.54 DX
H31.060.02.10	95 DX	3.74 DX
H31.060.03.01	50 DX	1.97 DX
H31.060.03.02	55 SX	2.17 SX
H31.060.03.03	60 SX	2.36 SX
H31.060.03.04	65 SX	2.56 SX
H31.060.03.05	70 SX	2.76 SX
H31.060.03.06	75 SX	2.95 SX
H31.060.03.07	80 SX	3.15 SX
H31.060.03.08	85 SX	3.35 SX
H31.060.03.09	90 SX	3.54 SX
H31.060.03.10	95 SX	3.74 SX

C45: 560-710 N/mm<sup>2</sup>



## ROLLERI DIES ROLLA-V

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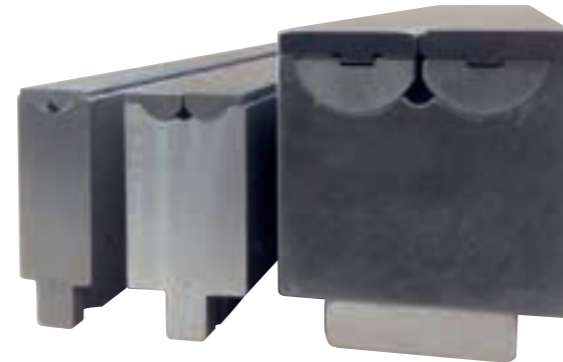


Compatibility

- RVP Dies (Models 1, 2, 3) are compatible with press brake machines (60 mm / 2.36 in die holder) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- RVS Dies (Models 1, 2, 3) are compatible with press brake machines (14 mm / 0.55 in pins) from: Amada Single V style
- RVT Dies (Models 1, 2, 3) are compatible with press brake machines (12.7 mm / 0.50 in / 13 mm / 0.51 in pins) from: Bystronic, Hämmerle, Beyeler, Edwards, Safan, SMD, Trumpf
- RVT90 Dies (Models 1, 2, 3) are compatible with press brakes machines (12.7 mm / 0.50 in pins) from: LVD
- RVM Dies (Models 2.5, 3, 4) are compatible with all press brake machines (various die holders)
- all dies are compatible on other press brakes machines with the means of adapter-systems or customized die holders.

Our Advantages – Your Convenience

- high precision grounded
- Interchangability guaranteed
- exact Parallelism
- avoiding bending marks on the sheet metals
- minimum borders bending mark free
- no tool contamination throughout the bending of galvanized sheet metal or aluminum
- extremely short flanges
- less tool exchange
- ideal for diagonal or tapered edges



Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4	1100-1200 N/mm <sup>2</sup>	50 - 55 HRC
Inserts	1	Toolox 44	1450 N/mm <sup>2</sup>	through hardened 44 HRC
Inserts	2 / 2.5 / 3 / 4	Toolox 33	1100 N/mm <sup>2</sup>	55 - 58 HRC

• Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN.**

	Equivalent V size mm (in)	Material Thickness mm (in)	min. outside flange mm (in)	needed press force (kN)	max. tool load (kN/m)	min. bending angle
Model 1 Max. recommended thickness = 1.5 mm (0.06 in) (2.0 mm / 0.08 in possible)	8 (0.31)	0.70 (0.03)	3.0 (0.12)	60	1000	40°
		1.10 (0.04)	3.9 (0.15)	110	1000	35°
		1.50 (0.06)	4.2 (0.17)	260	1000	35°
Model 2 Max. recommended thickness = 3.0 mm (0.12 in) (4.0 mm / 0.15 in possible)	15 (0.59)	2.00 (0.08)	8.5 (0.33)	200	1500	59°
		3.00 (0.12)	9.3 (0.37)	460	1500	46°
		3.20 (0.13)	9.3 (0.37)	550	1500	47°
Model 2.5 Max. recommended thickness = 5.0 mm (0.20 in) (6.35 mm / 0.24 in possible)	28 (1.10)	3.00 (0.12)	18.7 (0.74)	230	2000	67°
		4.00 (0.16)	18.7 (0.74)	450	2000	60°
		5.00 (0.20)	18.7 (0.74)	770	2000	57°
		6.00 (0.24)	18.7 (0.74)	1200	2000	51°
Model 3 Max. recommended thickness = 6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)	38 (1.50)	4.00 (0.16)	22.5 (0.89)	270	2500	47°
		6.00 (0.24)	22.5 (0.89)	800	2500	50°

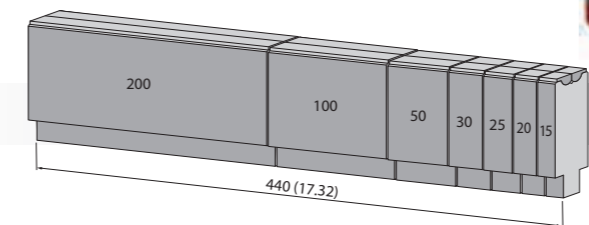
Tool lengths and sectioning

Standard

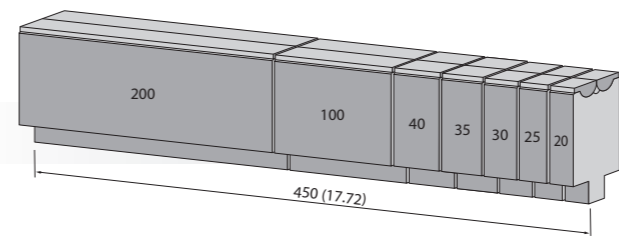


Segmented tools are delivered in complete sets. Single pieces are also available!  
More lengths and sectionings are possible upon request.

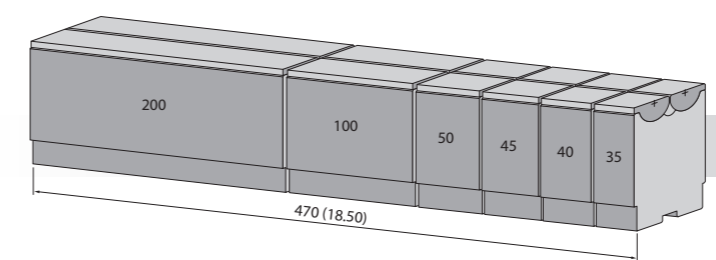
500 mm (19.68 in)  
200 mm (7.87 in)



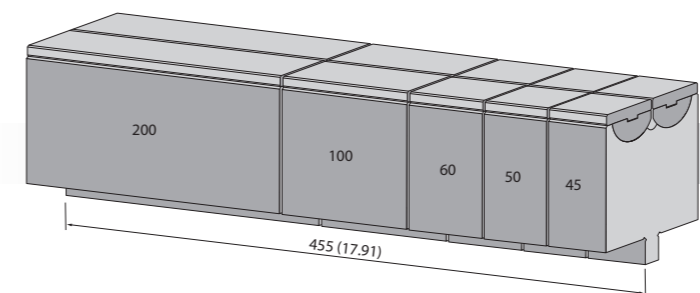
Model 1, 440 mm (17.32 in) segmented (7 segments)



Model 2, 450 mm (17.72 in) segmented (7 segments)



Model 2.5, 470 mm (18.50 in) segmented (6 segments)



Model 3, 455 mm (17.91 in) segmented (5 segments)





# DIES ROLLA-V

## Model 1

### RVP60-1 1000 kN/m max.

**NEW**

500 mm	16.68 in	6.9 kg
440 mm segmented	17.32 in segmented	6.1 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVS80-1 1000 kN/m max.

**NEW**

500 mm	16.68 in	6.3 kg
440 mm segmented	17.32 in segmented	5.8 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVT55-1 1000 kN/m max.

**NEW**

500 mm	16.68 in	5.5 kg
440 mm segmented	17.32 in segmented	5.0 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVT90-1 1000 kN/m max.

**NEW**

500 mm	16.68 in	8.5 kg
440 mm segmented	17.32 in segmented	7.8 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVT100-1 1000 kN/m max.

**NEW**

500 mm	16.68 in	9.4 kg
440 mm segmented	17.32 in segmented	8.6 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

**Ideal for thick material!**  
Making the impossible, possible ...



# DIES ROLLA-V

## Model 2

### RVP65-2 1500 kN/m max.

**NEW**

500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVS80-2 1500 kN/m max.

**NEW**

500 mm	16.68 in	8.3 kg
450 mm segmented	17.72 in segmented	7.8 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVT60-2 1500 kN/m max.

**NEW**

500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVT90-2 1500 kN/m max.

**NEW**

500 mm	16.68 in	11.3 kg
450 mm segmented	17.72 in segmented	10.6 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

### RVT100-2 1500 kN/m max.

**NEW**

500 mm	16.68 in	12.4 kg
450 mm segmented	17.72 in segmented	11.7 kg

42Cr: 1100-1200 N/mm<sup>2</sup>



## Model 2.5

### RVM2.5 2000 kN/m max.

**NEW**

500 mm	16.68 in	22.0 kg
470 mm segmented	18.50 in segmented	21.0 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

**Rolleri Videos**

Use and application of Rolla-V dies  
[www.rolleritools.com/videos/rolla-v](http://www.rolleritools.com/videos/rolla-v)

## DIES ROLLA-V

### Model 3

#### RVP100-3 2500 kN/m max.

**NEW**

500 mm	16.68 in	28.8 kg
455 mm segmented	17.91 in segmented	26.2 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

#### RVM70-3 2500 kN/m max.

**NEW**

500 mm	16.68 in	20.6 kg
455 mm segmented	17.91 in segmented	18.7 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

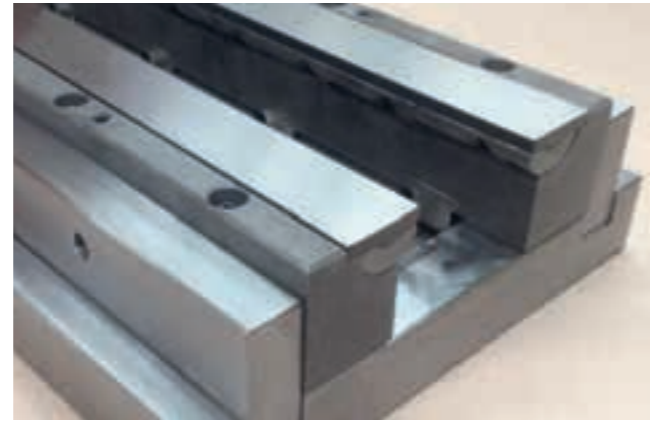
Possible Die Holders:  
 - 60 mm (2.36 in)  
 - 13 mm (0.51 in) pin  
 - 12.7 mm (0.50 in) pin  
 - 12.8 mm (0.50 in) offset pin

#### RVT100-3 2500 kN/m max.

**NEW**

500 mm	16.68 in	30.9 kg
455 mm segmented	17.91 in segmented	28.5 kg

42Cr: 1100-1200 N/mm<sup>2</sup>



### Model 4

#### Our Advantages – Your Convenience

The **model 4 tools** and the **adjustable dies** are for bending thick material and large radii. Material specifications vary greatly, therefore no specific data can be given.

- Minimum borders are highly dependant on the squareness of the component.
- Enlargement and hole distortion will be greatly reduced, however will be influenced depending on the type of material
- Radius bending is strongly influenced by the elastic return of specific material and flange-size.

For advice please contact us!

#### RVM90-4 3000 kN/m max.

**NEW**

500 mm	16.68 in	56.6 kg
200 mm	7.87 in	22.7 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

Possible Die Holders:  
 - 60 mm (2.36 in)  
 - 13 mm (0.51 in) pin  
 - 12.7 mm (0.50 in) pin  
 - 12.8 mm (0.50 in) offset pin

## DIES ROLLA-V

### Adjustable Dies



#### Our advantages – Your Convenience

- bending possible up to the thickness of 30 mm (1.18 in)
- inserts hardened
- no bending marks
- adjustable openings  
 RVPV3 = 39-94 mm (1.54-3.70 in)  
 RVHD3 = 39-118 mm (1.54-4.65 in)  
 RVPV4 = 69-180 mm (2.72-7.09 in)
- bends laser-cut sheet metal without damaging the tool
- exact inner radius

#### RVPV3 2500 kN/m max.

**NEW**

500 mm	16.68 in	50.0 kg
200 mm	7.87 in	20.0 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

#### RVHD3 3500 kN/m max.

**NEW**

500 mm	16.68 in	98.0 kg
200 mm	7.87 in	38.1 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

#### RVHD4 4000 kN/m max.

**NEW**

500 mm	16.68 in	200.0 kg
200 mm	7.87 in	80.0 kg

42Cr: 1100-1200 N/mm<sup>2</sup>

- V-Bending  
• flat inserts
- Radius-Bending  
• flat inserts
- Conical Bending  
• flat inserts
- Radius-Overbending  
• concave inserts
- U-Bending  
• V-inserts

### Hemming- and Z-Tools

#### Hemming Tool

**NEW**

per piece | Price upon request  
 Production according to your specifications

42Cr: 1100-1200 N/mm<sup>2</sup>

#### Joggle Tool

**NEW**

per piece | Price upon request  
 Production according to your specifications

42Cr: 1100-1200 N/mm<sup>2</sup>

## ROLLERI CLAMPING SYSTEMS

Content Explanation	198
Intermediates	199
Clamps	200 - 201
ROL100-System for Punches Roller Type R1	202 - 203
ROL1-System for Punches Roller Type R1	204 - 205
ROL4-System for Punches Roller Type R1	205
W-ROL PN-System for Punches Roller Type R2	206
ROL3-System for Punches Roller Type R3 and RX	207
ROL2-System for Dies Roller Type R1	208 - 209
Movable Die Clamps for Dies Roller Type R1	209



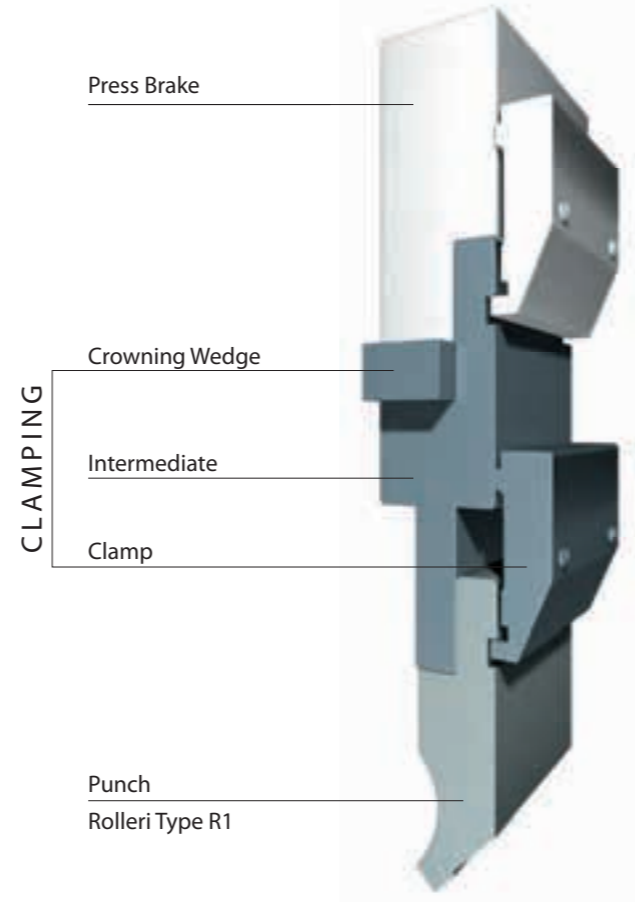
**Content Explanation**

**Standard-Clamping**

- for Punches Rollerri Type R1
- made of: Tensioning device + intermediate
- dual sided clamping (KDS-System)
- **horizontal tool exchange**
- see pages 199-201



horizontal



**ROL100 Clamping**

- for Punches Rollerri Type R1
- **vertical tool exchange**
- can be used **without modifying** Punches Rollerri Type R1
- safety guard
- including selectable intermediates
- manual and pneumatic models available
- see pages 202-203

NEW

vertical

**ROL1 Clamping**

- for Punches Rollerri Type R1
- **vertical tool exchange**
- **modification necessary:** Punches Rollerri Type R1 are equipped with spring-loaded balls
- safety guard
- including selectable intermediates
- manual, pneumatic and hydraulic models available
- dual sided clamping (KDS-System)
- see pages 204-205

vertical

**ROL4 Clamping**

- for Punches Rollerri Type R1
- **horizontal tool exchange**
- can be used **without modifying** Punches Rollerri Type R1
- safety guard
- including selectable intermediates
- manual and hydraulic models available
- dual sided clamping integrated
- see pages 205

horizontal

**W-ROL PN Clamping**

- for Punches Rollerri Type R2
- **vertical tool exchange** with ROL1-System and QuickLock-System
- Punches with Safety-Pins are inserted **horizontal**
- safety guard
- pneumatic model available only
- see page 206

vertical horizontal

**ROL3 Clamping**

- for Punches Rollerri Type R3/RX
- **vertical or horizontal tool exchange**
- custom manufacturing
- safety guard
- hydraulic model available only
- see page 207

vertical horizontal

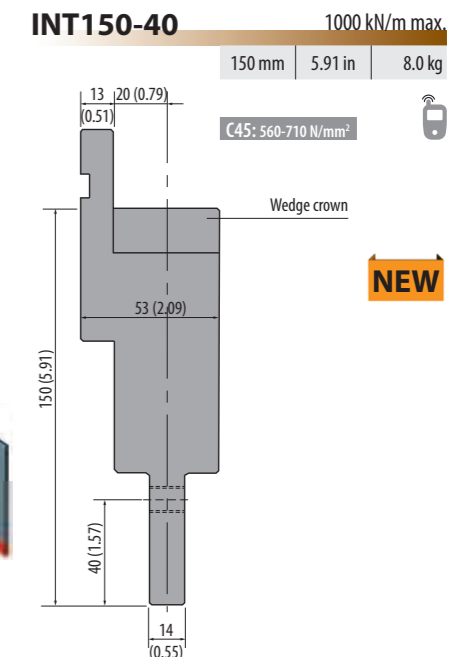
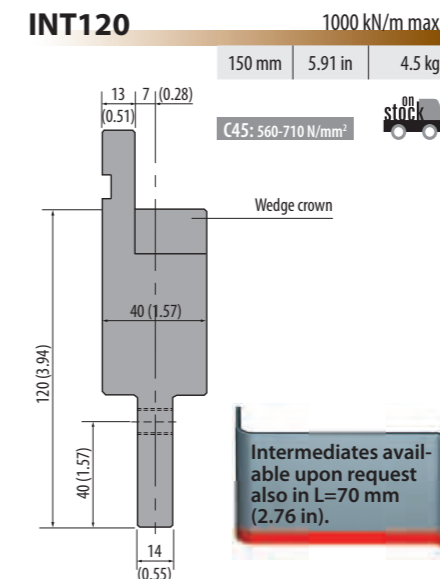
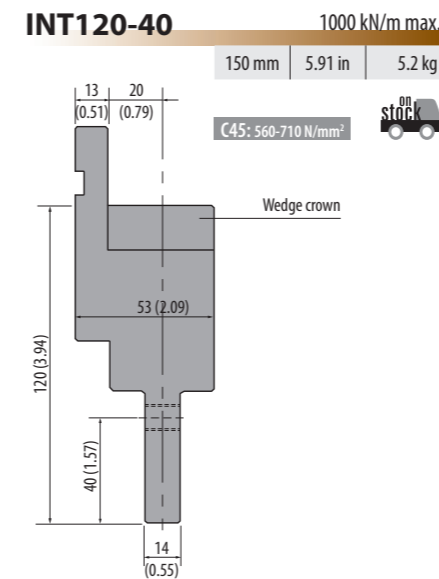
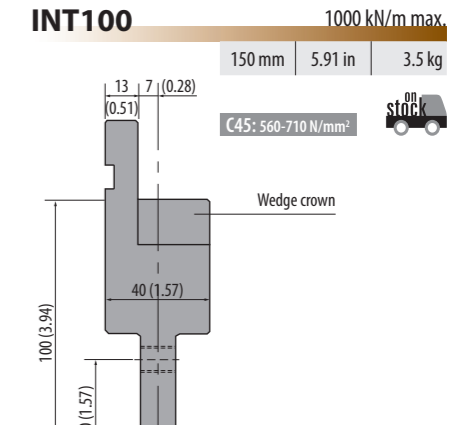
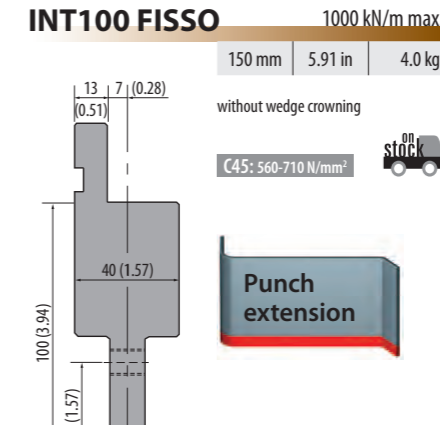
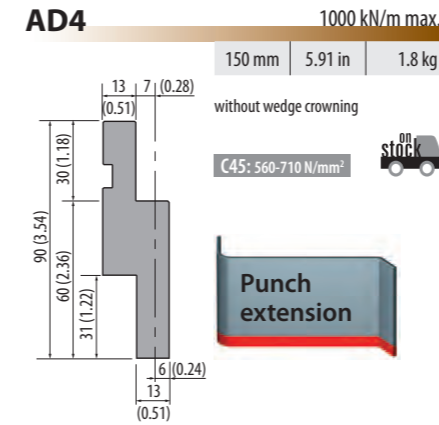
**ROL2 Clamping**

- for Dies Rollerri Type R1
- manual, pneumatic and hydraulic models available
- see pages 208-209

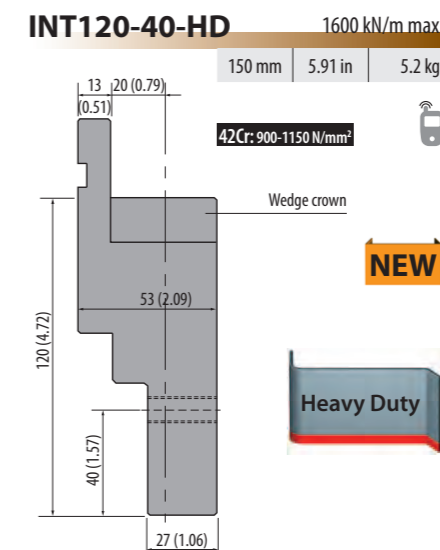
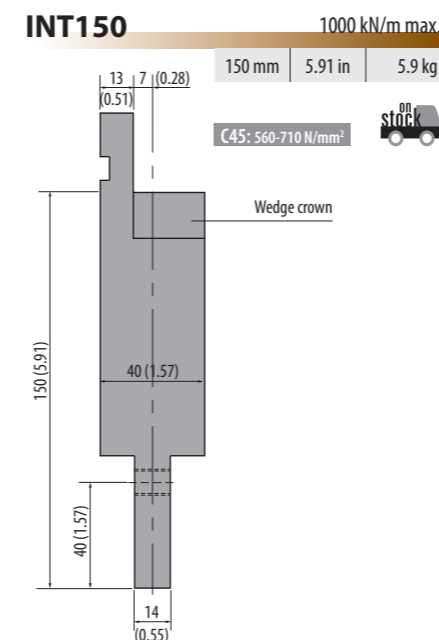
**Movable Die Clamps**

- for Dies Rollerri Type R1
- manual model available only
- see page 209

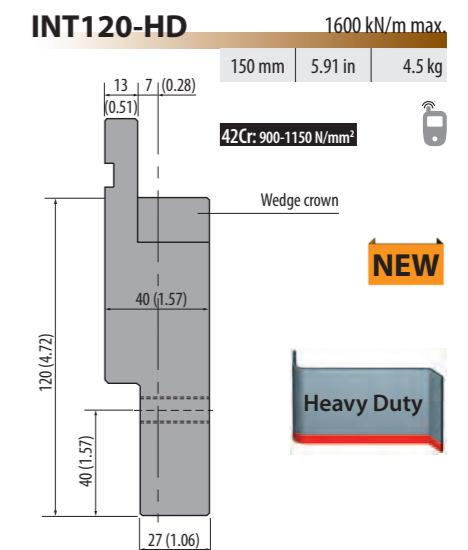
**Intermediates**



NEW



NEW



NEW

# R1 ROLLERI CLAMPING SYSTEMS

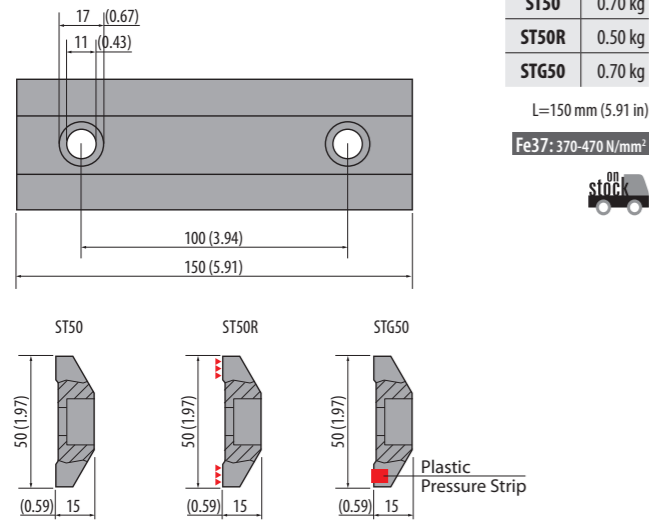
## Clamps

### Our Advantages – Your Convenience

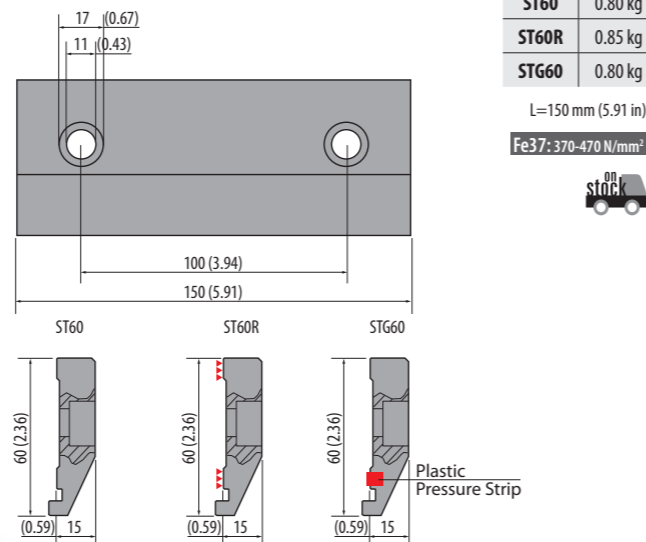
- Rapid Clamping Systems allow a fast horizontal tool exchange
- Plastic Pressure Strip improves the clamping especially with short tool pieces.

needed clamps	Length of press brake
4 pieces	835 mm (32.87 in)
6 pieces	1250 mm (49.21 in)
11 pieces	2100 mm (82.68 in)
14 pieces	2600 mm (102.36 in)
16 pieces	3100 mm (122.05 in)
21 pieces	4100 mm (161.42 in)

### ST50 / ST50R / STG50

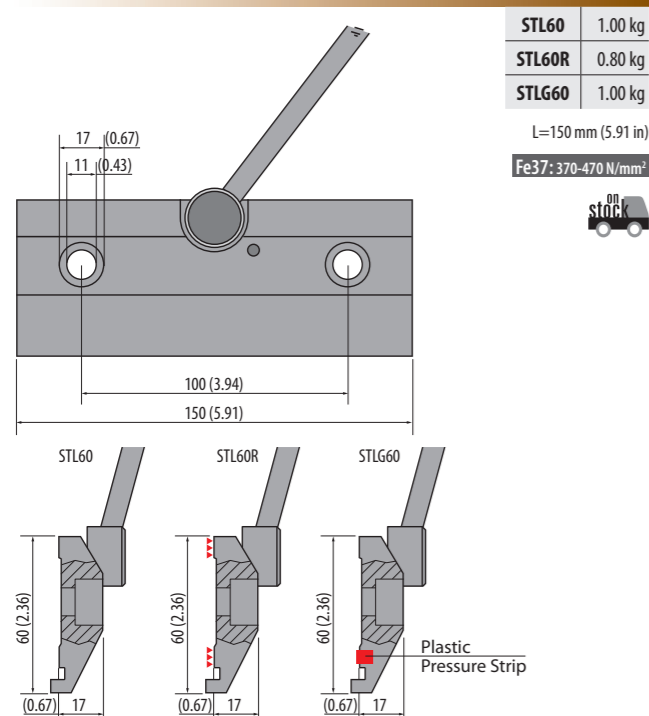


### ST60 / ST60R / STG60

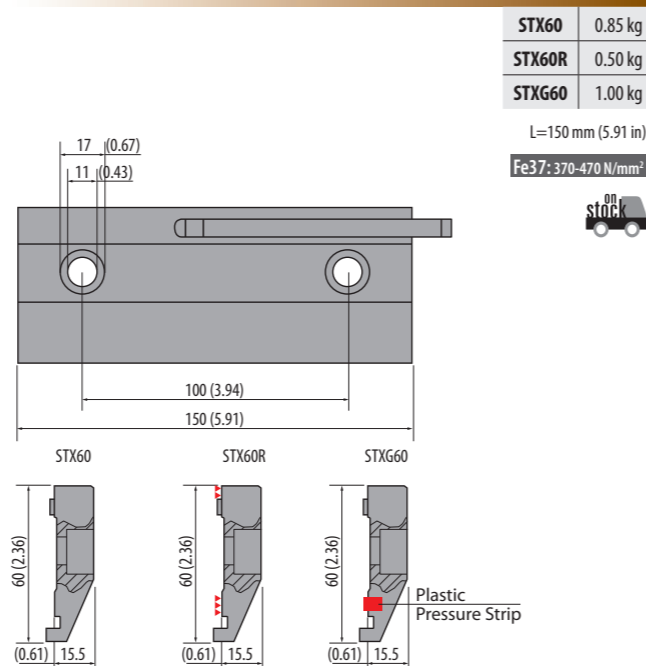


Compatible Intermediates on page 199

### STL60 / STL60R / STLG60



### STX60 / STX60R / STXG60

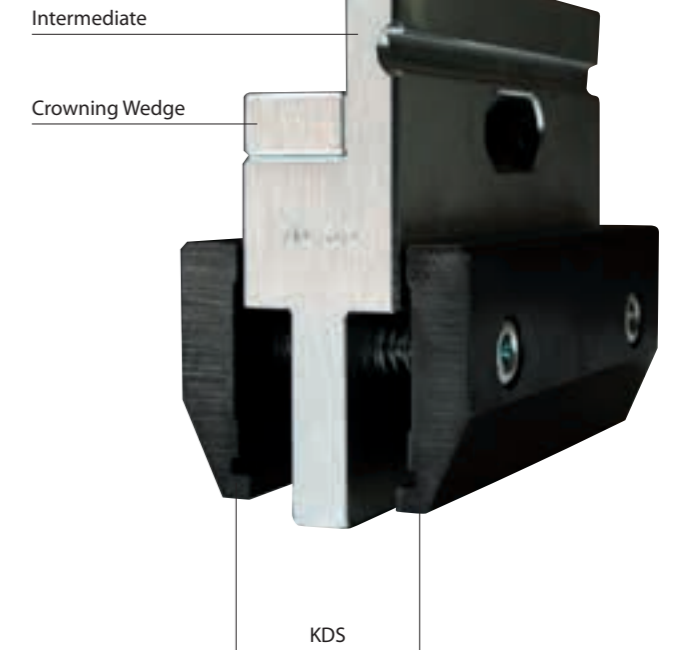
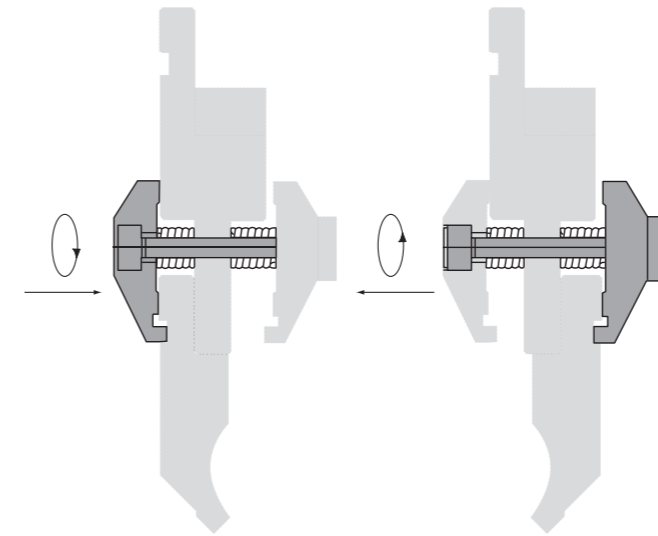
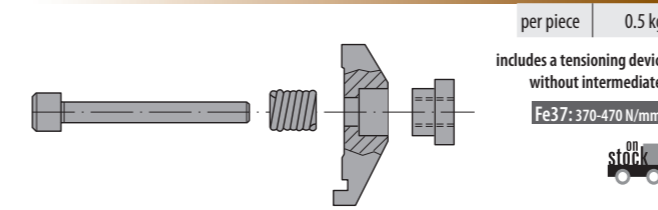


# R1 ROLLERI CLAMPING SYSTEMS

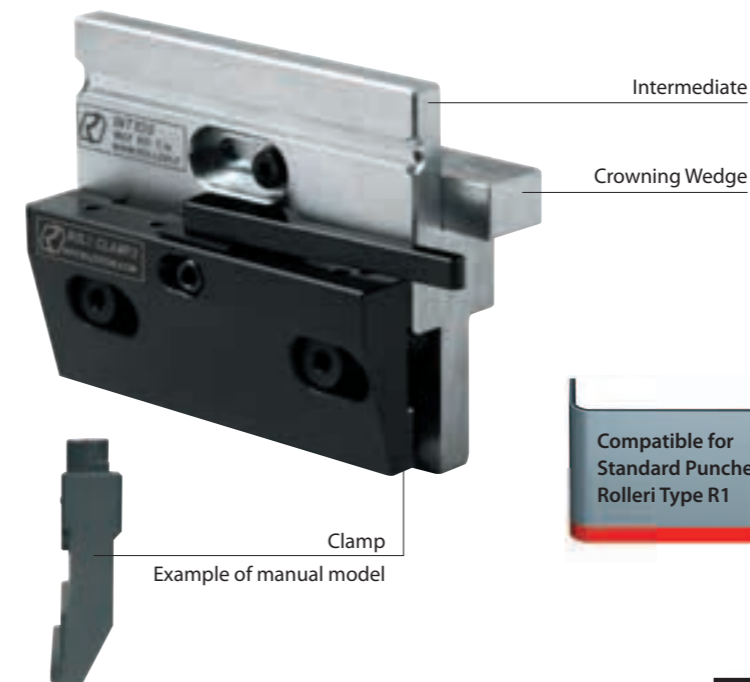
## Clamps



### KDS



### ROL1 CLAMP3 – manual – hydraulic – pneumatic



Compatible for Standard Punches Roller Type R1

Model	with Intermediate
ROL1 CLAMP3 manual	INT100
	INT120
	INT150
	INT100 FISSO
INT120-40	
ROL1 CLAMP3 manual without Intermediate	
Model	with Intermediate
ROL1 CLAMP3 hydraulic	INT100
	INT120
	INT150
	INT100 FISSO
INT120-40	
Model	with Intermediate
ROL1 CLAMP3 pneumatic	INT120
	INT150

L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates



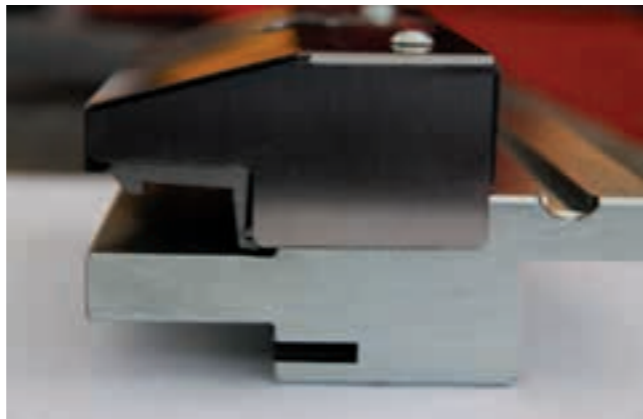
**Rolleri Videos**  
Application of Clamping System  
ROL1 CLAMP3: [www.rolleritools.com/videos/rol1-clamp3](http://www.rolleritools.com/videos/rol1-clamp3)

# R1 ROLLERI CLAMPING SYSTEMS

## ROL100-System for Punches Roller Type R1

### ... the newest innovation from our Research and Development Department

- fast **vertical** tool exchange for all Punches Roller Type R1
- can be used without modifying Punches Roller Type R1
- safe and fast tool exchange
- significant savings on your setup costs
- no falling out of tools
- available in manual and pneumatic models
- Mounting:  
Simply from the bottom into the housing, tighten – DONE!
- Disassembly:  
Untighten, gently lift tool and remove downwards.
- Easy to mount on your press brake.  
A conversion of the press brake is not necessary.
- For Press Brake Machines and Punches Roller Type R1:  
(ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.)



Articles on stock – Please note that delivery time varies according to your location. 



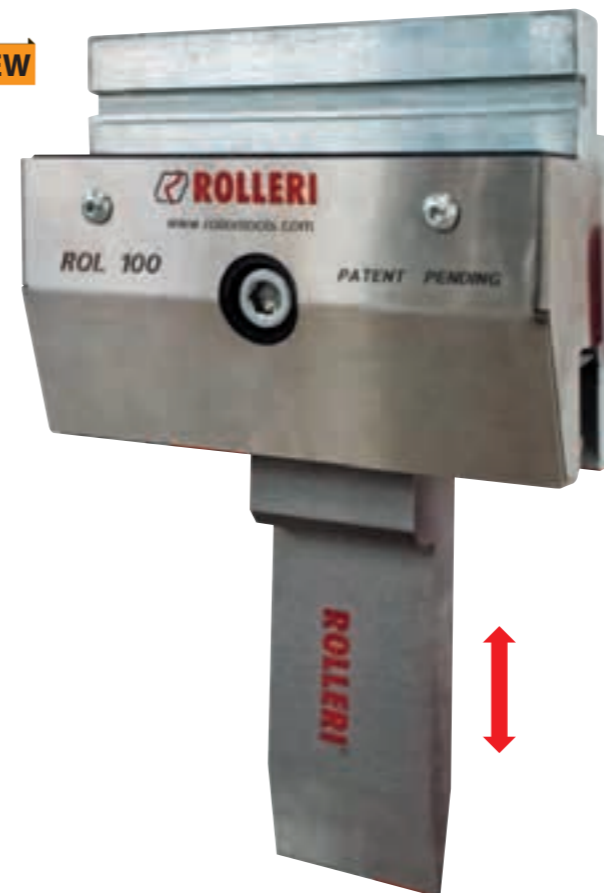
# R1 ROLLERI CLAMPING SYSTEMS

## ROL100-System for Punches Roller Type R1



### ROL100 – manual

**NEW**



Model	with Intermediate
ROL100 manual	INT100
	INT120
	INT150
	INT100 FISSO

 vertical

L=150 mm (5.91 in)  
vertical tool exchange  
including selectable intermediates



The ROL100-System is suited for Standard-Punches. There are no modifications necessary!

### ROL100 – pneumatic

**NEW**



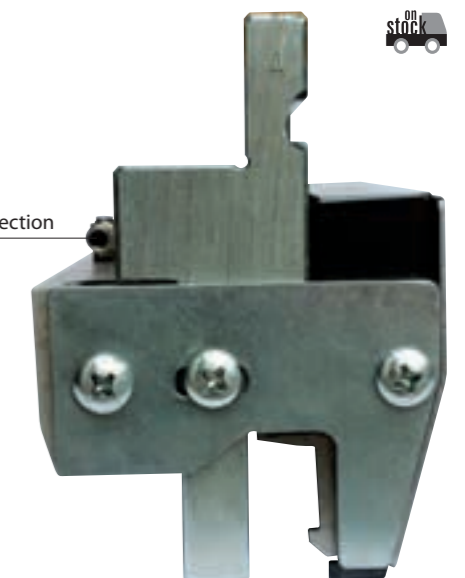
Model	with Intermediate
ROL100 pneumatic	INT100
	INT120
	INT150
	INT100 FISSO

 vertical

L=150 mm (5.91 in)  
vertical tool exchange  
including selectable intermediates



Pneumatic connection



# R1 ROLLERI CLAMPING SYSTEMS

## ROL1-System for Punches Roller Type R1

In order to use the ROL1 System, the punches are modified and equipped with spring-loaded balls.

ROL1 can be used on all press brakes with standard tang intermediates of Roller Type R1.

### Our Advantages – Your Convenience

- **vertical clamping** of tools is possible on press brakes thanks to a row of **spring-loaded balls** which are also used as **safety guards** to prevent the falling out of tools.
- complete mechanic functioning fast clamping system for press brake machines.
- Productivity and Versatility of the press brake machines will be increased.
- Significant **reduction in the set-up times** when changing tools



### ROL1 CLAMP1 – manual

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 CLAMP1	INT100	vertical
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	

ROL1 CLAMP1 without Intermediate



### Mounting example



### ROL1 PN CLAMP1 – pneumatic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 PN CLAMP1	INT120	vertical
	INT150	



**Rolleri Videos**  
Application of Clamping Systems  
ROL1 CLAMP1: [www.rolleritools.com/videos/rol1-clamp1](http://www.rolleritools.com/videos/rol1-clamp1)

# R1 ROLLERI CLAMPING SYSTEMS

## ROL1-System for Punches Roller Type R1



### ROL1 HYD CLAMP1 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 HYD CLAMP1	INT100	vertical
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



Detailed information about intermediates on page 199

### ROL1 KDS

Model	with Intermediate	with Clamp1	with Clamp3	L=150 mm vertical tool exchange including selectable intermediates
ROL1 KDS	INT100	vertical	horizontal	vertical
	INT120			
	INT150			
	INT100 FISSO			
	INT120-40			



## ROL4-System for Punches Roller Type R1

### ROL4 – manual

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates integrated KDS-System
ROL4 manual	INT100	horizontal
	INT120	
	INT150	
	INT100 FISSO	



### ROL4 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates integrated KDS-System
ROL4 hydraulic	INT100	horizontal
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



**Rolleri Videos**  
Application of hydraulic clamping ROL4  
[www.rolleritools.com/videos/rol4-hydraulic-clamping](http://www.rolleritools.com/videos/rol4-hydraulic-clamping)

The ROL4-System is suitable for Standard-Punches Roller Type R1. There are no modifications necessary!

# R2 ROLLERI CLAMPING SYSTEMS

W-ROL PN for Punches Roller Type R2

W-ROL PN – pneumatic

515 mm | 20.28 in | 26.8 kg/m

vertical



## Our Advantages – Your Convenience

- vertical tool exchange of punches with:
  - ROL1-System
  - QuickLock-System
- Horizontal tool exchange of punches with safety pins
- significantly more efficient bending productivity



# R3/RX ROLLERI CLAMPING SYSTEMS

ROL3-System for Punches Roller Type R3 and RX



ROL3 HYD – hydraulic

500 mm | 19.68 in

vertical

horizontal



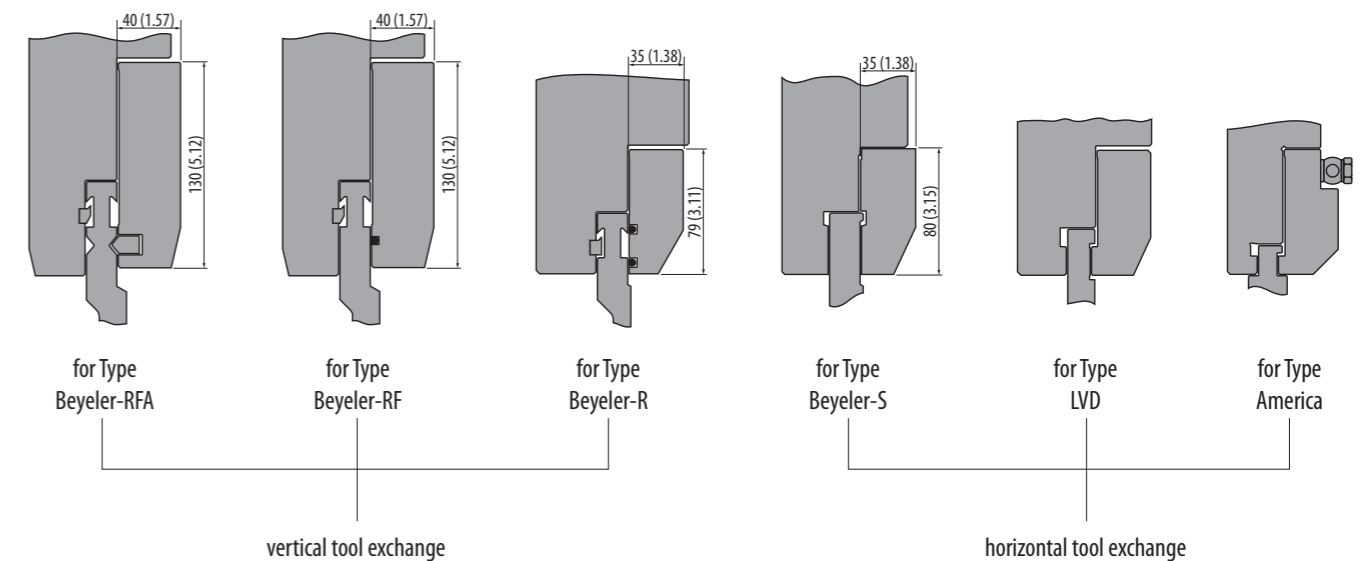
## Our Advantages – Your Convenience

- can be used on press brake machines with different tang types
- custom manufacturing possible upon request
- significantly more efficient bending productivity



Equip your press brake with our ROL3 system in order to use the advantages of a hydraulic clamping system!

## Examples of ROL3 with various systems





# R1 ROLLERI CLAMPING SYSTEMS

## ROL2-System for Dies Roller Type R1

### ■ Explanations

The **ROL2 System** is a system which is used to secure the die into place. It is made up of a special bar (known as **ROL2 CLAMP1**, L=500 mm / 19.68 in), which is operated through a centralized lever.

The **ROL2 System** has a built in spring mechanism and the clamp plates **ROL2 CLAMP1** are positioned in the inner lining of the system, which can be opened or tightened for the die to be perfectly secured.

A special rubber insert inside the clamp plates grants the best positioning for the tools. The press force of the clamp plates is evenly distributed along the complete length. Therefore short tools are also securely fastened.

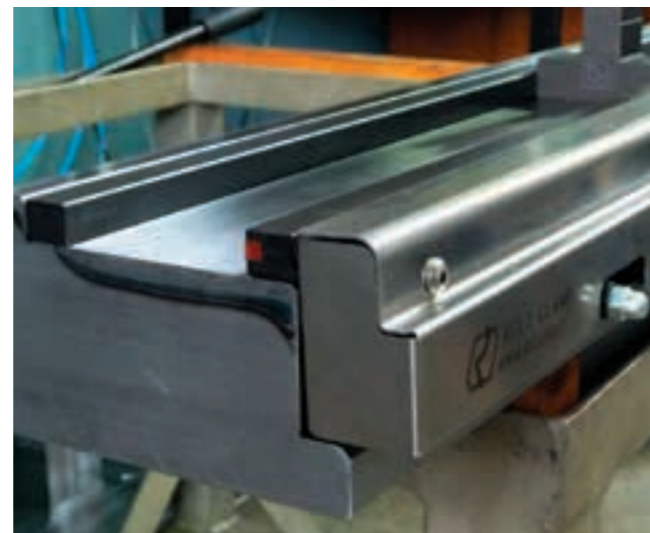
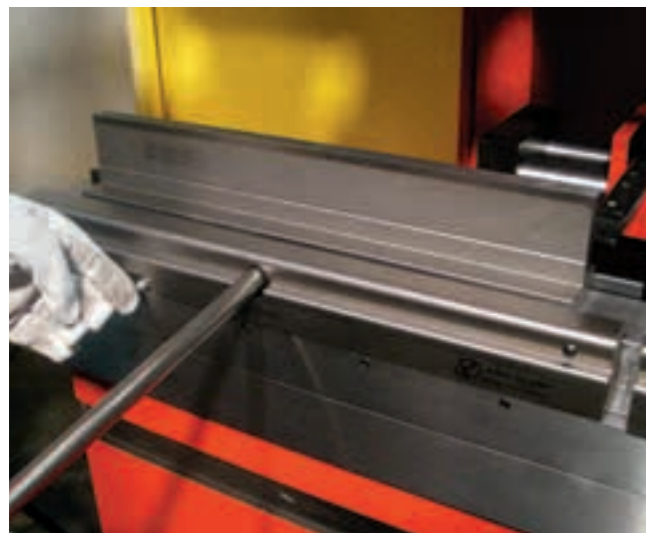
At a press brake of 3 meters (118.11 in), for example; all dies are secured with 6 simple hand movements.

### ■ Application

- **Directly on the die holder with 60 mm / 2.36 in width**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - alternatively modifications of the existing threaded holes necessary
  - system is compatible for press brakes with automatic coving tables
- **Directly on the die holder with 90 mm / 3.54 in width**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - alternatively modifications of the existing threaded holes necessary
  - for the use of dies Roller Type R1, two 15 mm / 0.59 in wide inserts are mounted and ground (securing with pins)
  - with rubber corners, the use of short tools is possible and are perfectly secured.
- **With Die Holder on the Die Rail**
  - 60 x 55 mm / 2.36 x 2.167 in die holder, ground and induction hardened.

### ■ Our Advantages – Your Convenience

- fast exchange of tools
- very time saving
- reduced production costs
- significantly increased profitability
- improved competitiveness



# R1 ROLLERI CLAMPING SYSTEMS

## ROL2-System for Dies Roller Type R1



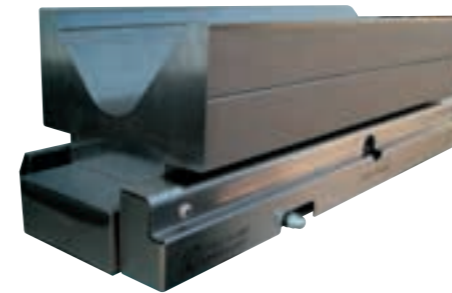
### ROL2 – manual

Clamp incl. Die holder		
table: 60 mm	2.36 in	38.0 kg
table: 90 mm	3.54 in	58.0 kg

only Clamp		
table: 60 mm	2.36 in	4.0 kg
table: 90 mm	3.54 in	4.5 kg

L=1075 mm (42.32 in)

L=500 mm (19.68 in)



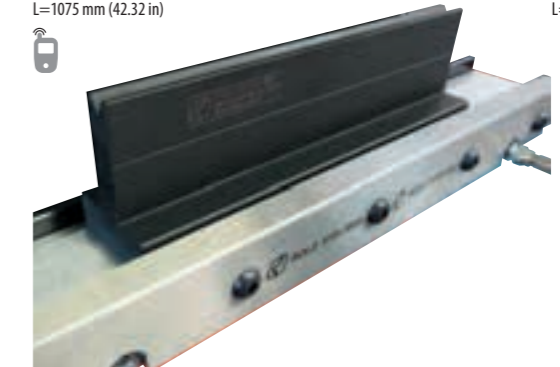
### ROL2 – hydraulic

Clamp incl. Die holder		
table: 60 mm	2.36 in	23.0 kg
table: 90 mm	3.54 in	31.7 kg

only Clamp		
table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	5.5 kg

L=1075 mm (42.32 in)

L=500 mm (19.68 in)



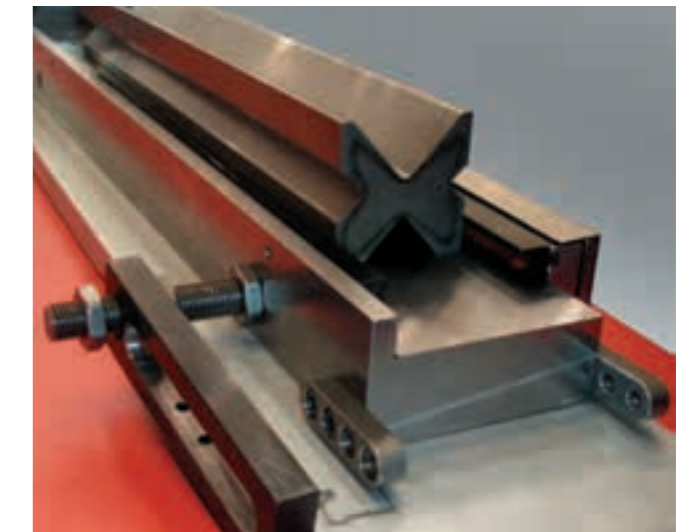
### ROL2 – pneumatic

Clamp incl. Die holder		
table: 60 mm	2.36 in	23.0 kg
table: 90 mm	3.54 in	31.7 kg

only Clamp		
table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	5.5 kg

L=1075 mm (42.32 in)

L=500 mm (19.68 in)



## Movable Die Clamps for Dies Roller Type R1

### ■ Our Advantages – Your Convenience

- lowerable clamping plate
- significantly easier exchange of tools, due the possibility of removing the tool by sliding it out and not lifting the tool.



### Rolleri Videos

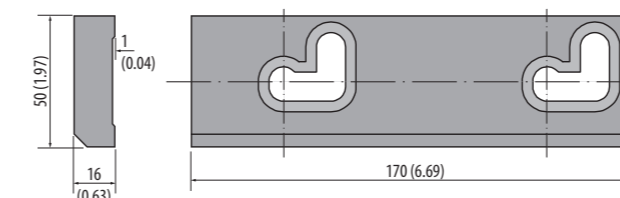
movable die holders ST50-S:  
[www.rolleritools.com/videos/movable-die-holders](http://www.rolleritools.com/videos/movable-die-holders)



### ST50-S

per piece 0.70 kg

Fe37: 370-470 N/mm<sup>2</sup>



## ROLLERI ADAPTERS

Punch Adapters	212 - 215
Bolted Adapters	216 - 217
Die Adapter Rails	218
Die Adapters	219 - 221
Modification: Wedge Bar / Tail	221




# ROLLERI ADAPTERS

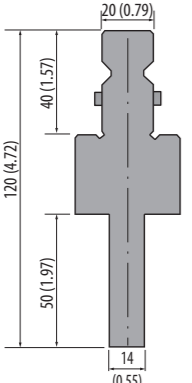
## Punch Adapters

**AD11** 1000 kN/m max.

150 mm	5.91 in	3.0 kg
--------	---------	--------

Rolleri Type R2  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

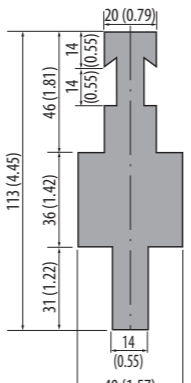


**AD22** 1000 kN/m max.

150 mm	5.91 in	3.4 kg
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Rolleri Type R3 Beyeler R  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

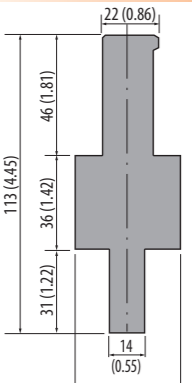


**AD3** 1000 kN/m max.

150 mm	5.91 in	3.3 kg
--------	---------	--------

Rolleri Type R3 Beyeler S  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

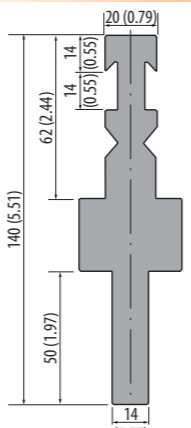


**AD10** 1000 kN/m max.

150 mm	5.91 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler RFA  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

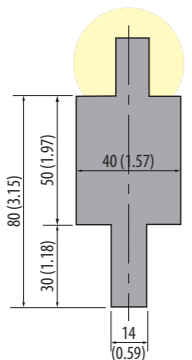


**AD1** 1000 kN/m max.

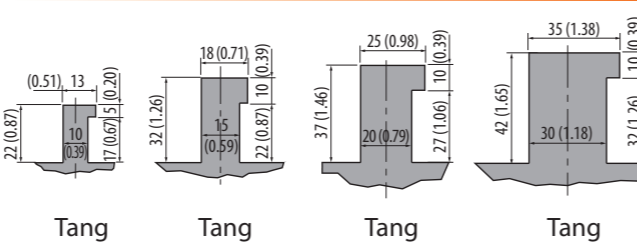
150 mm	5.91 in	3.1 kg
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Rolleri Type RX LVD  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup> 



**Tangs LVD**



Tang A: 22 (0.87) top width, 13 (0.51) stem height, 10 (0.39) stem width, 17 (0.67) stem height, 5 (0.20) stem width.

Tang B: 32 (1.26) top width, 18 (0.71) stem height, 10 (0.39) stem width, 22 (0.87) stem height, 10 (0.39) stem width.

Tang C: 37 (1.46) top width, 25 (0.98) stem height, 10 (0.39) stem width, 27 (1.06) stem height, 10 (0.39) stem width.

Tang D: 42 (1.65) top width, 35 (1.38) stem height, 10 (0.39) stem width, 32 (1.26) stem height, 10 (0.39) stem width.

With adapters you can use the vast amount of Punches Rolleri Type R1!

# ROLLERI ADAPTERS


## Punch Adapters

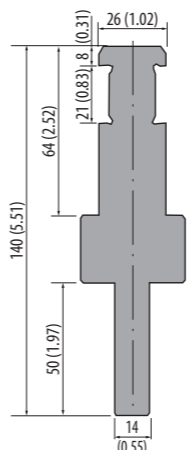


**AD13** 1000 kN/m max.

150 mm	5.91 in	3.0 kg
--------	---------	--------

Rolleri Type RX EHT  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

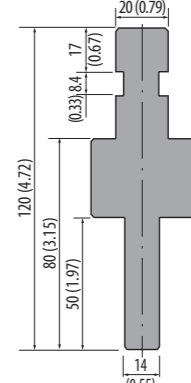


**AD14** 1000 kN/m max.

150 mm	5.91 in	3.2 kg
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Rolleri Type RX Gasparini  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

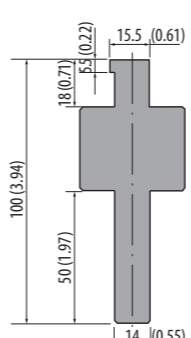


**AD15** 1000 kN/m max.

150 mm	5.91 in	4.0 kg
--------	---------	--------

Rolleri Type RX Ajjal-Axial  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

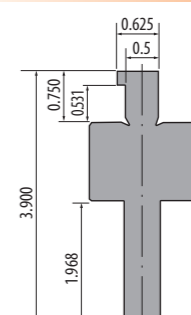


**AD16** 1000 kN/m max.

5.9 inch	5.91 in	4.0 kg
----------	---------	--------

Rolleri Type American  
→ Rolleri Type R1


C45: 560-710 N/mm<sup>2</sup> 

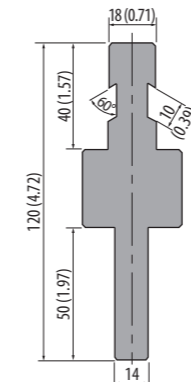


**AD12** 1000 kN/m max.

150 mm	5.91 in	1.5 kg
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Rolleri Type RX Colgar  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup> 




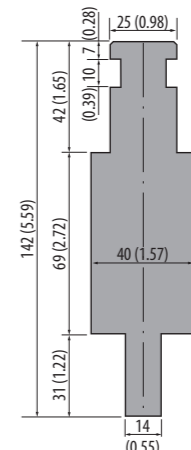
**AD23** 1000 kN/m max.

**NEW**

150 mm	5.91 in	5.0 kg
--------	---------	--------

Rolleri Type RX Weinbrenner  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup> 

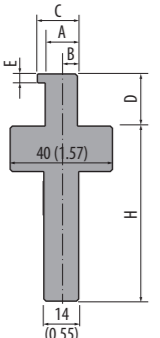


# ROLLERI ADAPTERS

## Punch Adapters

**ADX** 1000 kN/m max.

150 mm	5.91 in	3.5 kg
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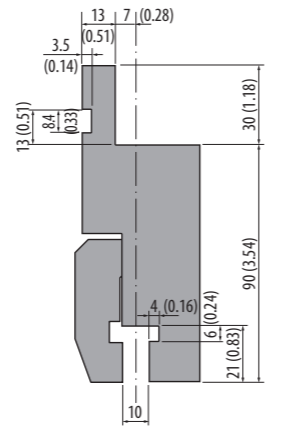
Type X  
→ **Rolleri Type R1**

Production according to your specifications

C45: 560-710 N/mm<sup>2</sup>

**AD19-A** 1000 kN/m max.

150 mm	5.91 in	6.0 kg
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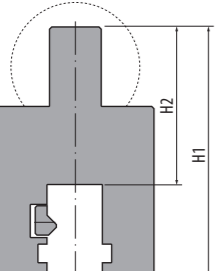
Rolleri Type R1  
→ **Rolleri Type RX LVD**

C45: 560-710 N/mm<sup>2</sup>

**ADX2** 1000 kN/m max.

**NEW**

150 mm	5.91 in	4.0 kg
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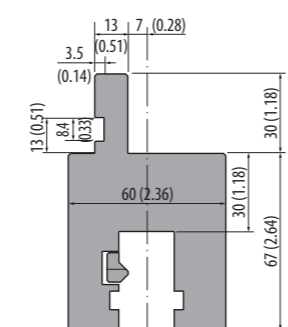
Type X  
→ **Rolleri Type R2**

Production according to your specifications

C45: 560-710 N/mm<sup>2</sup>

**AD20** 1000 kN/m max.

150 mm	5.91 in	4.0 kg
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Rolleri Type R1  
→ **Rolleri Type R2**

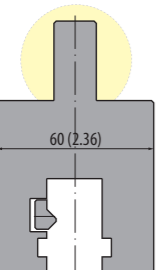
C45: 560-710 N/mm<sup>2</sup>

**Pneumatic Adapters**  
see page 206

**AD20 LVD** 1000 kN/m max.

**NEW**

Tang A: AD20 LVD-A	150 mm	5.91 in	3.6 kg
Tang B: AD20 LVD-B	150 mm	5.91 in	3.8 kg
Tang C: AD20 LVD-C	150 mm	5.91 in	4.0 kg
Tang D: AD20 LVD-D	150 mm	5.91 in	4.0 kg



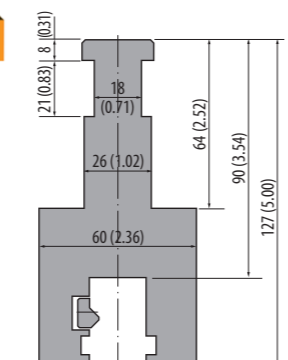
Rolleri Type RX LVD  
→ **Rolleri Type R2**

C45: 560-710 N/mm<sup>2</sup>

**AD28** 1000 kN/m max.

**NEW**

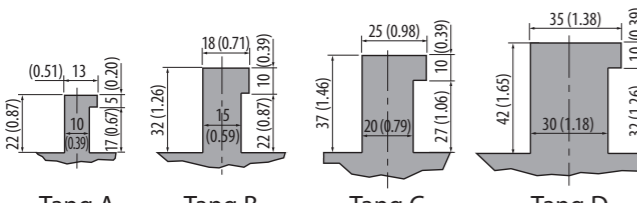
150 mm	5.91 in	5.0 kg
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Rolleri Type RX EHT  
→ **Rolleri Type R2**

C45: 560-710 N/mm<sup>2</sup>

**Tangs LVD**



Tang A: 22 (0.87), 13 (0.51), 10 (0.39), 17 (0.67), 5 (0.20)

Tang B: 32 (1.26), 18 (0.71), 15 (0.59), 22 (0.87), 10 (0.39)

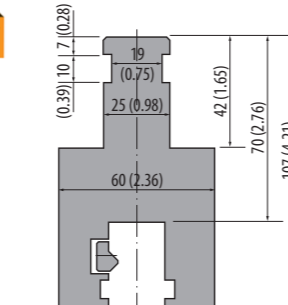
Tang C: 25 (0.98), 37 (1.46), 20 (0.79), 27 (1.06), 10 (0.39)

Tang D: 35 (1.38), 42 (1.65), 30 (1.18), 32 (1.26), 10 (0.39)

**AD29** 1000 kN/m max.

**NEW**

150 mm	5.91 in	4.5 kg
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Rolleri Type RX Weinbrenner  
→ **Rolleri Type R2**

C45: 560-710 N/mm<sup>2</sup>

**Rolleri Videos**

Bolted Adapters AW, P. 216-217

[www.rolleritools.com/videos/bolted-adapters](http://www.rolleritools.com/videos/bolted-adapters)

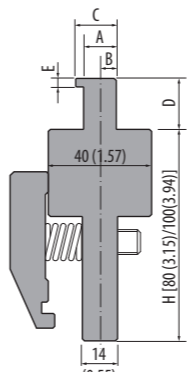



# ROLLERI ADAPTERS

## Punch Adapters

**INT80-100** 1000 kN/m max.

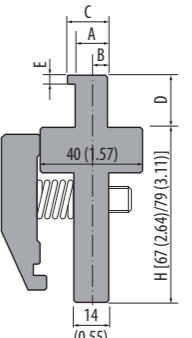
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg



C45: 560-710 N/mm<sup>2</sup>

**INT67-79** 1000 kN/m max.

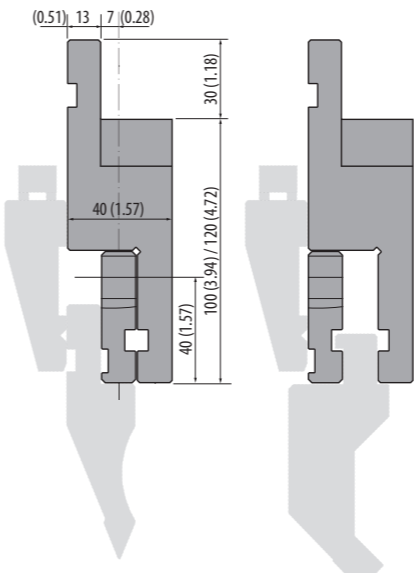
835 mm	32.87 in	20.5 kg
415 mm	16.34 in	10.0 kg



C45: 560-710 N/mm<sup>2</sup>

**INT100-A / INT120-A** 1000 kN/m max.

<b>INT100-A</b>	150 mm	5.91 in	3.5 kg
<b>INT120-A</b>	150 mm	5.91 in	5.2 kg



C45: 560-710 N/mm<sup>2</sup>

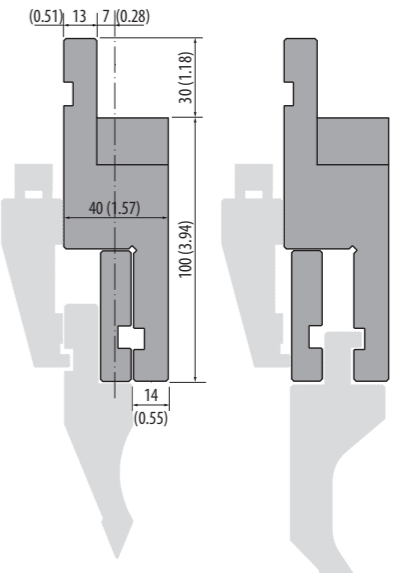
**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Pneumatic system only on INT120-A (ROL1 Clamp3 PN), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

**horizontal**

**INT100-N (Newton)** 1000 kN/m max.

150 mm	5.91 in	3.5 kg
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C45: 560-710 N/mm<sup>2</sup>

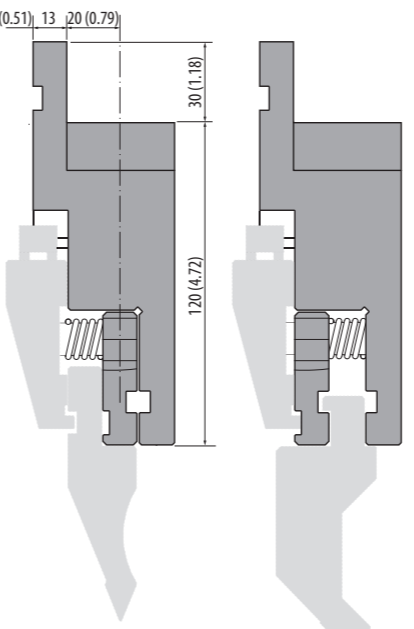
**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

**horizontal**

**INT120-40-A** 1000 kN/m max.

150 mm	5.91 in	6.0 kg
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C45: 560-710 N/mm<sup>2</sup>

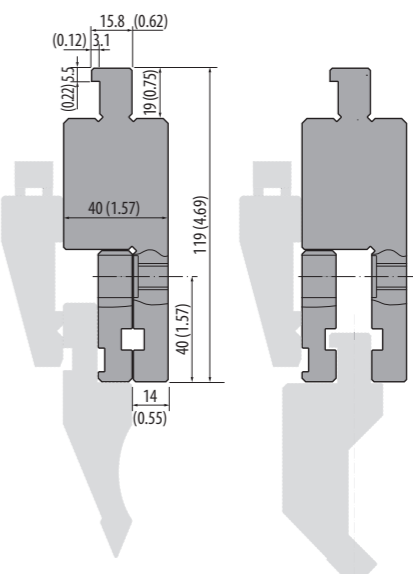
**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201

**horizontal**

**INT100-A (American)** 1000 kN/m max.

150 mm	5.91 in	3.5 kg
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C45: 560-710 N/mm<sup>2</sup>

**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

**horizontal**

# ROLLERI ADAPTERS

## Bolted Adapters

**AW11** 1000 kN/m max.

**NEW**

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	2.9 kg

Rolleri Type R2  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

Do you prefer our QuickLock or ROL1-System? Contact us now!

**AW3** 1000 kN/m max.

**NEW**

835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
805 mm segmented	31.69 in segmented	8.7 kg

Rolleri Type R3 Beyeler S  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW10** 1000 kN/m max.

**NEW**

835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
805 mm segmented	31.69 in segmented	9.6 kg

Rolleri Type R3 Beyeler RFA  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW12** 1000 kN/m max.

**NEW**

835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.5 kg
805 mm segmented	31.69 in segmented	6.7 kg

Rolleri Type RX Colgar  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-A** 1000 kN/m max.

**NEW**

835 mm	32.87 in	4.5 kg
415 mm	16.34 in	2.2 kg
805 mm segmented	31.69 in segmented	4.3 kg

Rolleri Type RX LVD A  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-B** 1000 kN/m max.

**NEW**

835 mm	32.87 in	6.3 kg
415 mm	16.34 in	3.1 kg
805 mm segmented	31.69 in segmented	6.0 kg

Rolleri Type RX LVD B  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-C** 1000 kN/m max.

**NEW**

835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
805 mm segmented	31.69 in segmented	9.4 kg

Rolleri Type RX LVD C  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-D** 1000 kN/m max.

**NEW**

835 mm	32.87 in	11.5 kg
415 mm	16.34 in	5.7 kg
805 mm segmented	31.69 in segmented	11.1 kg

Rolleri Type RX LVD D  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

# ROLLERI ADAPTERS

## Bolted Adapters



**AW13** 1000 kN/m max.

**NEW**

835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.3 kg
805 mm segmented	31.69 in segmented	12.1 kg

Rolleri Type RX EHT  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW14** 1000 kN/m max.

**NEW**

835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
805 mm segmented	31.69 in segmented	7.7 kg

Rolleri Type RX Gasparini  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW15** 1000 kN/m max.

**NEW**

835 mm	32.87 in	4.6 kg
415 mm	16.34 in	2.3 kg
805 mm segmented	31.69 in segmented	4.4 kg

Rolleri Type RX Ajial-Axial  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AWC16** 1000 kN/m max.

**NEW**

835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

Rolleri Type RX Colly  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AWC13.5** 1000 kN/m max.

**NEW**

835 mm	32.87 in	4.8 kg
415 mm	16.34 in	2.4 kg
805 mm segmented	31.69 in segmented	4.6 kg

Rolleri Type RX Colly  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AWX** 1000 kN/m max.

**NEW**

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	3.0 kg

Individual  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**INT35** 1000 kN/m max.

**NEW**

835 mm	32.87 in	4.0 kg
525 mm	20.67 in	2.5 kg
805 mm segmented	31.69 in segmented	3.9 kg

C45: 560-710 N/mm<sup>2</sup>

**INT35-A** 1000 kN/m max.

**NEW**

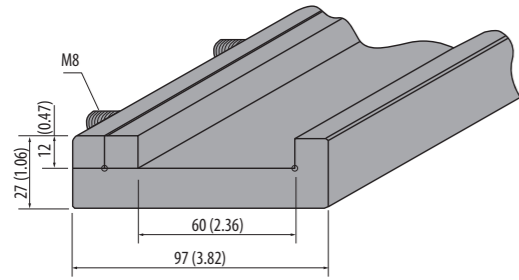
835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

C45: 560-710 N/mm<sup>2</sup>

# ROLLERI ADAPTERS

## Die Adapter Rails

### C 2000/S / C 2500/S / C 3000/S / C 4000/S



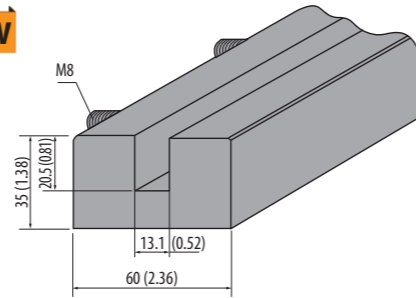
Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm<sup>2</sup>

### TC 2000/S / TC 2500/S / TC 3000/S / TC 4000/S

**NEW**

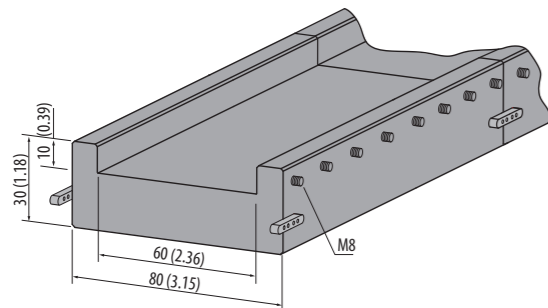


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm<sup>2</sup>

### C 1050/R

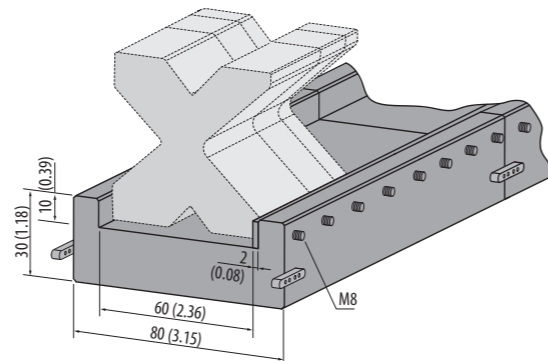


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg



C45: 560-710 N/mm<sup>2</sup>

### C 1050/RS

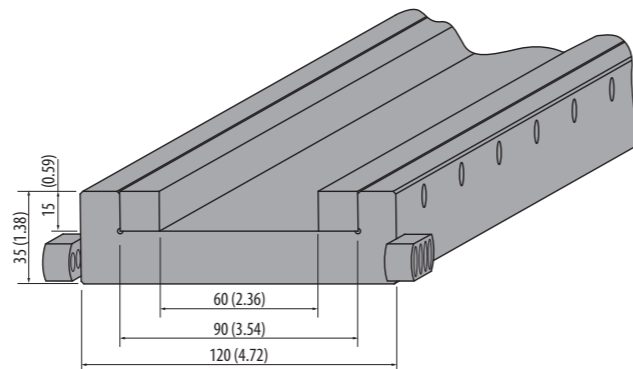
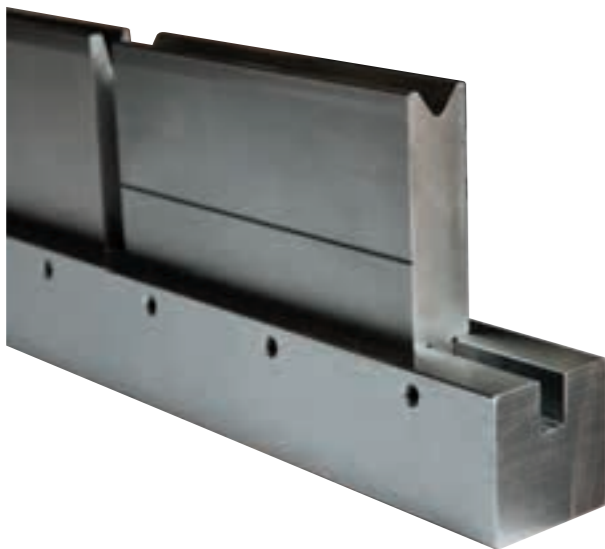


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



C45: 560-710 N/mm<sup>2</sup>

### C 1050-90



Model	Length (mm)	Length (in)	Weight
C 1050-90	1050	41.34	27.2 kg
C 1050-90/C	520	20.47	13.5 kg



C45: 560-710 N/mm<sup>2</sup>

# ROLLERI ADAPTERS

## Die Adapters



### AD6

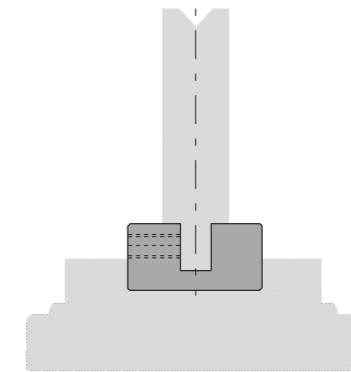
1000 kN/m max.

1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>

### AD6 Example of Application



### AD5

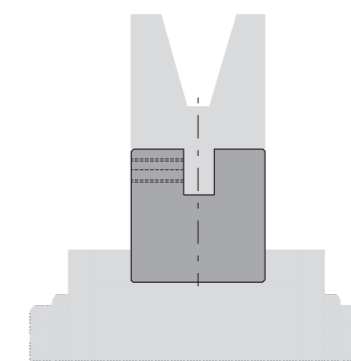
1000 kN/m max.

1000 mm	39.37 in	26.1 kg
500 mm	19.68 in	13.0 kg

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>

### AD5 Example of Application



### AD7

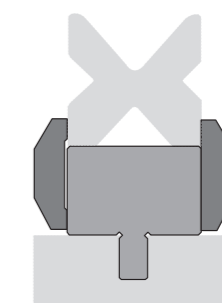
1000 kN/m max.

835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

### AD7 Example of Application



### AD24

1000 kN/m max.

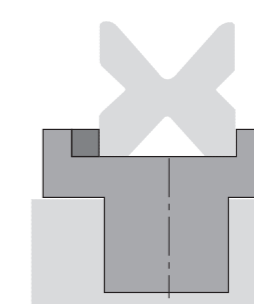
835 mm	32.87 in	28.5 kg
415 mm	16.34 in	14.2 kg

**NEW**

Rolleri Type RX EHT  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

### AD24 Example of Application

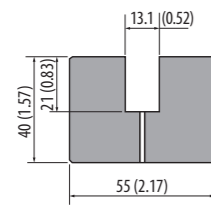


## ROLLERI ADAPTERS

### Die Adapters

#### AD25

**NEW**



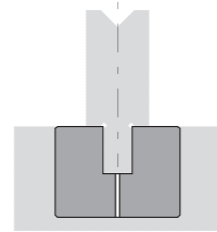
1000 kN/m max.  
500 mm 19.68 in 7.5 kg

Rolleri Type RX EHT  
→ Rolleri Type R2/R3

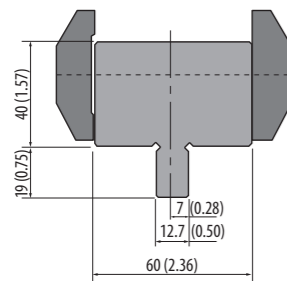
C45: 560-710 N/mm<sup>2</sup>



#### AD25 Example of Application



#### AD9-12.7



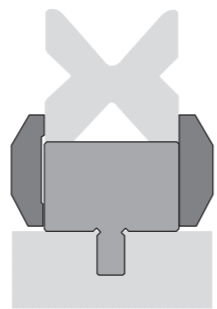
1000 kN/m max.  
835 mm 32.87 in 17.0 kg  
415 mm 16.34 in 8.5 kg

Rolleri Type RX LVD  
→ Rolleri Type R1

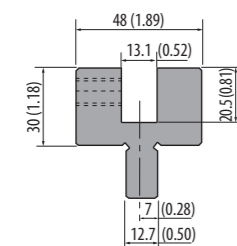
C45: 560-710 N/mm<sup>2</sup>



#### AD9-12.7 Example of Application



#### AD8-12.7



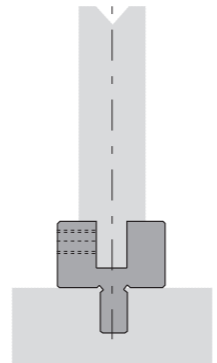
1000 kN/m max.  
1000 mm 39.37 in 15.0 kg  
500 mm 19.68 in 7.5 kg

Rolleri Type RX LVD  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>

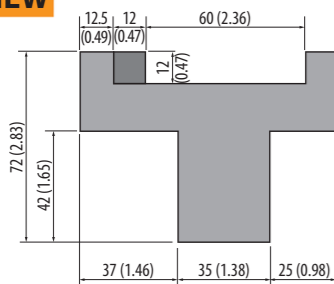


#### AD8-12.7 Example of Application



#### AD26

**NEW**



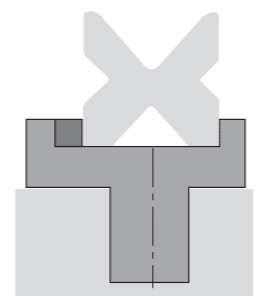
1000 kN/m max.  
835 mm 32.87 in 23.0 kg  
415 mm 16.34 in 11.4 kg

Rolleri Type RX  
Weinbrenner  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



#### AD26 Example of Application



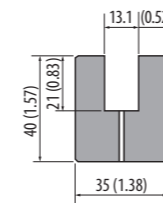
## ROLLERI ADAPTERS

### Die Adapters



#### AD27

**NEW**



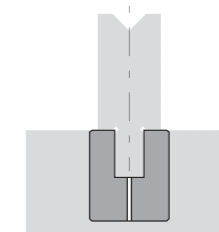
1000 kN/m max.  
500 mm 19.68 in 4.5 kg

Rolleri Type RX  
Weinbrenner  
→ Rolleri Type R2/R3

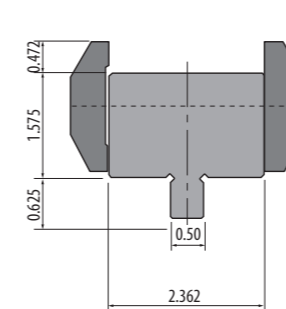
C45: 560-710 N/mm<sup>2</sup>



#### AD27 Example of Application



#### AD17



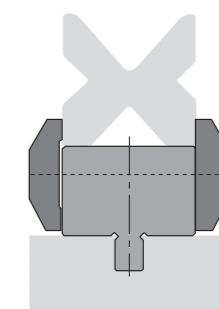
1000 kN/m max.  
835 mm 32.87 in 18.0 kg  
415 mm 16.34 in 9.0 kg

Type American  
→ Rolleri Type R1

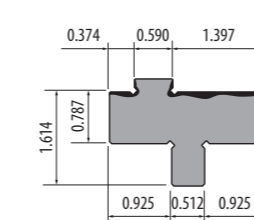
C45: 560-710 N/mm<sup>2</sup>



#### AD17 Example of Application



#### AD18



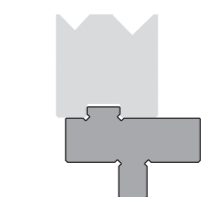
1000 kN/m max.  
835 mm 32.87 in 18.0 kg  
415 mm 16.34 in 9.0 kg

Type American  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



#### AD18 Example of Application



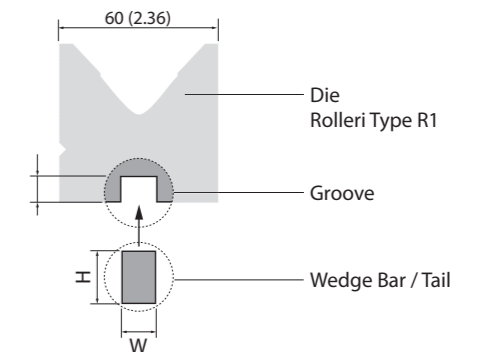
### Modification: Wedge Bar / Tail

In order to use the dies Rolleri Type R1 on other press brake machines, a 10 mm (0.39 in) groove is milled to insert a ground wedge bar / tail into the die.

Wedge Bar / Tail (W x H)	System
13 x 30 mm (0.51 x 1.18 in)	Rolleri Type R2 and R3 (Bystronic-Beyeler/Safan/Trumpf etc.)
55 x 55 mm (2.17 x 2.17 in)	Rolleri Type RX EHT
12.7 x 29 mm (0.50 x 1.14 in)	Rolleri Type RX LVD
35 x 55 mm (1.38 x 2.17 in)	Rolleri Type RX Weinbrenner

Specific information and prizes are found in the Rolleri Service / Modifications Chapter (see page 252)

### Mounting example



## ROLLERI MARK FREE BENDING

Prevention of Bending Marks	224
Bending Foil Holder/Tensioner	224
Bending Foil	225
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## ROLLERI MARK FREE BENDING

### Prevention of Bending Marks

One of the challenges of bending is to prevent the profile of having bending marks, such as; scratches and abrasions on the surface areas.

Especially of Profile made of:

- Stainless Steel
- Aluminium
- painted metal panels

It is often the case of a line building from the contact of the sheet metal with the die. This is the cause of friction of sheet metal on small radius.

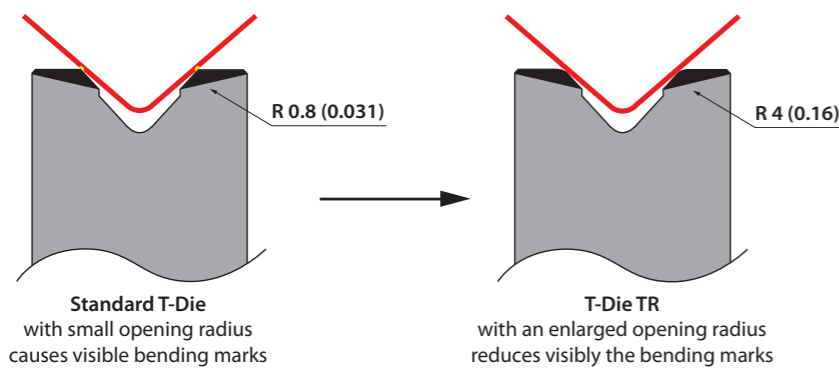
In order to prevent this markings, the following solutions are possible:

- Bending Foil
- PU-Upholstery
- Plastic Dies
- enlarged opening radius on special T-Dies



### Our Advantages – Your Convenience

- Prevention of scratches and abrasions on bent sheet metals
- No post-processing necessary, therefore time and cost saving
- No contamination of bended pieces
- increases the product quality
- easy handling



T-Dies (TR) with an enlarged opening radius for the prevention of bending marks see pages 54-55, 60-61

### Bending Foil - Holder / Tensioner

CT



## ROLLERI MARK FREE BENDING

### Bending Foil



### Our Advantages – Your Convenience

- easy handling
- can be used flexibly
- Prevention of Bending Marks
- decrease of post-processing of bent parts
- no contamination of the material
- increased product quality

Bending Foil:  
Practical, easy and economic!



### ROLFILM



Model	Thickness (mm)	Thickness (in)	Width (mm)	Width (in)	Length (m)	Length (in)
Rolfilm 3-0.4-100	0.4	0.016	100	3.94	3	118.11
Rolfilm 10-0.4-100	0.4	0.016	100	3.94	10	393.70
Rolfilm 20-0.4-100	0.4	0.016	100	3.94	20	787.40
Rolfilm 30-0.4-100	0.4	0.016	100	3.94	30	1181.10
Rolfilm 3-0.4-150	0.4	0.016	150	5.91	3	118.11
Rolfilm 10-0.4-150	0.4	0.016	150	5.91	10	393.70
Rolfilm 20-0.4-150	0.4	0.016	150	5.91	20	787.40
Rolfilm 30-0.4-150	0.4	0.016	150	5.91	30	1181.10
Rolfilm 3-0.6-150	0.6	0.024	150	5.91	3	118.11
Rolfilm 10-0.6-150	0.6	0.024	150	5.91	10	393.70
Rolfilm 20-0.6-150	0.6	0.024	150	5.91	20	787.40
Rolfilm 30-0.6-150	0.6	0.024	150	5.91	30	1181.10
Rolfilm 3-0.6-200	0.6	0.024	200	7.87	3	118.11
Rolfilm 10-0.6-200	0.6	0.024	200	7.87	10	393.70
Rolfilm 20-0.6-200	0.6	0.024	200	7.87	20	787.40
Rolfilm 30-0.6-200	0.6	0.024	200	7.87	30	1181.10
Rolfilm 3-2-150	2.0	0.079	150	5.91	3	118.11
Rolfilm 10-2-150	2.0	0.079	150	5.91	10	393.70
Rolfilm 20-2-150	2.0	0.079	150	5.91	20	787.40
Rolfilm 30-2-150	2.0	0.079	150	5.91	30	1181.10



### Rolleri Videos

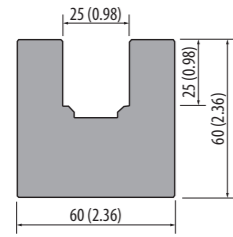
mark free bending:  
[www.rolleritools.com/videos/mark-free-bending](http://www.rolleritools.com/videos/mark-free-bending)



# ROLLERI MARK FREE BENDING

## PU-Holders and PU-Upholstery

### MPG25

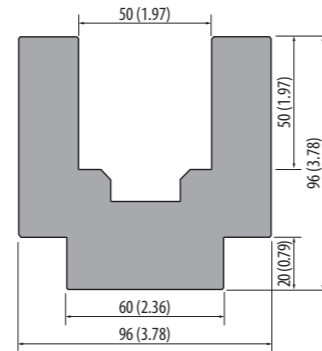


835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg

C45: 560-710 N/mm<sup>2</sup>



### MPG50

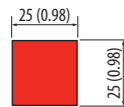


835 mm	32.87 in	44.0 kg
415 mm	16.34 in	22.0 kg

C45: 560-710 N/mm<sup>2</sup>



### GM 25x25

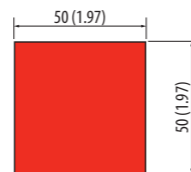


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane



### GM 50x50

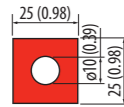


835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

polyurethane



### GMF 25x25x10

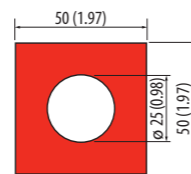


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane



### GMF 50x50x25



835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

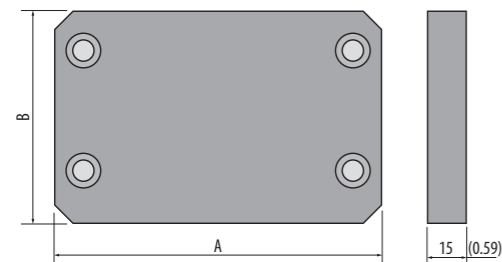
polyurethane



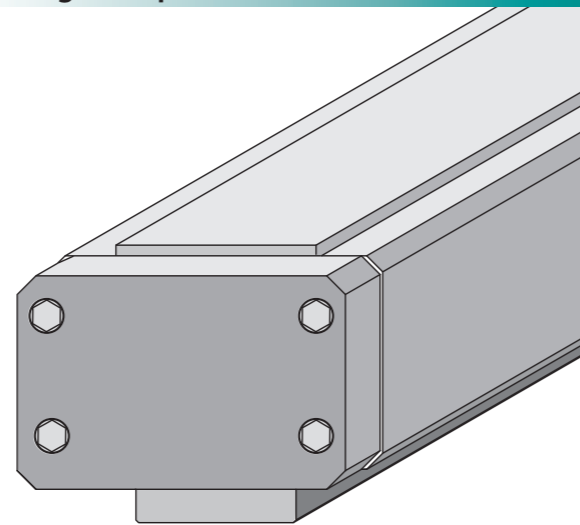
### PSTCON

cover plate	Model	A (mm)	A (in)	R (mm)	R (in)	Weight
	PSTCON25	58	2.28	58	2.28	1.2 kg
	PSTCON50	108	4.25	75	2.95	0.6 kg
	PSTCON75	123	4.84	80	3.15	0.8 kg
	PSTCON100	153	6.02	80	3.15	1.0 kg

C45: 560-710 N/mm<sup>2</sup>



### Mounting example

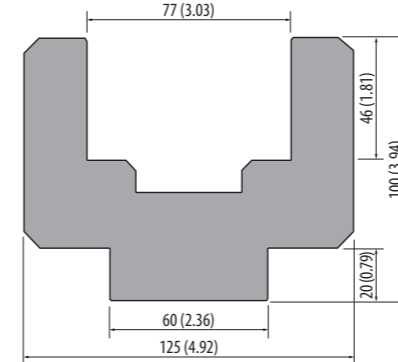


# ROLLERI MARK FREE BENDING

## PU-Holders and PU-Upholstery



### MPG75

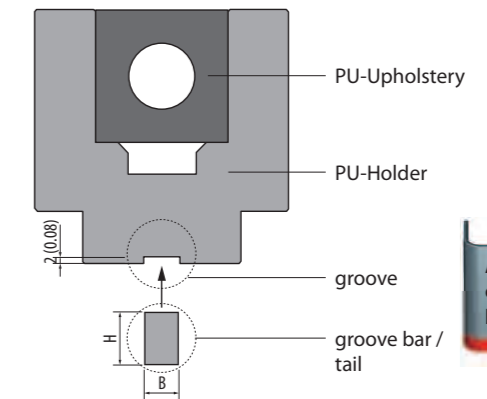


835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg

C45: 560-710 N/mm<sup>2</sup>



### Mounting example



Also mountable on other press brakes!

### GM 75x50

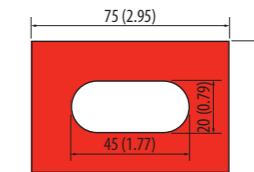


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane



### GMF 75x50x20

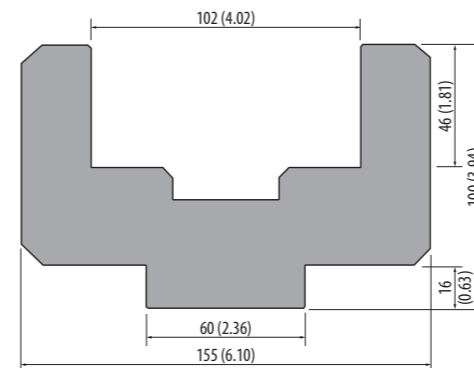


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane



### MPG100



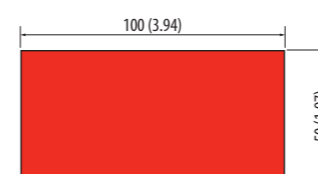
835 mm	32.87 in	55.0 kg
415 mm	16.34 in	27.5 kg

C45: 560-710 N/mm<sup>2</sup>



PU-Upholstery are suitable for radius- and U-profile bendings, etc.

### GM 100x50

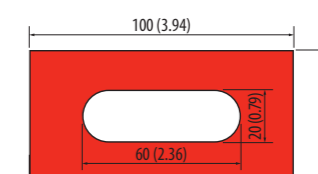


835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg

polyurethane



### GMF 100x50x20



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	2.2 kg

polyurethane



# ROLLERI MARK FREE BENDING

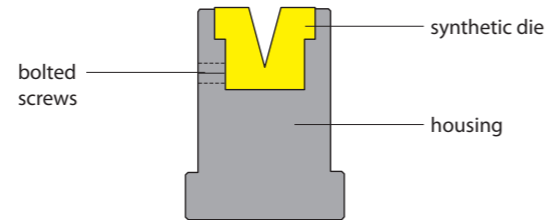
## Synthetic Dies

### Our Advantages – Your Convenience

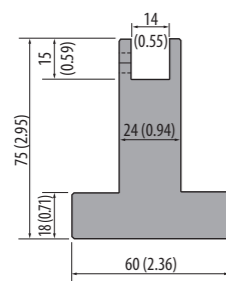
- easy Handling
- faster and easier exchange of plastic dies
- prevention of bending marks
- decrease of post-processing of bent pieces
- no contamination of the materials
- increased product quality

### Mounting example

Synthetic dies will be adjusted into the housing and secured with bolted screws.



### TN80.14 1000 kN/m max.



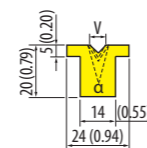
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg

Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



### INS14... 200 kN/m max.



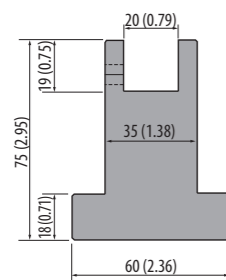
835 mm	32.87 in	0.30 kg
415 mm	16.34 in	0.15 kg



Model	α	V (mm)	V (in)
INS14.06.88	88°	6	0.24
INS14.08.88	88°	8	0.31
INS14.10.88	88°	10	0.39
INS14.06.60	60°	6	0.24
INS14.08.60	60°	8	0.31
INS14.10.60	60°	10	0.39

Model	α	V (mm)	V (in)
INS14.06.45	45°	6	0.24
INS14.08.45	45°	8	0.31
INS14.10.45	45°	10	0.39
INS14.06.30	30°	6	0.24
INS14.08.30	30°	8	0.31

### TN80.20 1000 kN/m max.



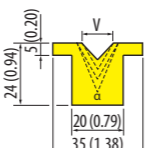
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg

Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



### INS20... 200 kN/m max.



835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg



Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

# ROLLERI MARK FREE BENDING

## Synthetic Dies

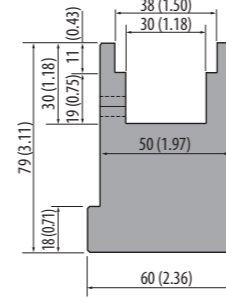


### TN80.30 1000 kN/m max.

835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

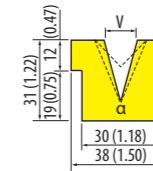
Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



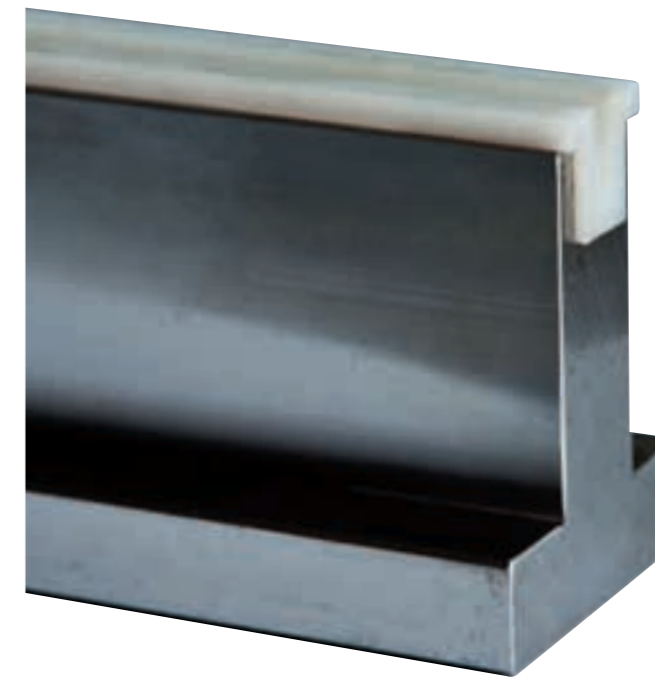
### INS30... 200 kN/m max.

835 mm	32.87 in	0.50 kg
415 mm	16.34 in	0.25 kg



Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.98
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16	0.63
INS30.20.60	60°	20	0.79

Model	α	V (mm)	V (in)
INS30.06.45	45°	6	0.24
INS30.08.45	45°	8	0.31
INS30.10.45	45°	10	0.39
INS30.12.45	45°	12	0.47
INS30.16.45	45°	16	0.63
INS30.20.45	45°	20	0.79
INS30.06.30	30°	6	0.24
INS30.08.30	30°	8	0.31
INS30.10.30	30°	10	0.39
INS30.12.30	30°	12	0.47
INS30.16.30	30°	16	0.63



Articles on stock – Please note that delivery time varies according to your location.

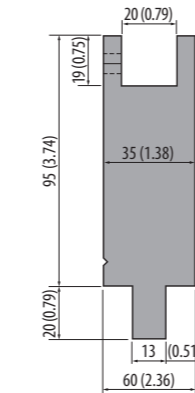


### TMN95.20 1000 kN/m max.

835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

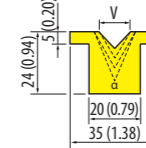
Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



### INS20... 200 kN/m max.

835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg



Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

## ROLLERI SPECIAL AND HEAVY DUTY TOOLS

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Explanation of Heavy Duty Tools	233
Heavy Duty Tools	234 - 235
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Dies with Rollers	239 - 241
ROL6-System	242
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BLACKFIRE	243



**Our Advantages – Your Convenience**

- in-house construction and production (no reseller or dealer)
- competent consulting
- client specific developments
- tracking of every tool possible, with a unique serial number on every article after the quality control check
- precision grinding (tolerance of +/-0.01mm)
- guaranteed tool reproduction
- exact parallelism
- bending tests upon request

**Special Tooling for:**

- Z-Profiles
- Hat-Profiles
- Trapezoidal Profiles
- Pressed contours
- Foldings
- Hinges
- Radii
- Beads
- Special Profiles
- etc.



**Material**

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm <sup>2</sup>	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm <sup>2</sup>	12 - 15.5 HRC	54 - 60 HRC
1.2767	830 N/mm <sup>2</sup>	22 - 25 HRC	54 - 60 HRC

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.



**Our Advantages – Your Convenience**

The bending of materials with extreme high resistance, (Hardox, Weldom, etc.), has developed into an important task.

The Heavy Duty tools of Rollerli are built and finished for these challenges.

Tools that have a press force up to 4000 kN/m, offer you many production possibility.

Our many years of experience in the area of special and heavy duty tooling, along with our own developing department, guarantee you functional and economic solutions in the bending sector.

From the compatible tang to the punch onto the compatible die; we manufacture everything in our own production facilities.

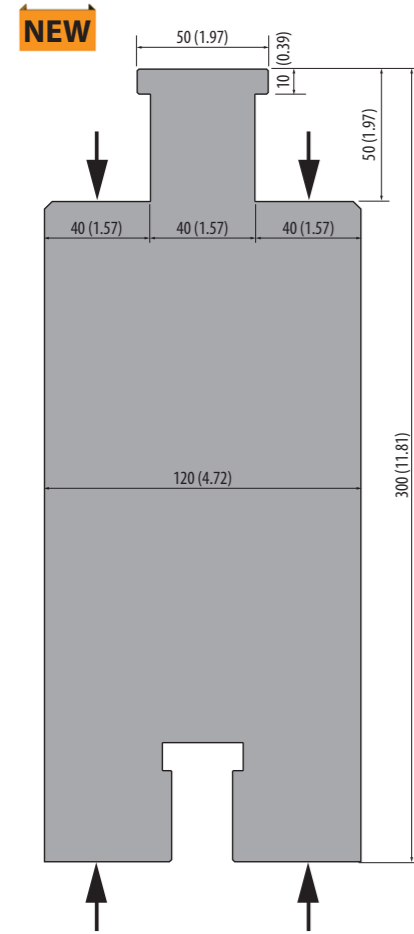
Take advantage of the direct contact to the manufacturer and the benefits which come along with it.



Contact us now!  
We are here to help you!



RHD.300



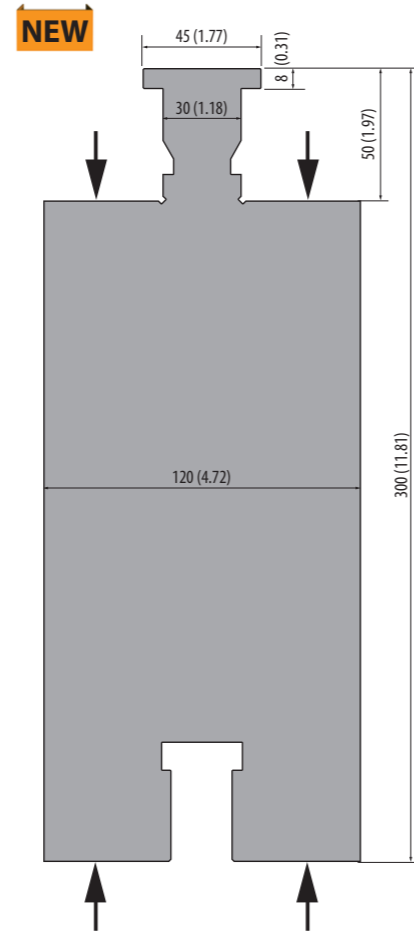
RHD.300-250		
500 mm	19.68 in	122.0 kg

2500 kN/m max.  
42Cr: 900-1150 N/mm<sup>2</sup>

RHD.300-400		
500 mm	19.68 in	122.0 kg

4000 kN/m max.  
1.2767: 830 N/mm<sup>2</sup>

RHD.300 HYD



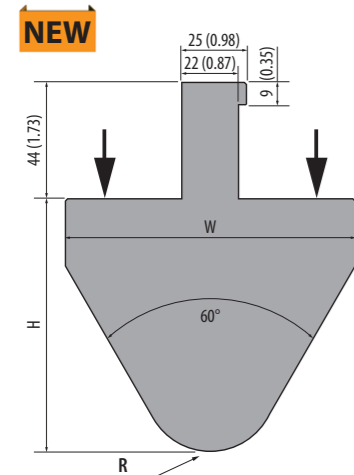
RHD.300-250 HYD		
500 mm	19.68 in	120.0 kg

2500 kN/m max.  
42Cr: 900-1150 N/mm<sup>2</sup>

RHD.300-400 HYD		
500 mm	19.68 in	120.0 kg

4000 kN/m max.  
1.2767: 830 N/mm<sup>2</sup>

RHDP.60



Model	2500 kN/m max.					
	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-250	96	3.78	110	4.33	20	0.79
RHDP.60.25-250	96	3.78	110	4.33	25	0.98
RHDP.60.30-250	96	3.78	110	4.33	30	1.18
RHDP.60.40-250	96	3.78	110	4.33	40	1.57
RHDP.60.50-250	96	3.78	110	4.33	50	1.97
RHDP.60.60-250	96	3.78	110	4.33	60	2.36
RHDP.60.70-250	86	3.39	140	5.51	70	2.76
RHDP.60.80-250	86	3.39	150	5.91	80	3.15
RHDP.60.90-250	86	3.39	165	6.50	90	3.54
RHDP.60.100-250	86	3.39	185	7.28	100	3.94

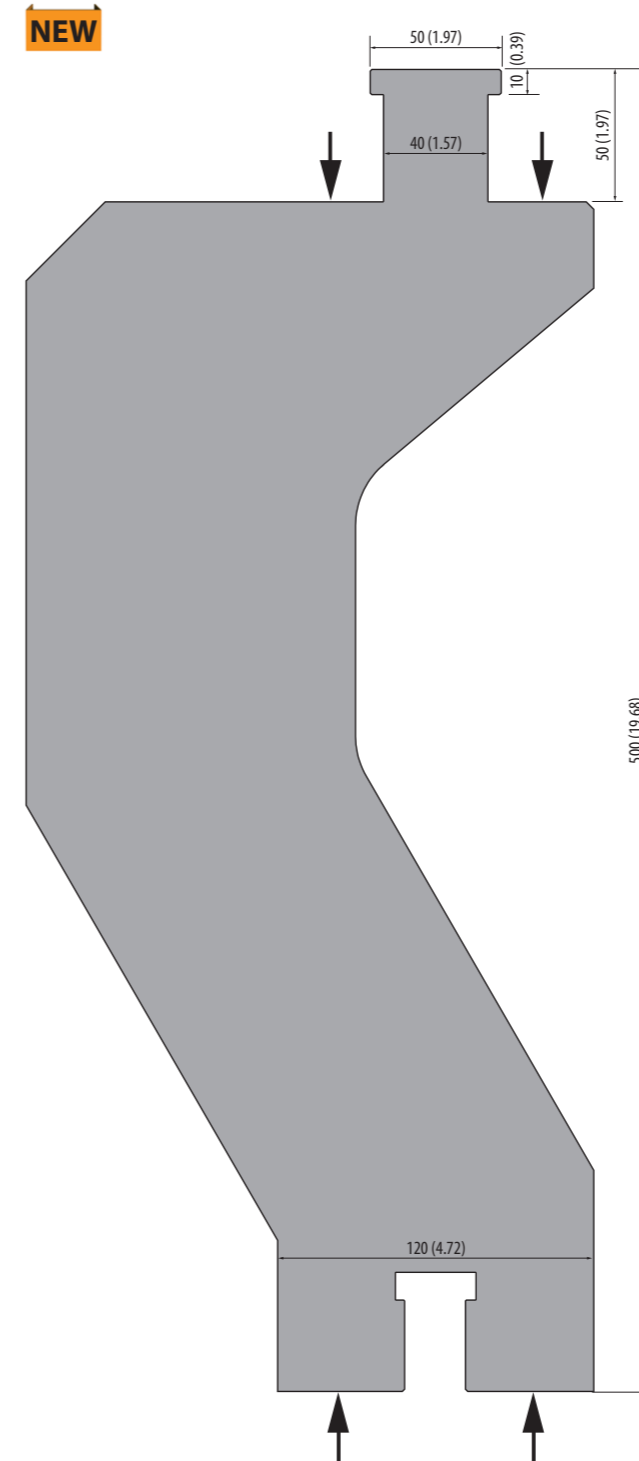
42Cr: 900-1150 N/mm<sup>2</sup>

Model	4000 kN/m max.					
	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-400	96	3.78	110	4.33	20	0.79
RHDP.60.25-400	96	3.78	110	4.33	25	0.98
RHDP.60.30-400	96	3.78	110	4.33	30	1.18
RHDP.60.40-400	96	3.78	110	4.33	40	1.57
RHDP.60.50-400	96	3.78	110	4.33	50	1.97
RHDP.60.60-400	96	3.78	110	4.33	60	2.36
RHDP.60.70-400	86	3.39	140	5.51	70	2.76
RHDP.60.80-400	86	3.39	150	5.91	80	3.15
RHDP.60.90-400	86	3.39	165	6.50	90	3.54
RHDP.60.100-400	86	3.39	185	7.28	100	3.94

1.2767: 830 N/mm<sup>2</sup>

500 mm | 19.68 in

RHD.500-200



2000 kN/m max.  
150 mm | 19.68 in | 253.0 kg

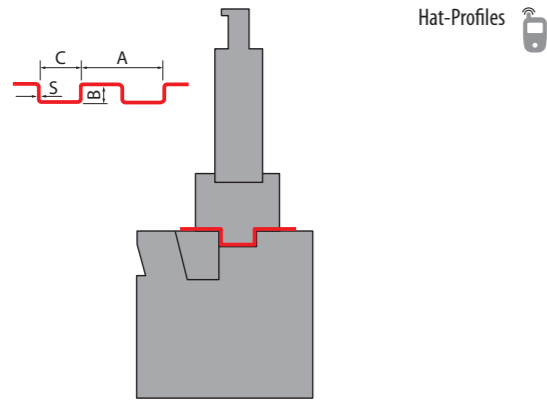
42Cr: 900-1150 N/mm<sup>2</sup>

More Tools for Heavy Duty operations can be found on pages 156-158

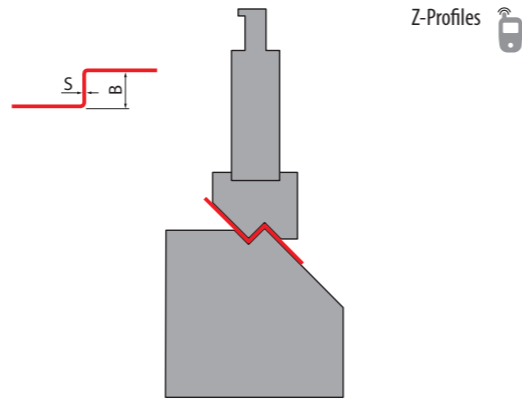


Tool examples

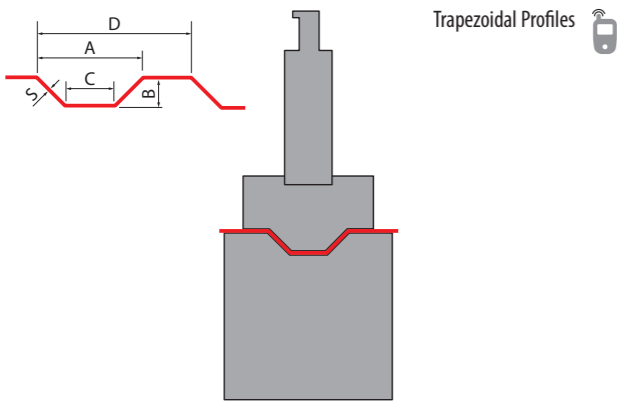
SPE1 Hat-Profiles



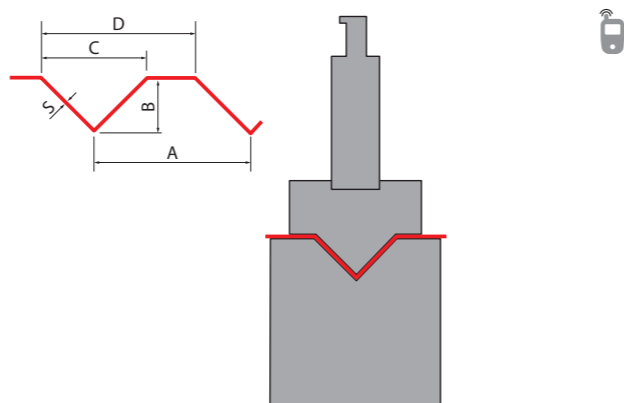
SPE2 Z-Profiles



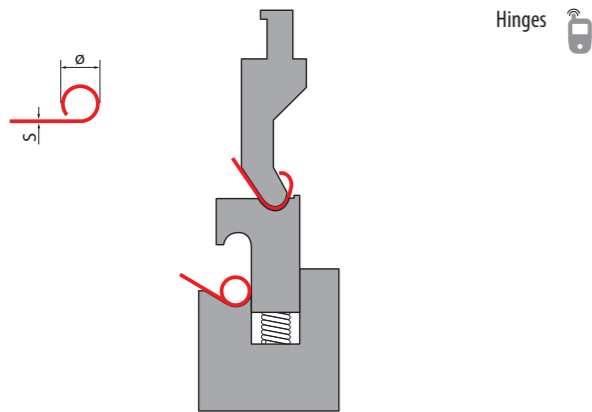
SPE3 Trapezoidal Profiles



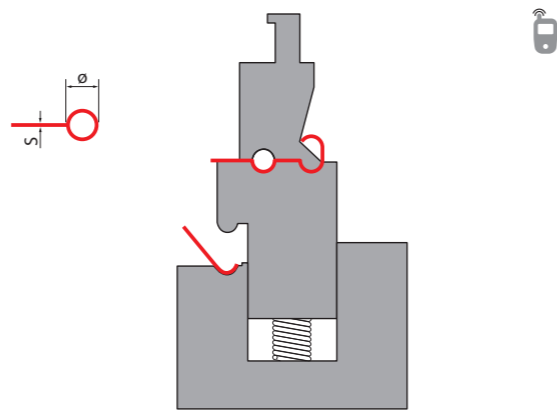
SPE4 Trapezoidal Profiles



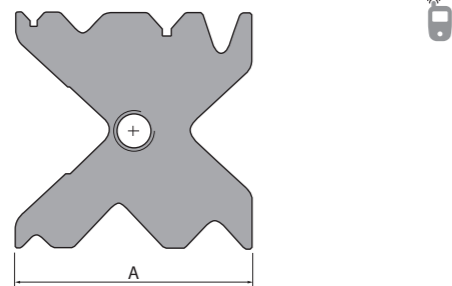
SPE5 Hinges



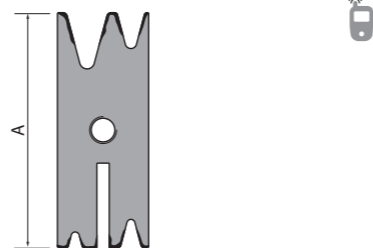
SPE6 Hinges



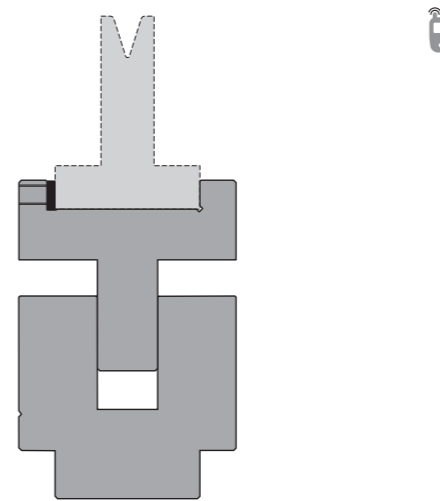
SPE7



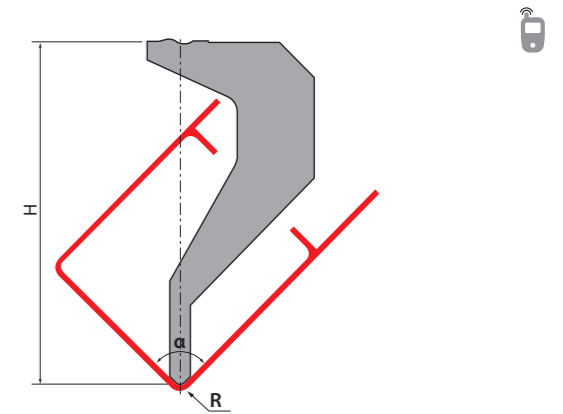
SPE-X



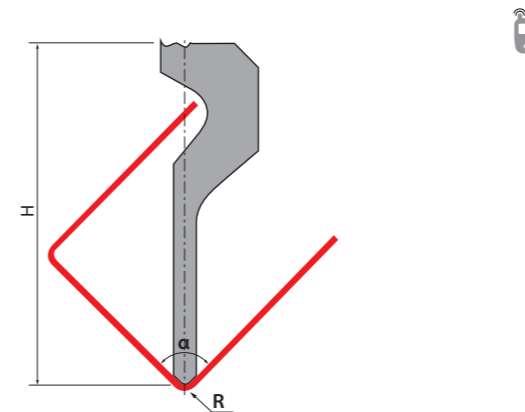
SPE9



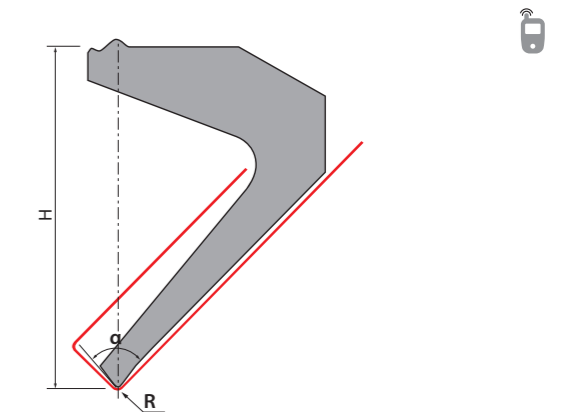
SPE-P1



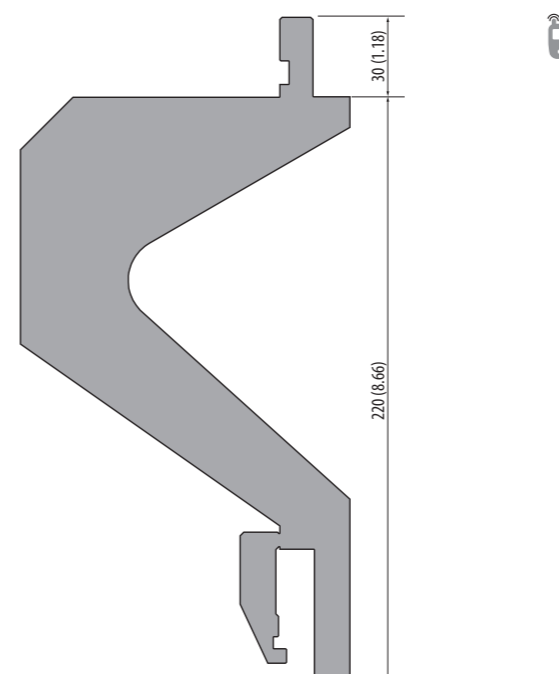
SPE-P2



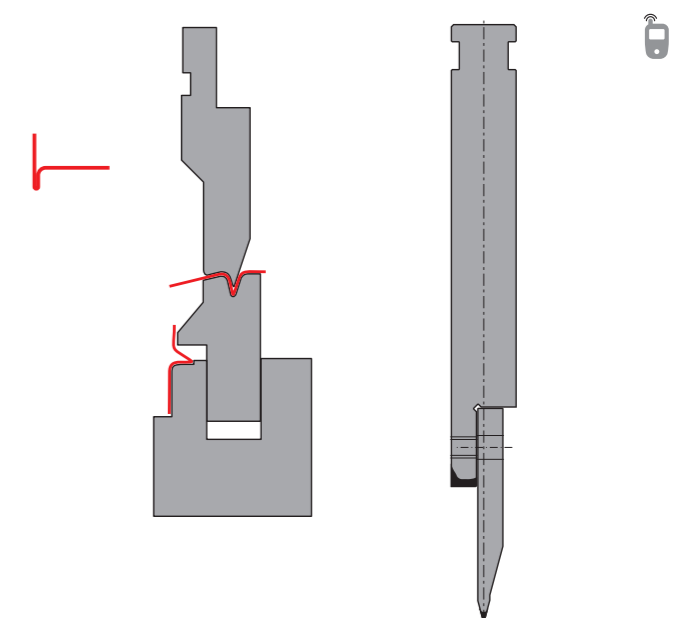
SPE-P3



SPE-P4

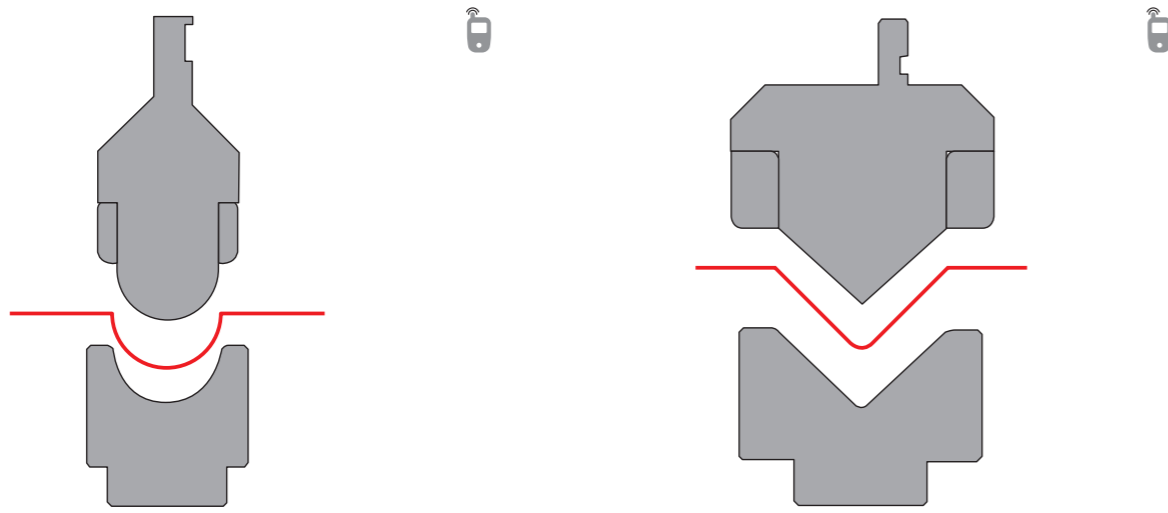


Front- and Hemming Tool (Foldings)

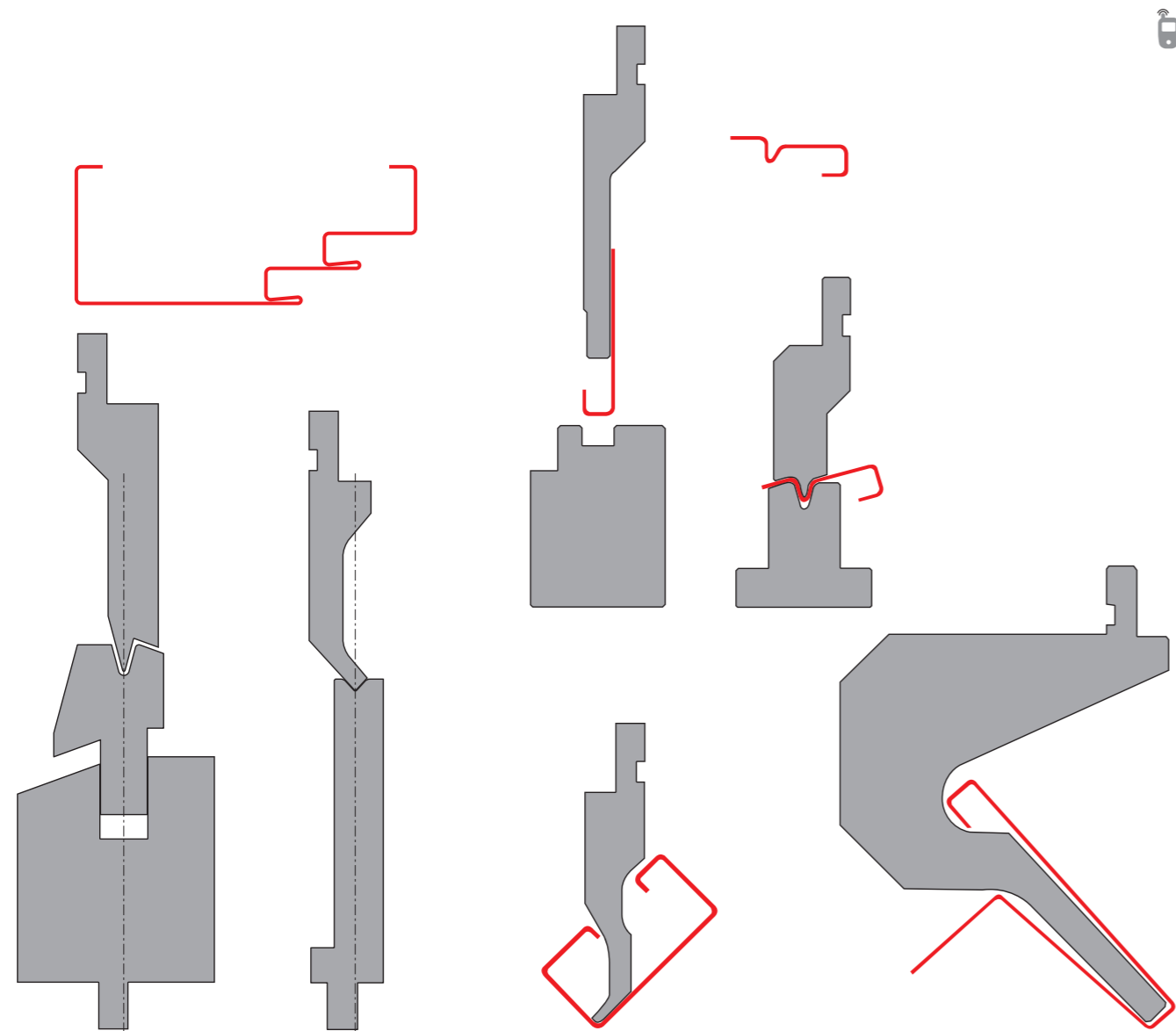


Tool examples

Radii Pressing



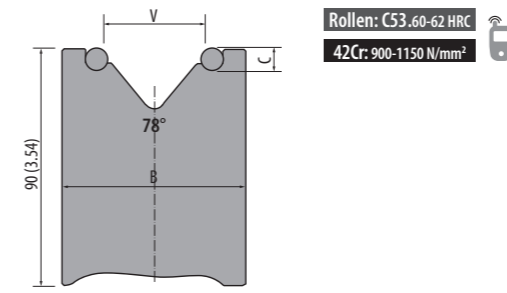
Special Profiles



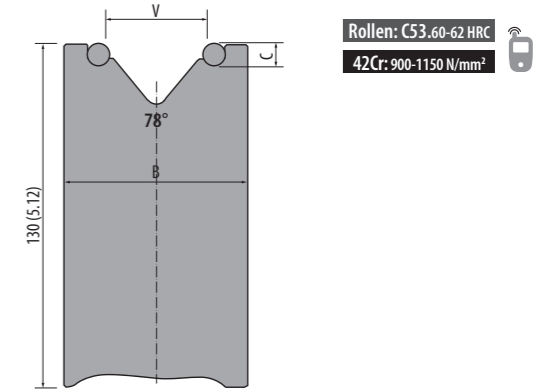
Dies with Rollers



MR90



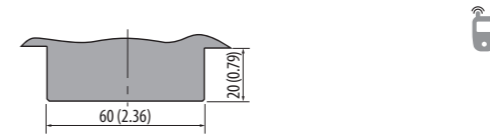
MR130



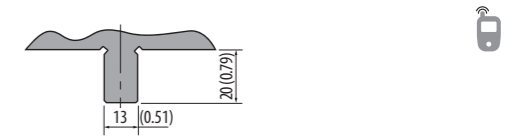
Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
MR90.20.78	20	0.79	45	1.77	6	0.24	835	32.87	15.0
MR90.24.78	24	0.94	49	1.93	6	0.24	835	32.87	17.0
MR90.30.78	30	1.18	60	2.36	8	0.31	835	32.87	21.0
MR90.40.78	40	1.57	70	2.76	8	0.31	835	32.87	24.0
MR90.50.78	50	1.97	84	3.31	10	0.39	835	32.87	28.0
MR90.60.78	60	2.36	94	3.70	10	0.39	835	32.87	31.0
MR90.70.78	70	2.76	104	4.09	10	0.39	835	32.87	35.0

Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
MR130.20.78	20	0.79	45	1.77	6	0.24	835	32.87	22.0
MR130.24.78	24	0.94	49	1.93	6	0.24	835	32.87	25.0
MR130.30.78	30	1.18	60	2.36	8	0.31	835	32.87	28.0
MR130.40.78	40	1.57	70	2.76	8	0.31	835	32.87	34.0
MR130.50.78	50	1.97	84	3.31	10	0.39	835	32.87	40.0
MR130.60.78	60	2.36	94	3.70	10	0.39	835	32.87	45.0
MR130.75.78	75	2.95	118	4.65	16	0.63	835	32.87	50.0
MR130.80.78	80	3.15	123	4.84	16	0.63	835	32.87	55.0
MR130.90.78	90	3.54	133	5.24	16	0.63	835	32.87	60.0
MR130.100.78	100	3.94	143	5.63	16	0.63	835	32.87	65.0
MR130.120.78	120	4.72	163	6.42	16	0.63	835	32.87	70.0

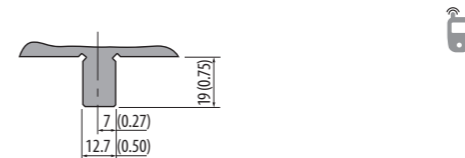
A10



A11



A13





Our Advantages – Your Convenience

- increase in wear resistance through rollers
- induction hardened rollers (approx. 60 HRC)
- decrease in bending marks
- decrease in press force
- easy and economic exchange of rollers

AD MR13

**NEW**

98 mm | 3.86 in  
Adapter for Rolleri Type R2/R3  
C45: 560-710 N/mm<sup>2</sup>

AD MR55

**NEW**

98 mm | 3.86 in  
Adapter for Rolleri Type RX EHT  
C45: 560-710 N/mm<sup>2</sup>

AD MR35

**NEW**

98 mm | 3.86 in  
Adapter for Rolleri Type RX Weinbrenner  
C45: 560-710 N/mm<sup>2</sup>

AD MR12.7

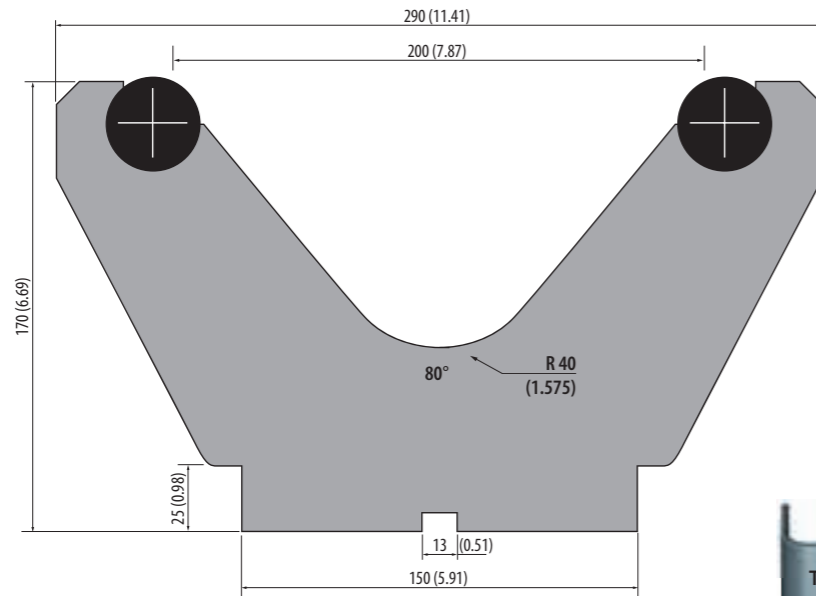
**NEW**

98 mm | 3.86 in  
Adapter for Rolleri Type RX LVD  
C45: 560-710 N/mm<sup>2</sup>

MR170.200.80

**NEW**

2000 kN/m max.  
100 mm | 3.94 in | 19.0 kg  
42Cr: 900-1150 N/mm<sup>2</sup>



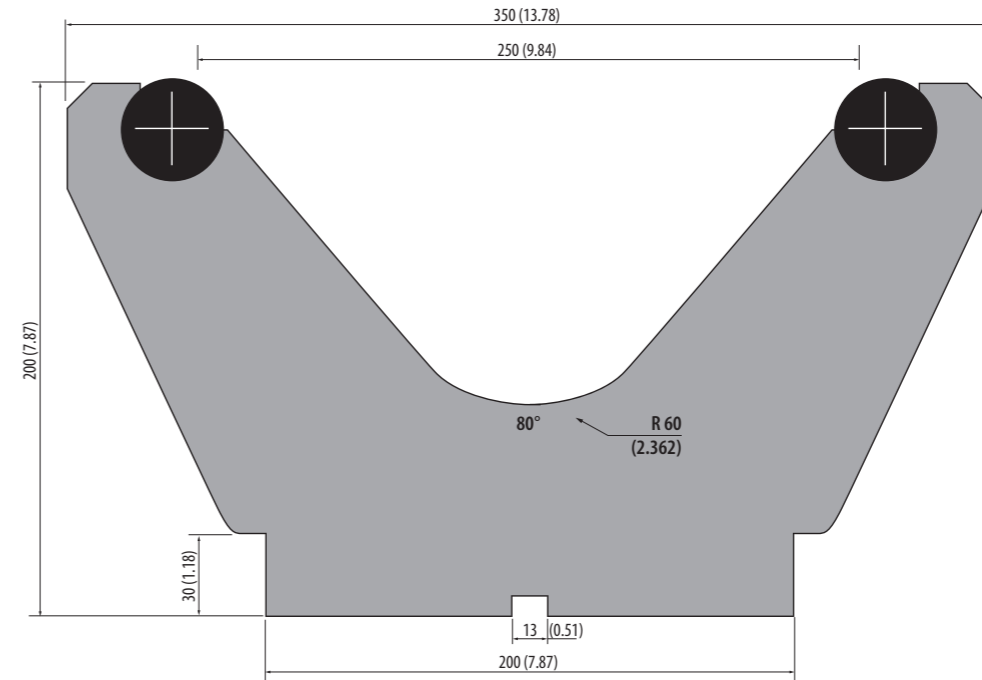
Take advantage of our dies with rollers with means of groove bars/tails to use on other press brake machines.



MR200.250.80

**NEW**

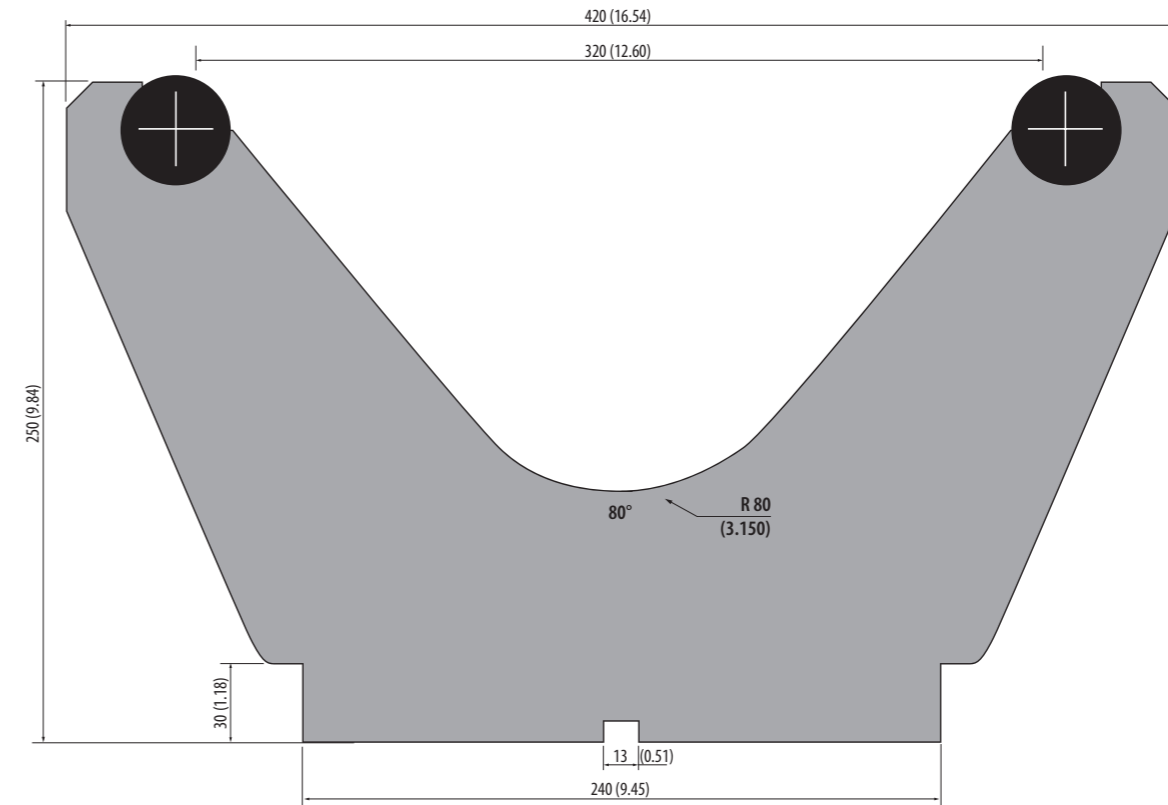
2000 kN/m max.  
100 mm | 3.94 in | 28.0 kg  
42Cr: 900-1150 N/mm<sup>2</sup>



MR250.320.80

**NEW**

2000 kN/m max.  
100 mm | 3.94 in | 42.0 kg  
42Cr: 900-1150 N/mm<sup>2</sup>



ROL6-System

Our Advantages – Your Convenience

- various V-Openings: 40-360 mm (1.57-14.17 in)
- Instructions:
  - secured manually with steering wheel
  - driven by gear motor or
  - CNC-system

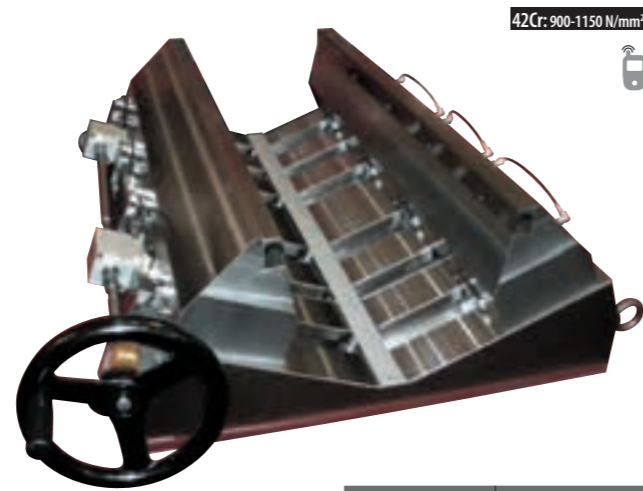
While using the manual version, the opening is set in place by a turn of the steering wheel, or with a gear reduction which is attached to the die.

The automatic version, on the other hand, is operated by a control panel. The standard system does not come with the CNC-Connection for the press brake. It is available upon request at an additional cost.

The base of the ROL6-system is 720 mm (28.35 in) wide, but can also be fitted onto narrow designed tables. There is a adapter available in order to secure the system onto a table with a width of 400 mm (15.75 in). The inserts in the opening radius are exchangeable. The standard version comes with an opening radius of R=10 mm (0.39 in).

Die weight: approx. 1 ton/m

ROL6



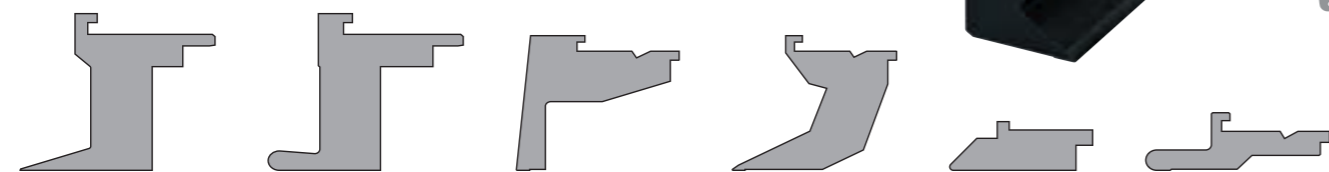
bending angle	kN/m max.
0°	6000
90°	6000
60°	4000

 **Rolleri Videos**  
 Application of various dies ROL6:  
[www.rolleritools.com/videos/rol6](http://www.rolleritools.com/videos/rol6)

Panelling Tools

Our Advantages – Your Convenience

- in-house construction (no reseller or dealer)
- production according to your specifications
- tracking of every tool possible, with a unique serial number on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- exact parallelism
- use of the best materials, guaranteed high resistance and tensile strength



BLACKFIRE



The Unique Coating

Rolleri BLACKFIRE is a particular coating of your tools which defines itself by its increased corrosion resistance and special design.

The chemical treatment permanently solves the problem of oxidation.

The top surface of the metals changes through the phosphate process. It builds phosphate-like crystals, that attach themselves chemically on the substance. This improves the durability of the surface against corrosion.

Your equipment will have a long-term lifecycle left unchanged. The glossy black color of BLACKFIRE is compatible with the new technology and that allows a unique and esthetic look which connects well with the advantages of it.

You can have the BLACKFIRE treatment on all standard tools with a surcharge of 30%.

Please note that the delivery times vary by a BLACKFIRE Treatment.

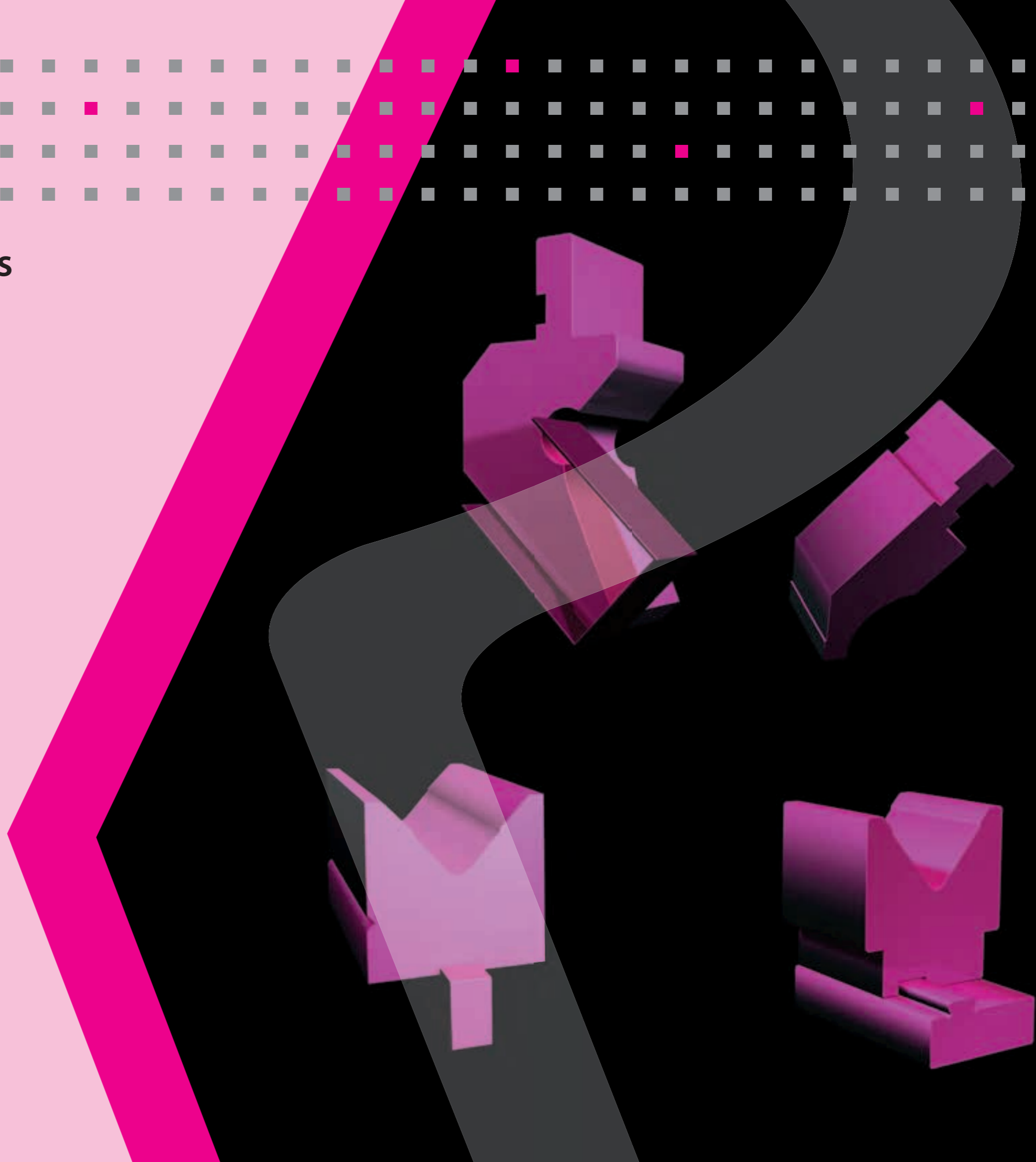
Our Advantages – Your Convenience

- no corrosion
- better gliding by the exchange of tools
- appealing design
- long-life cycle



## ROLLERI SERVICES / MODIFICATIONS

Our Production Department	246 - 247
Modified Tangs	248 - 249
Special Sectioning	250
Horn Pieces	250
Modifying the V-Opening	250
Radius and Angle Modification	251
Grooves for Dies	251
Grooves and Groove Bars/Tails for Dies	252
Gaps and Windows	253

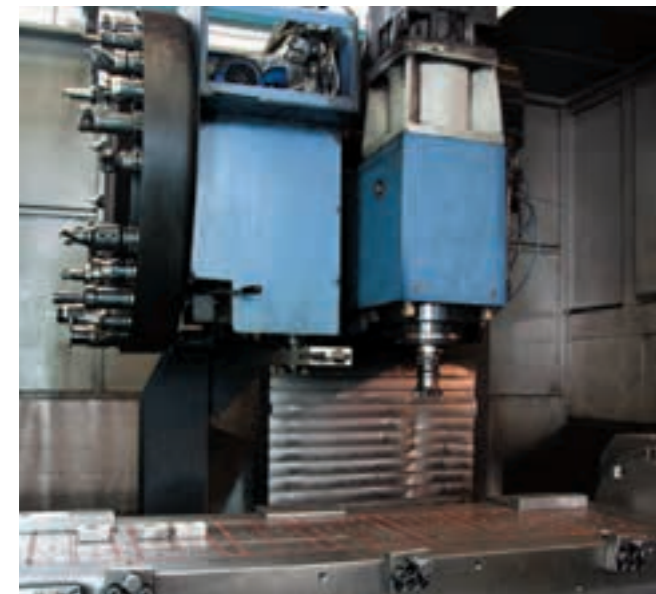


Our Machine Park

Our comprehensive machinery with state-of-the-art technology ensures you the highest quality in tools.

In addition to the manufactured standard and special tools, we perform all modifications individually according to your requirements.

Take advantage the modifications to reduce costs and increase the productivity of your existing tools!



CNC-Milling

With our state-of-the-art milling centers we can do your modification requests fast, precise and with high-quality.

Swivel milling heads with high swivel range allows flexible and universal production.

This is where, grooves, gaps, and openings are created.

CNC-Profile Grinding

Our CNC-Professional grinding machines guarantee, highest precision ground (tolerance of +/-0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tool pieces. Radius and angle modifications are precisely grounded after your measurements.



Hardening

The surface areas of the tools are exposed to the highest mechanical stress. Due to the fact that, the whole press force of the press brake machine is focused on small surface of the sheet metal. Therefore the stress is very high on these surfaces. During the bending process of the sheet metal, friction occurs.

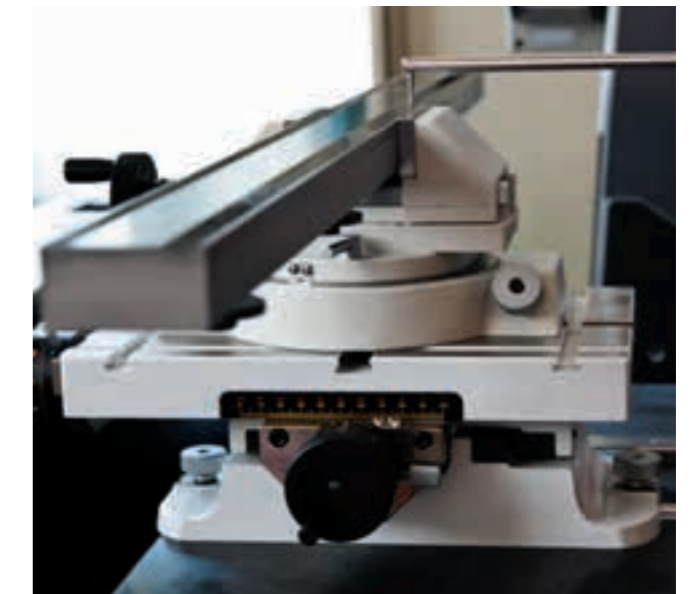
For more resistance strength the hardening of the surfaces can be increased. The depth of the hardening must be at least 3 mm to avoid deformations. We use the electromagnetic technique also known as induction hardening to the best quality for your money's worth.



Quality Control and Laser Marking

After the laser marking, tracking of every tool is possible with a unique serial number on every article. Therefore the tracking of your tools is guaranteed and a new productions with the exact same measurements (angle, radius, hardening, etc.) is possible. This step is happens after quality control.

Individual markings are upon request possible.



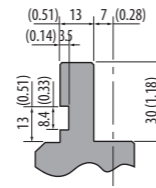
EDM Wire

By using EDM wire, hardened and very tough material can be retrofitted. The process is operated based on a CAD-system which can also process high dimensions such as special shapes.

**Modified Tangs**

- Rolleri Punches Type R1, R2, and R3 can be used on other press brake machines by modifying the tang.
- Precision ground (Tolerance of +/-0.01 mm)
- exact parallelism
- fast, economic, precise

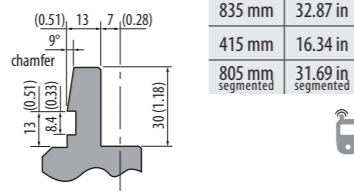
**Standard Rolleri Type R1**



Fast delivery on these items guaranteed. Please note that delivery terms vary according to your location.

**OT**

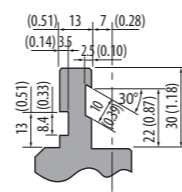
- Modification for:
- for Amada fast clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

**A1**

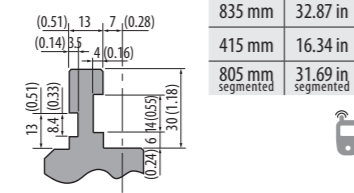
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- pneumatic clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

**A6**

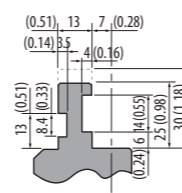
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- Rolleri Type R3
  - Bystronic-Beyeler Euro
  - Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

**A7**

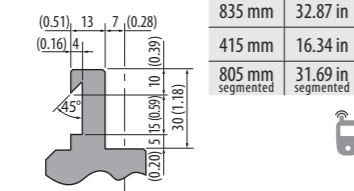
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
- Rolleri Type R3
  - Bystronic-Beyeler Euro
  - Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

**A8**

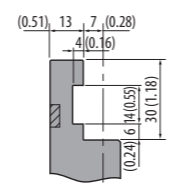
- Groove Bar/Tail for:
- hydraulic clamping system Gasparini



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

**A41**

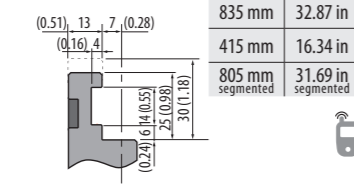
- older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

**A42**

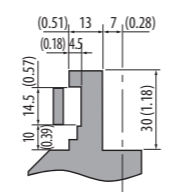
- older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

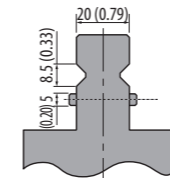
**A43**

- Groove with steel bar for:
- segmented punches



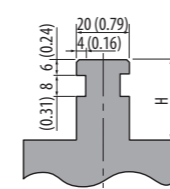
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

**Standard Rolleri Type R2**

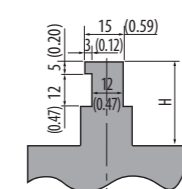


**Modification examples Type R2**

production according to your specifications

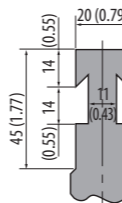


production according to your specifications



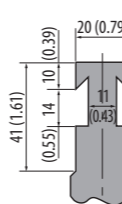
Take advantage of your existing tools with means of modifications.

**Standard Rolleri Type R3**

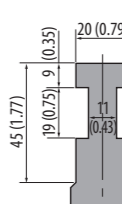


**Modification examples Type R3**

production according to your specifications



production according to your specifications



## ROLLERI MODIFICATIONS

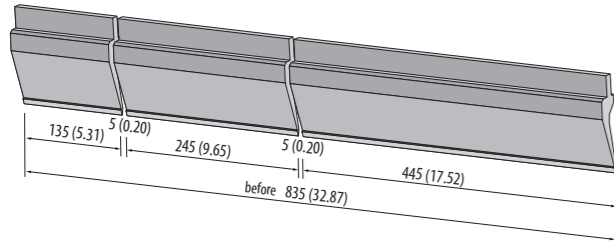
### Special Sectioning

- Individual sectioning of your punches and dies
- fast, economic, precise

Pro separation cutting causes a decrease in length of approx. 5 mm

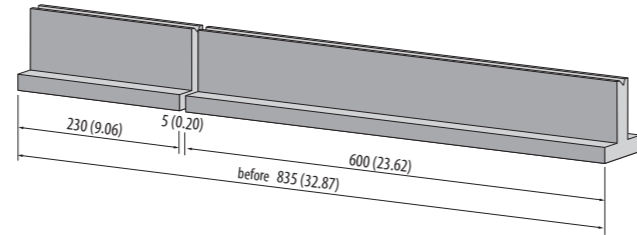
#### Special Sectioning of Punches

Example of punches production according to your specifications



#### Special Sectioning of Dies

Example of Dies production according to your specifications

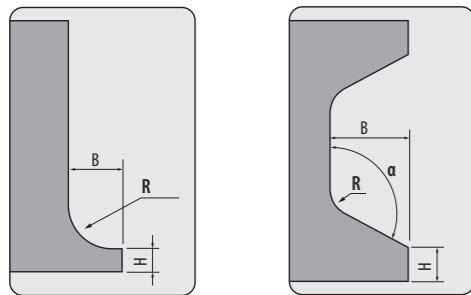


## Horn Pieces

- individual horn pieces on punches and dies
- on one or both sides
- fast, economic, precise

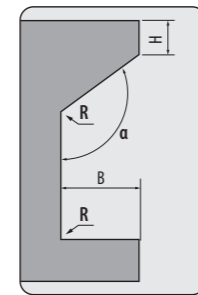
#### Horn Pieces for Punches

Punch example production according to your specifications



#### Horn Pieces for Dies

Die example production according to your specifications

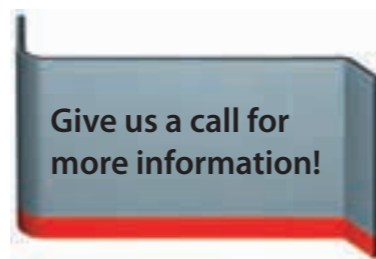
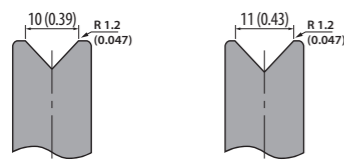


## Modifying the V-Opening

- individual modification for dies
- fast, economic, precise

#### Modifying the V-Opening

Example production according to your specifications



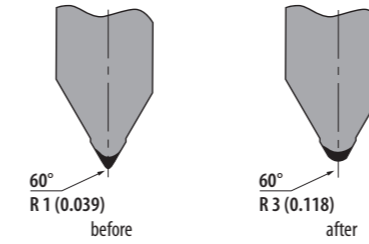
## ROLLERI MODIFICATIONS

### Radius and Angle Modifications

- Individual modifications of your punches and dies
- fast, economic, precise

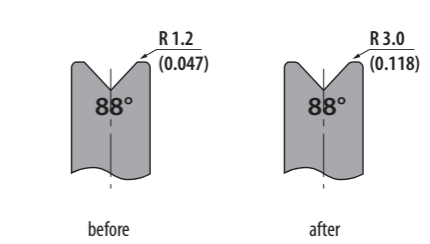
#### Radius Modifications for Punches

Radii modification Punch example production according to your specifications



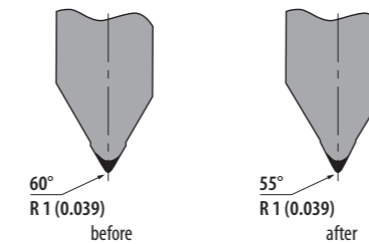
#### Radius Modifications for Dies

Opening Radius modification die example production according to your specifications



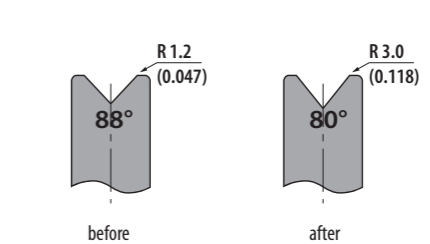
#### Angle Modification Punches

Angle modification punch example production according to your specifications



#### Angle Modification Dies

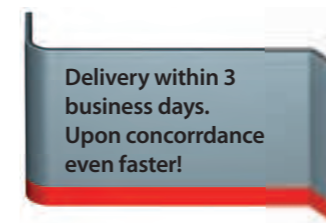
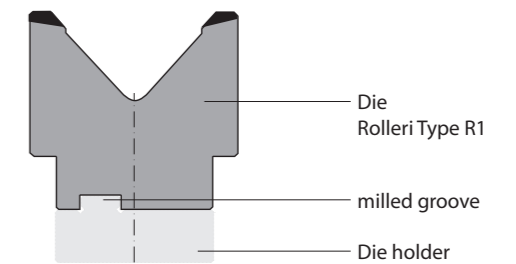
Angle modification die example production according to your specifications



## Grooves for Dies

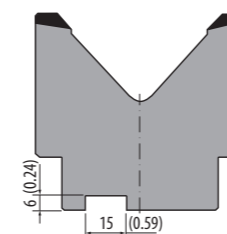
- Milling of grooves for use on other press brake systems
- fast, economic, precise

#### Mounting example



#### A28

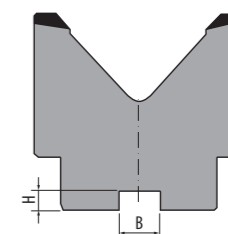
Groove for die holder



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

#### A29

groove production according to your specifications



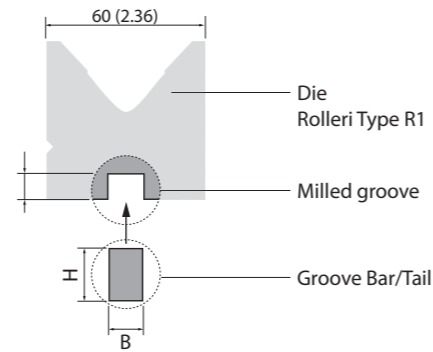
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

## ROLLERI MODIFICATIONS

### Grooves und Groove Bars/Tails for Dies

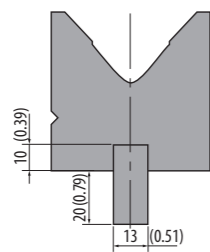
- For milling of the groove and the insert of a ground groove bar/tail the exact measurement is needed to use on other press brake systems
- fast, economic, precise

#### Mounting example



#### A30

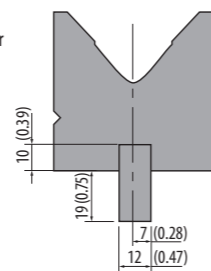
Groove Bars/Tails:  
13 x 30 mm (0.51 x 1.18 in) for  
• Roller Type R2  
• Roller Type R3



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

#### A31

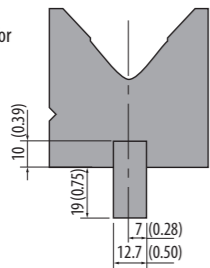
Groove Bars/Tails:  
12 x 29 mm (0.47 x 1.14 in) for  
• Roller Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

#### A32

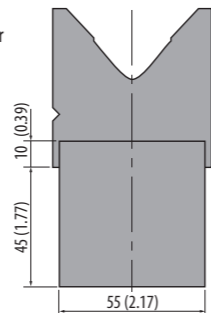
Groove Bars/Tails:  
12.7 x 29 mm (0.50 x 1.14 in) for  
• Roller Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

#### A44

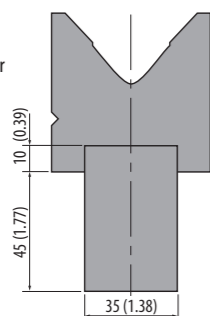
Groove Bars/Tails:  
55 x 55 mm (2.17 x 2.17 in) for  
• Roller Type RX EHT



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

#### A45

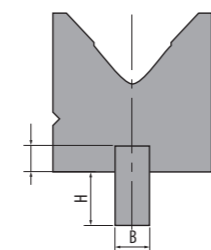
Groove Bars/Tails:  
35 x 55 mm (1.38 x 2.17 in) for  
• Roller Type RX Weinbrenner



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

#### AX

individual Groove Bars/Tails  
for other systems

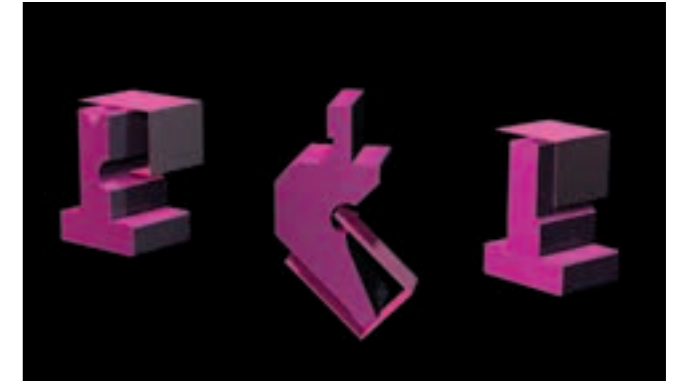


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

## ROLLERI MODIFICATIONS

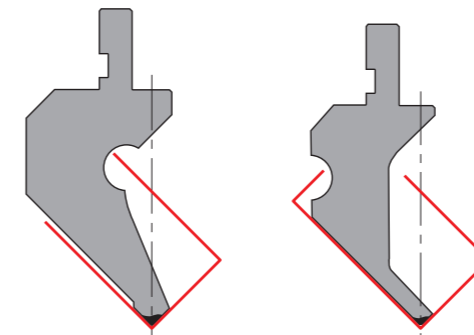
### Gaps and Windows

- The retrofitting of the tool edges of long parts, short U-profiles and similar
- fast, economic, precise



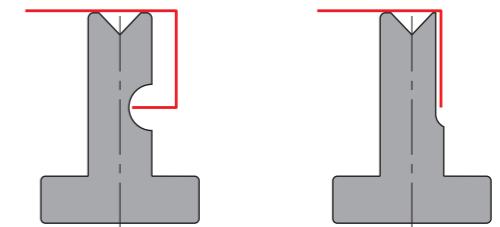
#### Gaps on Punches

Example Punches  
production according to your specifications



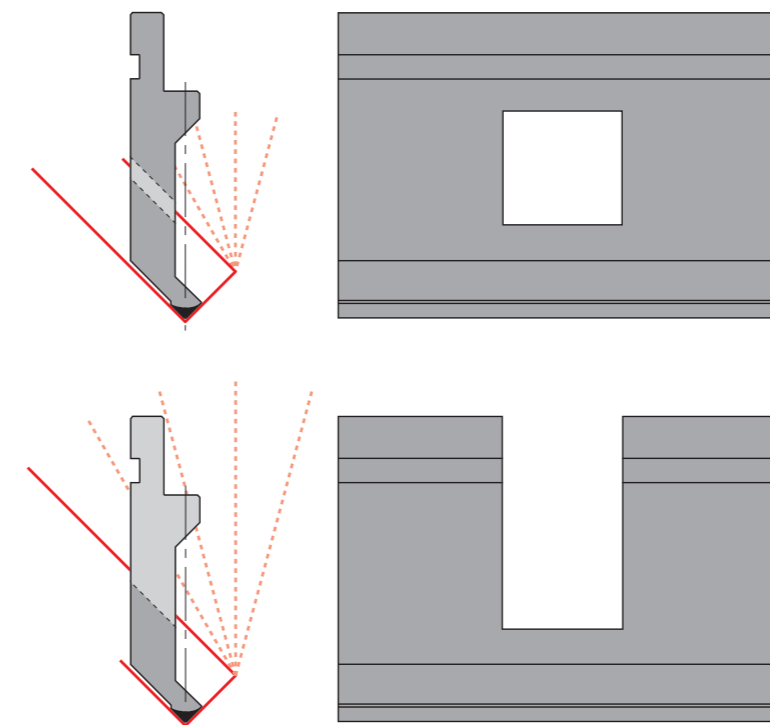
#### Gaps on Dies

Example Dies  
production according to your specifications



#### Windows for Punches

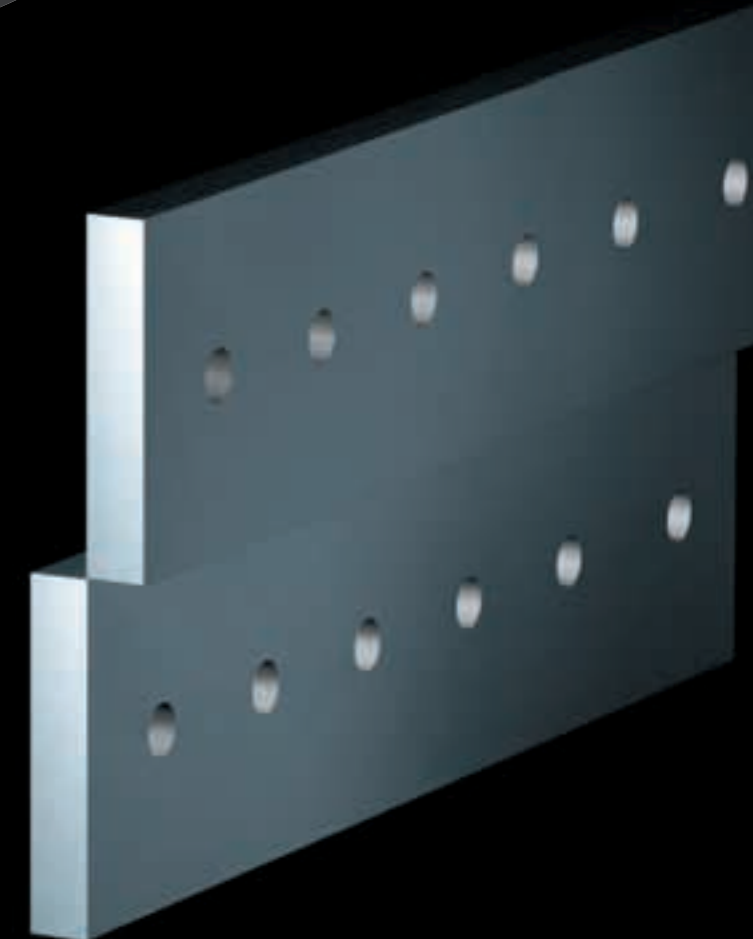
Example Punches  
production according to your specifications



For Roller BLACKFIRE  
see page 243

## ROLLERI SHEAR BLADES AND ACCESSORIES

Tooling Cabinets	256 - 257
Tool Trolley	258
Bending Box	258
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Supporting Arms	260
Back Gauge	260
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## ROLLERI ACCESSORIES

### Tooling Cabinets

#### Our Advantages – Your Convenience

- Protection against contamination and damage
- Faster access
- Robust construction
- Clear and tidy storage
- Cabinet doors specially designed for lift trucks and truck
- Adjustable height, zinc-plated shelves



#### Rolleri Videos

Tool storage demonstration at:  
[www.rolleritools.com/videos/tooling-cabinets](http://www.rolleritools.com/videos/tooling-cabinets)



#### ARM 835-4 for max. tool length = 835 mm (32.87 in)



850 x 1240 x 1050 (W x H x D)  
33.46 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1  
approx. 20 m (787.40 in)  
Storage capacity



Equipment	
4 Drawers	vertical, on wheels (see CS-1)
16 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
4 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	271.0 kg

#### ARM 835-5 for max. tool length = 835 mm (32.87 in)



1040 x 1240 x 1050 (W x H x D)  
40.94 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1  
approx. 25 m (984.25 in)  
Storage capacity



Equipment	
5 Drawers	vertical, on wheels (see CS-1)
20 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
5 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	350.0 kg

#### ARM 1060-4 / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)  
33.46 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3  
approx. 26 m / 39 m (1023.62 in / 1535.43 in) Storage capacity



Equipment ARM 1060-4	
4 Drawers	vertical, on wheels (see CS-2)
16 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
4 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	340.0 kg

Equipment ARM 1060-4-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	351.0 kg

#### ARM 1060-5 / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)  
40.94 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3  
approx. 32.5 m / 52 m (1279.52 in / 2047.24 in) Storage capacity



Equipment ARM 1060-5	
5 Drawers	vertical, on wheels (see CS-2)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
5 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	400.0 kg

Equipment ARM 1060-5-CV	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
30 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	490.0 kg

## ROLLERI ACCESSORIES

### Tool Cabinets



#### ARM 1060-4-T / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)  
33.46 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3  
approx. 20.8 m / 31.2 m (818.89 in / 1228.34 in) Storage capacity



Equipment ARM 1060-4-T	
4 Drawers	vertical, on wheels (see CS-2)
8 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	383.0 kg

Equipment ARM 1060-4-T-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
16 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	360.0 kg

#### ARM 1060-5-T / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)  
40.94 x 48.82 x 53.54 (W x H x D)

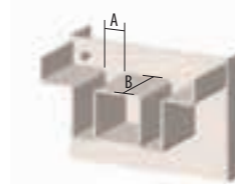
for Tools Roller Type R2/R3  
approx. 26 m / 41.6 m (1023.62 in / 1637.79 in) Storage capacity



Equipment ARM 1060-5-T	
5 Drawers	vertical, on wheels (see CS-2)
10 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
10 Shelves	for type R2/R3 (see shelves UT-4)
Weight	447.0 kg

Equipment ARM 1060-5-T-CV	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
24 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	500.0 kg

#### UC-Shelves



Model	L mm (in)	A mm (in)	B mm (in)	Weight
UC-13-1	125 (4.92)	13 (0.51)	76 (2.99)	0.5 kg
UC-13-2	250 (9.84)	13 (0.51)	232 (9.13)	1.0 kg
UC-20-1	125 (4.92)	20 (0.79)	76 (2.99)	0.5 kg
UC-20-2	250 (9.84)	20 (0.79)	232 (9.13)	1.0 kg

2 pieces

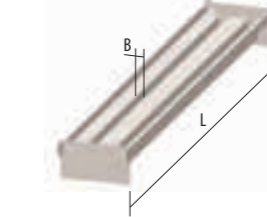
#### UT-Shelves



Model	L (mm)	L (in)	Weight
UT-1	270	10.63	1.4 kg
UT-2	580	22.83	3.2 kg
UT-3	1050	41.34	5.8 kg
UT-4	1360	53.54	7.5 kg

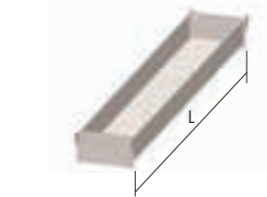
enough room for punches with safety pins

#### UL-Shelves



Model	L mm (in)	B mm (in)	Weight
UL-13-1	270 (10.63)	13 (0.51)	1.2 kg
UL-13-2	580 (22.83)	13 (0.51)	2.5 kg
UL-13-3	1050 (41.34)	13 (0.51)	4.6 kg
UL-13-4	1360 (53.54)	13 (0.51)	6.0 kg
UL-20-1	270 (10.63)	20 (0.79)	1.4 kg
UL-20-2	580 (22.83)	20 (0.79)	3.2 kg
UL-20-3	1050 (41.34)	20 (0.79)	5.8 kg
UL-20-4	1360 (53.54)	20 (0.79)	7.5 kg

#### UV-Shelves



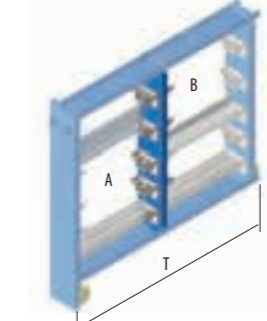
Model	L (mm)	L (in)	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg

#### CS-Drawers



Model	T mm (in)	L mm (in)	Weight
CS-1	1050 (41.34)	856 (33.70)	22.0 kg
CS-2	1360 (53.54)	1166 (45.91)	25.0 kg

#### CV-Dividers



Model	T mm (in)	A mm (in)	B mm (in)	Weight
CV-1	1050 (41.34)	580 (22.83)	270 (10.63)	7.0 kg
CV-2	1360 (53.54)	580 (22.83)	580 (22.83)	7.0 kg

## ROLLERI ACCESSORIES

### Tool Trolley

#### Our Advantages – Your Convenience

- faster access
- robust construction
- clear and tidy storage
- visibility of tools

#### Tool Trolleys

Model	Content	Tool System	Weight
A Trolley	30 Shelves	for R1 tools	108.0 kg
T Trolley	21 Shelves	for R2 tools	175.0 kg
B Trolley	21 Shelves	for R3 tools	135.0 kg



#### Rolleri Videos

Secure storage and mobility:  
[www.rolleritools.com/videos/tool-trolley](http://www.rolleritools.com/videos/tool-trolley)



## ROLLERI ACCESSORIES

### Squaring Arms

#### Our Advantages – Your Convenience

- easy and fast securing
- precise and flexible adjustability
- adjustable angle stop
- mountable on all dies
- ideal for long, and thin sheet metals



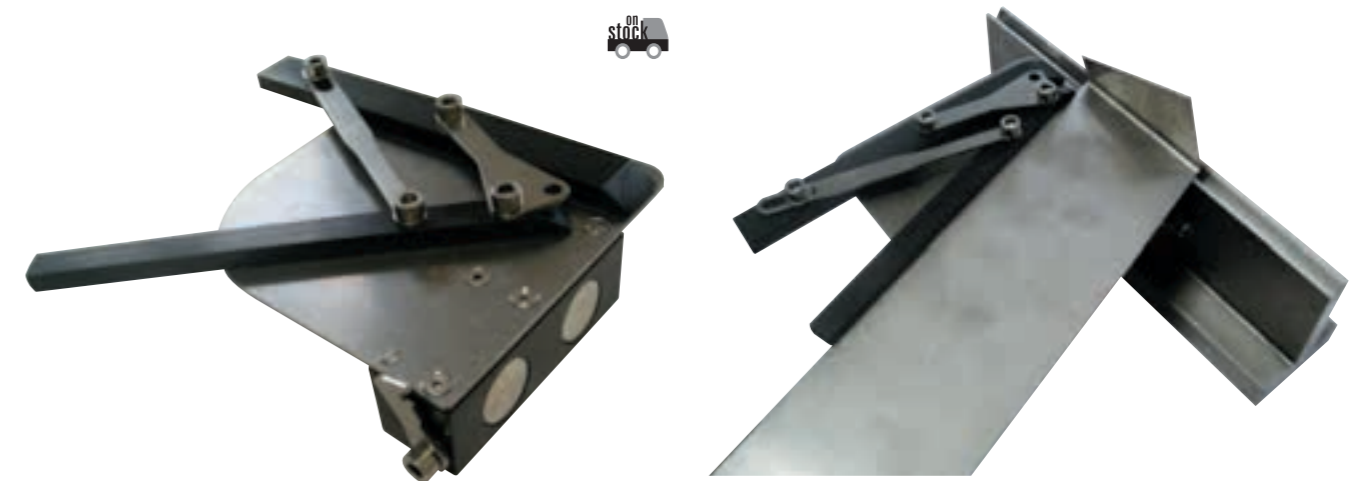
#### Rolleri Videos

Magnetic Squaring Arms :  
[www.rolleritools.com/videos/squaring-arms](http://www.rolleritools.com/videos/squaring-arms)



#### MSA – magnetic

MSA.D (right)	per piece	1.4 kg
MSA.S (left)	per piece	1.4 kg



## Bending Box

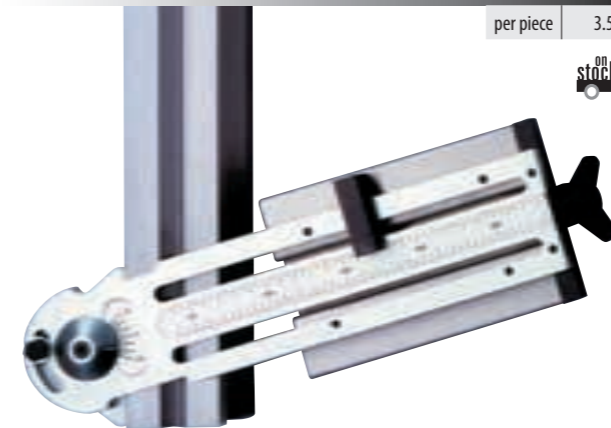
### Bending Box

per piece 1.6 kg



#### AS

per piece 3.5 kg



Give us a call for more information!

## ROLLERI ACCESSORIES

### Supporting Arms and Back Gauge

#### RIF-Supporting Arm

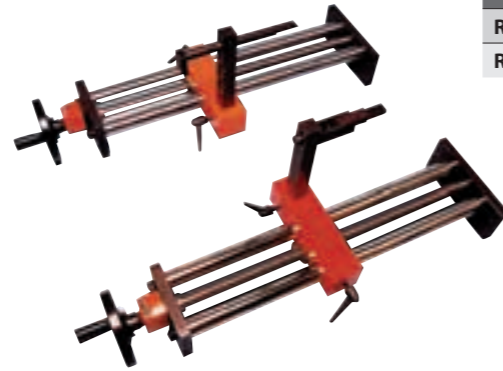
Model	Length mm (in)		Weight
RIF500	500	(19.68)	7.0 kg
RIF1000	1000	(39.37)	12.0 kg
RIF1500	1500	(59.05)	17.0 kg



- for secure support for high volume sheet metals
- greater surface guarantees a trouble-free support for sheet metals
- easy handling

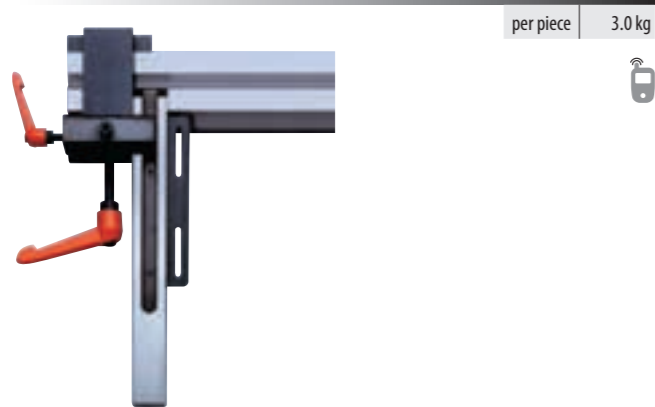
#### RP-Back Gauge

Model	Weight
RP500A	8.0 kg
RP500B	8.0 kg



- ensures for the correct positioning of tools on the press brake and secures herewith the exact border distance.
- fast and exact repeatability
- easy handling

#### AS FIX



per piece 3.0 kg

## Shear Blades

We manufacture in our company over more than 20 years shear blades.

High-quality steels are finished according to your specifications.

New production and retrofitting service: fast, economic, precise!

Please provide us with the following information:

- What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.
- How thick is the material in diameter?
- How often do you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

## ROLLERI SHEAR BLADES

### Shear Blades



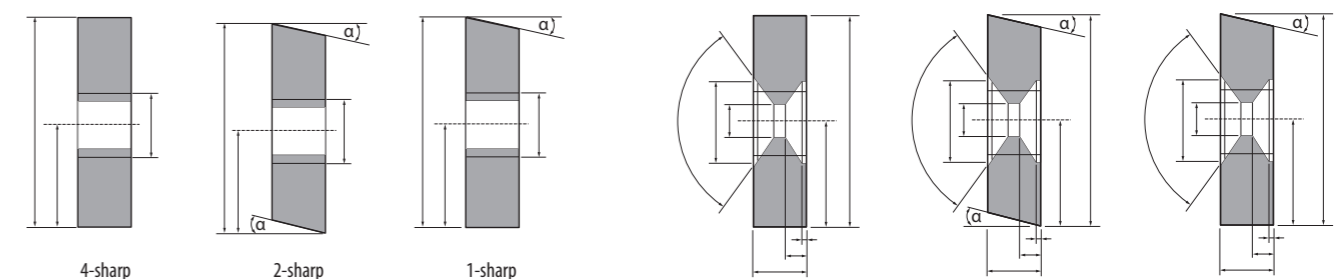
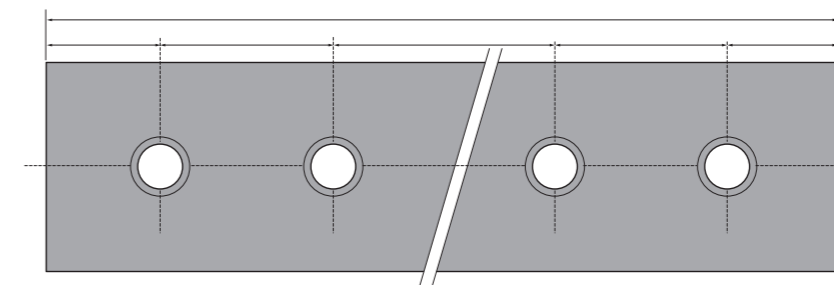
#### Our Advantages – Your Convenience

- own production
- custom production
- depending on the cutting material
- high quality Materials
- 4-, 2- or 1-sharp
- with threaded holes or bilateral reduction
- hardened according to your specifications and request



available sizes mm (in)				
50 x 10 (1.97 x 0.39)	55 x 12 (2.17 x 0.47)	60 x 12 (2.36 x 0.47)	65 x 13 (2.56 x 0.51)	70 x 13 (2.76 x 0.51)
50 x 11 (1.97 x 0.43)	55 x 13 (2.17 x 0.51)	60 x 13 (2.36 x 0.51)	65 x 14 (2.56 x 0.55)	70 x 14 (2.76 x 0.55)
50 x 12 (1.97 x 0.47)	55 x 14 (2.17 x 0.55)	60 x 14 (2.36 x 0.55)	65 x 15 (2.56 x 0.59)	70 x 15 (2.76 x 0.59)
50 x 13 (1.97 x 0.51)	55 x 15 (2.17 x 0.59)	60 x 15 (2.36 x 0.59)	65 x 16 (2.56 x 0.63)	70 x 16 (2.76 x 0.63)
50 x 14 (1.97 x 0.55)	55 x 16 (2.17 x 0.63)	60 x 16 (2.36 x 0.63)	65 x 17 (2.56 x 0.67)	70 x 17 (2.76 x 0.67)
50 x 15 (1.97 x 0.59)	55 x 17 (2.17 x 0.67)	60 x 17 (2.36 x 0.67)	65 x 18 (2.56 x 0.71)	70 x 18 (2.76 x 0.71)
	55 x 18 (2.17 x 0.71)	60 x 18 (2.36 x 0.71)	65 x 19 (2.56 x 0.75)	70 x 19 (2.76 x 0.75)
	55 x 19 (2.17 x 0.75)	60 x 19 (2.36 x 0.75)	65 x 20 (2.56 x 0.79)	70 x 20 (2.76 x 0.79)
	55 x 20 (2.17 x 0.79)	60 x 20 (2.36 x 0.79)		

available sizes mm (in)				
75 x 15 (2.95 x 0.59)	80 x 16 (3.15 x 0.63)	85 x 18 (3.35 x 0.71)	90 x 20 (3.54 x 0.79)	100 x 20 (3.94 x 0.79)
75 x 16 (2.95 x 0.63)	80 x 18 (3.15 x 0.71)	85 x 19 (3.35 x 0.75)	90 x 21 (3.54 x 0.83)	100 x 22 (3.94 x 0.87)
75 x 17 (2.95 x 0.67)	80 x 19 (3.15 x 0.75)	85 x 20 (3.35 x 0.79)	90 x 22 (3.54 x 0.87)	100 x 25 (3.94 x 0.98)
75 x 18 (2.95 x 0.71)	80 x 20 (3.15 x 0.79)	85 x 21 (3.35 x 0.83)	90 x 23 (3.54 x 0.91)	100 x 26 (3.94 x 1.02)
75 x 19 (2.95 x 0.75)	80 x 21 (3.15 x 0.83)	85 x 22 (3.35 x 0.87)	90 x 24 (3.54 x 0.94)	100 x 27 (3.94 x 1.06)
75 x 20 (2.95 x 0.79)	80 x 22 (3.15 x 0.87)	85 x 23 (3.35 x 0.91)	90 x 25 (3.54 x 0.98)	100 x 28 (3.94 x 1.10)
75 x 21 (2.95 x 0.83)	80 x 23 (3.15 x 0.91)	85 x 24 (3.35 x 0.94)		100 x 29 (3.94 x 1.14)
75 x 22 (2.95 x 0.87)	80 x 24 (3.15 x 0.94)	85 x 25 (3.35 x 0.98)		100 x 30 (3.94 x 1.18)
75 x 23 (2.95 x 0.91)	80 x 25 (3.15 x 0.98)			
75 x 24 (2.95 x 0.94)				
75 x 25 (2.95 x 0.98)				



## ROLLERI ACCESSORIES

### Supporting Arms and Back Gauge

#### RIF-Supporting Arm

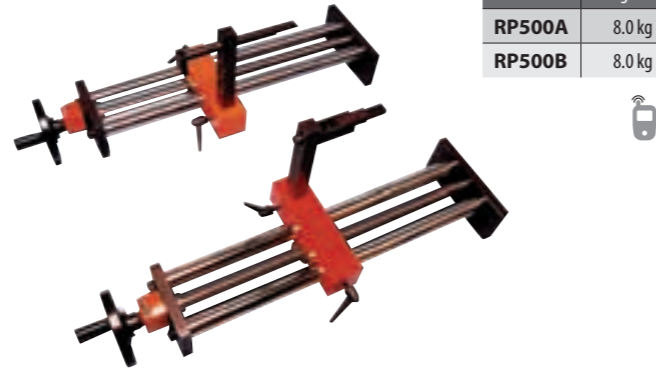
Model	Length mm (in)		Weight
RIF500	500	(19.68)	7.0 kg
RIF1000	1000	(39.37)	12.0 kg
RIF1500	1500	(59.05)	17.0 kg



- for secure support for high volume sheet metals
- greater surface guarantees a trouble-free support for sheet metals
- easy handling

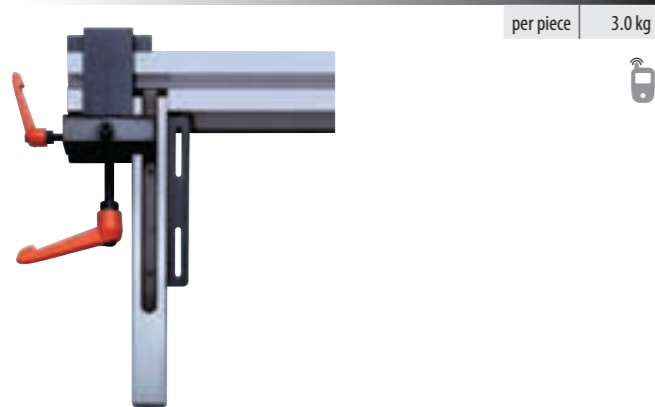
#### RP-Back Gauge

Model	Weight
RP500A	8.0 kg
RP500B	8.0 kg



- ensures for the correct positioning of tools on the press brake and secures herewith the exact border distance.
- fast and exact repeatability
- easy handling

#### AS FIX



per piece 3.0 kg

## Shear Blades

We manufacture in our company over more than 20 years shear blades.

High-quality steels are finished according to your specifications.

New production and retrofitting service: fast, economic, precise!

Please provide us with the following information:

- What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.
- How thick is the material in diameter?
- How often to you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

## ROLLERI SHEAR BLADES

### Shear Blades



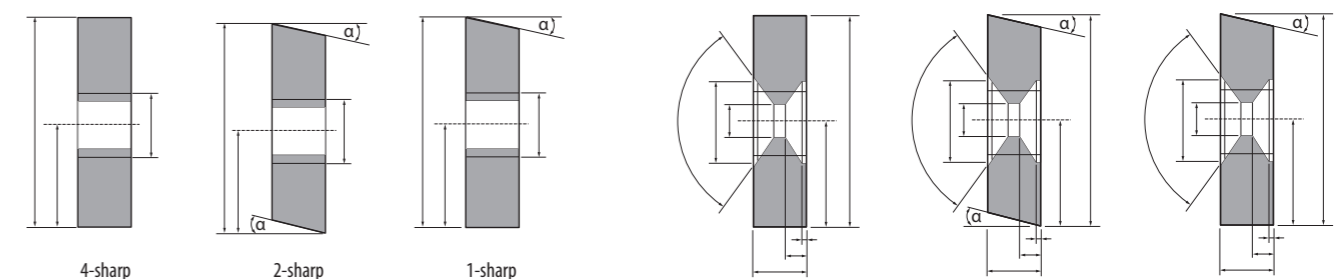
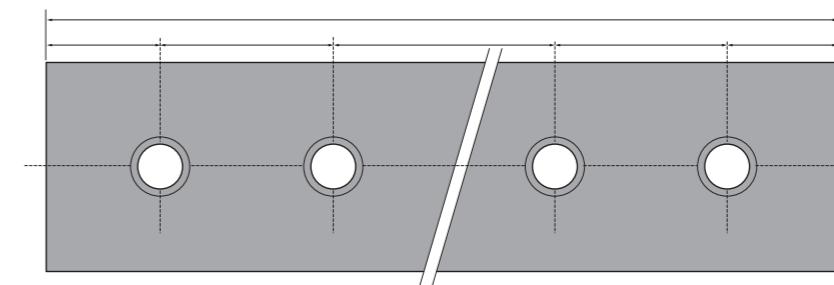
#### Our Advantages – Your Convenience

- own production
- custom production
- depending on the cutting material
- high quality Materials
- 4-, 2- or 1-sharp
- with threaded holes or bilateral reduction
- hardened according to your specifications and request



available sizes mm (in)				
50 x 10 (1.97 x 0.39)	55 x 12 (2.17 x 0.47)	60 x 12 (2.36 x 0.47)	65 x 13 (2.56 x 0.51)	70 x 13 (2.76 x 0.51)
50 x 11 (1.97 x 0.43)	55 x 13 (2.17 x 0.51)	60 x 13 (2.36 x 0.51)	65 x 14 (2.56 x 0.55)	70 x 14 (2.76 x 0.55)
50 x 12 (1.97 x 0.47)	55 x 14 (2.17 x 0.55)	60 x 14 (2.36 x 0.55)	65 x 15 (2.56 x 0.59)	70 x 15 (2.76 x 0.59)
50 x 13 (1.97 x 0.51)	55 x 15 (2.17 x 0.59)	60 x 15 (2.36 x 0.59)	65 x 16 (2.56 x 0.63)	70 x 16 (2.76 x 0.63)
50 x 14 (1.97 x 0.55)	55 x 16 (2.17 x 0.63)	60 x 16 (2.36 x 0.63)	65 x 17 (2.56 x 0.67)	70 x 17 (2.76 x 0.67)
50 x 15 (1.97 x 0.59)	55 x 17 (2.17 x 0.67)	60 x 17 (2.36 x 0.67)	65 x 18 (2.56 x 0.71)	70 x 18 (2.76 x 0.71)
	55 x 18 (2.17 x 0.71)	60 x 18 (2.36 x 0.71)	65 x 19 (2.56 x 0.75)	70 x 19 (2.76 x 0.75)
	55 x 19 (2.17 x 0.75)	60 x 19 (2.36 x 0.75)	65 x 20 (2.56 x 0.79)	70 x 20 (2.76 x 0.79)
	55 x 20 (2.17 x 0.79)	60 x 20 (2.36 x 0.79)		

available sizes mm (in)				
75 x 15 (2.95 x 0.59)	80 x 16 (3.15 x 0.63)	85 x 18 (3.35 x 0.71)	90 x 20 (3.54 x 0.79)	100 x 20 (3.94 x 0.79)
75 x 16 (2.95 x 0.63)	80 x 18 (3.15 x 0.71)	85 x 19 (3.35 x 0.75)	90 x 21 (3.54 x 0.83)	100 x 22 (3.94 x 0.87)
75 x 17 (2.95 x 0.67)	80 x 19 (3.15 x 0.75)	85 x 20 (3.35 x 0.79)	90 x 22 (3.54 x 0.87)	100 x 25 (3.94 x 0.98)
75 x 18 (2.95 x 0.71)	80 x 20 (3.15 x 0.79)	85 x 21 (3.35 x 0.83)	90 x 23 (3.54 x 0.91)	100 x 26 (3.94 x 1.02)
75 x 19 (2.95 x 0.75)	80 x 21 (3.15 x 0.83)	85 x 22 (3.35 x 0.87)	90 x 24 (3.54 x 0.94)	100 x 27 (3.94 x 1.06)
75 x 20 (2.95 x 0.79)	80 x 22 (3.15 x 0.87)	85 x 23 (3.35 x 0.91)	90 x 25 (3.54 x 0.98)	100 x 28 (3.94 x 1.10)
75 x 21 (2.95 x 0.83)	80 x 23 (3.15 x 0.91)	85 x 24 (3.35 x 0.94)		100 x 29 (3.94 x 1.14)
75 x 22 (2.95 x 0.87)	80 x 24 (3.15 x 0.94)	85 x 25 (3.35 x 0.98)		100 x 30 (3.94 x 1.18)
75 x 23 (2.95 x 0.91)	80 x 25 (3.15 x 0.98)			
75 x 24 (2.95 x 0.94)				
75 x 25 (2.95 x 0.98)				

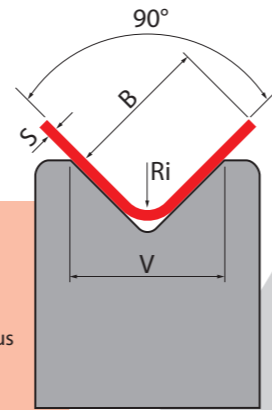


**Press Force Table**

The press force table is based on the press force caliper and is very useful to those who deal with sheet metal profiles. It can assist you from the projection of profiles, to technical construction, to the buying of tools, and to the finished profile from the press brake machine.

In the first left column the thickness of the sheet metal is noted as (S). In the three first lines you can find the die width (V), the minimum boarder (B), and the ideal inner profile radius (Ri).

By crossing the thickness with the die width, you will find the necessary press force per meter. Furthermore, depicted are the span of 5 different die widths. The correction factors are found below in the table.



S = Thickness  
V = Die Width  
B = Min. Boarder  
Ri = Inner Profile Radius

		420 N/mm <sup>2</sup>																			
S (mm)		4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
		3.0	3.5	4.0	5.5	6.5	8.0	10.5	13.0	16.5	21.0	26.0	32.5	41.0	52.0	65.0	81.5	104.0	130.0	163.0	B
		0,5	0,7	0,8	1,0	1,3	1,5	2,0	2,5	3,2	4,4	5,0	6,5	8,0	10,0	12,0	15,0	20,0	25,0	37,0	Ri
0.6		60	50	30	20																
0.8		120	90	70	50	40															
1.0			150	110	80	60	50														
1.2				180	120	90	70	50													
1.5					210	150	120	80	60												
2.0						300	230	160	120	90											
2.5							390	270	200	140	110										
3.0								430	310	230	160	120									
4.0									600	440	320	230	180								
5.0										760	540	390	290	220							
6.0											850	620	450	330	250						
8.0												1210	880	700	460	350					
10.0													1510	1090	790	580	440				
12.0														1730	1240	910	660	500			
15.0															2130	1550	1130	810	620		
20.0																3020	2200	1580	1150	890	
25.0																	3780	2690	1970	1440	

F  
kN/m

30°	B x 1.6	R=200 N/mm <sup>2</sup>	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm <sup>2</sup>	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm <sup>2</sup>	r x 1.4	INOX

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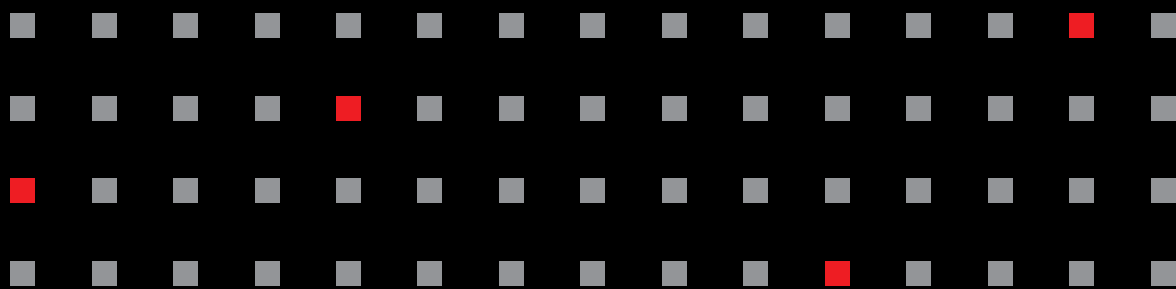
- drawings 1:1 format available
- extra information and tips
- helpful videos and application examples
- easy website browsing



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