



ROLLERI®
PROFESSIONAL
BENDING



**DIRECTLY
FROM THE
MANUFACTURER**

INT

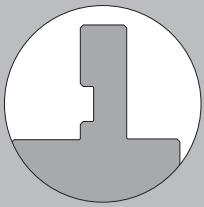
PRESS BRAKE TOOLS

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



YOUR BENEFITS AT A GLANCE

- direct from the manufacturer
- one of the largest stocks for press brake tools in Europe
- ISO certification
- fair prices and fast delivery times
- production with quality control
- construction and development department
- all tools with serial number and therefore 100% accurate reproduction
- all tools with batch number and therefore a complete tool traceability
- all tools induction hardened to 54-60 HRc
- best raw materials
- motivated and qualified team
- useful application videos
- direct line to production
- reliable service
- family-run company
- operates worldwide

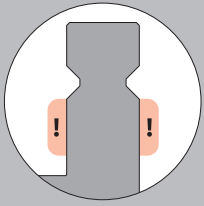


R1

Compatible with: Amada, Atlantic, Baykal, Boschert, Bystronic-Beyeler Euro-B, Colgar, Durmazlar, Ermaksan, Gasparini, Haco, Prima Power, Promecam, Salvagnini, SMD, Warcom, Yangli, etc.

PUNCHES

DIES



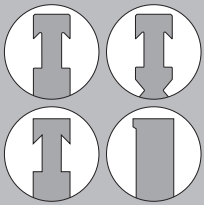
R2

Compatible with:
LVD, Trumpf, Darley, Safan or on press brake machines with System NSCL (New Standard Clamping)

Compatible with:
Bystronic-Beyeler, Safan, SMD, Trumpf, Darley, Press brake machines with System NSCR

PUNCHES

DIES



R3

Compatible with:
Bystronic-Beyeler RFA
Bystronic-Beyeler RF
Bystronic-Beyeler R
Bystronic-Beyeler S

Compatible with:
Bystronic-Beyeler, Safan, SMD, Trumpf, Darley, Press brake machines with System NSCR

PUNCHES

DIES

TOOLS ROLLERI TYPE RX

ROLLERI DIES ROLLA-V

ROLLERI CLAMPING SYSTEMS

ROLLERI ADAPTERS

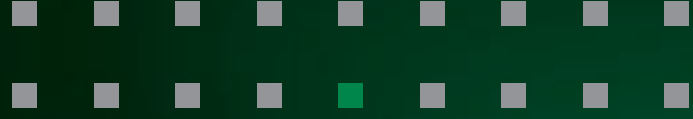
ROLLERI MARK FREE BENDING

ROLLERI SPECIAL AND HEAVY DUTY TOOLS

ROLLERI MODIFICATIONS

ROLLERI ACCESSORIES / SHEAR BLADES

ABOUT US / VARIOUS INFORMATION



R1

Compatibility

Punches Rolleri Type R1 are compatible with press brakes:

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

With the use of adapters Rolleri R1 type punches can be mounted in other press brake models.

PUNCHES ROLLER TYPE R1

Content Explanation	6 - 7
85° TOP-Punches	8
75° TOP-Punches	8
60° TOP-Punches	9
26° TOP-Punches	9
28°/24° TOP-Hemming tools	10
TOP-Radius tools	11
90° Punches	12 - 13
90° Mobile Horns	13
88° Punches	14 - 17
88° Mobile Horns	18
88° Punches for closed profiles	19
85° Punches	20 - 21
75° Punches	22
70° Punches	22
60° Punches	23
45° Punches	24
35° Punches	24
30° Punches	25
26° Punches	26
88°/90° A-Punches	27 - 28
60° A-Punches	29
45° A-Punches	29
30° A-Punches	29
Joggle Tools	30
Radius tools	31 - 33
Hemming tools	33
Punch extensions / Intermediates	34 - 35
Intermediates, Heavy duty	35
Punch adapters	35

Compatibility

Punches Rolleri Type R1 are:

- **compatible** with press brakes: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, JMT, LFK, Metfab, MVD, Oriance, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brakes **with adapters** (see pages 226-231)

Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

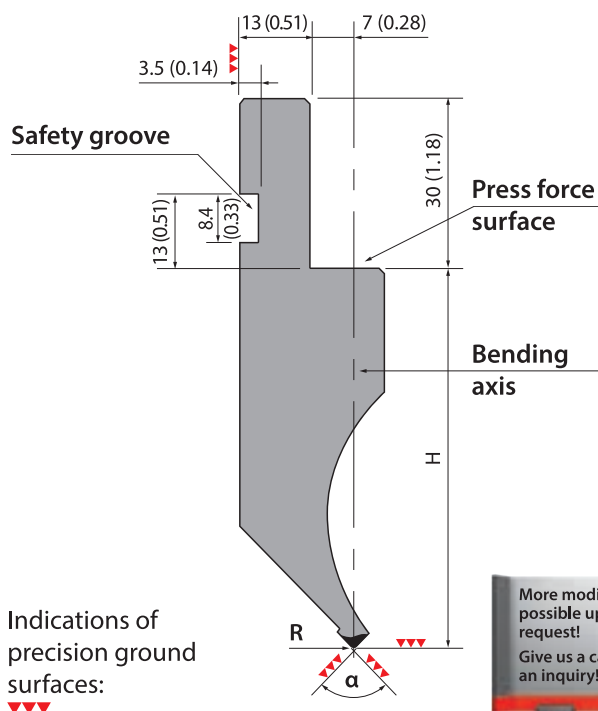
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

All punches Rolleri Type R1:

- are standardized with a **8.4 x 3.5 mm (0.331 x 0.138 in) safety groove**, which keeps the tool from falling out.
- depending on the clamping system: **horizontal** or **vertical**, tool exchange is possible (see pages 210-218)



Indications of precision ground surfaces:
▼▼▼

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

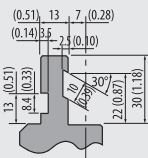
Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 264-265)
- very large stock availability

Modifications from Safety Grooves

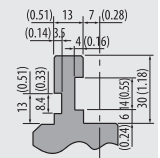
A1

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



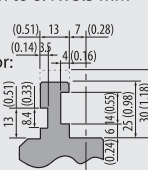
A6

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



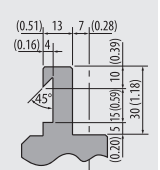
A7

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



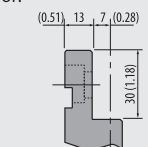
A8

Groove for:
• hydraulic clamping
Gasparini



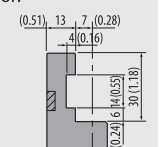
A9

Modified groove for:
• Rolleri Type R3



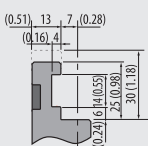
A41

Modified groove for:
• Rolleri Type R3



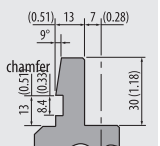
A42

Modified groove for:
• Rolleri Type R3



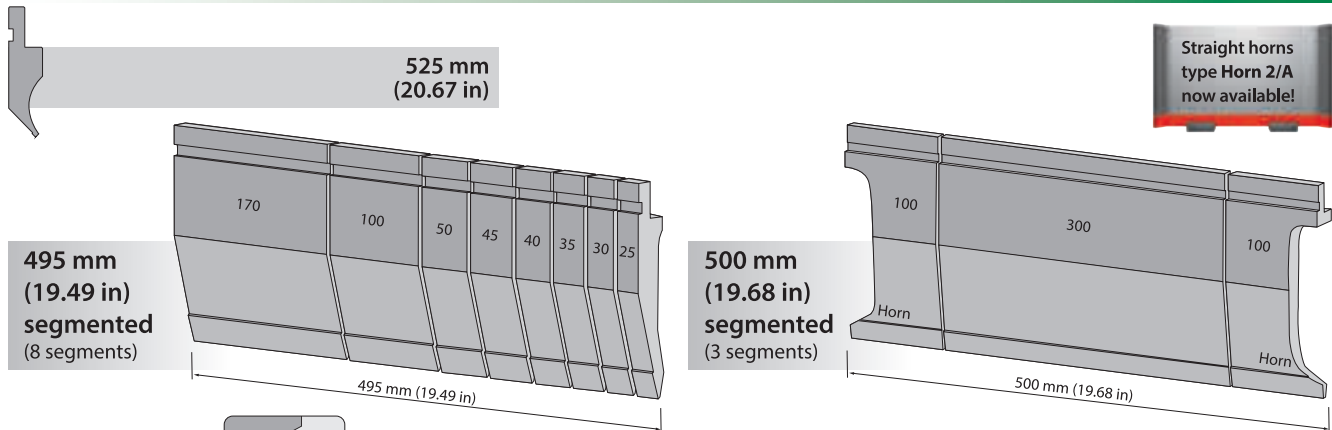
OT

Modification for:
• for Amada fast clamping system

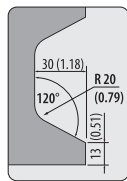


Tool lengths and sectioning

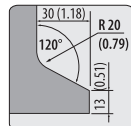
Rolleri TOP-System



Horn Types

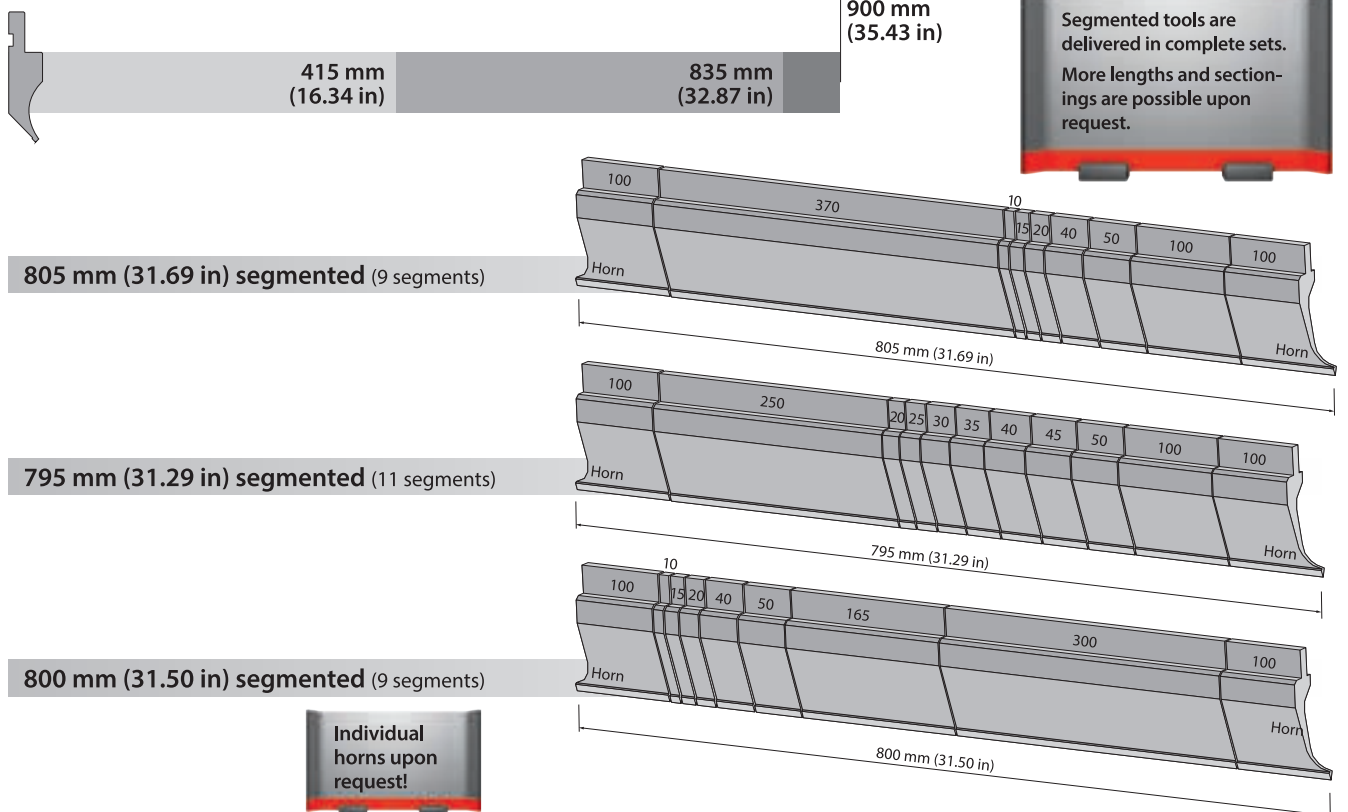


HORN 2 Horn 2 TOP

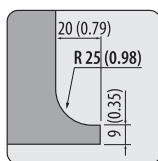


HORN 2/A Horn 2/A TOP

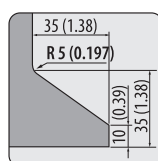
Standard



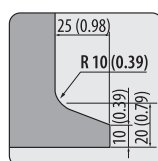
Horn Types



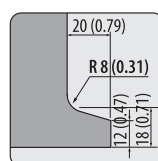
HORN 1 Horn 1 Standard



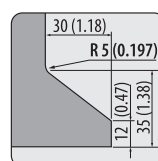
HORN 3 Horn 3A A-Punches



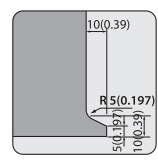
HORN 4 Horn 4A A-Punches



HORN 5 Horn 5A A-Punches



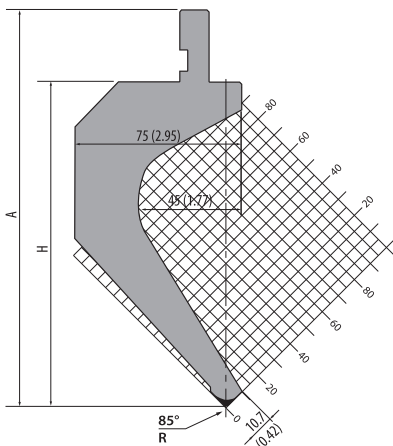
HORN 6 Horn 6A A-Punches



HORN 7 Horn 7 A-Punches

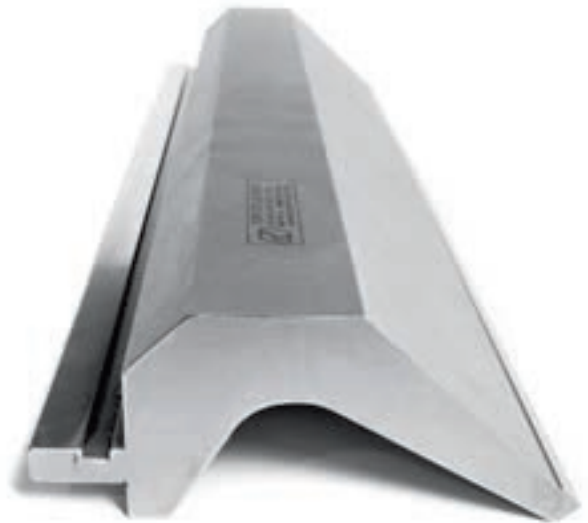
TOP.175.85.R08 / R2

900 kN/m max.



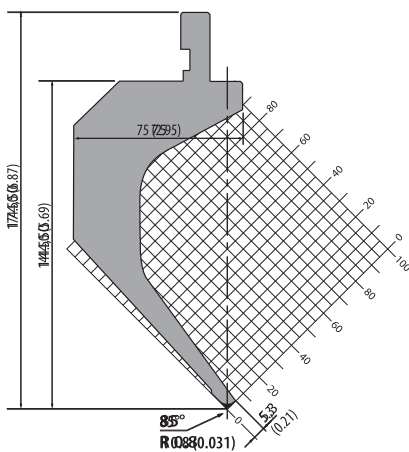
TOP.175.85.R08	H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
	525 mm	20.67 in	20.9 kg
	495 mm segmented	19.49 in segmented	19.7 kg
TOP.175.85.R2	H=144.30 / A=174.30 / R=2.0 (H=5.68 / A=6.86 / R=0.079)		
	525 mm	20.67 in	20.9 kg
	495 mm segmented	19.49 in segmented	19.7 kg
	500 mm segmented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

42Cr: 900-1150 N/mm²



TOP.175.85.R08.S

200 kN/m max.



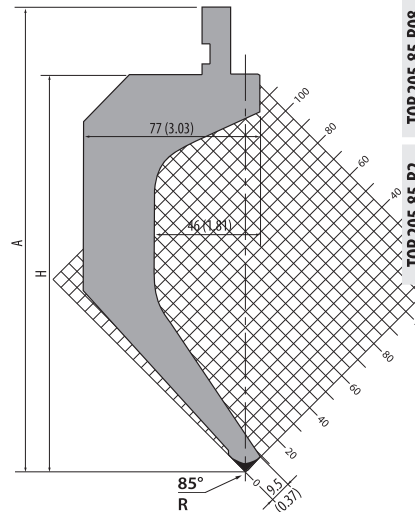
525 mm	20.67 in	18.5 kg
495 mm segmented	19.49 in segmented	17.4 kg
500 mm segmented	19.68 in segmented	17.6 kg

42Cr: 900-1150 N/mm²



TOP.205.85.R08 / R2

700 kN/m max.



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

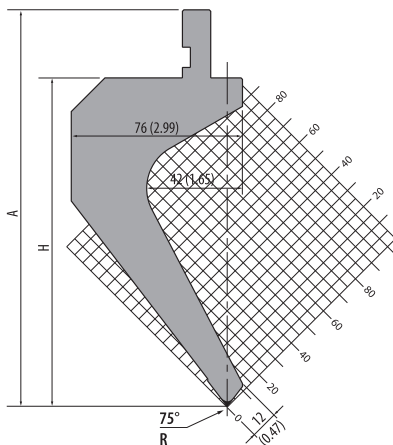
42Cr: 900-1150 N/mm²



75° TOP-Punches

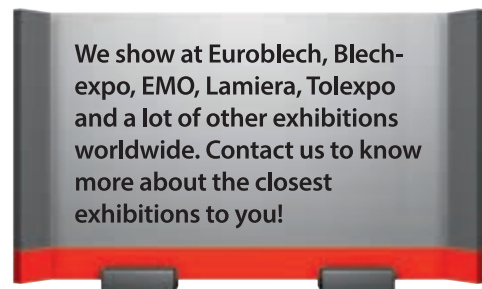
TOP.175.75.R08 / R2

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

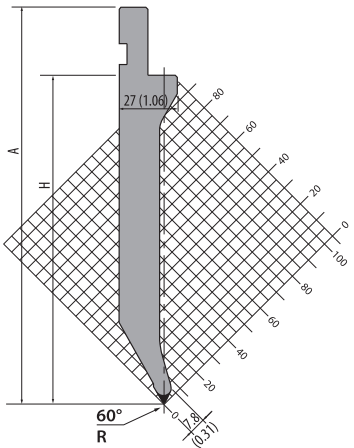
42Cr: 900-1150 N/mm²



We show at Euroblech, Blechexpo, EMO, Lamiera, Tolexpo and a lot of other exhibitions worldwide. Contact us to know more about the closest exhibitions to you!

TOP.175.60.R08 / R2

800 kN/m max.



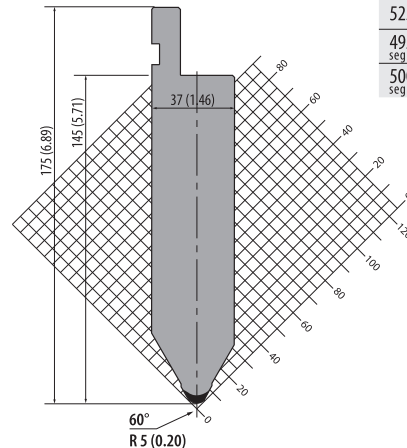
TOP.175.60.R08		
H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg
TOP.175.60.R2		
H=143.80 / A=173.80 / R=2.0 (H=5.66 / A=6.84 / R=0.079)		
525 mm	20.67 in	12.0 kg
495 mm segmented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

42Cr: 900-1150 N/mm²



TOP.175.60.R5

1600 kN/m max.



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

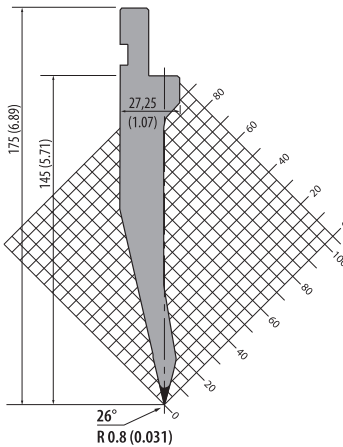
42Cr: 900-1150 N/mm²



26° TOP-Punches

TOP.175.26.R08

950 kN/m max.



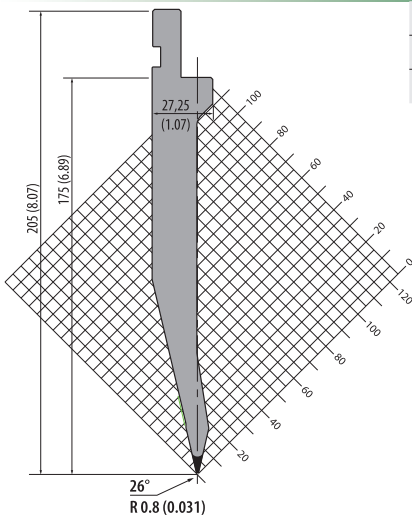
525 mm	20.67 in	11.0 kg
495 mm segmented	19.49 in segmented	10.4 kg
500 mm segmented	19.68 in segmented	10.5 kg

42Cr: 900-1150 N/mm²



TOP.205.26.R08

950 kN/m max.



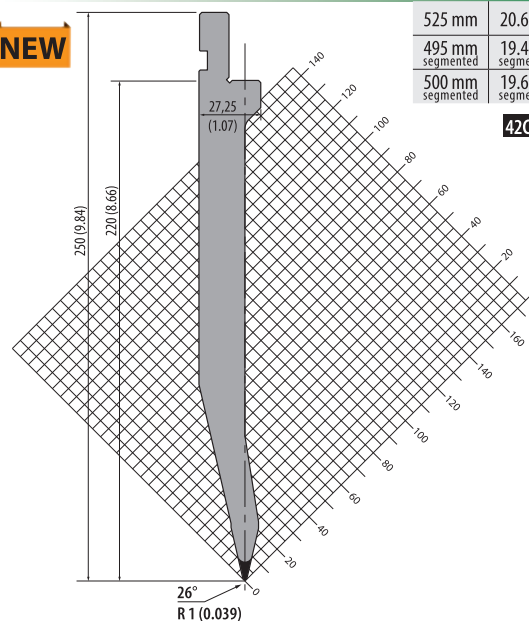
525 mm	20.67 in	14.0 kg
495 mm segmented	19.49 in segmented	13.2 kg
500 mm segmented	19.68 in segmented	13.3 kg

42Cr: 900-1150 N/mm²



TOP.250.26.R1

1000 kN/m max.

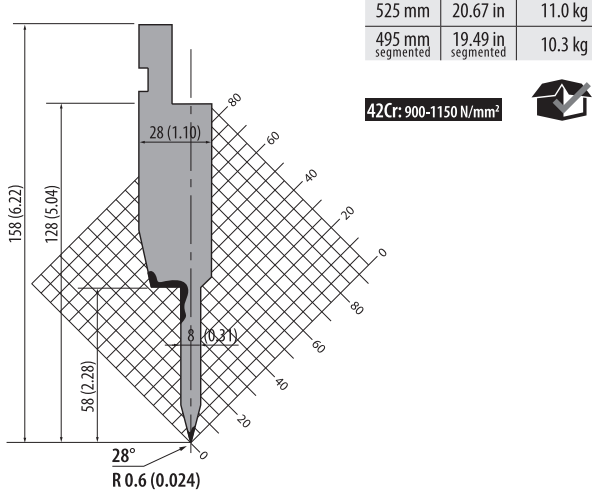


525 mm	20.67 in	17.7 kg
495 mm segmented	19.49 in segmented	16.7 kg
500 mm segmented	19.68 in segmented	16.8 kg

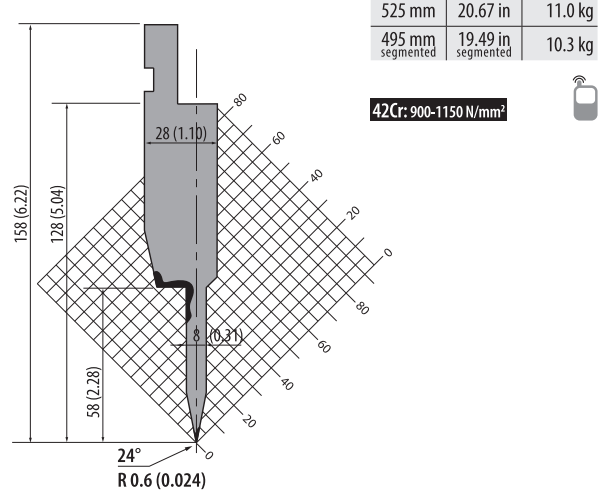
42Cr: 900-1150 N/mm²



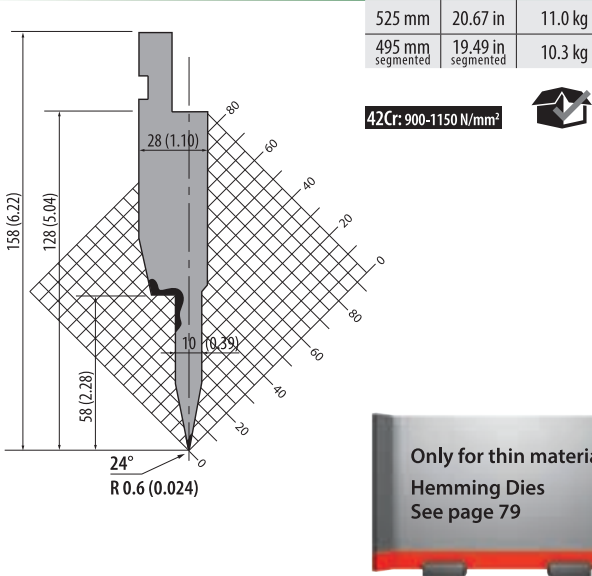
TOP.SP.134.28.8



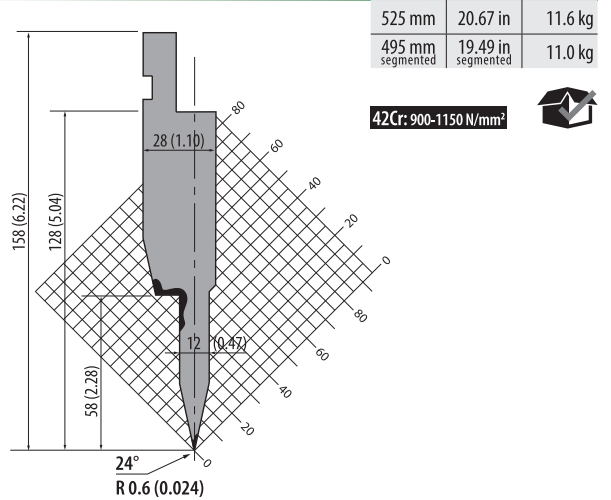
TOP.SP.134.24.8



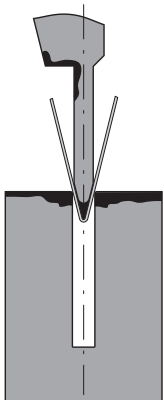
TOP.SP.134.24.10



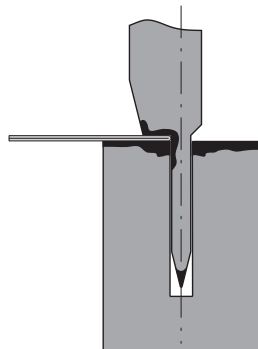
TOP.SP.134.24.12



Example of application



800 kN/m max.



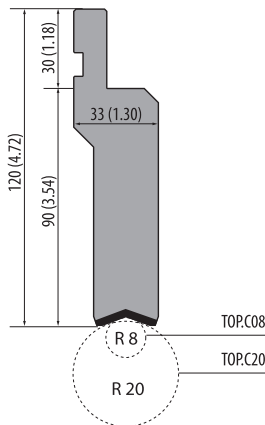
1000 kN/m max.



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	kN/mm ²	mm	in	mm	in	kN/mm ²	kN/mm ²
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

TOP.PC.120-08

1000 kN/m max.



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

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

42Cr: 900-1150 N/mm²

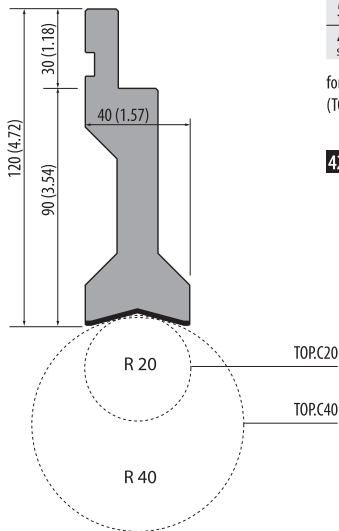


Rolleri radius tools are on stock in sectioned version too!
Take advantage of our tool availability!



TOP.PC.120-20

1000 kN/m max.



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

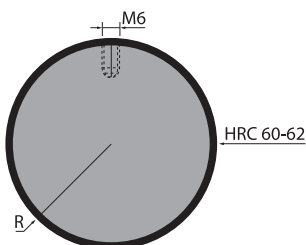
for Radius tools with R20-R40 (TOP.C20-TOP.C40) see below

42Cr: 900-1150 N/mm²



TOP-Radius Tools: R8-40

1000 kN/m max.



NEW

Material: C53
induction hardened
60-62 HRC

C53: 610-760 N/mm²

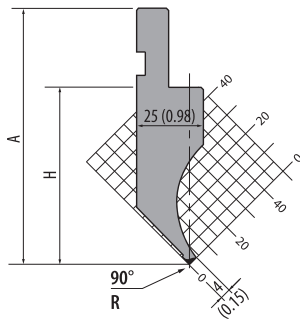


Model	R (mm)	R in	Weight	Weight
TOP.C08	8	0.31	0.8 kg	1.9 kg
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C22.5	22.5	0.88	6.6 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C27.5	27.5	1.08	9.8 kg	9.2 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C32.5	32.5	1.28	13.7 kg	12.9 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C37.5	37.5	1.47	18.2 kg	17.2 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg

525 mm
495 mm segmented

PK.97.90.R06 / P.97.90.R025

350 kN/m max.

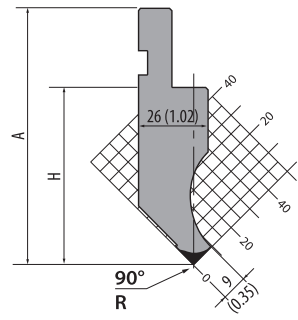


PK.97.90.R06	H=66.80 / A=96.80 / R=0.6 (H=2.63 / A=3.81 / R=0.024)		
	835 mm	32.87 in	10.5 kg
	415 mm	16.34 in	5.2 kg
	795 mm segmented	31.29 in segmented	10.0 kg
P.97.90.R025	H=66.80 / A=96.80 / R=0.25 (H=2.63 / A=3.81 / R=0.010)		
	835 mm	32.87 in	10.5 kg
	415 mm	16.34 in	5.2 kg
	795 mm segmented	31.29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

42Cr: 900-1150 N/mm² **HORN 1**

PK.97.90.R08 / R025

1000 kN/m max.

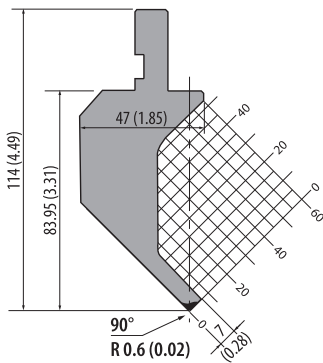


PK.97.90.R08	H=66.35 / A=96.35 / R=0.8 (H=2.61 / A=3.79 / R=0.031)		
	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.5 kg
PK.97.90.R025	H=66.60 / A=96.60 / R=0.25 (H=2.62 / A=3.80 / R=0.010)		
	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented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

C45: 560-710 N/mm² **HORN 1**

PK.114.90.R06

200 kN/m max.



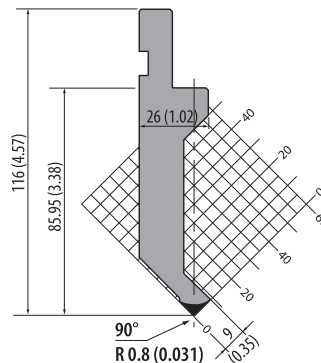
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm²

HORN 1

PK.116.90.R08

400 kN/m max.



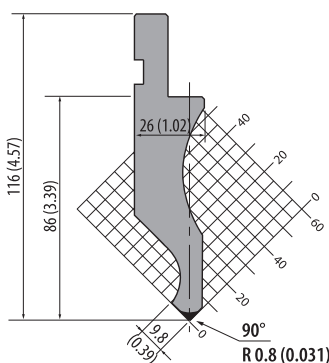
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

HORN 1

DK.116.90.R08

500 kN/m max.



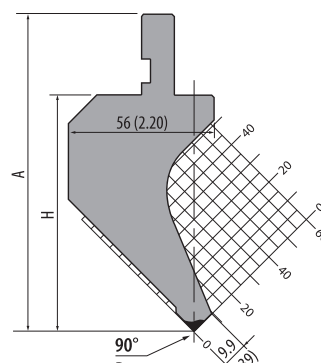
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.4 kg

C45: 560-710 N/mm²

HORN 1

PK.120.90.R08 / R025

600 kN/m max.



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

C45: 560-710 N/mm² **HORN 1**



Rolleri Videos

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

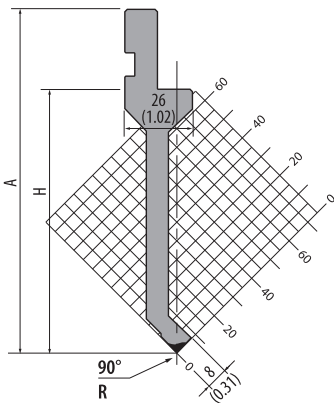


Articles on stock – Please note that delivery time varies according to your location.



P.130.90.R06 / R025

350 kN/m max.



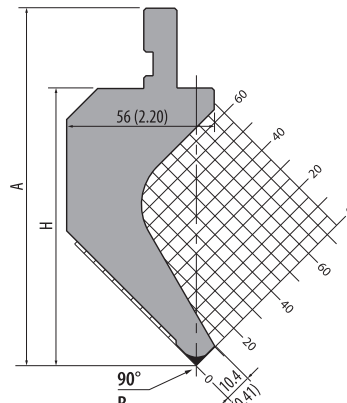
P.130.90.R06		
H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024)		
835 mm	32.87 in	11.5 kg
415 mm	16.34 in	5.7 kg
795 mm segmented	31.29 in segmented	10.9 kg
805 mm segmented	31.69 in segmented	11.0 kg

P.130.90.R025		
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/mm²

PK.135.90.R08 / R025

500 kN/m max.



PK.135.90.R08		
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

PK.135.90.R025		
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/mm²

90° Mobile Horns



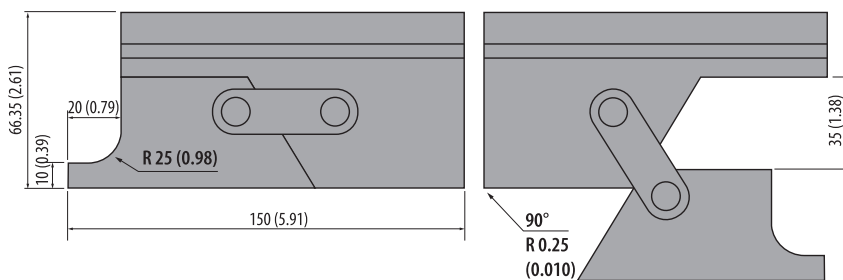
Area of Application

- for easy bending of special box profiles
- can be produced for these tool models:

	88°	85°	70°	60°	26°
Rolleri Type R1	P97.88.R06	TOP.175.85.R08	P.160.70.R08	P.135.60.R08	PU.117.26.R08
	P97.88.R08	TOP.205.85.R08		P.145.60.R08	TOP.205.26.R08
	P.130.88.R08			TOP.175.60.R08	TOP.175.26.R08
	P.150.88.R08				
Rolleri Type R2	86°	80°	28°		
	TPR.157.86.R1	TPR.200.80.R1	TPR.200.28.R1		
	TPR.237.86.R1				

SCA.M.90.R08

150 kN/m max.



per pair 3.5 kg

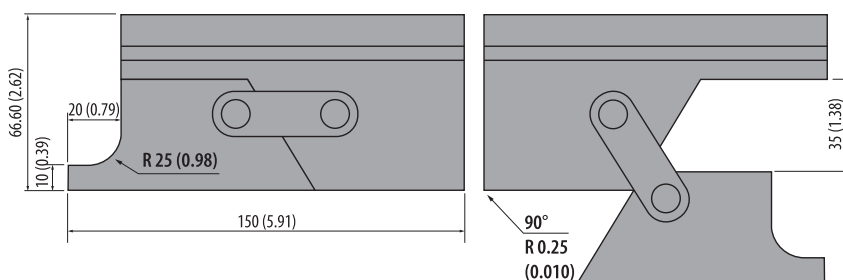
1 Pair left/right compatible with PK.97.90.R08

C45: 560-710 N/mm²



SCA.M.90.R025

150 kN/m max.



per pair 3.5 kg

1 Pair left/right compatible with PK.97.90.R025

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

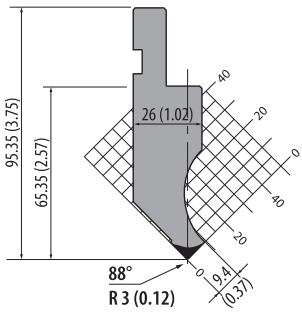
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

P.95.88.R3

1000 kN/m max.



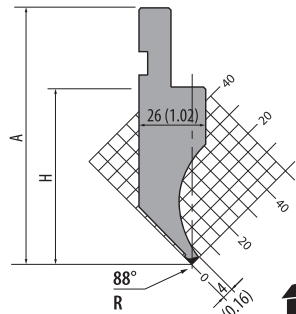
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.97.88.R06 / R025

350 kN/m max.



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

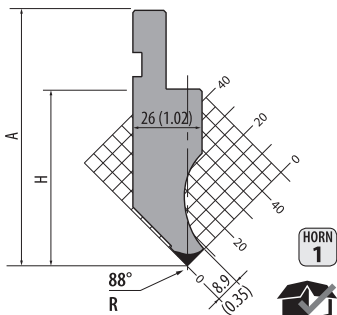
H=66.95 / A=96.95 / R=0.25 (H=2.64 / A=3.82 / R=0.010)		
835 mm	32.87 in	9.5 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.0 kg
805 mm segmented	31.69 in segmented	9.2 kg
900 mm	35.43 in	11.0 kg

42Cr: 900-1150 N/mm²



P.97.88.R08 / PK.97.88.R025

1000 kN/m max.



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

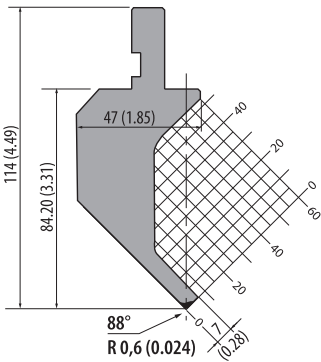
H=66.60 / A=96.60 / R=0.25 (H=2.62 / A=3.80 / R=0.010)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.5 kg
805 mm segmented	31.69 in segmented	10.6 kg
900 mm	35.43 in	11.8 kg

C45: 560-710 N/mm²



P.114.88.R06

200 kN/m max.



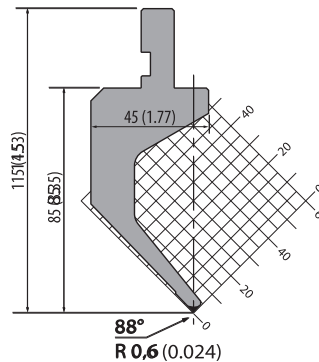
835 mm	32.87 in	15.6 kg
415 mm	16.34 in	7.7 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	15.0 kg

42Cr: 900-1150 N/mm²



P.115.88.R06

130 kN/m max.



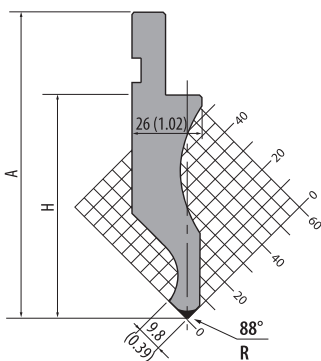
835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.7 kg
805 mm segmented	31.69 in segmented	5.8 kg

42Cr: 900-1150 N/mm²



D.116.88.R08 / R3

500 kN/m max.



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

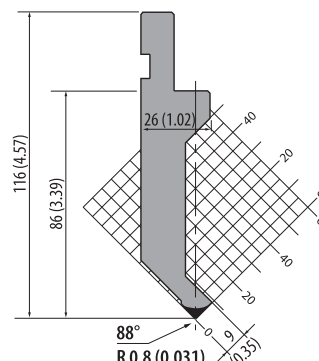
H=85.00 / A=115.00 / R=3.0 (H=3.35 / A=4.53 / R=0.118)		
835 mm	32.87 in	11.9 kg
415 mm	16.34 in	5.9 kg
795 mm segmented	31.29 in segmented	11.3 kg
805 mm segmented	31.69 in segmented	11.5 kg

C45: 560-710 N/mm²



P.116.88.R08

400 kN/m max.



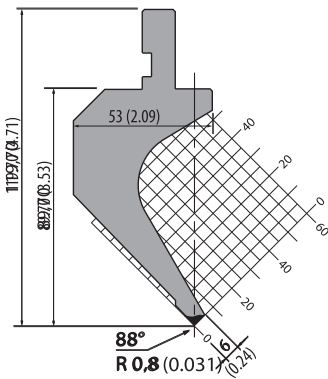
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.4 kg
805 mm segmented	31.69 in segmented	11.5 kg

C45: 560-710 N/mm²



PS.120.88.R08

450 kN/m max.



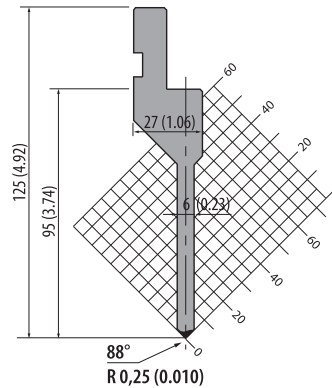
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg

C45: 560-710 N/mm²



P.125.88.R025

500 kN/m max.



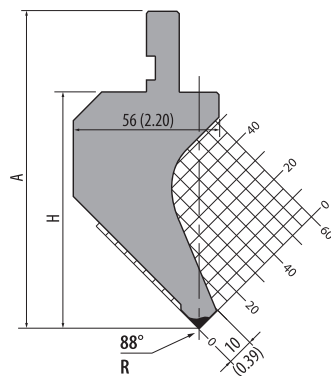
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
795 mm segmented	31.29 in segmented	8.5 kg
805 mm segmented	31.69 in segmented	8.6 kg

42Cr: 900-1150 N/mm²



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

600 kN/m max.



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

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

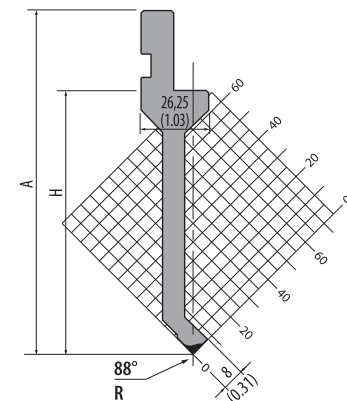
PK.120.88.R025	H=89.60 / A=120.00 / R=0.25 (H=3.53 / A=4.72 / R=0.010)		
	835 mm	32.87 in	21.0 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.0 kg
	805 mm segmented	31.69 in segmented	20.2 kg

C45: 560-710 N/mm²



P.130.88.R06 / PK.130.88.R025

350 kN/m max.



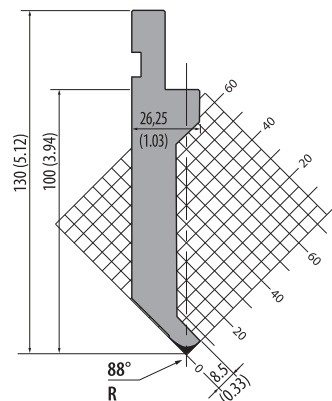
P.130.88.R06	H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024)		
	835 mm	32.87 in	9.8 kg
	415 mm	16.34 in	4.9 kg
	795 mm segmented	31.29 in segmented	9.3 kg
	805 mm segmented	31.69 in segmented	9.4 kg
PK.130.88.R025	H=99.95 / A=129.95 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
	835 mm	32.87 in	9.7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

42Cr: 900-1150 N/mm²



P.130.88.R08 / R025

400 kN/m max.



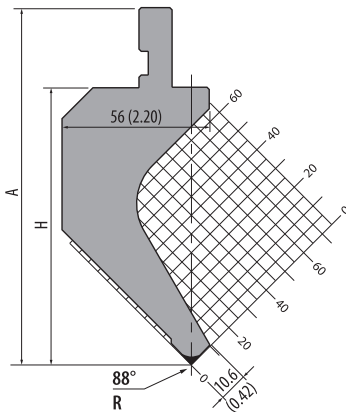
P.130.88.R08	H=100.00 / A=130.00 / R=0.8 (H=3.94 / A=5.12 / R=0.031)		
	835 mm	32.87 in	14.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.3 kg
	805 mm segmented	31.69 in segmented	13.4 kg

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

C45: 560-710 N/mm²



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

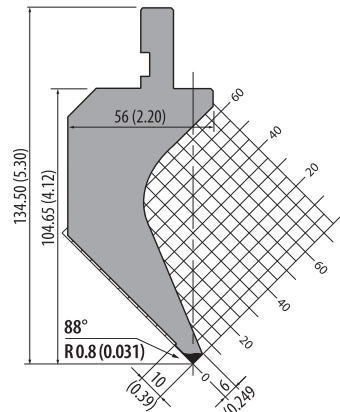


P.135.88.R08		H=104.65 / A=134.50 / R=0.8 (H=4.12 / A=5.30 / R=0.031)	
835 mm	32.87 in	22.5 kg	
415 mm	16.34 in	11.2 kg	
795 mm segmented	31.29 in segmented	21.4 kg	
805 mm segmented	31.69 in segmented	21.7 kg	
P.135.88.R3		H=103.40 / A=133.40 / R=3.0 (H=4.07 / A=5.25 / R=0.118)	
835 mm	32.87 in	22.5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

C45: 560-710 N/mm²



PS.135.88.R08 450 kN/m max.

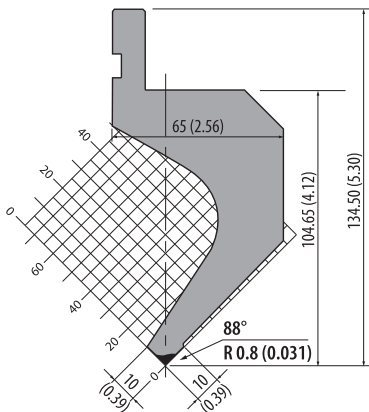


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	12.5 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



PR.135.88.R08 450 kN/m max.

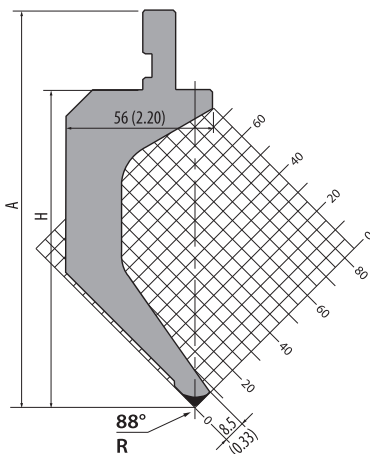


835 mm	32.87 in	25.0 kg
415 mm	16.34 in	11.5 kg
795 mm segmented	31.29 in segmented	23.8 kg
805 mm segmented	31.69 in segmented	24.1 kg

C45: 560-710 N/mm²



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

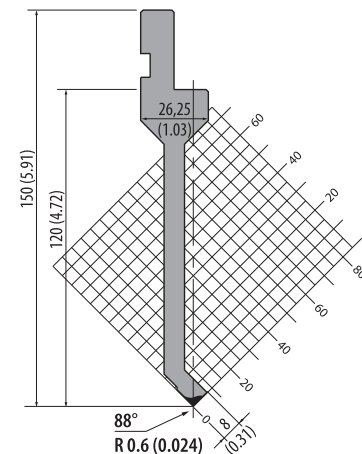


P.150.88.R08		H=120.00 / A=150.00 / R=0.8 (H=4.72 / A=5.91 / R=0.031)	
835 mm	32.87 in	21.5 kg	
415 mm	16.34 in	10.5 kg	
795 mm segmented	31.29 in segmented	20.4 kg	
805 mm segmented	31.69 in segmented	20.7 kg	
900 mm	35.43 in	23.1 kg	
P.150.88.R3		H=119.00 / A=149.00 / R=3.0 (H=4.69 / A=5.87 / R=0.118)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

42Cr: 900-1150 N/mm²



P.150.88.R06 350 kN/m max.



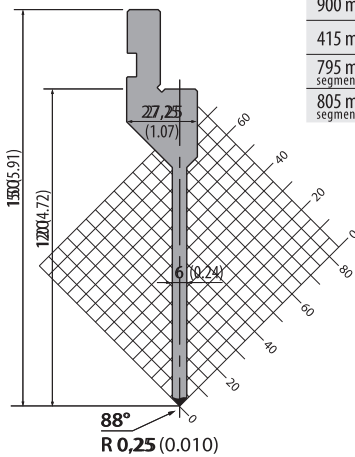
900 mm	35.43 in	12.9 kg
415 mm	16.34 in	5.9 kg
795 mm segmented	31.29 in segmented	12.2 kg
805 mm segmented	31.69 in segmented	12.4 kg

42Cr: 900-1150 N/mm²



P.150.88.R025

500 kN/m max.



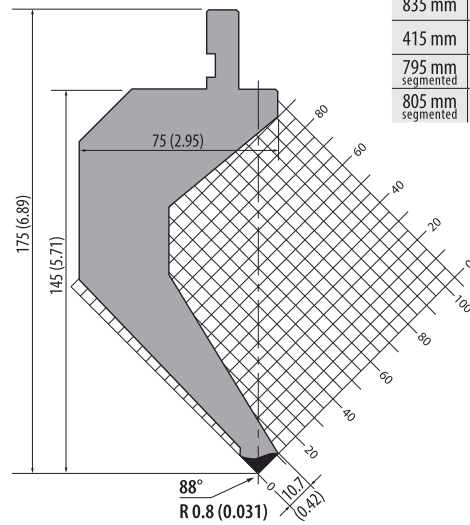
900 mm	32.87 in	10.0 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



P.175.88.R08

500 kN/m max.



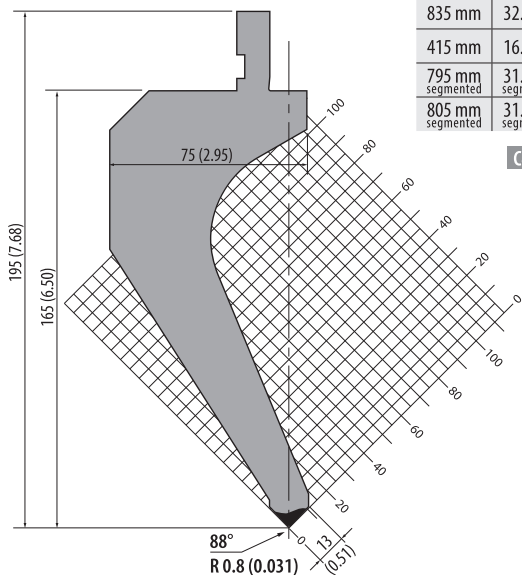
835 mm	32.87 in	35.0 kg
415 mm	16.34 in	17.5 kg
795 mm segmented	31.29 in segmented	33.3 kg
805 mm segmented	31.69 in segmented	33.7 kg

C45: 560-710 N/mm²



P.195.88.R08

600 kN/m max.



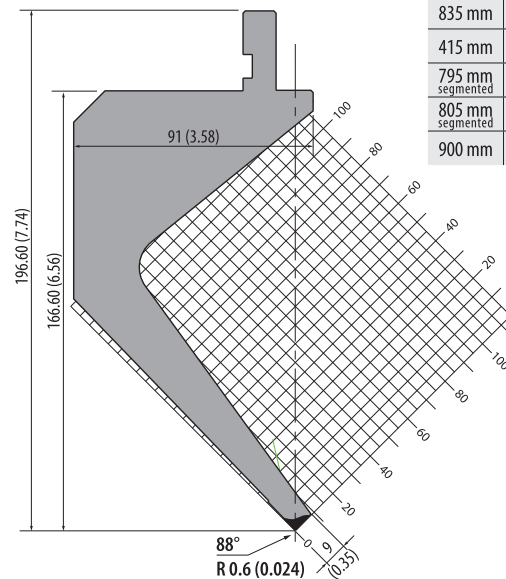
835 mm	32.87 in	41.0 kg
415 mm	16.34 in	20.4 kg
795 mm segmented	31.29 in segmented	39.0 kg
805 mm segmented	31.69 in segmented	39.5 kg

C45: 560-710 N/mm²



P.196.88.R06

300 kN/m max.



835 mm	32.87 in	41.8 kg
415 mm	16.34 in	20.8 kg
795 mm segmented	31.29 in segmented	39.7 kg
805 mm segmented	31.69 in segmented	40.2 kg
900 mm	35.43 in	45.0 kg

C45: 560-710 N/mm²

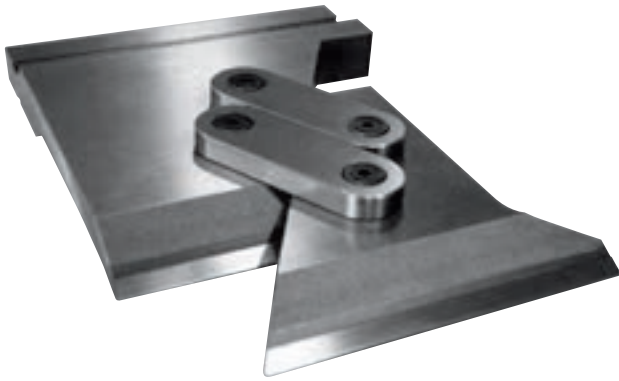


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R1

ROLLERI TYPE R1 88° Mobile Horns



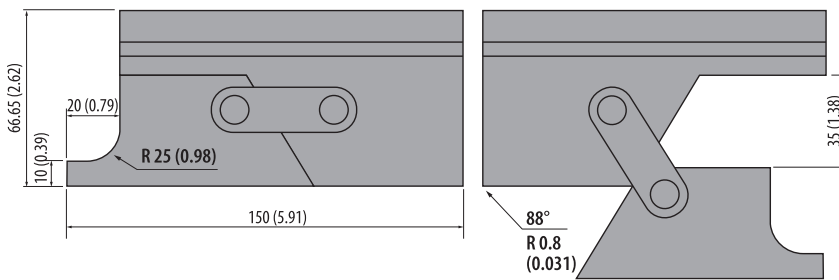
Area of Application

- for easy bending of special box profiles
- can be produced for these tool models:

	88°	85°	70°	60°	26°
Rolleri Type R1	P.97.88.R06	TOP.175.85.R08	P.160.70.R08	P.135.60.R08	PU.117.26.R08
	P.97.88.R08	TOP.205.85.R08		P.145.60.R08	TOP.205.26.R08
	P.130.88.R08			TOP.175.60.R08	TOP.175.26.R08
	P.150.88.R08				
Rolleri Type R2	86°	80°	28°		
	TPR.157.86.R1	TPR.200.80.R1	TPR.200.28.R1		
	TPR.237.86.R1				

SCA.M.88.R08

150 kN/m max.



per pair 3.5 kg

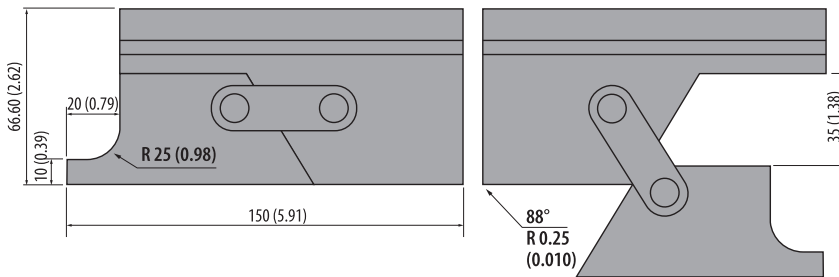
1 Pair left/right compatible with P.97.88.R08

C45: 560-710 N/mm²



SCA.M.88.R025

150 kN/m max.



per pair 3.5 kg

1 Pair left/right compatible with PK.97.88.R025

C45: 560-710 N/mm²

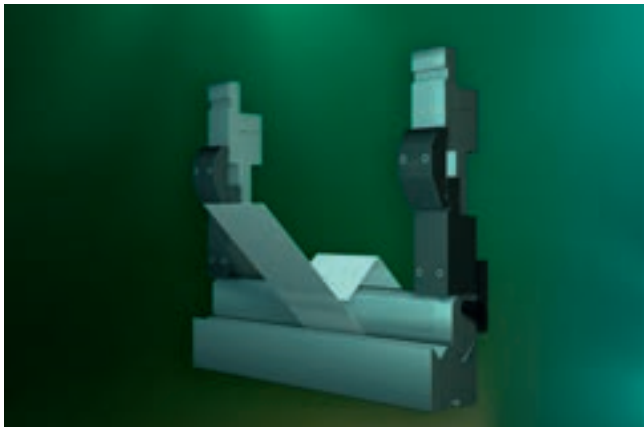
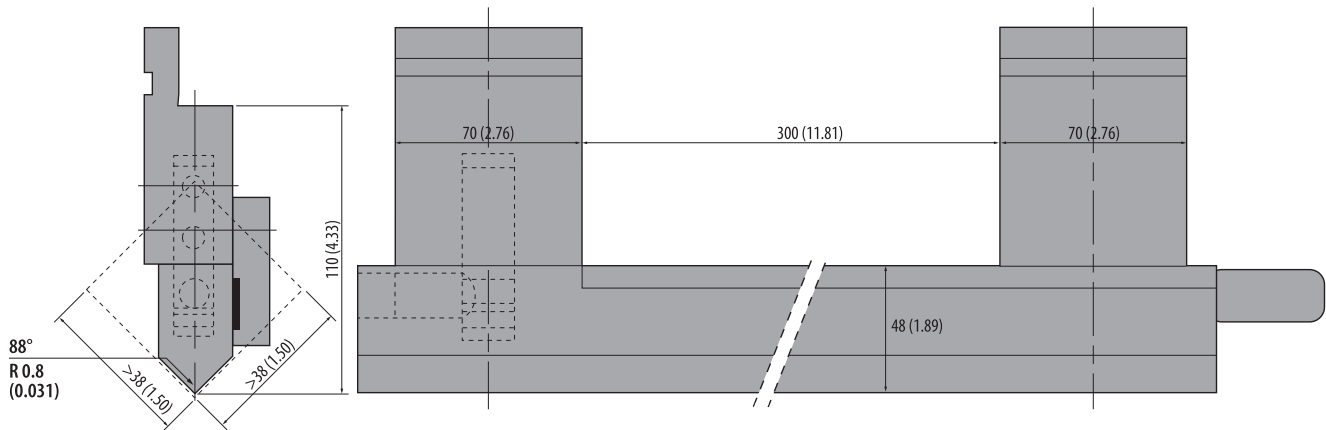


SPE.11

150 kN/m.max.

per piece 7.0 kg

42Cr: 900-1150 N/mm²



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



Article on stock



Please ask for delivery time!

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



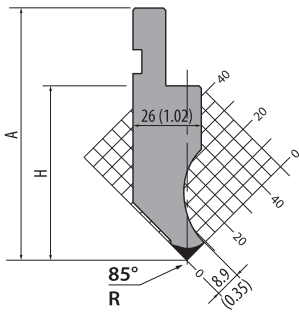
Articles on stock – Please note that delivery time depends on your location.

R1

ROLLERI TYPE R1 85° Punches

P.97.85.R08 / PK.95.85.R3

1000 kN/m max.



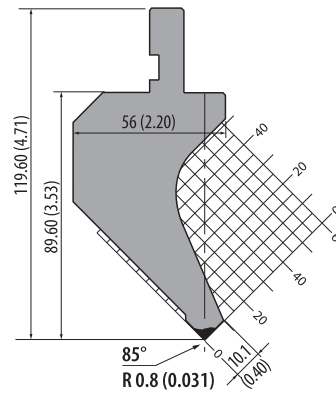
P.97.85.R08		
H=66.60 / A=96.50 / R=0.8 (H=2.62 / A=3.80 / R=0.031)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

PK.95.85.R3		
H=65.45 / A=95.45 / R=3.0 (H=2.58 / A=3.76 / R=0.118)		
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm² **HORN 1**

PK.120.85.R08

600 kN/m max.



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

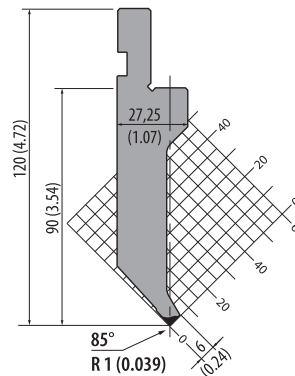
C45: 560-710 N/mm²

HORN 1



P.120.85.R1

800 kN/m max.



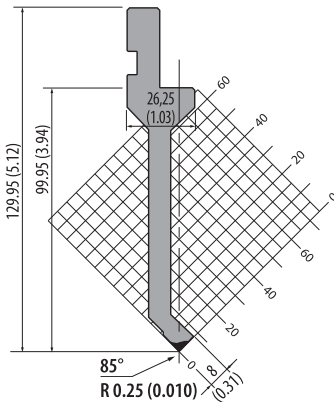
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	6.7 kg
795 mm segmented	31.29 in segmented	12.9 kg
805 mm segmented	31.69 in segmented	13.0 kg

42Cr: 900-1150 N/mm²

HORN 1

P.130.85.R025

350 kN/m max.



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

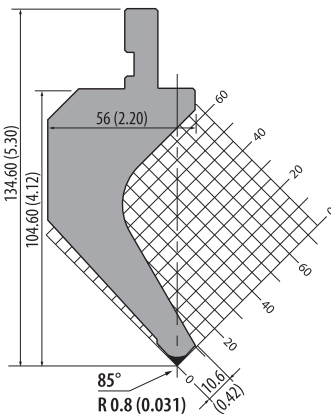
42Cr: 900-1150 N/mm²

HORN 1



PK.135.85.R08

500 kN/m max.



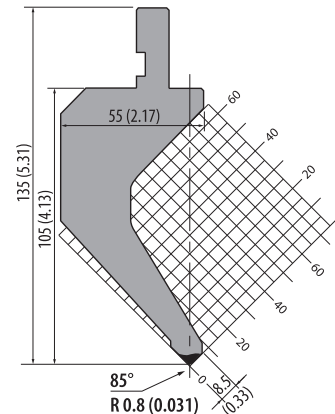
835 mm	32.87 in	22.2 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	21.1 kg
805 mm segmented	31.69 in segmented	21.4 kg

C45: 560-710 N/mm²

HORN 1

P.135.85.R08

800 kN/m max.



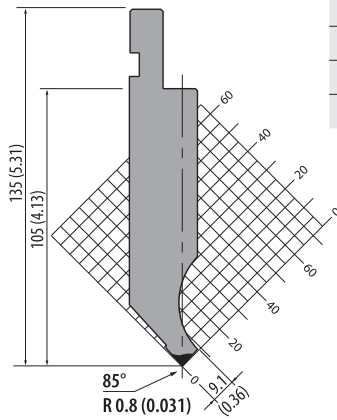
835 mm	32.87 in	20.9 kg
415 mm	16.34 in	10.4 kg
795 mm segmented	31.29 in segmented	19.9 kg
805 mm segmented	31.69 in segmented	20.1 kg

42Cr: 900-1150 N/mm²

HORN 1

PS.135.85.R08

1000 kN/m max.



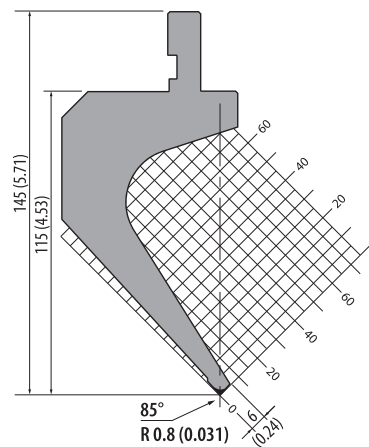
835 mm	32.87 in	17.7 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	16.8 kg
805 mm segmented	31.69 in segmented	17.0 kg

C45: 560-710 N/mm²



P.145.85.R08

600 kN/m max.



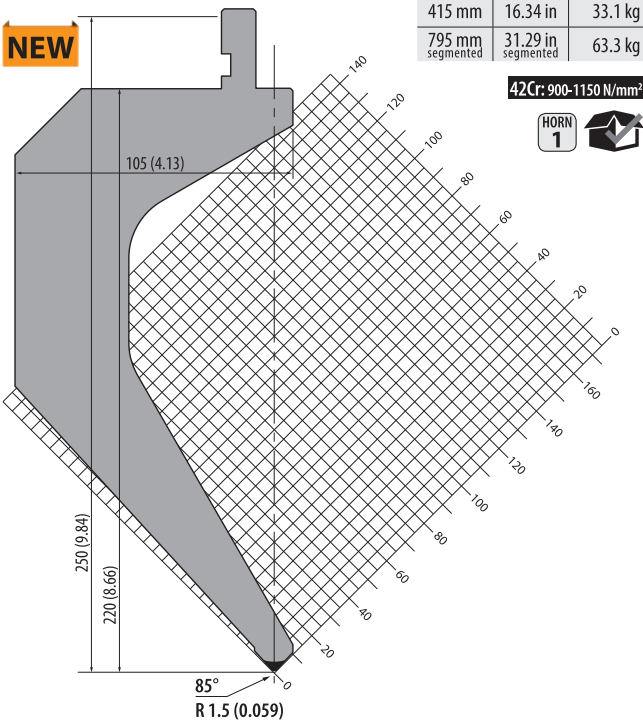
835 mm	32.87 in	22.6 kg
415 mm	16.34 in	11.2 kg
795 mm segmented	31.29 in segmented	21.5 kg
805 mm segmented	31.69 in segmented	21.7 kg

42Cr: 900-1150 N/mm²



P.250.85.R15

850 kN/m max.



415 mm	16.34 in	33.1 kg
795 mm segmented	31.29 in segmented	63.3 kg

42Cr: 900-1150 N/mm²



For a rapid vertical tool change, punches RollerI R1 Type can be equipped with the spring-loaded ROL1-System (20% Surcharge).
Retrofitted or new!
See pages 214-215

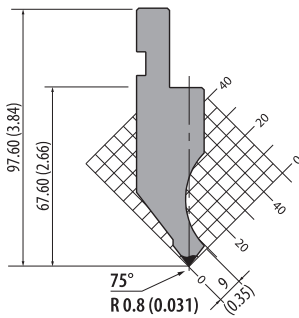
R1

ROLLERI TYPE R1

75° Punches

P.97.75.R08

1000 kN/m max.



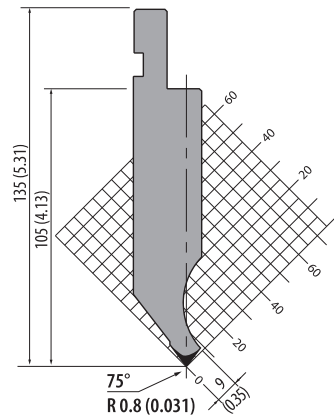
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

42Cr: 900-1150 N/mm²



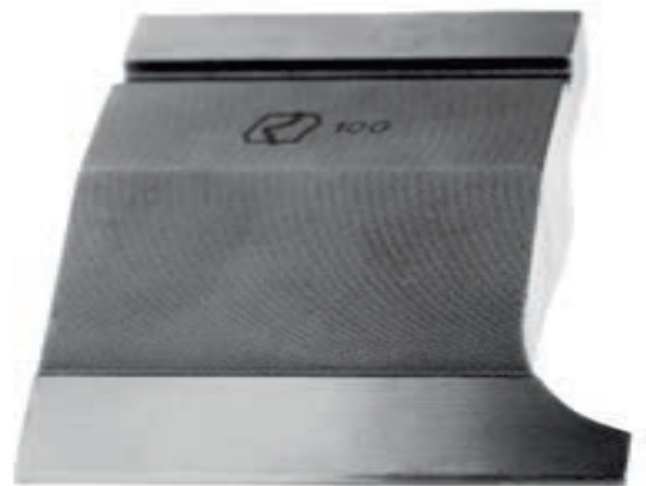
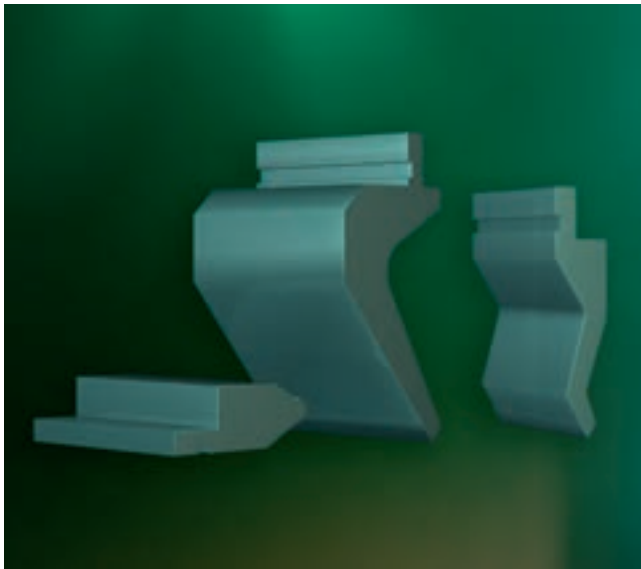
P.135.75.R08

1000 kN/m max.



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

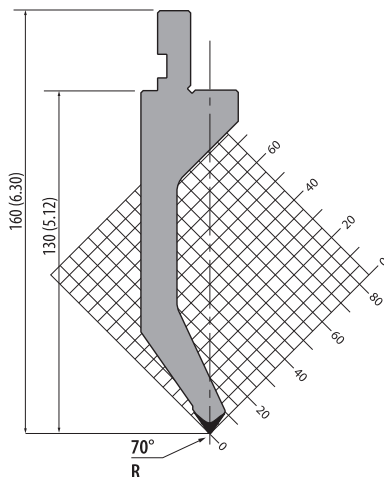
42Cr: 900-1150 N/mm²



70° Punches

P.160.70.R08 / R3

450 kN/m max.



R=0.8 (0.031)			
P.160.70.R08	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)			
P.160.70.R3	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	8.9 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.3 kg

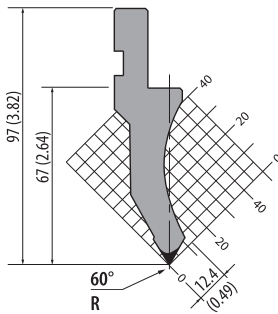
42Cr: 900-1150 N/mm²



Modifications of standard tools: fast and precise, directly from the manufacturer!
See pages 264-269

P.97.60.R08 / R2

600 kN/m max.

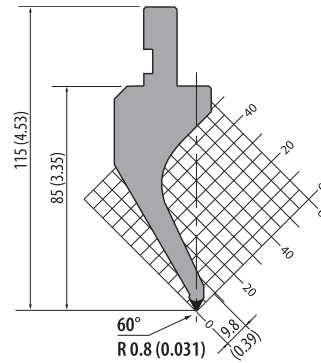


R=0.8 (0.031)			
P.97.60.R08	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	805 mm segmented	31.69 in segmented	8.7 kg
R=2.0 (0.079)			
P.97.60.R2	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	5.0 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	805 mm segmented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

C45: 560-710 N/mm²

P.115.60.R08

400 kN/m max.



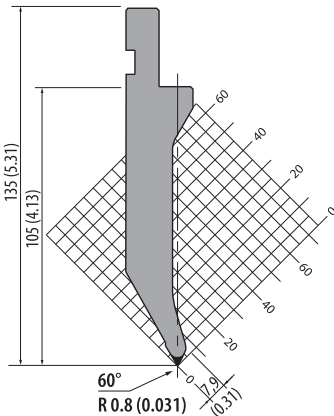
835 mm	32.87 in	11.9 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.3 kg
805 mm segmented	31.69 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



P.135.60.R08

800 kN/m max.



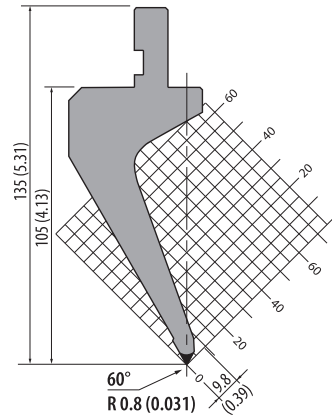
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm²



PG.135.60.R08

700 kN/m max.



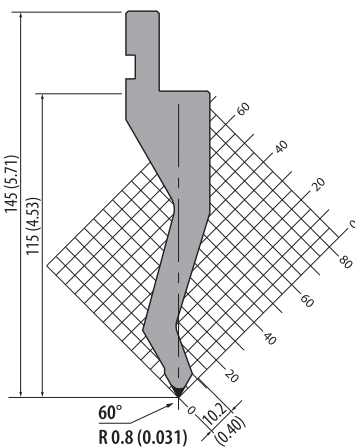
835 mm	32.87 in	16.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	15.7 kg
805 mm segmented	31.69 in segmented	15.9 kg

42Cr: 900-1150 N/mm²



P.145.60.R08

700 kN/m max.



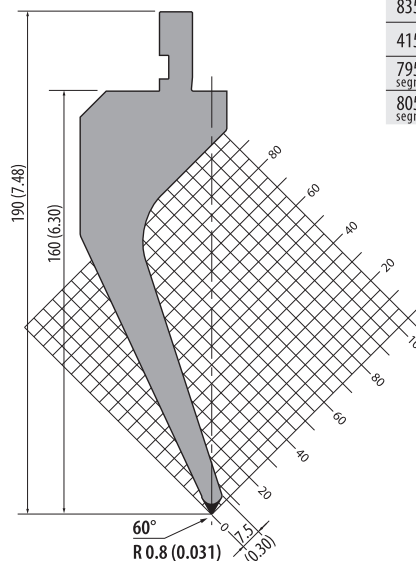
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	14.4 kg

42Cr: 900-1150 N/mm²



P.190.60.R08

400 kN/m max.



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

C45: 800-850 N/mm²



Article on stock



Please ask for delivery time!

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



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

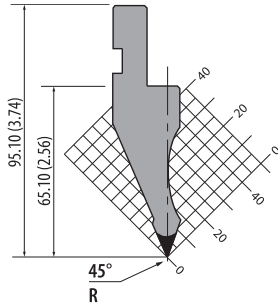
R1

ROLLERI TYPE R1

45° Punches

P.95.45.R08 / R15

800 kN/m max.



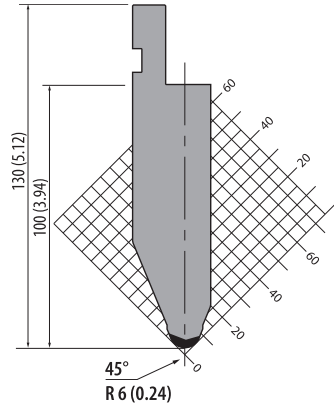
R=0.8 (0.031)			
P.95.45.R08	835 mm	32.87 in	9.5 kg
	415 mm	16.34 in	4.2 kg
	795 mm segmented	31.29 in segmented	9.0 kg
	805 mm segmented	31.69 in segmented	9.0 kg
R=1.5 (0.059)			
P.95.45.R15	835 mm	32.87 in	9.5 kg
	415 mm	16.34 in	4.2 kg
	795 mm segmented	31.29 in segmented	9.5 kg
	805 mm segmented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

C45: 560-710 N/mm²



P.130.45.R6

1000 kN/m max.



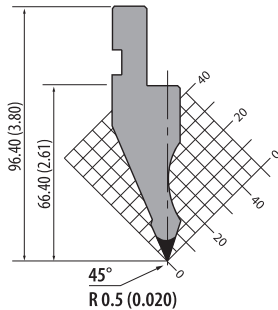
835 mm	32.87 in	19.5 kg
415 mm	16.34 in	9.6 kg
795 mm segmented	31.29 in segmented	18.6 kg
805 mm segmented	31.69 in segmented	18.8 kg

C45: 560-710 N/mm²



P.97.45.R05

800 kN/m max.



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

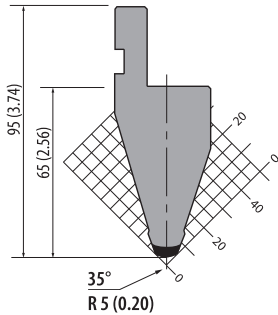
C45: 560-710 N/mm²



35° Punches

P.95.35.R5

1000 kN/m max.



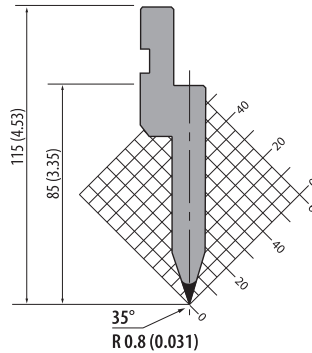
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm²



PU.85.35.R08

1000 kN/m max.



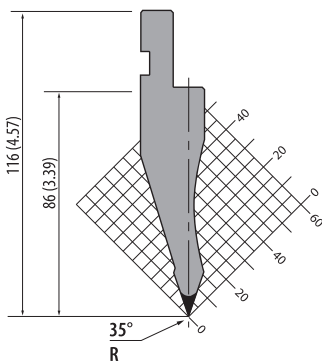
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²



P.116.35.R08 / R15

700 kN/m max.



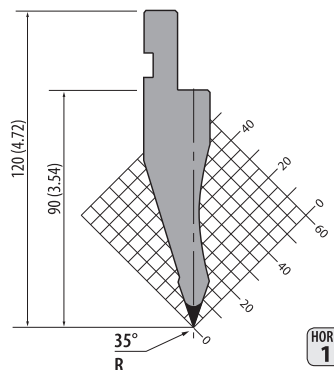
R=0.8 (0.031)			
P.116.35.R08	835 mm	32.87 in	10.5 kg
	415 mm	16.34 in	5.7 kg
	795 mm segmented	31.29 in segmented	10.0 kg
	805 mm segmented	31.69 in segmented	10.1 kg
R=1.5 (0.059)			
P.116.35.R15	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.7 kg
	795 mm segmented	31.29 in segmented	10.4 kg
	805 mm segmented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

C45: 560-710 N/mm²



P.120.35.R08 / R15 / R3

700 kN/m max.



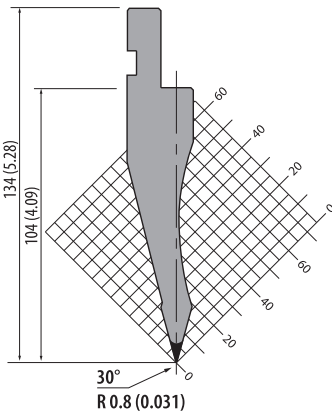
R=0.8 (0.031)			
P.120.35.R08	835 mm	32.87 in	12.3 kg
	415 mm	16.34 in	6.0 kg
	795 mm segmented	31.29 in segmented	11.7 kg
	805 mm segmented	31.69 in segmented	11.9 kg
R=1.5 (0.059)			
P.120.35.R15	835 mm	32.87 in	12.5 kg
	415 mm	16.34 in	6.0 kg
	795 mm segmented	31.29 in segmented	11.9 kg
	805 mm segmented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

C45: 560-710 N/mm²



PS.134.30.R08

700 kN/m max.



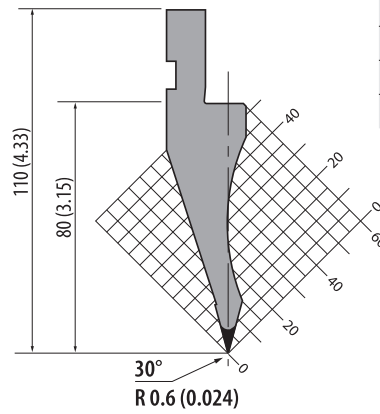
835 mm	32.87 in	13.3 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.6 kg
805 mm segmented	31.69 in segmented	12.8 kg

C45: 560-710 N/mm²



P.110.30.R06

500 kN/m max.



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

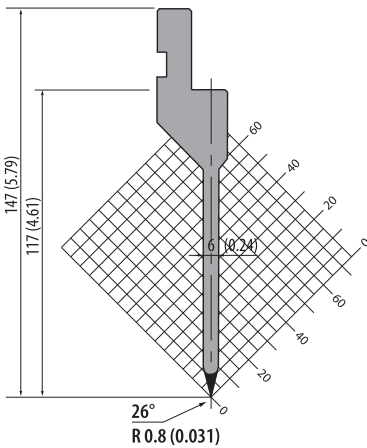
C45: 560-710 N/mm²



26° Punches

P.147.26.R08

500 kN/m max.



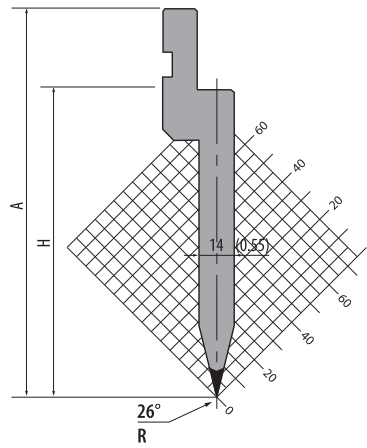
835 mm	32.87 in	9.8 kg
415 mm	16.34 in	4.9 kg
795 mm segmented	31.29 in segmented	9.3 kg
805 mm segmented	31.69 in segmented	9.4 kg

42Cr: 900-1150 N/mm²



PU.117.26.R08 / R3

1000 kN/m max.



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

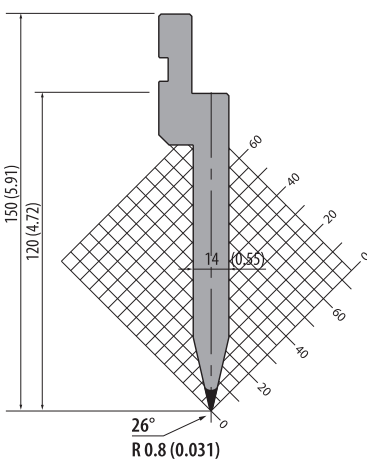
PU.117.26.R3	H=109.00 / A=139.00 / R=3.0 (H=4.29 / A=5.47 / R=0.118)	835 mm	32.87 in	13.5 kg
		415 mm	16.34 in	6.7 kg
		795 mm segmented	31.29 in segmented	12.8 kg
		805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm²



PU.150.26.R08.L

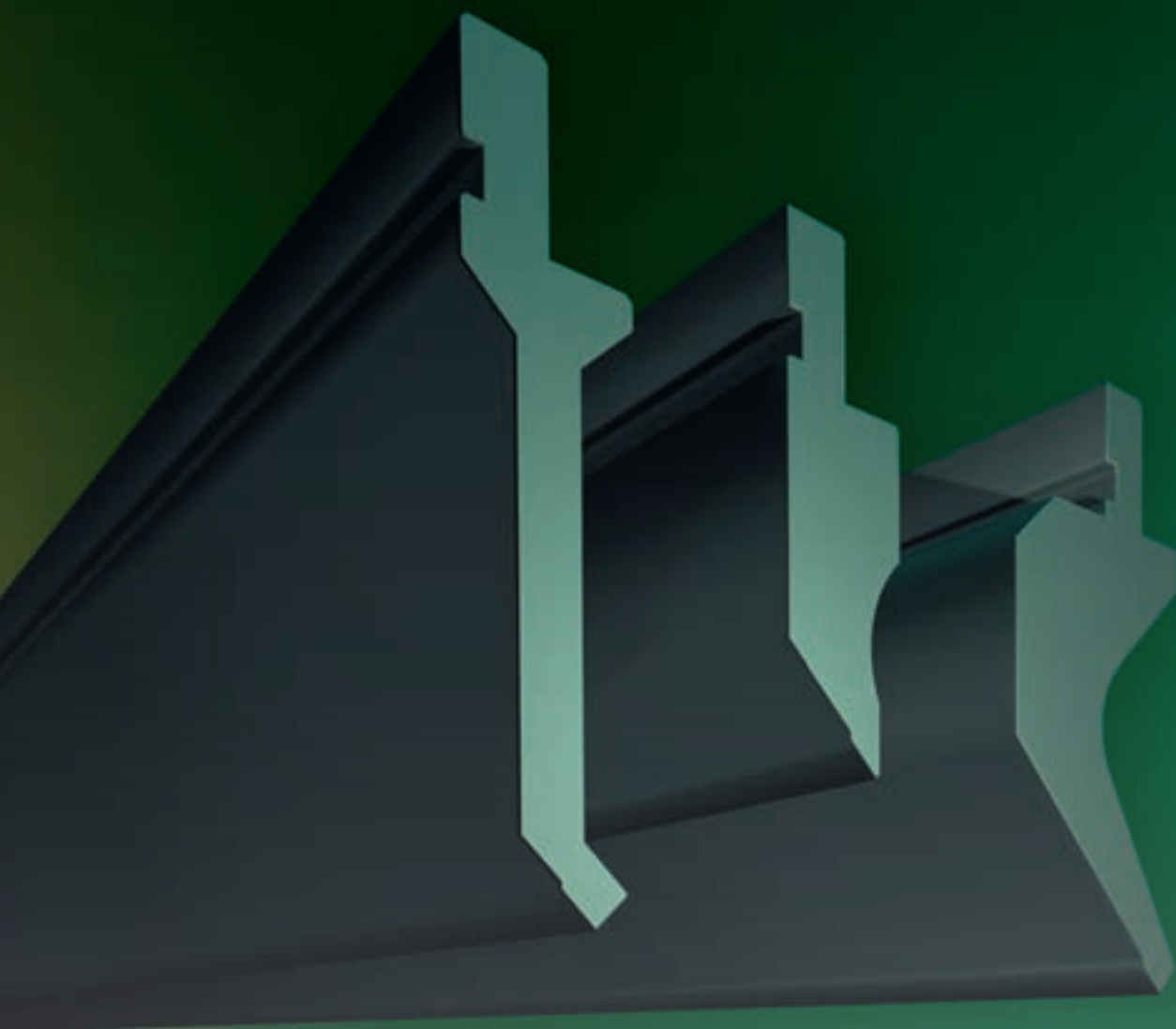
1000 kN/m max.



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

C45: 560-710 N/mm²

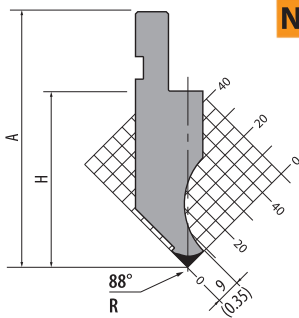




R1
A

A-PUNCHES
ROLLERI TYPE R1

00402 / 00430 / 01630 / 01602 1000 kN/m max.

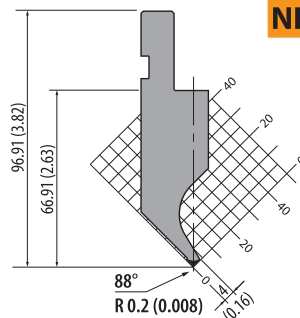


NEW

H=94.91 / A=124.91 / R=0.2 (H=3.74 / A=4.92 / R=0.008)			
00402 / 88°	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)			
00430 / 88°	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=65.60 / A=95.60 / R=3 (H=2.58 / A=3.76 / R=0.008)			
01630 / 90°	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=66.92 / A=96.92 / R=0.2 (H=2.63 / A=3.81 / R=0.118)			
01602 / 90°	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.5 kg
	800 mm segmented	31.50 in segmented	10.5 kg

C45: 560-710 N/mm² **HORN 3**

11700 / 11600 200 kN/m max.

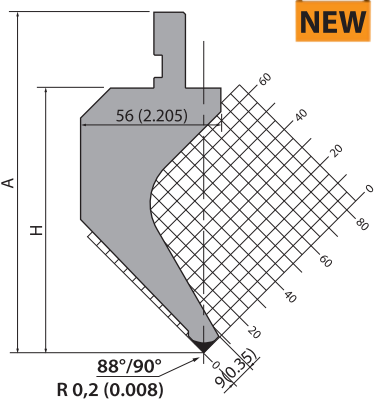


NEW

H=66.91 / A=96.91 (H=2.63 / A=3.81)			
11700 / 88°	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
H=66.90 / A=96.90 (H=2.63 / A=3.81)			
11600 / 90°	835 mm	32.87 in	10.6 kg
	415 mm	16.34 in	5.3 kg
	795 mm segmented	31.29 in segmented	10.1 kg
	800 mm segmented	31.50 in segmented	10.2 kg

42Cr: 900-1150 N/mm² **HORN 3**

04502 / 04600 500 kN/m max.

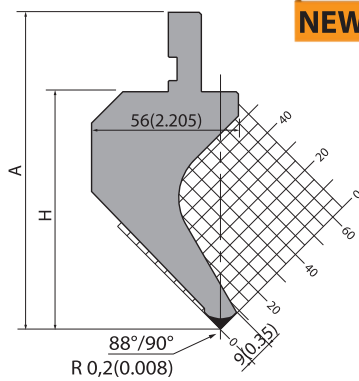


NEW

H=104.91 / A=134.91 (H=4.13 / A=5.31)			
04502 / 88°	835 mm	32.87 in	25.6 kg
	415 mm	16.34 in	12.8 kg
	795 mm segmented	31.29 in segmented	20.1 kg
	800 mm segmented	31.50 in segmented	20.2 kg
H=104.91 / A=134.91 (H=4.13 / A=5.31)			
04600 / 90°	835 mm	32.87 in	22.0 kg
	415 mm	16.34 in	11.0 kg
	795 mm segmented	31.29 in segmented	21.0 kg
	800 mm segmented	31.50 in segmented	21.3 kg

42Cr: 900-1150 N/mm² **HORN 3**

45202 / 46200 700 kN/m max.

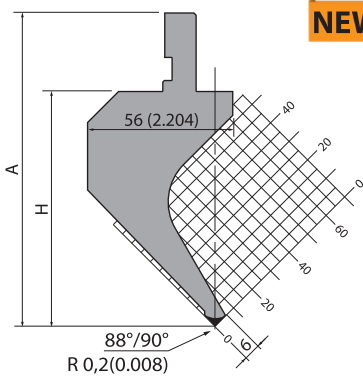


NEW

H=89.91 / A=119.91 (H=3.54 / A=4.72)			
45202 / 88°	835 mm	32.87 in	19.6 kg
	415 mm	16.34 in	9.8 kg
	795 mm segmented	31.29 in segmented	18.7 kg
	800 mm segmented	31.50 in segmented	18.9 kg
H=89.91 / A=119.91 (H=3.54 / A=4.72)			
46200 / 90°	835 mm	32.87 in	19.6 kg
	415 mm	16.34 in	9.8 kg
	795 mm segmented	31.29 in segmented	18.7 kg
	800 mm segmented	31.50 in segmented	18.9 kg

42Cr: 900-1150 N/mm² **HORN 3**

45302 / 46300 500 kN/m max.

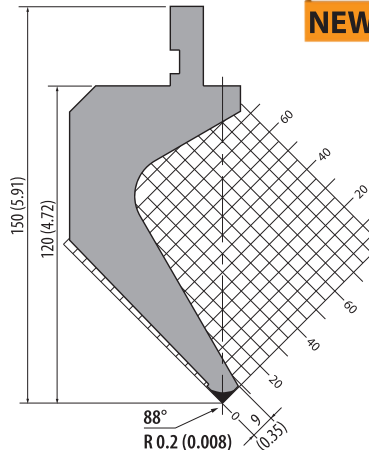


NEW

H=89.91 / A=119.91 (H=3.54 / A=4.72)			
45302 / 88°	835 mm	32.87 in	18.6 kg
	415 mm	16.34 in	9.3 kg
	795 mm segmented	31.29 in segmented	17.7 kg
	800 mm segmented	31.50 in segmented	17.9 kg
H=89.91 / A=119.91 (H=3.54 / A=4.72)			
46300 / 90°	835 mm	32.87 in	18.6 kg
	415 mm	16.34 in	9.3 kg
	795 mm segmented	31.29 in segmented	17.7 kg
	800 mm segmented	31.50 in segmented	17.9 kg

42Cr: 900-1150 N/mm² **HORN 7**

04702 / 04800 500 kN/m max.



NEW

H=120.00 / A=150.00 (H=4.72 / A=5.90)			
04702 / 88°	835 mm	32.87 in	25.9 kg
	415 mm	16.34 in	12.9 kg
	795 mm segmented	31.29 in segmented	24.6 kg
	800 mm segmented	31.50 in segmented	24.9 kg
H=120.00 / A=150.00 (H=4.72 / A=5.90)			
04800 / 90°	835 mm	32.87 in	25.9 kg
	415 mm	16.34 in	12.9 kg
	795 mm segmented	31.29 in segmented	24.6 kg
	800 mm segmented	31.50 in segmented	24.9 kg

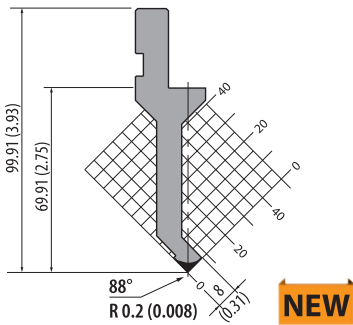
42Cr: 900-1150 N/mm² **HORN 3**

R1

ROLLERI TYPE R1 88°/90° A-Punches

20000 / 20100

300 kN/m max.



H=69.91 / A=99.91 (H=2.75 / A=3.93)			
20000 / 88°	835 mm	32.87 in	7.9 kg
	415 mm	16.34 in	3.9 kg
20100 / 90°	795 mm segmented	31.29 in segmented	7.6 kg
	800 mm segmented	31.50 in segmented	7.7 kg

NEW

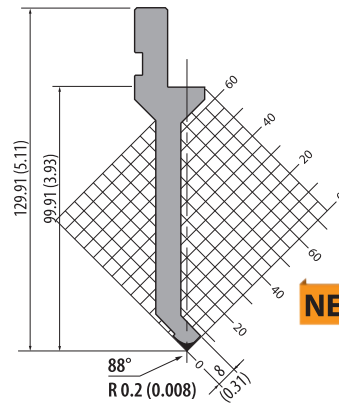
42Cr: 900-1150 N/mm²

HORN 4



20200 / 20300

300 kN/m max.



H=99.91 / A=129.91 (H=3.93 / A=5.11)			
20200 / 88°	835 mm	32.87 in	10.0 kg
	415 mm	16.34 in	5.0 kg
20300 / 90°	795 mm segmented	31.29 in segmented	9.5 kg
	800 mm segmented	31.50 in segmented	9.6 kg

NEW

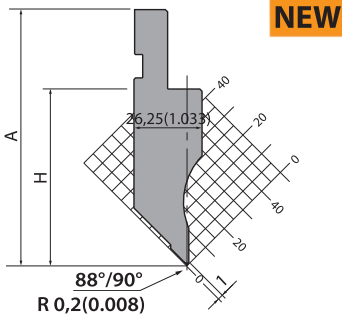
42Cr: 900-1150 N/mm²

HORN 4



00480 / 01680

400 kN/m max.



NEW

H=66.91 / A=96.91 (H=2.63 / A=3.82)			
00480 / 88°	835 mm	32.87 in	10.7 kg
	415 mm	16.34 in	5.3 kg
01680 / 90°	795 mm segmented	31.29 in segmented	10.2 kg
	800 mm segmented	31.50 in segmented	10.3 kg

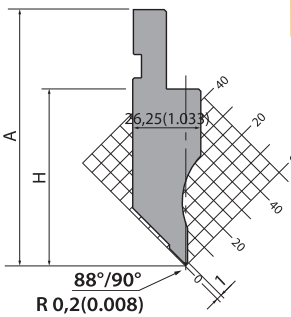
C45: 560-710 N/mm²

HORN 3



00490 / 01690

800 kN/m max.



NEW

H=94.91 / A=124.91 / R=0.2 (H=3.74 / A=4.92 / R=0.008)			
10900	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
10906	795 mm segmented	31.29 in segmented	8.5 kg
	800 mm segmented	31.50 in segmented	8.6 kg

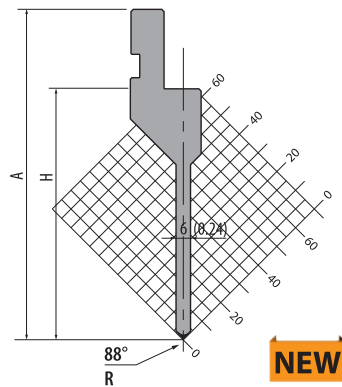
42Cr: 900-1150 N/mm²

HORN 4



10900 / 10906 / 10800

500 kN/m max.



NEW

H=94.91 / A=124.91 / R=0.2 (H=3.74 / A=4.92 / R=0.008)			
10900 / 88°	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
10906 / 88°	795 mm sektioniert	31.29 in segmented	8.5 kg
	800 mm sektioniert	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)			
10800 / 90°	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
10800 / 90°	795 mm sektioniert	31.29 in segmented	8.5 kg
	800 mm sektioniert	31.50 in segmented	8.6 kg

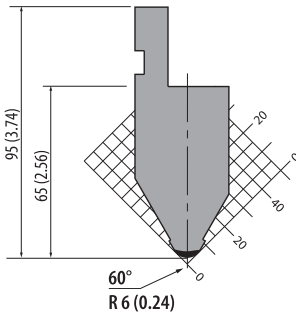
42Cr: 900-1150 N/mm²

HORN 4



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

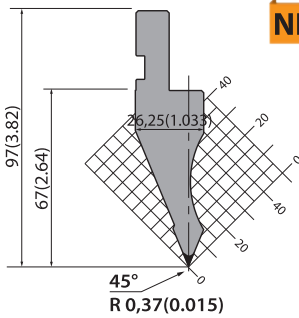
C45: 560-710 N/mm²



45° A-Punches

00800

600 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

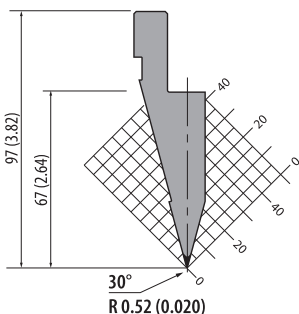
C45: 560-710 N/mm²



30° A-Punches

10300

1000 kN/m max.



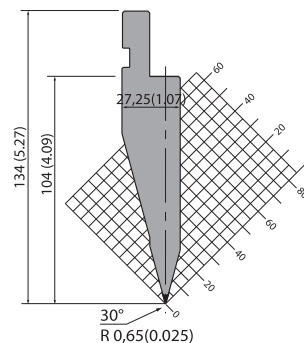
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
800 mm segmented	31.50 in segmented	10.6 kg

42Cr: 900-1150 N/mm²



21000

1000 kN/m max.



835 mm	32.87 in	15.3 kg
415 mm	16.34 in	7.6 kg
795 mm segmented	31.29 in segmented	14.5 kg
800 mm segmented	31.50 in segmented	14.6 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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



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

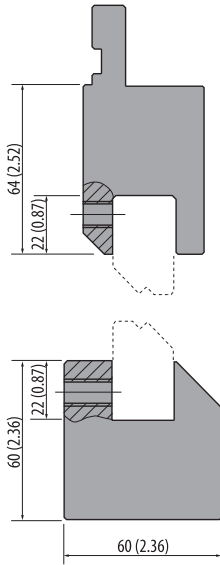
R1

ROLLERI TYPE R1 Joggle Tools

CPZ

1000 kN/m max.

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

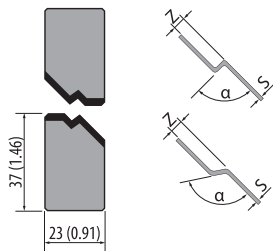


C45: 560-710 N/mm²



Joggle Tool Inserts 160° / 150° / 140° / 90°

1000 kN/m max.



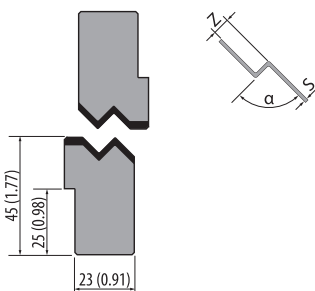
C45: 560-710 N/mm²

Model	Z mm	Z in	α	S* mm	S* inch	Weight	
CEZ 1.0	1.0	0.04	160°	1.2	0.05	835 mm / 32.87 in	415 mm / 16.34 in
CEZ 1.5	1.5	0.06	160°	1.5	0.06		
CEZ 2.0	2.0	0.08	150°	1.4	0.06		
CEZ 2.5	2.5	0.10	140°	1.3	0.05		
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01		
CEZ 1.5/90	1.5	0.06	90°	0.3	0.01		
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02		
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02		
CEZ 3.0	3.0	0.12	90°	1.0	0.04		
CEZ 3.5	3.5	0.14	90°	1.0	0.04		
CEZ 4.0	4.0	0.16	90°	1.2	0.05		
CEZ 4.5	4.5	0.18	90°	1.2	0.05		
CEZ 5.0	5.0	0.20	90°	1.3	0.05		
CEZ 5.5	5.5	0.22	90°	1.4	0.06		
CEZ 6.0	6.0	0.24	90°	1.5	0.06		
CEZ 6.5	6.5	0.26	90°	1.5	0.06		
CEZ 7.0	7.0	0.28	90°	1.5	0.06		
CEZ 7.5	7.5	0.30	90°	1.6	0.06		
CEZ 8.0	8.0	0.31	90°	1.6	0.06		
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						11.0 kg	5.5 kg
						10.3 kg	5.1 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg
						10.0 kg	5.0 kg

* Fe Rmax = 42 Kg/mm²

Joggle Tool Inserts 90°

1000 kN/m max.



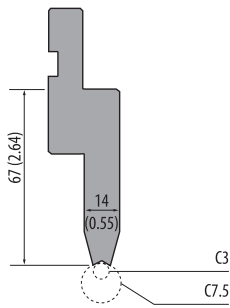
C45: 560-710 N/mm²

Model	Z mm	Z in	α	S* mm	S* inch	Weight			
CEZ 9.0	9	0.35	90°	1.8	0.07	835 mm / 32.87 in	415 mm / 16.34 in		
CEZ 10.0	10	0.39	90°	1.8	0.07				
CEZ 11.0	11	0.43	90°	2	0.08				
CEZ 12.0	12	0.47	90°	2	0.08				
CEZ 13.0	13	0.51	90°	2	0.08				
CEZ 14.0	14	0.55	90°	2	0.08				
CEZ 15.0	15	0.59	90°	2.3	0.09				
								13.5 kg	6.5 kg
								13.5 kg	6.5 kg
								13.5 kg	6.5 kg
								13.5 kg	6.5 kg
								13.5 kg	6.5 kg
								13.5 kg	6.5 kg
								13.5 kg	6.5 kg
								13.5 kg	6.5 kg
						13.5 kg	6.5 kg		

* Fe Rmax = 42 Kg/mm²

PU.67.14-S

400 kN/m max.



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

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

C45: 560-710 N/mm²



Mark-free bending
with polyurethane
inserts
See pages 240-241

C3 - C7.5

400 kN/m max.



C45: 560-710 N/mm²

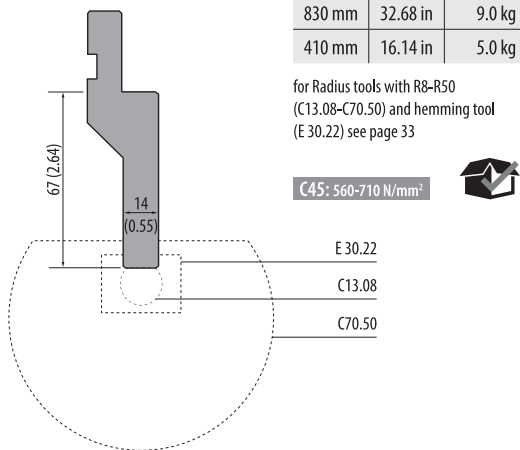


Model	R mm	R in	Weight	
C3	3.0	0.12	0.20 kg	0.10 kg
C3.5	3.5	0.14	0.20 kg	0.10 kg
C4	4.0	0.16	0.35 kg	0.17 kg
C4.5	4.5	0.18	0.50 kg	0.25 kg
C5	5.0	0.20	0.60 kg	0.30 kg
C5.5	5.5	0.22	0.70 kg	0.35 kg
C6	6.0	0.24	0.80 kg	0.40 kg
C6.5	6.5	0.26	1.00 kg	0.50 kg
C7	7.0	0.28	0.80 kg	0.40 kg
C7.5	7.5	0.30	1.00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

835 mm / 32.87 in
415 mm / 16.34 in

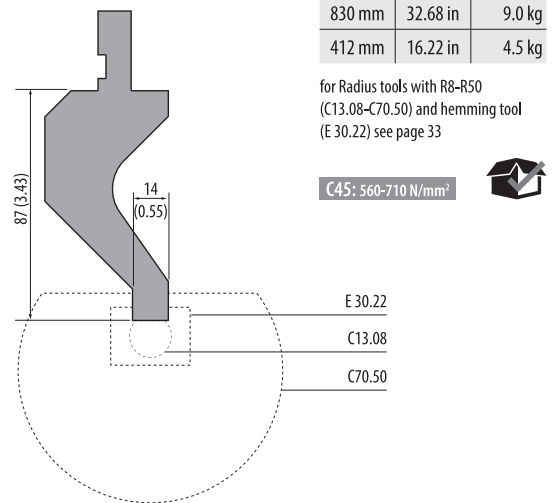
PU.67.14

800 kN/m max.



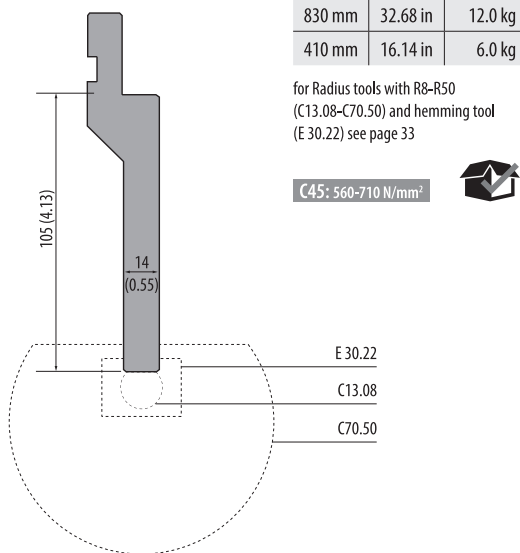
PU.87.14

500 kN/m max.



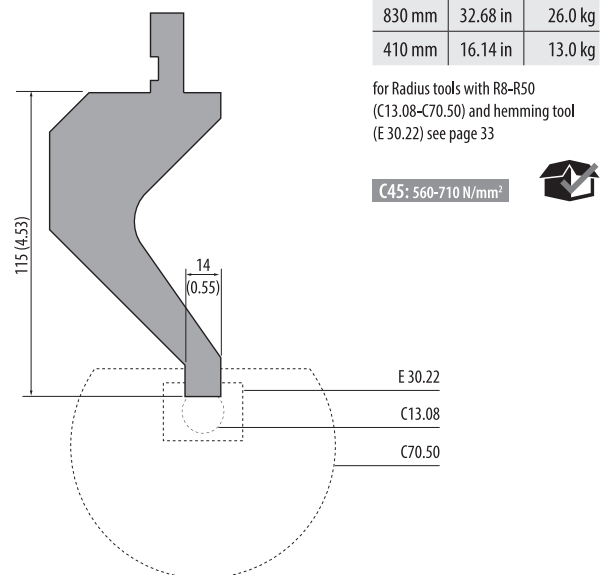
PU.105.14

800 kN/m max.



PU.115.14

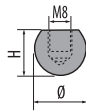
500 kN/m max.



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

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

800 kN/m max.

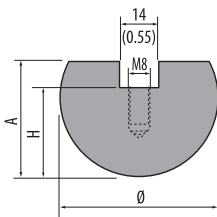


C45: 560-710 N/mm²

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

Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.



NEW



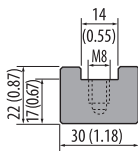
C45: 560-710 N/mm²

Model	Ø (mm)	H (mm)	A (mm)	835 mm	Weight	415 mm	Weight
C17.12	25	17	22	835 mm	2.5 kg	415 mm	1.2 kg
C20.15	30	20	27		3.7 kg		1.8 kg
C22.17	35	22	32		5.0 kg		2.4 kg
C24.20	40	24	34		7.0 kg		3.5 kg
C25.22	45	25	35		7.5 kg		3.8 kg
C29.25	50	29	39		10.0 kg		4.7 kg
C34.27	55	34	44		12.4 kg		6.2 kg
C34.30	60	34	44		13.5 kg		6.7 kg
C37.32	65	37	47		15.9 kg		7.9 kg
C45.35	70	45	55		20.3 kg		10.0 kg
C42.37	75	42	52		20.5 kg		10.3 kg
C45.40	80	45	55		23.0 kg		11.5 kg
C60.45	90	60	70		34.0 kg		17.0 kg
C70.50	100	70	80		43.5 kg		21.7 kg

Hemming Tool

E30.22

800 kN/m max.



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

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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



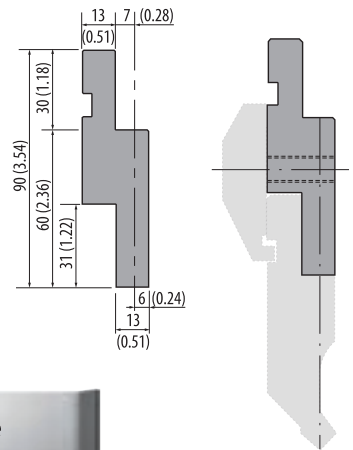
Articles on stock – Please note that delivery time depends on your location.

Our Advantages – Your Convenience

- Wedge crowning prevents deflection
- high boxes can be bent
- To bend **big boxes** see SPE-P4 in the area of special tools on page 251

AD4

1000 kN/m max.



per piece 1.8 kg

L=150 mm (5.91 in)

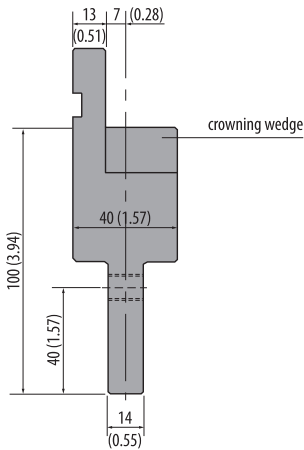
Punch extension without wedge crowning

C45: 560-710 N/mm²



INT100

1000 kN/m max.



per piece 3.5 kg

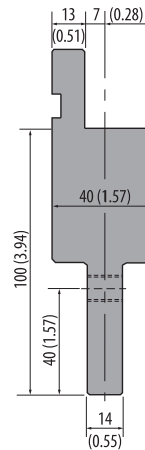
L=150 mm (5.91 in)

C45: 560-710 N/mm²



INT100 FISSO

1000 kN/m max.



per piece 4.0 kg

L=150 mm (5.91 in)

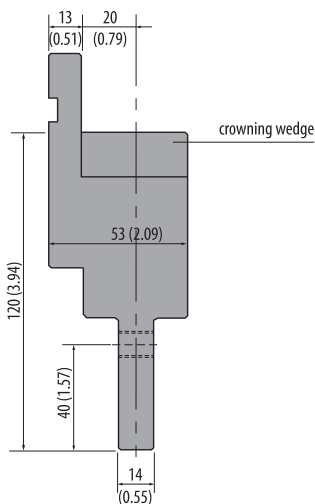
Punch extension without wedge crowning

C45: 560-710 N/mm²



INT120-40

1000 kN/m max.



per piece 5.2 kg

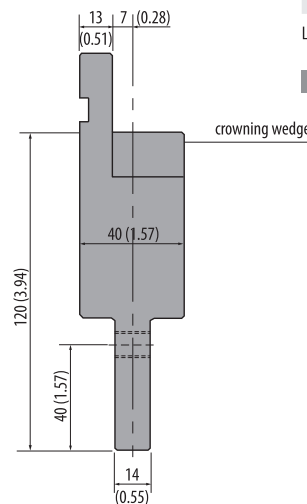
L=150 mm (5.91 in)

C45: 560-710 N/mm²



INT120

1000 kN/m max.



per piece 4.5 kg

L=150 mm (5.91 in)

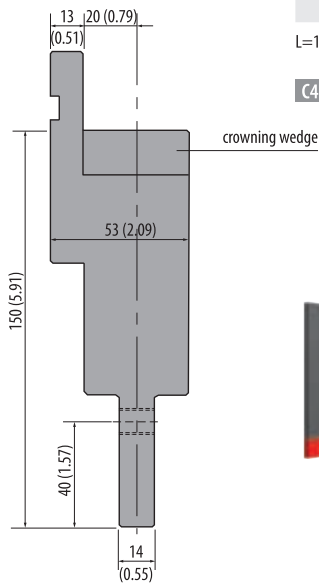
C45: 560-710 N/mm²



Intermediates also available in L=70 mm upon request.

INT150-40

1000 kN/m max.

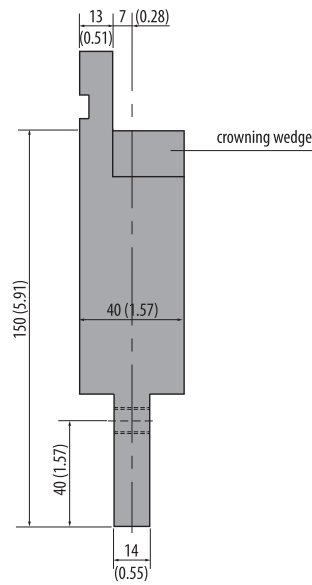


per piece 8.0 kg
L=150 mm (5.91 in)
C45: 560-710 N/mm²

**Rolleri Clamping
Systems**
See pages 210-218

INT150

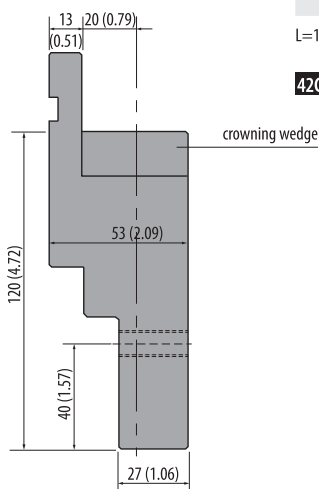
1000 kN/m max.



per piece 5.9 kg
L=150 mm (5.91 in)
C45: 560-710 N/mm²

INT120-40-HD (Heavy Duty)

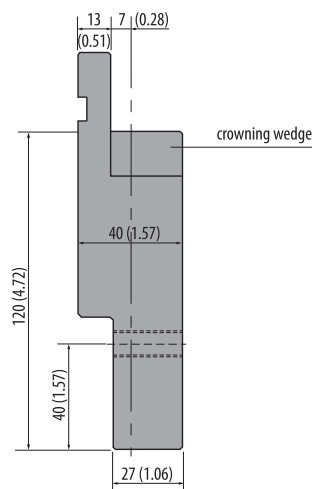
1600 kN/m max.



per piece 5.2 kg
L=150 mm (5.91 in)
42Cr: 900-1150 N/mm²

INT120-HD (Heavy Duty)

1600 kN/m max.

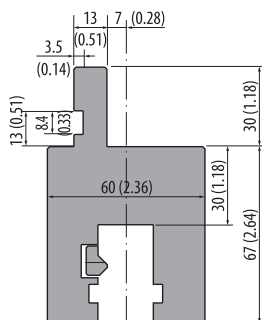


per piece 4.5 kg
L=150 mm (5.91 in)
42Cr: 900-1150 N/mm²

Punch Adapters

AD20

1000 kN/m max.

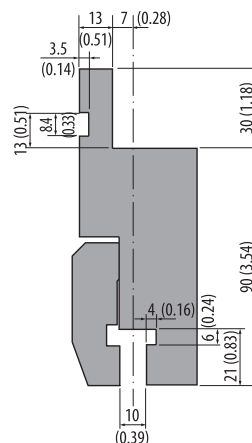


per piece 4.0 kg
L=150 mm (5.91 in)
head-bearing
Rolleri Type R1
→ Rolleri Type R2
C45: 560-710 N/mm²

**Punches
Rolleri Type R2
see pages 89-94**

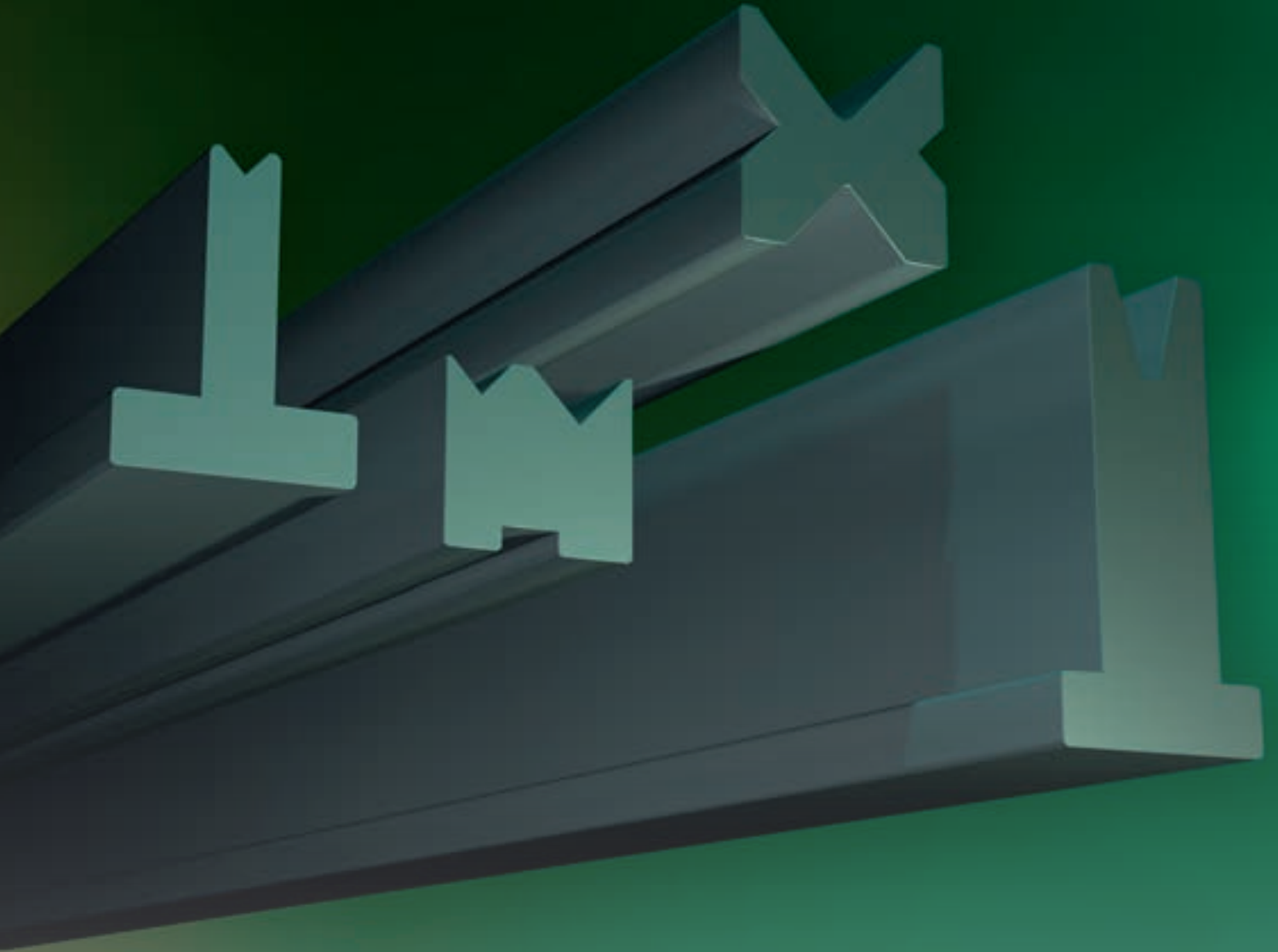
AD19-A

1000 kN/m max.



per piece 6.0 kg
L=150 mm (5.91 in)
Rolleri Type R1
→ Rolleri Type RX LVD
C45: 560-710 N/mm²

**Punches
Rolleri Type RX LVD
see page 158-159**



R1

Compatibility

Dies Rolleri Type R1 are compatible with press brakes:

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

With the use of adapters Rolleri R1 type dies can be mounted in other press brake models.

DIES ROLLER TYPE R1

Content Explanation	38 - 39	85° 1-V dies	64
90° 2-V dies	40	80° 1-V dies	65
88° 2-V dies	40	70° 1-V dies	66
60° 2-V dies	41	60° 1-V dies	67
35° 2-V dies	41	45° 1-V dies	67
Die Holders for 2-V dies	42	Multi-V dies	68 - 69
90° self-centering 2-V dies	43	90° 2-V A-dies	71
88° self-centering 2-V dies	43 - 44	88° 2-V A-dies	71
85° self-centering 2-V dies	44	90° self-centering 2-V A-dies	72
30° self-centering 2-V dies	44	88° self-centering 2-V A-dies	72 - 73
Die Holder for self-centering 2-V dies	45	30° 2-V A-dies	74
Clamping Piece for self-centering 2-V dies	45	90° self-centering 1-V A-dies	74
88° self-centering 1-V dies	46	88° self-centering 1-V A-dies	75
85° self-centering 1-V dies	47	85° / 45° / 30° 1-V A-dies	76
30° self-centering 1-V dies	48	A-Die Holder	77
Die Holder for self-centering 1-V dies	49	Synthetic dies	78
90° T-dies, H=80 mm (3.15), H=120 mm (4.72)	50	Hemming dies	79
88° T-dies, H=80 mm (3.15)	51	Spring-Loaded Hemming dies	80
88° T-dies, H=120 mm (4.72)	52	Pneumatic Hemming dies	81
85° T-dies, H=80 mm (3.15)	53	Die Holders	82
85° T-dies, H=120 mm (4.72)	54	Die Adapters	83
80° T-dies, H=80 mm (3.15)	55	Die Extensions	83
80° T-dies, H=120 mm (4.72)	56		
60° T-dies, H=80 mm (3.15)	57		
60° T-dies, H=120 mm (4.72)	58		
45° T-dies, H=80 mm (3.15) / H=120 mm (4.72)	59		
35° T-dies, H=80 mm (3.15) / H=120 mm (4.72)	60		
30° T-dies, H=80 mm (3.15)	61		
30° T-dies, H=120 mm (4.72)	62		
26° T-dies, H=80 mm (3.15)	63		
26° T-dies, H=120 mm (4.72)	63		

Compatibility

Dies Roller Type R1 are:

- **compatible** with press brakes (60 mm clamping-width) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, JMT, LFK, Metfab, MVD, Newton, Oriance, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- also applicable on all other press brakes **with adapters and die holders** (see pages 232-235)

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 266-269)
- very large stock availability

Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

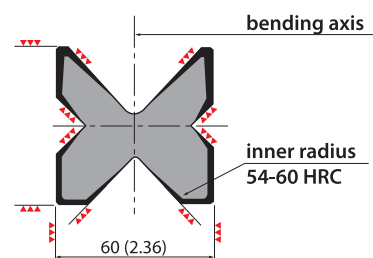
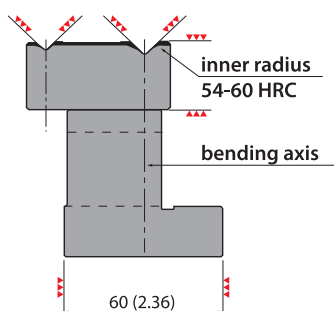
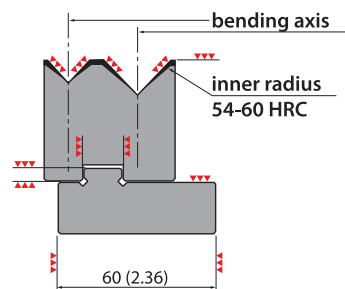
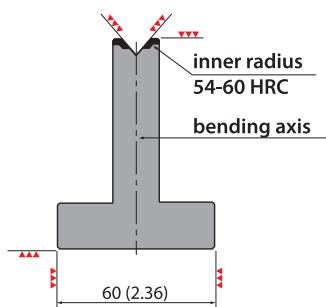
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

All dies Roller Type R1 have base 60 mm, 90 mm or 120 mm (look at each tool for more precise information)

Indications of precision ground surfaces:

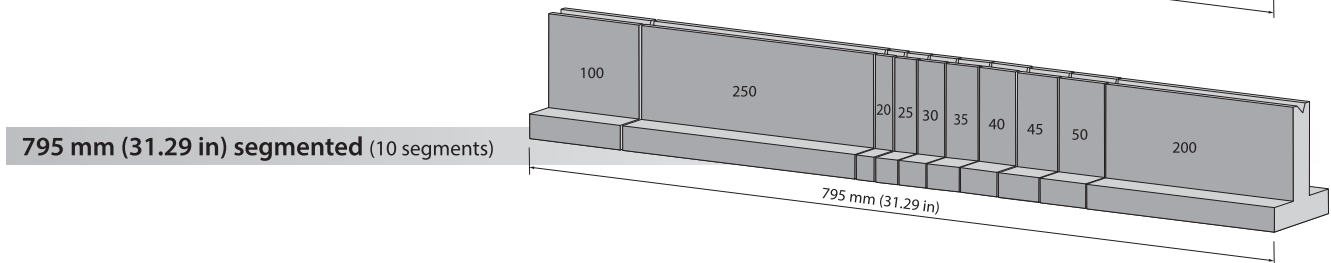
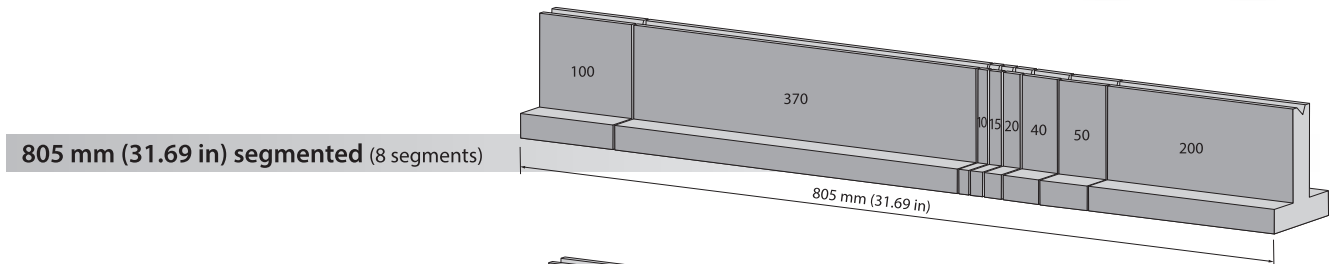


Tool lengths and sectioning

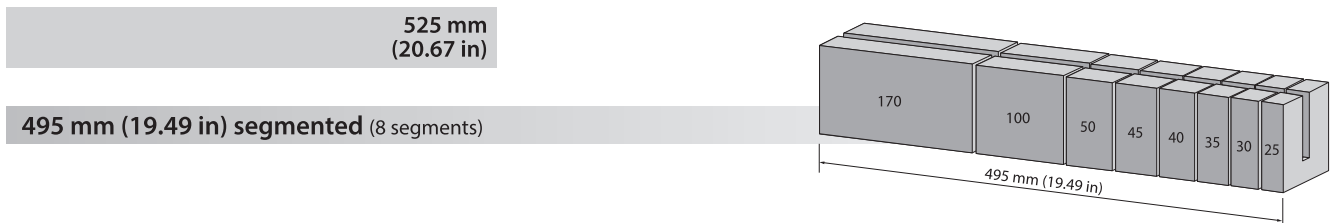
Standard



Segmented tools are delivered in complete sets. More lengths and sectionings are possible upon request.



Rolleri TOP-System

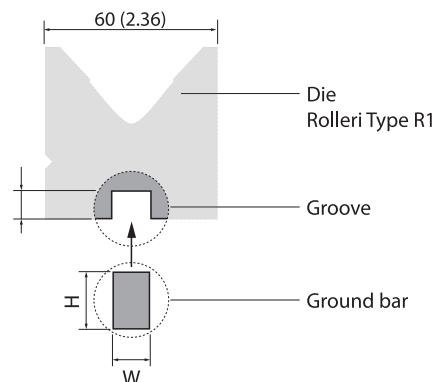


Modification: Wedge Bar / Tail

To use Rolleri Type R1 dies in other press brakes, a 10 mm (0.39 in) groove is milled where a ground bar is mounted

Mounting example

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 prices are found in the Rolleri Modifications Chapter (see page 268)

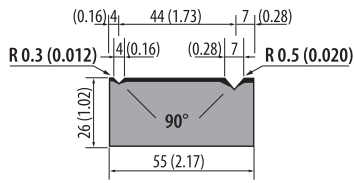
R1

ROLLERI TYPE R1

90° 2-V dies

M26.90.03

1000 kN/m max.



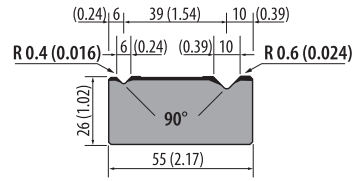
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.90.01

1000 kN/m max.



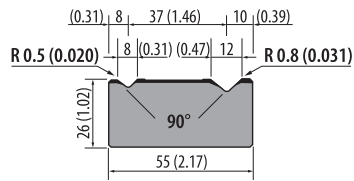
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
900 mm	35.43 in	10.0 kg

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

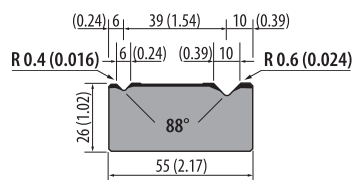
C45: 560-710 N/mm²



88° 2-V dies

M26.88.01

1000 kN/m max.



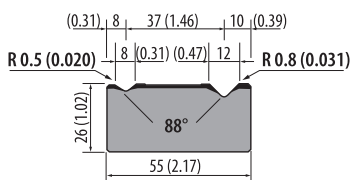
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.88.02

1000 kN/m max.



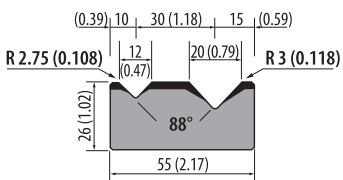
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.88.03

1000 kN/m max.



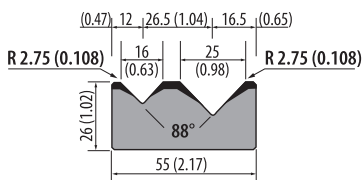
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.88.04

1000 kN/m max.



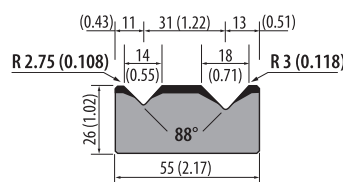
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg

C45: 560-710 N/mm²



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



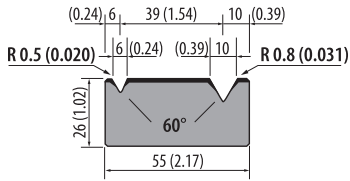
R1

ROLLERI TYPE R1 60° 2-V dies



M26.60.01

600 kN/m max.



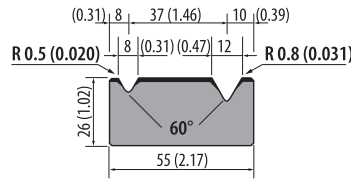
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
900 mm	35.43 in	10.0 kg

C45: 560-710 N/mm²



M26.60.02

800 kN/m max.



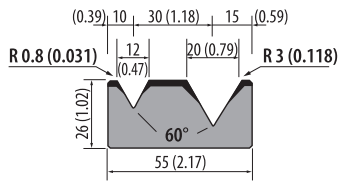
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²



M26.60.03

800 kN/m max.



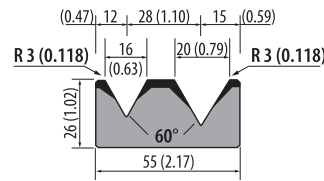
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg

C45: 560-710 N/mm²



M26.60.05

800 kN/m max.



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

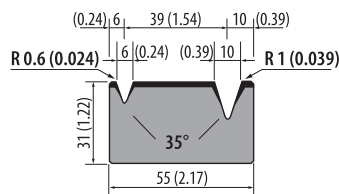
C45: 560-710 N/mm²



35° 2-V dies

M31.35.01

300 kN/m max.



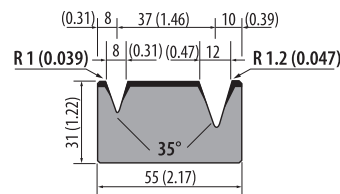
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg

C45: 560-710 N/mm²



M31.35.02

300 kN/m max.



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

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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

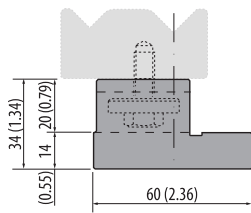


Articles on stock – Please note that delivery time depends on your location.

R1

ROLLERI TYPE R1 Die Holders for 2-V dies

SU034



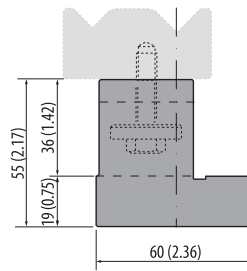
830 mm	32.68 in	9.0 kg
410 mm	16.14 in	4.5 kg

for all 2-V Dies
pages 40-41

C45: 560-710 N/mm²



SU055



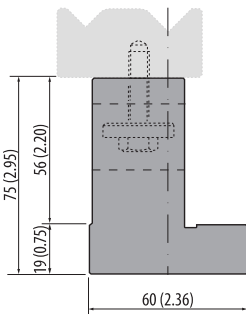
830 mm	32.68 in	14.5 kg
410 mm	16.14 in	7.2 kg

for all 2-V Dies
pages 40-41

C45: 560-710 N/mm²



SU075



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

for all 2-V Dies
pages 40-41

C45: 560-710 N/mm²

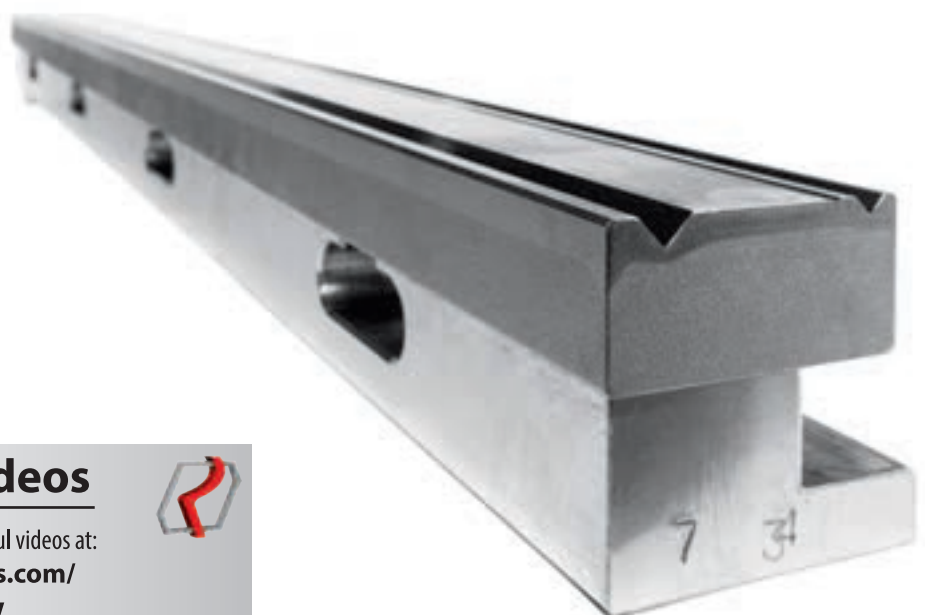


Articles on stock – Please note that delivery time varies according to your location.



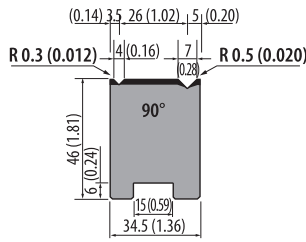
Rolleri Videos

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



46-10

800 kN/m max.



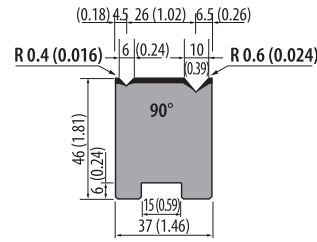
835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
795 mm segmented	31.29 in segmented	9.2 kg
805 mm segmented	31.69 in segmented	9.4 kg

C45: 800-850 N/mm²



46-11

800 kN/m max.



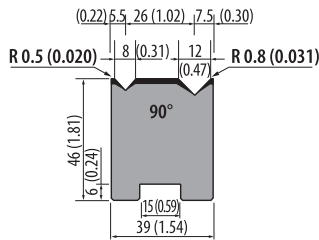
835 mm	32.87 in	10.3 kg
415 mm	16.34 in	5.1 kg
795 mm segmented	31.29 in segmented	9.8 kg
805 mm segmented	31.69 in segmented	9.9 kg

C45: 800-850 N/mm²



46-12

800 kN/m max.



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

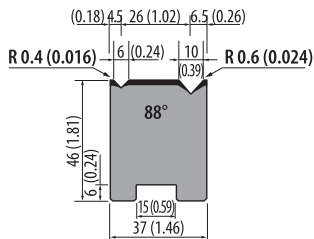
C45: 800-850 N/mm²



88° self-centering 2-V dies

46.11.88

800 kN/m max.



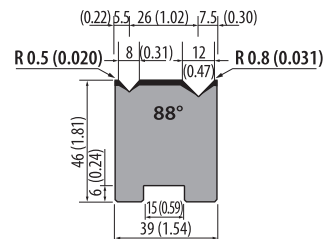
835 mm	32.87 in	10.3 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	9.8 kg
805 mm segmented	31.69 in segmented	9.9 kg

C45: 800-850 N/mm²



46.13

800 kN/m max.



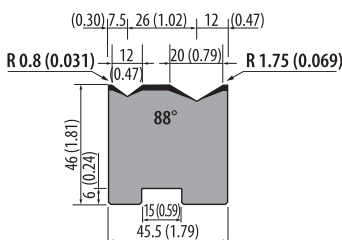
835 mm	32.87 in	10.9 kg
415 mm	16.34 in	5.4 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.5 kg

C45: 800-850 N/mm²



46.14

800 kN/m max.



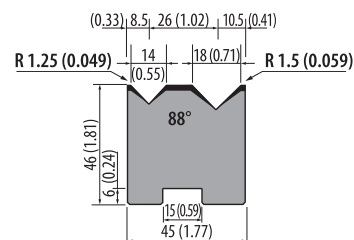
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.4 kg
805 mm segmented	31.69 in segmented	11.6 kg

C45: 800-850 N/mm²



46.15

800 kN/m max.



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

C45: 800-850 N/mm²



Article on stock



Please ask for delivery time!

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



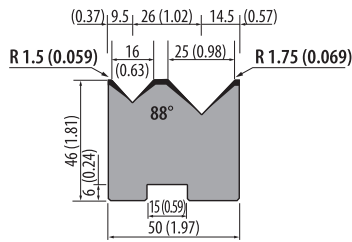
Articles on stock – Please note that delivery time depends on your location.

R1

ROLLERI TYPE R1 88° self-centering 2-V dies

46.16

800 kN/m max.



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

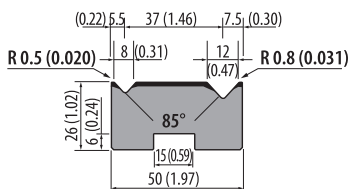
C45: 800-850 N/mm²



85° self-centering 2-V dies

M26.85.02

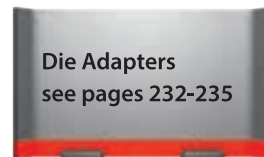
1000 kN/m max.



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

PM50 + Support is needed

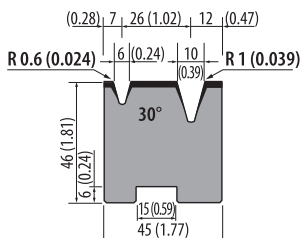
42Cr: 900-1150 N/mm²



30° self-centering 2-V dies

46.17

400 kN/m max.



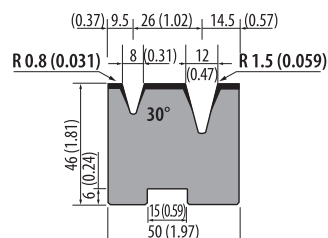
835 mm	32.87 in	12.2 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.6 kg
805 mm segmented	31.69 in segmented	11.8 kg

C45: 800-850 N/mm²



46.18

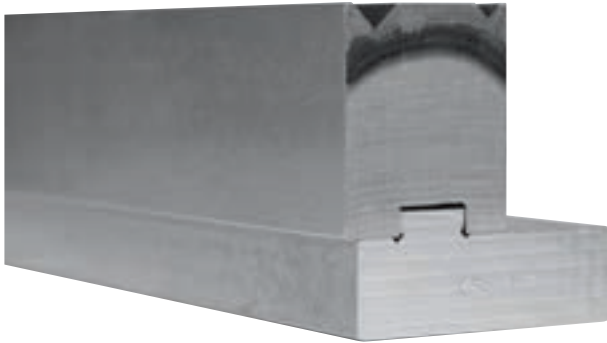
400 kN/m max.



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

C45: 800-850 N/mm²





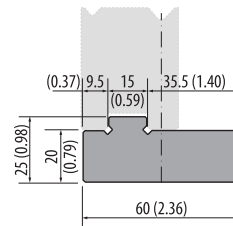
PM60

1000 kN/m max.

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

for self centering 2-V dies
pages 43-44

C45: 560-710 N/mm²



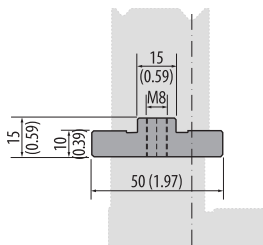
PM50

1000 kN/m max.

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

for all self centering 2-V dies
pages 43-44

C45: 560-710 N/mm²



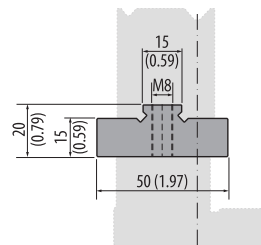
PM50.20

1000 kN/m max.

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

for all self centering 2-V dies
pages 43-44

C45: 800-850 N/mm²

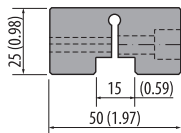


Mechanical retainer for self-centering 2-V dies

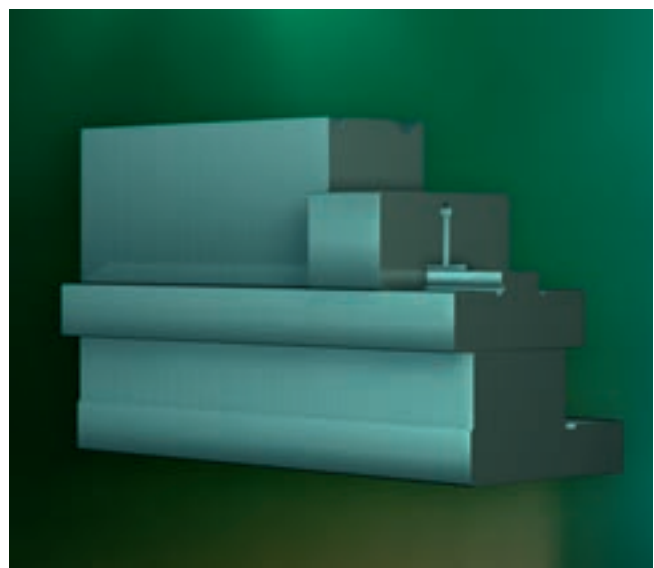
PB60

pair 0.2 kg

Fe37



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

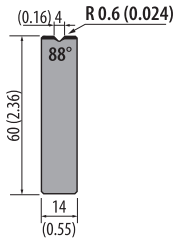


R1

ROLLERI TYPE R1 88° self-centering 1-V dies

AMR60.04.88

1000 kN/m max.



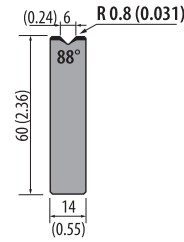
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.06.88

1000 kN/m max.



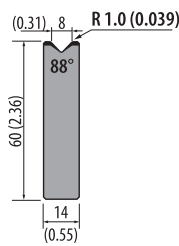
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.08.88

1000 kN/m max.



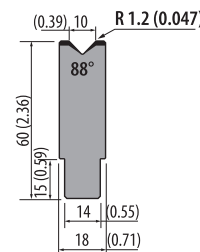
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.10.88

1000 kN/m max.



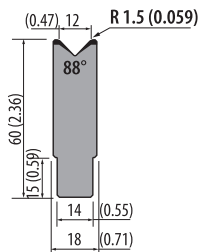
835 mm	32.87 in	5.6 kg
415 mm	16.34 in	2.8 kg
795 mm segmented	31.29 in segmented	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

C45: 560-710 N/mm²



AMR60.12.88

1000 kN/m max.



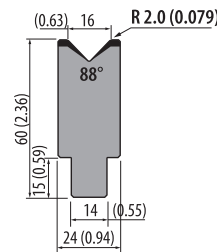
835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

C45: 560-710 N/mm²



AMR60.16.88

1000 kN/m max.



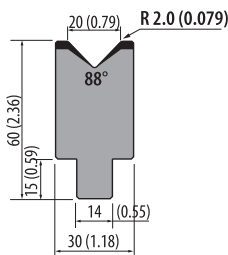
835 mm	32.87 in	7.1 kg
415 mm	16.34 in	3.5 kg
795 mm segmented	31.29 in segmented	6.8 kg
805 mm segmented	31.69 in segmented	6.9 kg

C45: 560-710 N/mm²



AMR60.20.88

1000 kN/m max.



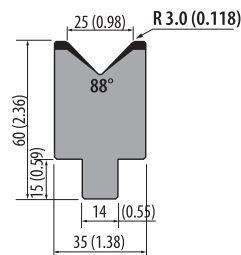
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
795 mm segmented	31.29 in segmented	7.6 kg
805 mm segmented	31.69 in segmented	7.7 kg

C45: 560-710 N/mm²



AMR60.25.88

1000 kN/m max.



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

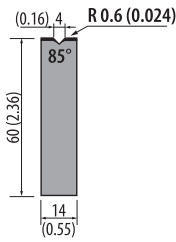
C45: 560-710 N/mm²



Compatible Die Holders
for bolted 1-V Dies
see page 49,
Article No. SU61F

AMR60.04.85

1000 kN/m max.



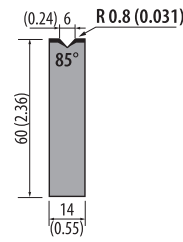
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.06.85

1000 kN/m max.



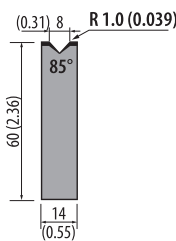
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.08.85

1000 kN/m max.



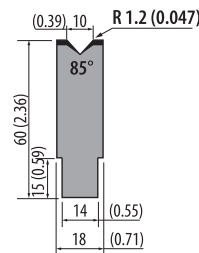
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²



AMR60.10.85

1000 kN/m max.



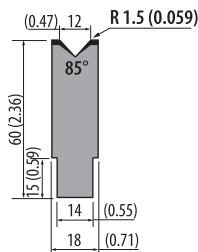
835 mm	32.87 in	5.6 kg
415 mm	16.34 in	2.8 kg
795 mm segmented	31.29 in segmented	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

C45: 560-710 N/mm²



AMR60.12.85

1000 kN/m max.



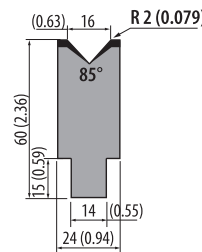
835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

C45: 560-710 N/mm²



AMR60.16.85

1000 kN/m max.



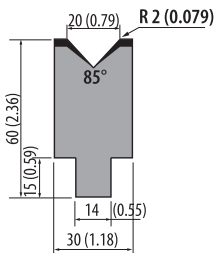
835 mm	32.87 in	7.1 kg
415 mm	16.34 in	3.5 kg
795 mm segmented	31.29 in segmented	6.8 kg
805 mm segmented	31.69 in segmented	6.9 kg

C45: 560-710 N/mm²



AMR60.20.85

1000 kN/m max.



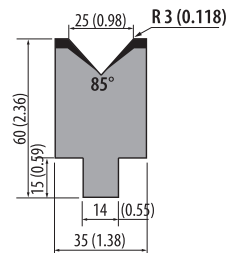
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
795 mm segmented	31.29 in segmented	7.6 kg
805 mm segmented	31.69 in segmented	7.7 kg

C45: 560-710 N/mm²



AMR60.25.85

1000 kN/m max.



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

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

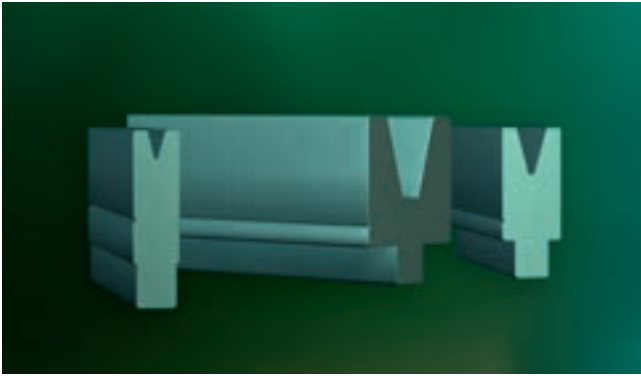
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

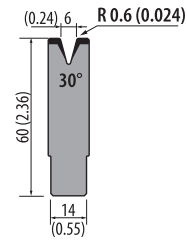
R1

ROLLERS TYPE R1 30° self-centering 1-V dies



AMR60.06.30

350 kN/m max.



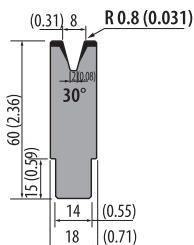
835 mm	32.87 in	5.9 kg
415 mm	16.34 in	2.9 kg
795 mm segmented	31.29 in segmented	5.6 kg
805 mm segmented	31.69 in segmented	5.7 kg

C45: 560-710 N/mm²



AMR60.08.30

350 kN/m max.



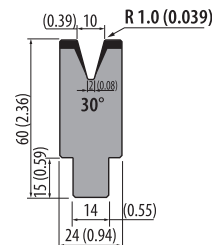
835 mm	32.87 in	6.6 kg
415 mm	16.34 in	3.3 kg
795 mm segmented	31.29 in segmented	6.3 kg
805 mm segmented	31.69 in segmented	6.4 kg

C45: 560-710 N/mm²



AMR60.10.30

500 kN/m max.



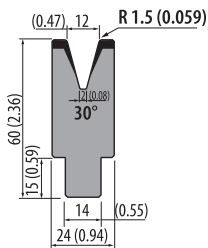
835 mm	32.87 in	7.8 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.4 kg
805 mm segmented	31.69 in segmented	7.5 kg

C45: 560-710 N/mm²



AMR60.12.30

400 kN/m max.



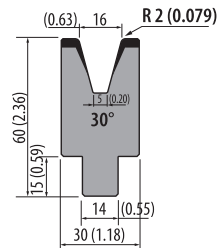
835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
805 mm segmented	31.69 in segmented	7.6 kg

C45: 560-710 N/mm²



AMR60.16.30

450 kN/m max.



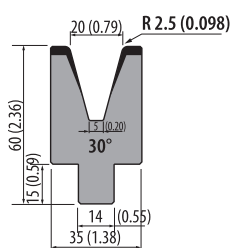
835 mm	32.87 in	8.8 kg
415 mm	16.34 in	4.7 kg
795 mm segmented	31.29 in segmented	8.4 kg
805 mm segmented	31.69 in segmented	8.5 kg

C45: 560-710 N/mm²



AMR60.20.30

500 kN/m max.



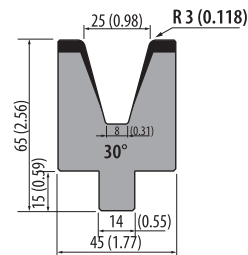
835 mm	32.87 in	15.9 kg
415 mm	16.34 in	7.9 kg
795 mm segmented	31.29 in segmented	15.1 kg
805 mm segmented	31.69 in segmented	15.3 kg

C45: 560-710 N/mm²



AMR65.25.30

500 kN/m max.



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

C45: 560-710 N/mm²



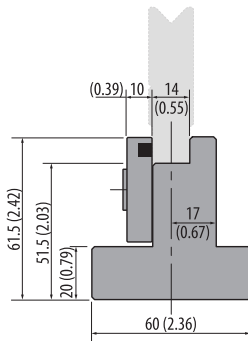
SU61F

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 46-48

C45: 560-710 N/mm²



Prevention of Bending Marks

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

- Protective Sheets
- Polyurethane Inserts
- Synthetic Dies
- Rolla-V

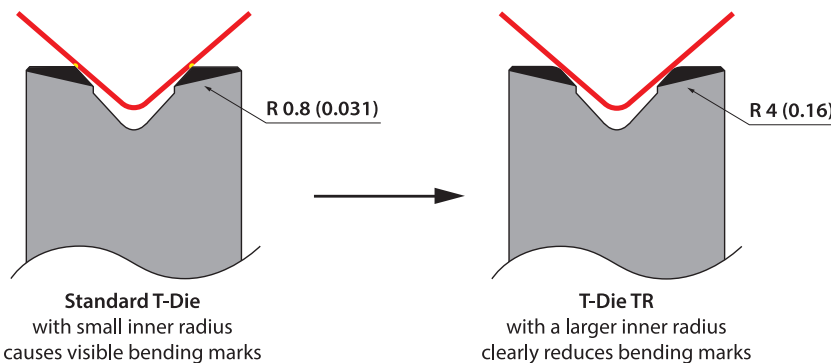
An alternative to these options mentioned above is a modification of the dies:

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

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

Our Advantages – Your Convenience

- Prevention of scratches and markings on the bent sheet metals
- No post processing necessary with subsequent time and cost efficiency
- No material residues
- increases product quality
- easy handling



Article on stock



Please ask for delivery time!

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



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

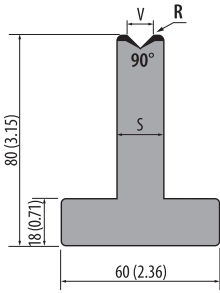
R1

ROLLERI TYPE R1

90° T-dies, H=80 (3.15), H=120 (4.72)

90° T-dies, H=80 mm (3.15 in)

1000 kN/m max.



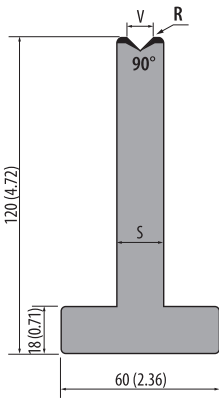
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	795 mm / 31.30 in segmented	Weight	805 mm / 31.69 in segmented	Weight	900 mm / 35.43 in	Weight
T80.06.90	6	0.24	0.4	0.02	14	0.55		13.0 kg		6.5 kg		12.4 kg		12.5 kg		14.0 kg
T80.08.90	8	0.31	0.5	0.02	14	0.55		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/mm²



90° T-dies, H=120 mm (4.72 in)

1000 kN/m max.

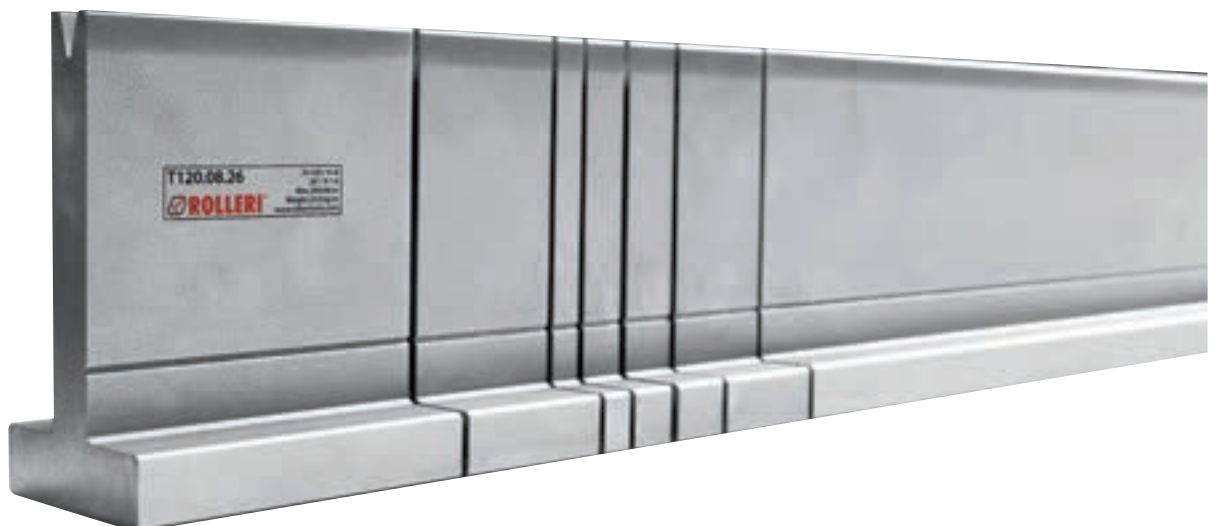


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight	795 mm / 31.30 in segmented	Weight	805 mm / 31.69 in segmented	Weight
T120.06.90	6	0.24	0.4	0.02	14	0.55		16.0 kg		8.0 kg		15.2 kg		15.4 kg
T120.08.90	8	0.31	0.5	0.02	14	0.55		16.0 kg		8.0 kg		15.2 kg		15.4 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/mm²

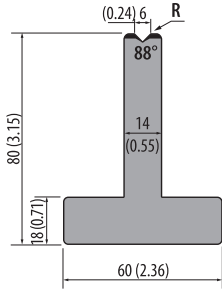


Articles on stock - Please note that delivery time varies according to your location. 



T80.06.88 / TR80.06.88

1000 kN/m max.



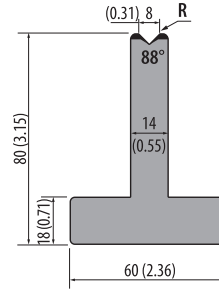
R=0.4 (0.016)			
T80.06.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=2.75 (0.108)			
TR80.06.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²



T80.08.88 / TR80.08.88

1000 kN/m max.



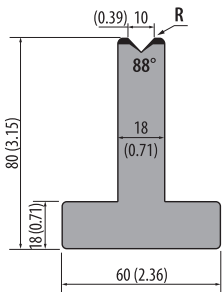
R=0.5 (0.020)			
T80.08.88	835 mm	32.87 in	12.6 kg
	415 mm	16.34 in	6.3 kg
	795 mm segmented	31.29 in segmented	12.0 kg
	805 mm segmented	31.69 in segmented	12.1 kg
R=2.75 (0.108)			
TR80.08.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²



T80.10.88 / TR80.10.88

1000 kN/m max.



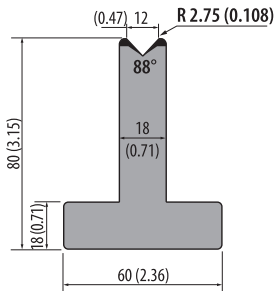
R=0.8 (0.031)			
T80.10.88	835 mm	32.87 in	14.2 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.5 kg
	805 mm segmented	31.69 in segmented	13.7 kg
R=2.75 (0.108)			
TR80.10.88	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented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

C45: 560-710 N/mm²



T80.12.88

1000 kN/m max.



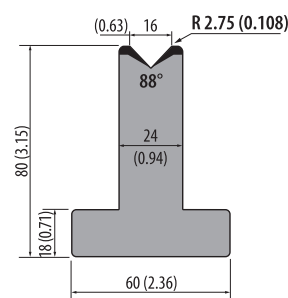
	835 mm	32.87 in	14.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.3 kg
	805 mm segmented	31.69 in segmented	13.5 kg

C45: 560-710 N/mm²



T80.16.88

1000 kN/m max.



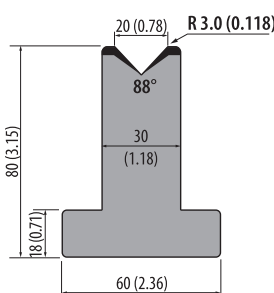
	835 mm	32.87 in	16.6 kg
	415 mm	16.34 in	8.3 kg
	795 mm segmented	31.29 in segmented	15.8 kg
	805 mm segmented	31.69 in segmented	16.0 kg

C45: 560-710 N/mm²



T80.20.88

1000 kN/m max.



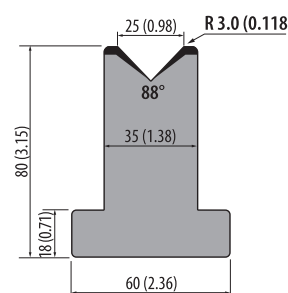
	835 mm	32.87 in	18.5 kg
	415 mm	16.34 in	9.2 kg
	795 mm segmented	31.29 in segmented	17.6 kg
	805 mm segmented	31.69 in segmented	17.8 kg

C45: 560-710 N/mm²



T80.25.88

1000 kN/m max.



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

C45: 560-710 N/mm²

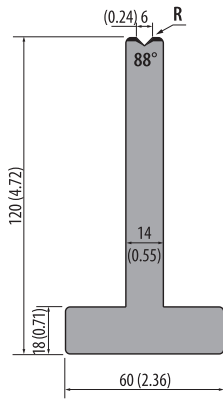


R1

ROLLERI TYPE R1 88° T-dies, H=120 (4.72)

T120.06.88 / TR120.06.88

1000 kN/m max.



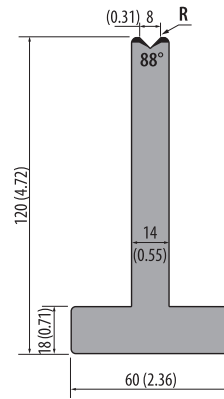
R=0.4 (0.016)			
T120.06.88	835 mm	32.87 in	16.5 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.7 kg
	805 mm segmented	31.69 in segmented	16.0 kg
R=2.75 (0.108)			
TR120.06.88	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²



T120.08.88 / TR120.08.88

1000 kN/m max.



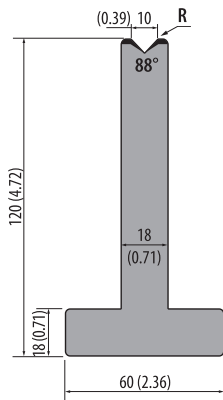
R=0.5 (0.020)			
T120.08.88	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
R=2.75 (0.108)			
TR120.08.88	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²



T120.10.88 / TR120.10.88

1000 kN/m max.



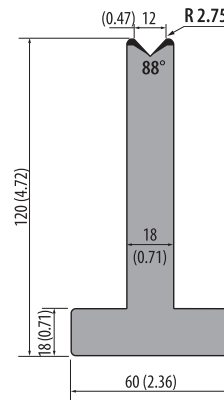
R=0.8 (0.031)			
T120.10.88	835 mm	32.87 in	19.0 kg
	415 mm	16.34 in	9.5 kg
	795 mm segmented	31.29 in segmented	18.0 kg
	805 mm segmented	31.69 in segmented	18.3 kg
R=2.75 (0.108)			
TR120.10.88	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented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

C45: 560-710 N/mm²



T120.12.88

1000 kN/m max.



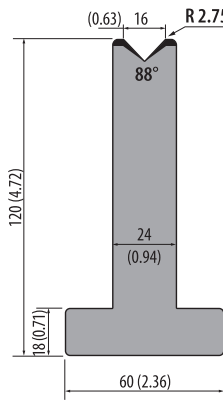
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	18.0 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.16.88

1000 kN/m max.



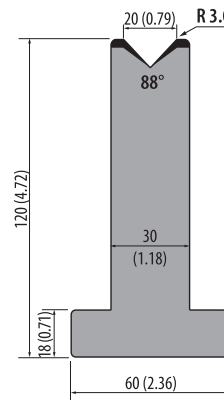
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



T120.20.88

1000 kN/m max.



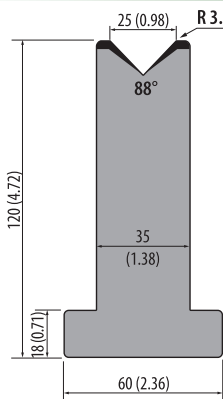
835 mm	32.87 in	27.0 kg
415 mm	16.34 in	13.5 kg
795 mm segmented	31.29 in segmented	25.7 kg
805 mm segmented	31.69 in segmented	26.0 kg

C45: 560-710 N/mm²



T120.25.88

1000 kN/m max.



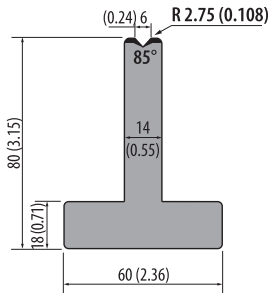
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

C45: 560-710 N/mm²



T80.06.85

1000 kN/m max.



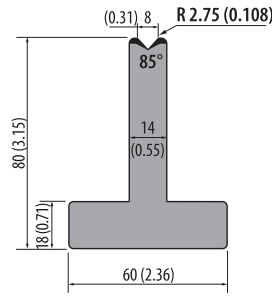
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.08.85

1000 kN/m max.



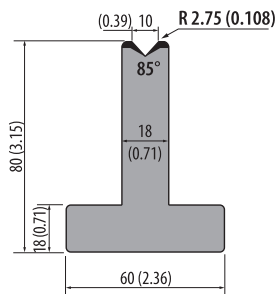
835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.2 kg
795 mm segmented	31.29 in segmented	12.0 kg
805 mm segmented	31.69 in segmented	12.1 kg

C45: 560-710 N/mm²



T80.10.85

1000 kN/m max.



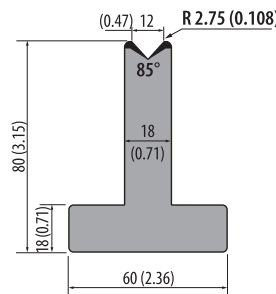
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

C45: 560-710 N/mm²



T80.12.85

1000 kN/m max.



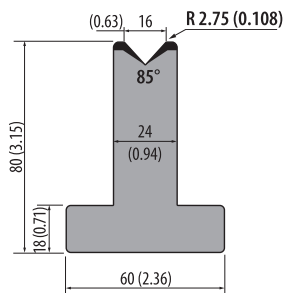
835 mm	32.87 in	14.1 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.4 kg
805 mm segmented	31.69 in segmented	13.6 kg

C45: 560-710 N/mm²



T80.16.85

1000 kN/m max.



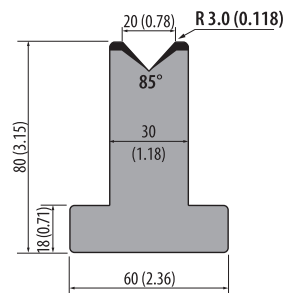
835 mm	32.87 in	16.4 kg
415 mm	16.34 in	8.2 kg
795 mm segmented	31.29 in segmented	15.6 kg
805 mm segmented	31.69 in segmented	15.8 kg

C45: 560-710 N/mm²



T80.20.85

1000 kN/m max.



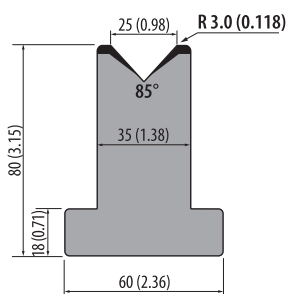
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T80.25.85

1000 kN/m max.



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

C45: 560-710 N/mm²

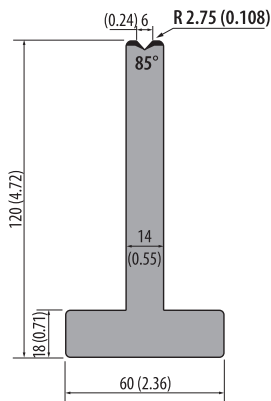


R1

ROLLERI TYPE R1 85° T-dies, H=120 (4.72)

T120.06.85

1000 kN/m max.



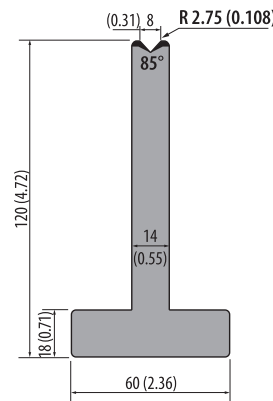
835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

C45: 560-710 N/mm²



T120.08.85

1000 kN/m max.



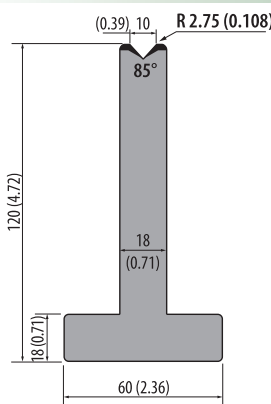
835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

C45: 560-710 N/mm²



T120.10.85

1000 kN/m max.



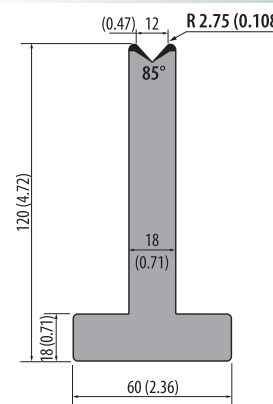
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.12.85

1000 kN/m max.



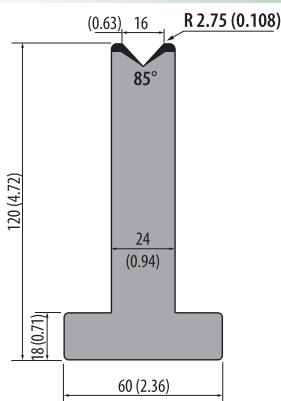
835 mm	32.87 in	18.9 kg
415 mm	16.34 in	9.4 kg
795 mm segmented	31.29 in segmented	18.0 kg
805 mm segmented	31.69 in segmented	18.2 kg

C45: 560-710 N/mm²



T120.16.85

1000 kN/m max.



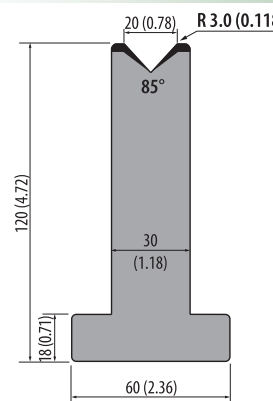
835 mm	32.87 in	22.7 kg
415 mm	16.34 in	11.3 kg
795 mm segmented	31.29 in segmented	21.7 kg
805 mm segmented	31.69 in segmented	21.9 kg

C45: 560-710 N/mm²



T120.20.85

1000 kN/m max.



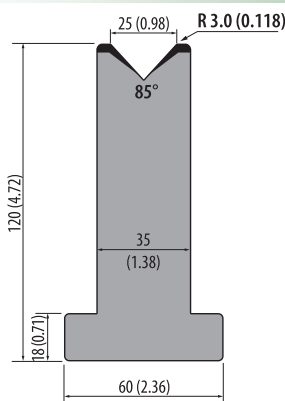
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

C45: 560-710 N/mm²



T120.25.85

1000 kN/m max.



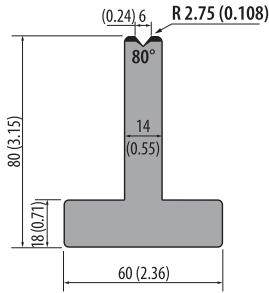
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

C45: 560-710 N/mm²



T80.06.80

950 kN/m max.



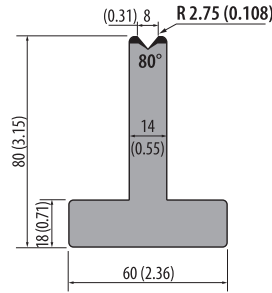
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.08.80

950 kN/m max.



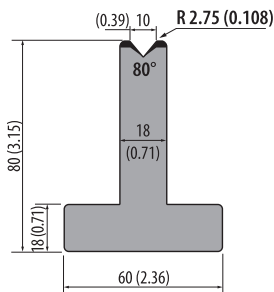
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.10.80

950 kN/m max.



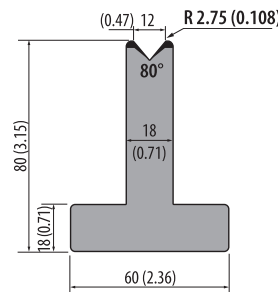
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.12.80

950 kN/m max.



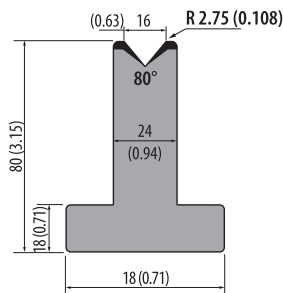
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.16.80

950 kN/m max.



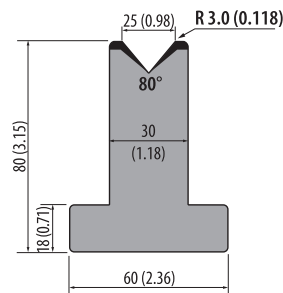
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.20.80

950 kN/m max.



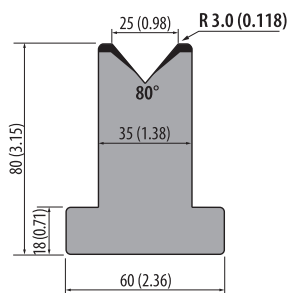
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²



T80.25.80

950 kN/m max.



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

C45: 560-710 N/mm²

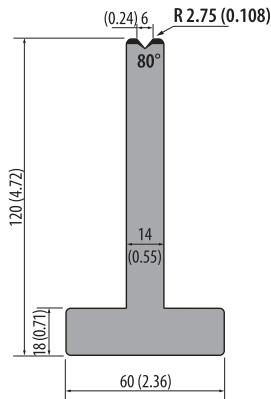


R1

ROLLERI TYPE R1 80° T-dies, H=120 (4.72)

T120.06.80

950 kN/m max.



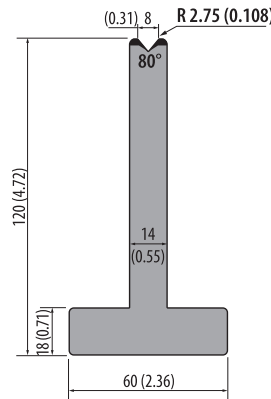
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.08.80

950 kN/m max.



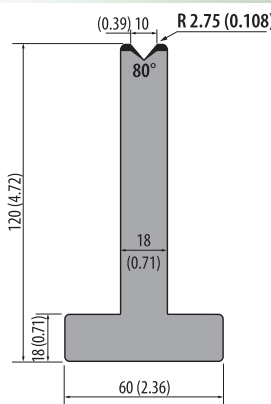
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.10.80

950 kN/m max.



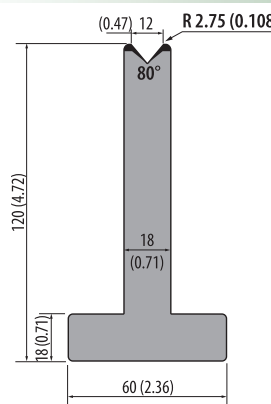
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.12.80

950 kN/m max.



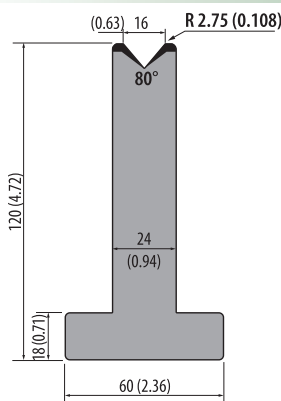
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T120.16.80

950 kN/m max.



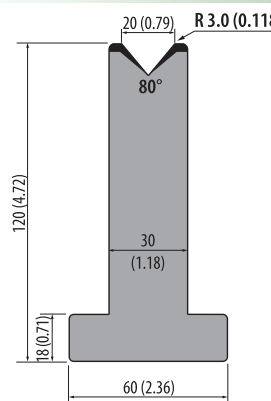
835 mm	32.87 in	18.8 kg
415 mm	16.34 in	9.3 kg
795 mm segmented	31.29 in segmented	17.9 kg
805 mm segmented	31.69 in segmented	18.1 kg

C45: 560-710 N/mm²



T120.20.80

950 kN/m max.



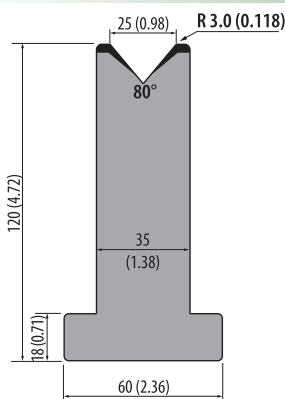
835 mm	32.87 in	26.3 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	25.0 kg
805 mm segmented	31.69 in segmented	25.4 kg

C45: 560-710 N/mm²



T120.25.80

950 kN/m max.



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

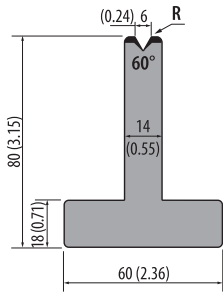
C45: 560-710 N/mm²



We show at Euroblech, Blechexpo, EMO, Lamiera, Tolexpo and a lot of other exhibitions worldwide. Contact us to know more about the closest exhibitions to you!

T80.06.60 / TR80.06.60

600 kN/m max.



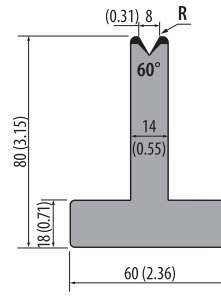
R=0.5 (0.020)			
T80.06.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=1.5 (0.059)			
TR80.06.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²



T80.08.60 / TR80.08.60

600 kN/m max.



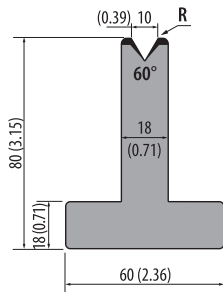
R=0.8 (0.031)			
T80.08.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
R=1.5 (0.059)			
TR80.08.60	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²



T80.10.60 / TR80.10.60

600 kN/m max.



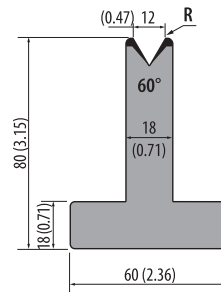
R=0.8 (0.031)			
T80.10.60	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
R=2.75 (0.108)			
TR80.10.60	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented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

C45: 560-710 N/mm²



T80.12.60 / TR80.12.60

600 kN/m max.



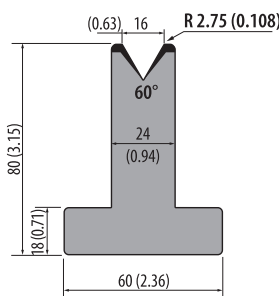
R=0.8 (0.031)			
T80.12.60	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
R=2.75 (0.108)			
TR80.12.60	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented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

C45: 560-710 N/mm²



T80.16.60

600 kN/m max.



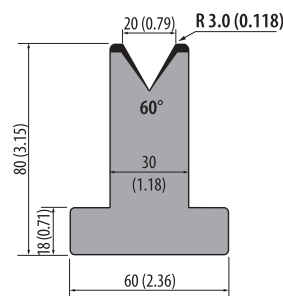
	835 mm	32.87 in	15.6 kg
	415 mm	16.34 in	8.7 kg
	795 mm segmented	31.29 in segmented	14.8 kg
	805 mm segmented	31.69 in segmented	15.0 kg

C45: 560-710 N/mm²



T80.20.60

600 kN/m max.



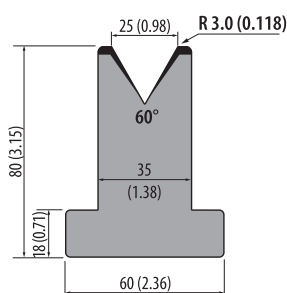
	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.5 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²



T80.25.60

600 kN/m max.



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

C45: 560-710 N/mm²

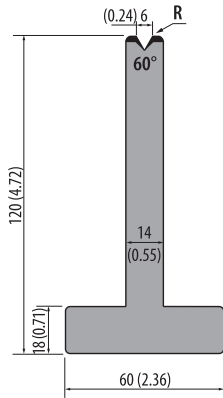


R1

ROLLERI TYPE R1 60° T-dies, H=120 (4.72)

T120.06.60 / TR120.06.60

600 kN/m max.



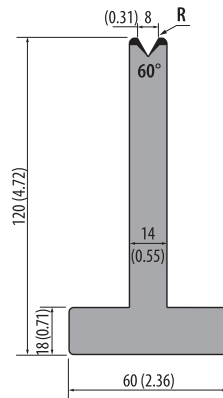
R=0.5 (0.020)			
T120.06.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
R=1.5 (0.059)			
TR120.06.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²



T120.08.60 / TR120.08.60

600 kN/m max.



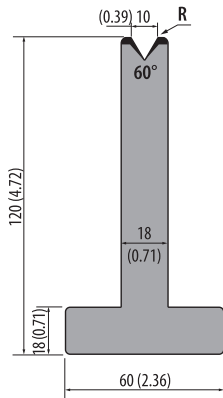
R=0.8 (0.031)			
T120.08.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
R=1.5 (0.059)			
TR120.08.60	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²



T120.10.60 / TR120.10.60

600 kN/m max.



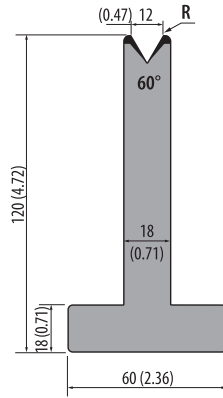
R=0.8 (0.031)			
T120.10.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
R=2.75 (0.108)			
TR120.10.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented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

C45: 560-710 N/mm²



T120.12.60 / TR120.12.60

600 kN/m max.



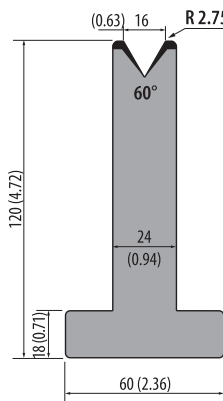
R=0.8 (0.031)			
T120.12.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
R=2.75 (0.108)			
TR120.12.60	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented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

C45: 560-710 N/mm²



T120.16.60

600 kN/m max.



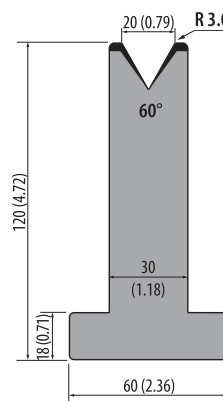
835 mm	32.87 in	22.4 kg
415 mm	16.34 in	11.1 kg
795 mm segmented	31.29 in segmented	21.3 kg
805 mm segmented	31.69 in segmented	21.6 kg

C45: 560-710 N/mm²



T120.20.60

600 kN/m max.



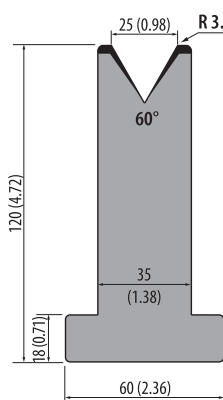
835 mm	32.87 in	26.0 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	24.8 kg
805 mm segmented	31.69 in segmented	25.0 kg

C45: 560-710 N/mm²



T120.25.60

600 kN/m max.



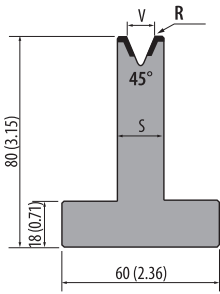
835 mm	32.87 in	28.5 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	27.1 kg
805 mm segmented	31.69 in segmented	27.5 kg

C45: 560-710 N/mm²



45° T-dies, H=80 mm (3.15 in)

500 kN/m max.



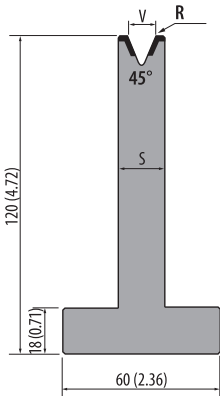
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight
T80.06.45	6	0.24	0.8	0.03	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.45	8	0.31	1.0	0.04	18	0.71	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.10.45	10	0.39	1.2	0.05	18	0.71	14.0 kg	7.0 kg	13.3 kg	13.5 kg
T80.12.45	12	0.47	1.6	0.06	24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

C45: 560-710 N/mm²



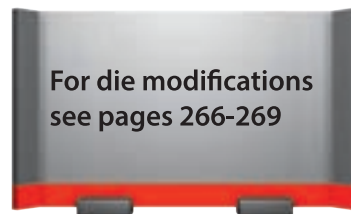
45° T-dies, H=120 mm (4.72 in)

500 kN/m max.

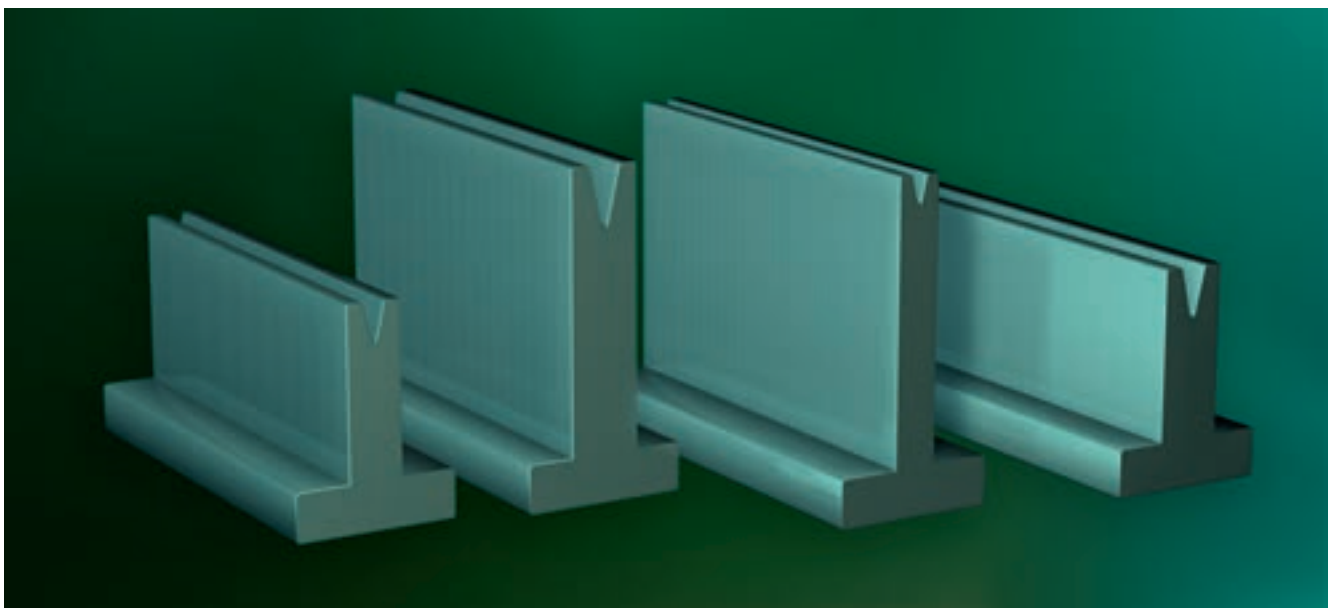


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	Weight	Weight	Weight	Weight
T120.06.45	6	0.24	0.8	0.03	14	0.55	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.45	8	0.31	1.0	0.04	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T120.10.45	10	0.39	1.2	0.05	18	0.71	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T120.12.45	12	0.47	1.6	0.06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

C45: 560-710 N/mm²



For die modifications
see pages 266-269

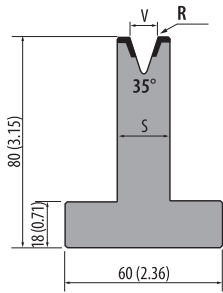


R1

ROLLERI TYPE R1

35° T-dies, H=80 (3.15), H=120 (4.72)

35° T-dies, H=80 mm (3.15 in)

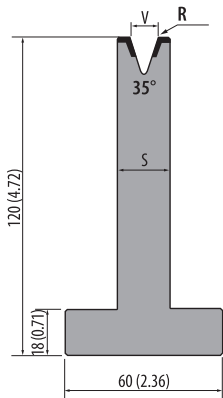


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	Weight	Weight	Weight	Weight
T80.06.35	6	0.24	0.8	0.03	14	0.55	350	12.5 kg	6.5 kg	11.9 kg	12.0 kg
T80.08.35	8	0.31	1.0	0.04	16	0.63	350	13.0 kg	7.0 kg	12.4 kg	12.6 kg
T80.10.35	10	0.39	1.2	0.05	20	0.79	400	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.12.35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

C45: 560-710 N/mm²



35° T-dies, H=120 mm (4.72 in)



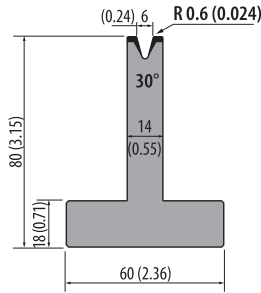
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	Weight	Weight	Weight	Weight
T120.06.35	6	0.24	0.8	0.03	14	0.55	350	16.0 kg	8.0 kg	15.2 kg	15.4 kg
T120.08.35	8	0.31	1.0	0.04	16	0.63	350	18.0 kg	9.0 kg	17.1 kg	17.3 kg
T120.10.35	10	0.39	1.2	0.05	20	0.79	400	19.9 kg	8.5 kg	18.9 kg	19.1 kg
T120.12.35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

C45: 560-710 N/mm²



T80.06.30

350 kN/m max.



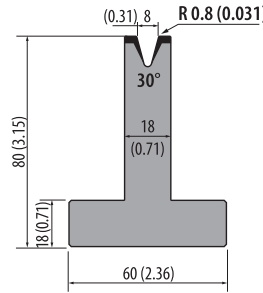
835 mm	32.87 in	12.4 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	11.8 kg
805 mm segmented	31.69 in segmented	12.0 kg

C45: 560-710 N/mm²



T80.08.30

350 kN/m max.



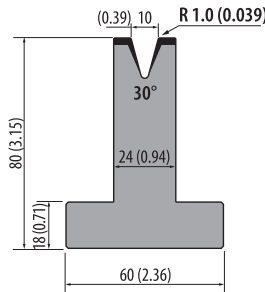
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.6 kg

C45: 560-710 N/mm²



T80.10.30

500 kN/m max.



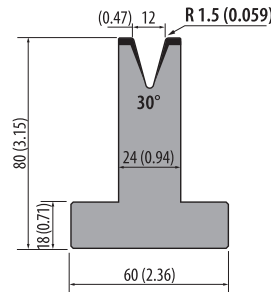
835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T80.12.30

400 kN/m max.



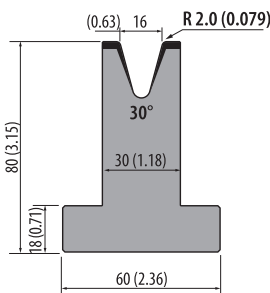
835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T80.16.30

450 kN/m max.



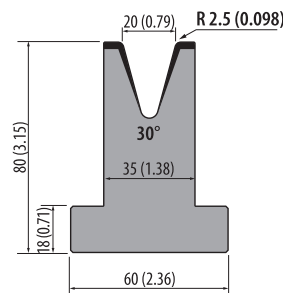
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



T80.20.30

500 kN/m max.



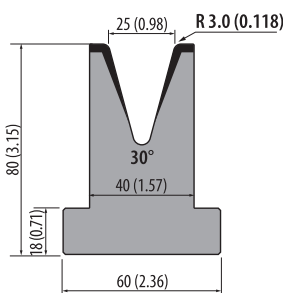
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



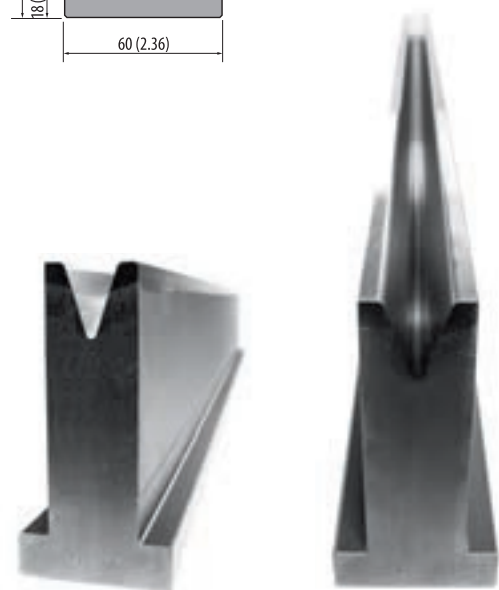
T80.25.30

500 kN/m max.



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

C45: 560-710 N/mm²

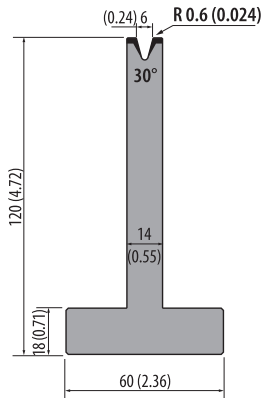


R1

ROLLERI TYPE R1 30° T-dies, H=120 (4.72)

T120.06.30

350 kN/m max.



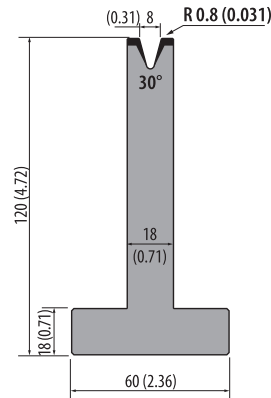
835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²



T120.08.30

350 kN/m max.



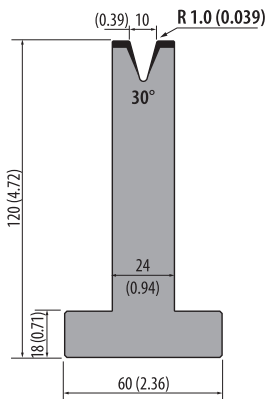
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.10.30

500 kN/m max.



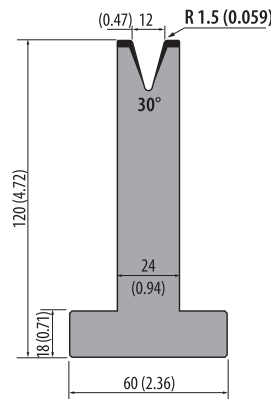
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.9 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



T120.12.30

400 kN/m max.



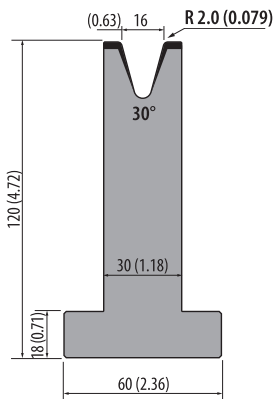
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



T120.16.30

450 kN/m max.



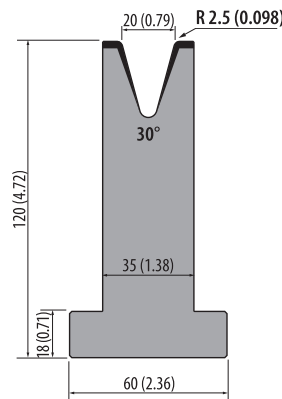
835 mm	32.87 in	25.8 kg
415 mm	16.34 in	12.8 kg
795 mm segmented	31.29 in segmented	24.6 kg
805 mm segmented	31.69 in segmented	24.9 kg

C45: 560-710 N/mm²



T120.20.30

500 kN/m max.



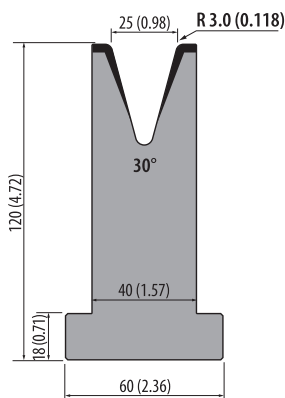
835 mm	32.87 in	28.0 kg
415 mm	16.34 in	14.0 kg
795 mm segmented	31.29 in segmented	26.7 kg
805 mm segmented	31.69 in segmented	27.0 kg

C45: 560-710 N/mm²



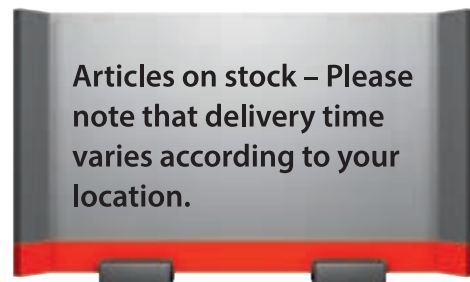
T120.25.30

500 kN/m max.



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

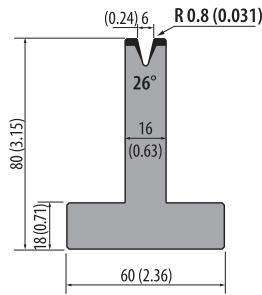
C45: 560-710 N/mm²



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

T80.06.26

200 kN/m max.



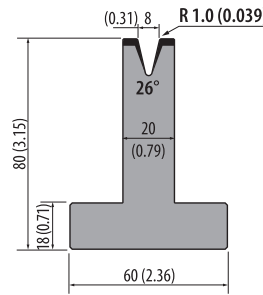
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

C45: 560-710 N/mm²



T80.08.26

200 kN/m max.



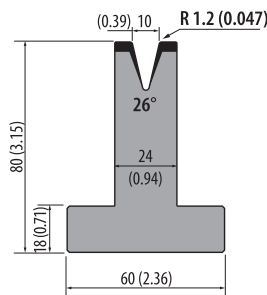
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	14.5 kg

C45: 560-710 N/mm²



T80.10.26

200 kN/m max.



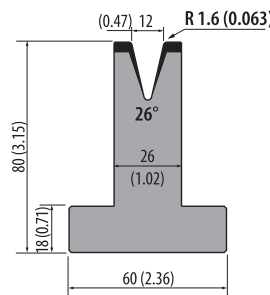
835 mm	32.87 in	15.5 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	14.9 kg

C45: 560-710 N/mm²



T80.12.26

200 kN/m max.



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

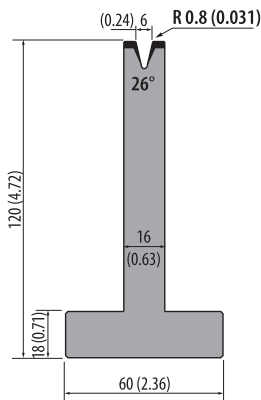
C45: 560-710 N/mm²



26° T-dies, H=120 (4.72)

T120.06.26

200 kN/m max.



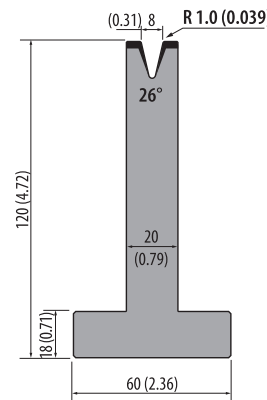
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



T120.08.26

200 kN/m max.



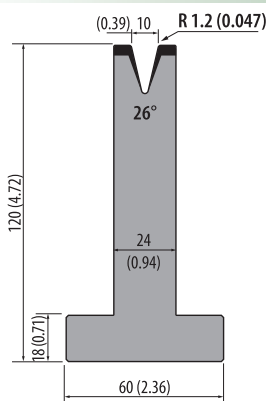
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



T120.10.26

200 kN/m max.



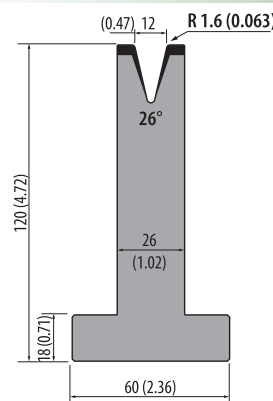
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²



T120.12.26

200 kN/m max.



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

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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



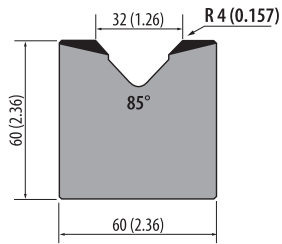
Articles on stock – Please note that delivery time depends on your location.

R1

ROLLERI TYPE R1 85° 1-V dies

M60.85.32

1000 kN/m max.



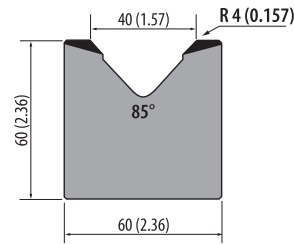
835 mm	32.87 in	21.6 kg
415 mm	16.34 in	10.7 kg
795 mm segmented	31.29 in segmented	20.6 kg
805 mm segmented	31.69 in segmented	20.8 kg

C45: 560-710 N/mm²



M60.85.40

1000 kN/m max.



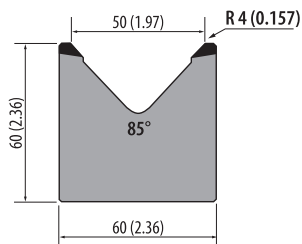
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M60.85.50

1000 kN/m max.



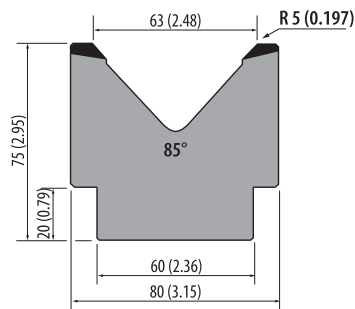
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²



M75.85.63

1000 kN/m max.



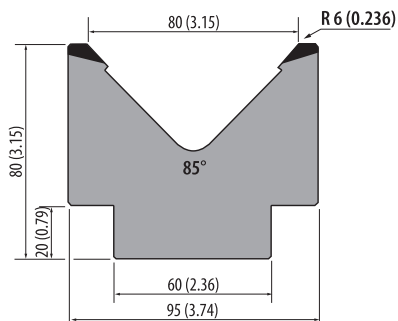
835 mm	32.87 in	29.2 kg
415 mm	16.34 in	14.5 kg
795 mm segmented	31.29 in segmented	27.8 kg
805 mm segmented	31.69 in segmented	28.0 kg

C45: 560-710 N/mm²



M80.85.80

1000 kN/m max.



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

C45: 560-710 N/mm²

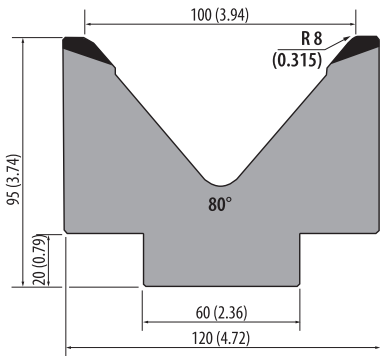


R1

ROLLERI TYPE R1 80° 1-V dies

M95.80.100

1000 kN/m max.



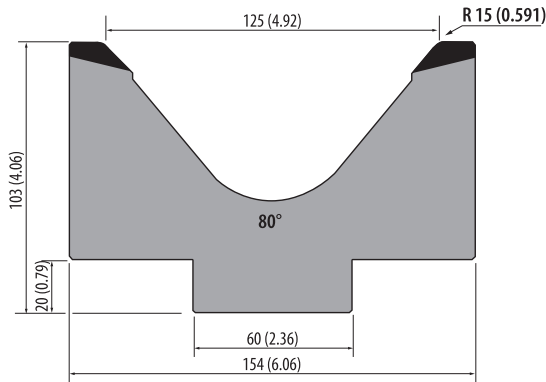
835 mm	32.87 in	46.2 kg
415 mm	16.34 in	22.9 kg
795 mm segmented	31.29 in segmented	44.0 kg
805 mm segmented	31.69 in segmented	44.5 kg

C45: 560-710 N/mm²



MK103.80.125

700 kN/m max.



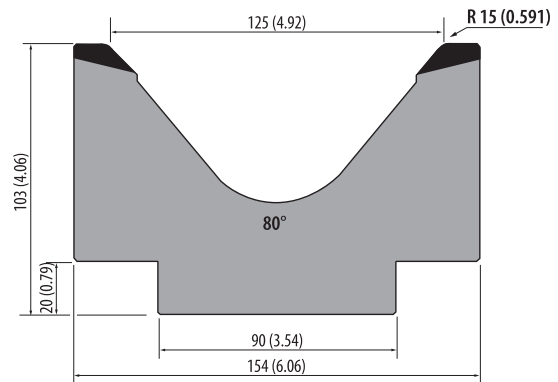
835 mm	32.87 in	62.0 kg
415 mm	16.34 in	31.0 kg
795 mm segmented	31.29 in segmented	59.0 kg
805 mm segmented	31.69 in segmented	59.8 kg



C45: 560-710 N/mm²

M103.80.125

1000 kN/m max.



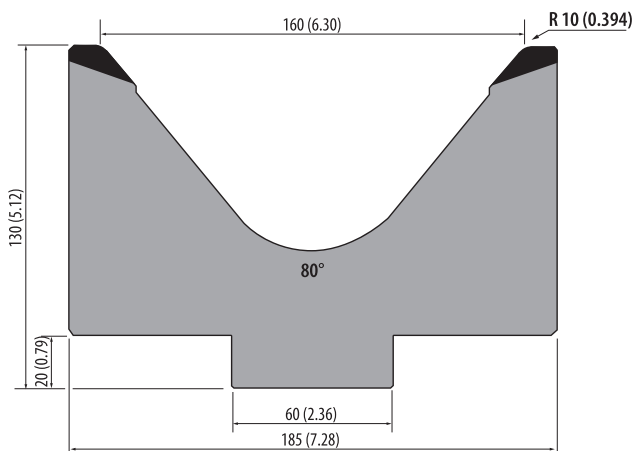
835 mm	32.87 in	64.9 kg
415 mm	16.34 in	32.2 kg
795 mm segmented	31.29 in segmented	61.4 kg
805 mm segmented	31.69 in segmented	62.5 kg



C45: 560-710 N/mm²

MK130.80.160

700 kN/m max.



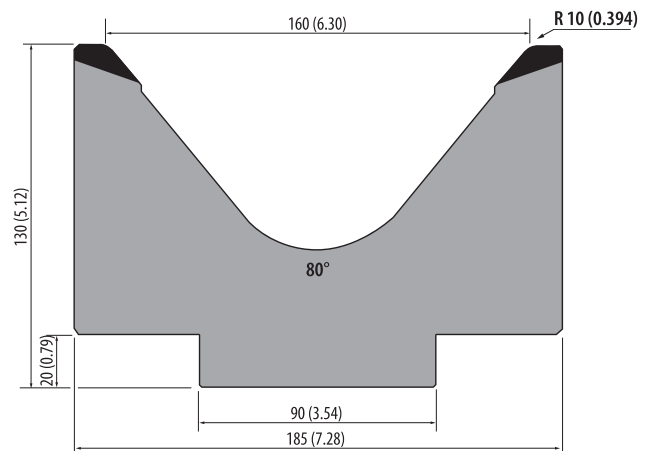
835 mm	32.87 in	93.0 kg
415 mm	16.34 in	46.5 kg
795 mm segmented	31.29 in segmented	88.5 kg
805 mm segmented	31.69 in segmented	89.7 kg



C45: 560-710 N/mm²

M130.80.160

1000 kN/m max.



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



C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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



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

R1

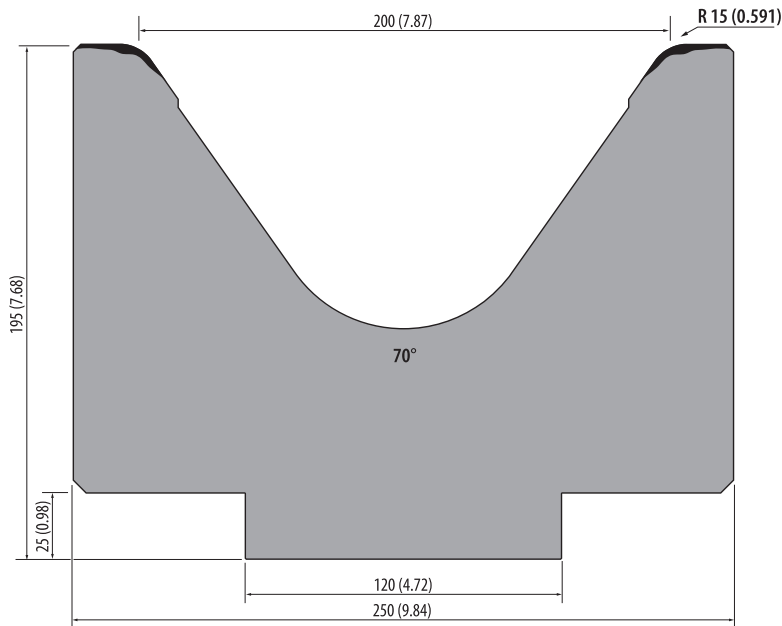
ROLLERI TYPE R1 70° 1-V dies

M195.70.200

1800 kN/m max.

415 mm | 16.34 in | 104.0 kg

42Cr: 900-1150 N/mm²



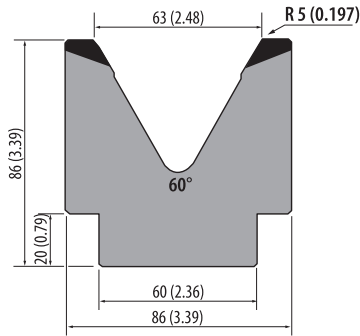
R1

ROLLERI TYPE R1 60° 1-V dies



M86.60.63

1000 kN/m max.



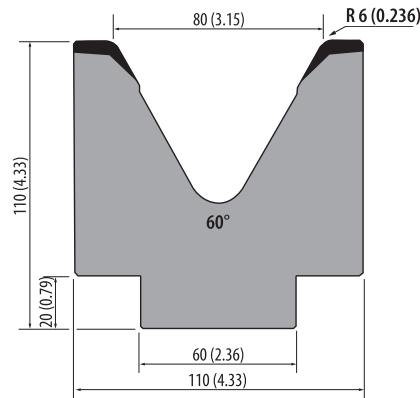
835 mm	32.87 in	34.0 kg
415 mm	16.34 in	17.0 kg
795 mm segmented	31.29 in segmented	32.4 kg
805 mm segmented	31.69 in segmented	32.8 kg

C45: 560-710 N/mm²



M110.60.80

1000 kN/m max.



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

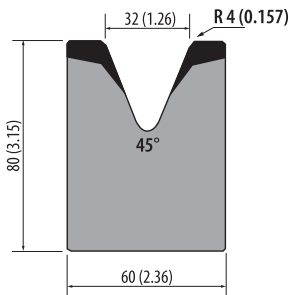
C45: 560-710 N/mm²



45° 1-V dies

M80.45.32

1000 kN/m max.



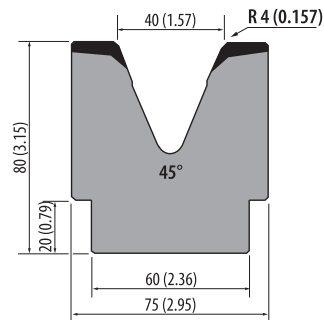
835 mm	32.87 in	27.5 kg
415 mm	16.34 in	13.7 kg
795 mm segmented	31.29 in segmented	26.2 kg
805 mm segmented	31.69 in segmented	26.5 kg

C45: 560-710 N/mm²



M80.45.40

1000 kN/m max.



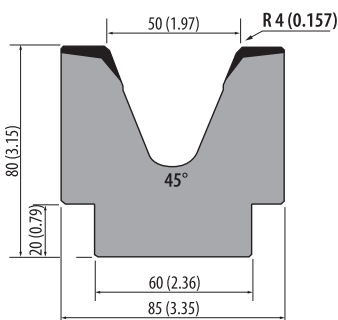
835 mm	32.87 in	30.9 kg
415 mm	16.34 in	16.5 kg
795 mm segmented	31.29 in segmented	29.4 kg
805 mm segmented	31.69 in segmented	29.8 kg

C45: 560-710 N/mm²



M80.45.50

950 kN/m max.



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

C45: 560-710 N/mm²



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Article on stock



Please ask for delivery time!

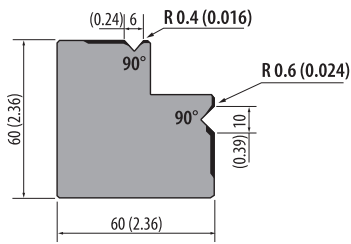
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

M60.90.01

1000 kN/m max.



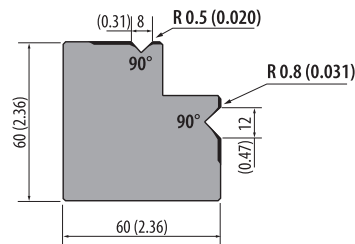
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M60.90.02

800 kN/m max.



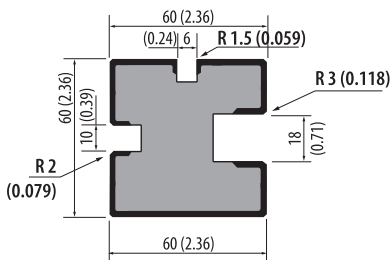
835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.0 kg
805 mm segmented	31.69 in segmented	20.2 kg

C45: 560-710 N/mm²



M.360.R

1000 kN/m max.



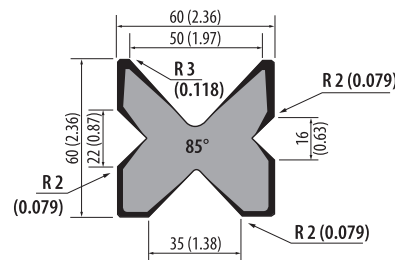
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²



M.460.R

800 kN/m max.



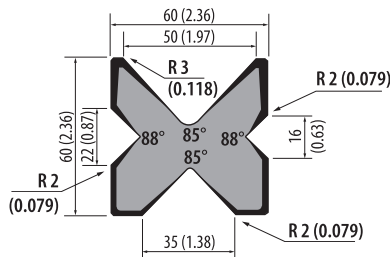
835 mm	32.87 in	15.7 kg
415 mm	16.34 in	7.7 kg
795 mm segmented	31.29 in segmented	14.9 kg
805 mm segmented	31.69 in segmented	15.1 kg

C45: 560-710 N/mm²



M.460

800 kN/m max.



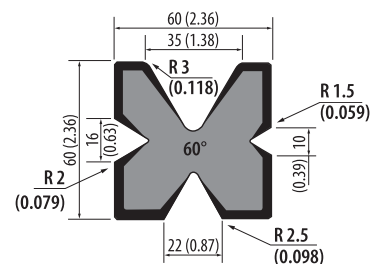
835 mm	32.87 in	15.8 kg
415 mm	16.34 in	7.8 kg
795 mm segmented	31.29 in segmented	15.0 kg
805 mm segmented	31.69 in segmented	15.2 kg

C45: 560-710 N/mm²



M.460.60

600 kN/m max.



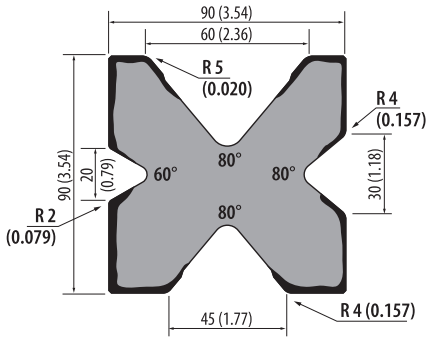
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²



M.490

1000 kN/m max.



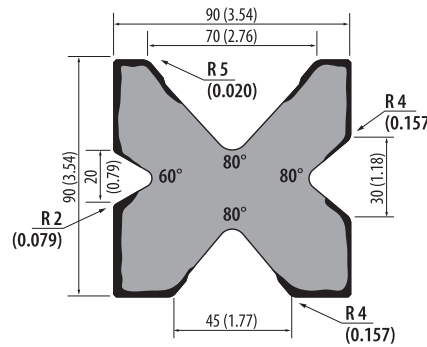
835 mm	32.87 in	38.9 kg
415 mm	16.34 in	20.0 kg
795 mm segmented	31.29 in segmented	37.0 kg
805 mm segmented	31.69 in segmented	37.5 kg

C45: 560-710 N/mm²



M.490.70

600 kN/m max.



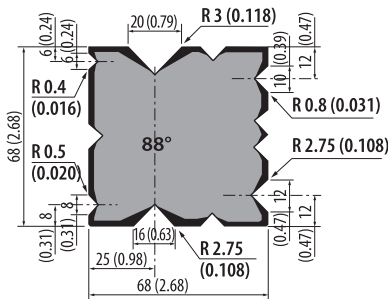
835 mm	32.87 in	35.9 kg
415 mm	16.34 in	18.0 kg
795 mm segmented	31.29 in segmented	34.2 kg
805 mm segmented	31.69 in segmented	34.6 kg

C45: 560-710 N/mm²



T70-88

1000 kN/m max.

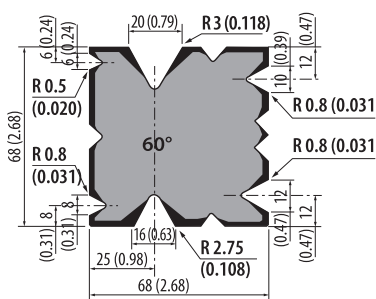


525 mm	20.67 in	17.5 kg
495 mm segmented	19.49 in segmented	16.5 kg

42Cr: 900-1150 N/mm²



T70-60



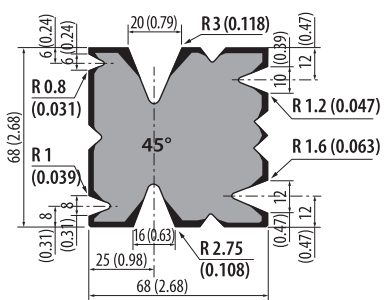
525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.8 kg

42Cr: 900-1150 N/mm²



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

T70-45



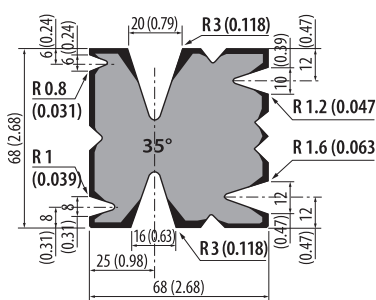
525 mm	20.67 in	16.1 kg
495 mm segmented	19.49 in segmented	15.2 kg

42Cr: 900-1150 N/mm²



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

T70-35



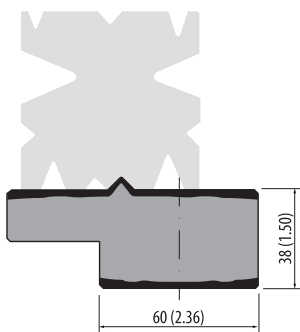
525 mm	20.67 in	15.3 kg
495 mm segmented	19.49 in segmented	14.4 kg

42Cr: 900-1150 N/mm²



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

SU-T70

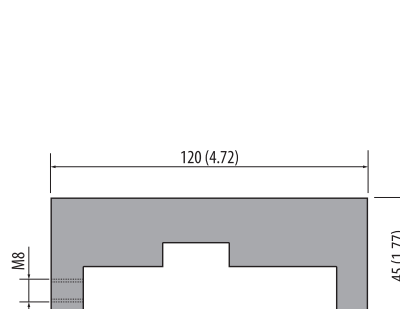


525 mm	20.67 in	12.4 kg
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C45: 560-710 N/mm²



PB-T70



20 mm	0.79 in	0.2 kg
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per pair

Fe37

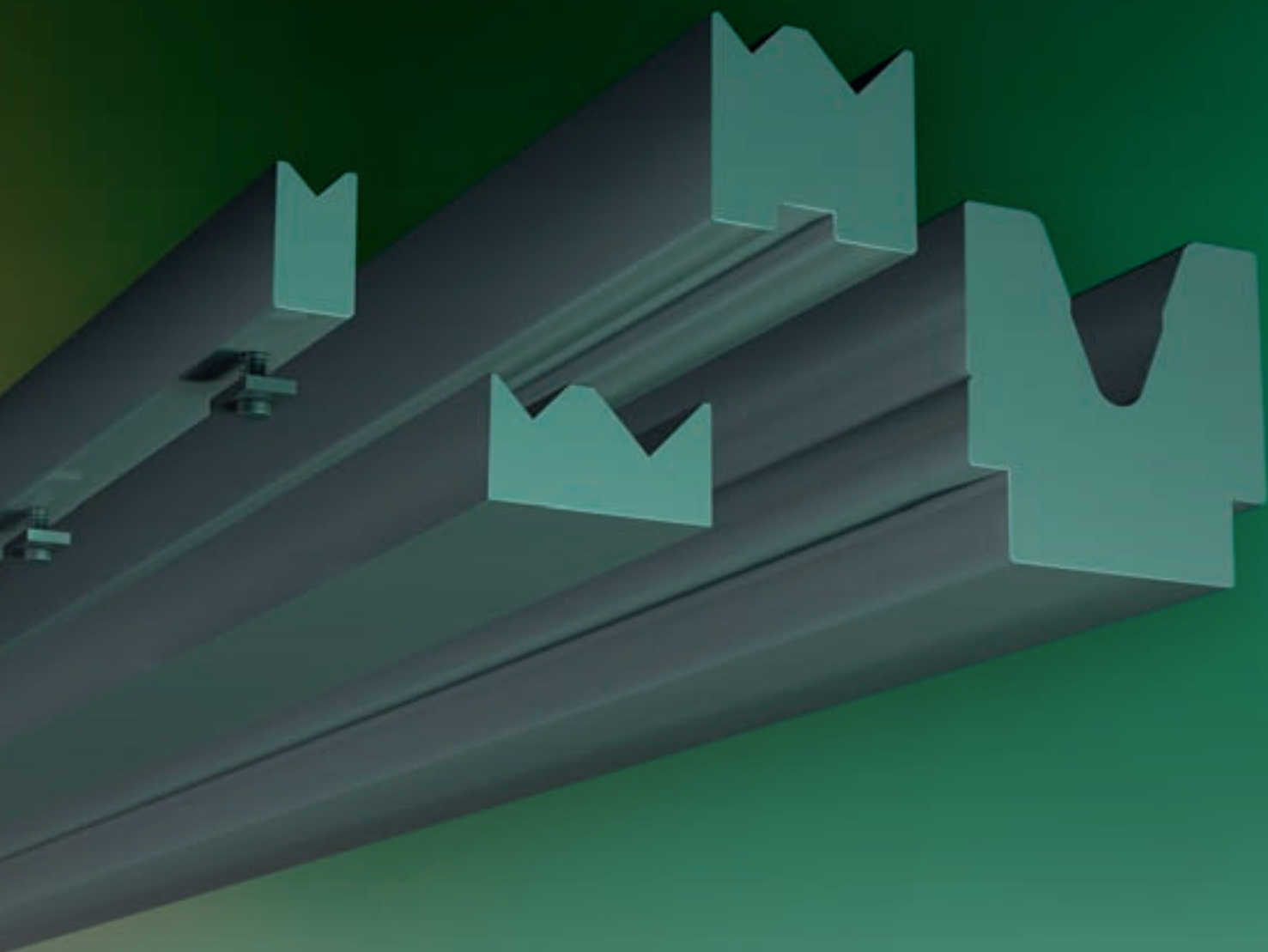


Please ask for delivery time!

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



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



R1
A

A-DIES
ROLLERI TYPE R1

12100 600 kN/m max.

835 mm	32.87 in	8.4 kg
415 mm	16.34 in	4.2 kg

C45: 560-710 N/mm²

NEW

12300 700 kN/m max.

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

C45: 560-710 N/mm²

12400 800 kN/m max.

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

C45: 560-710 N/mm²

31100 800 kN/m max.

835 mm	32.87 in	9.1 kg
415 mm	16.34 in	4.6 kg

C45: 560-710 N/mm²

NEW

88° 2-V A-dies

12106 600 kN/m max.

835 mm	32.87 in	8.4 kg
415 mm	16.34 in	4.2 kg

C45: 560-710 N/mm²

NEW

12306 700 kN/m max.

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

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

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

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

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

C45: 560-710 N/mm²

31106 800 kN/m max.

835 mm	32.87 in	8.8 kg
415 mm	16.34 in	4.4 kg

C45: 560-710 N/mm²

NEW

31400 1000 kN/m max.

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

C45: 560-710 N/mm²

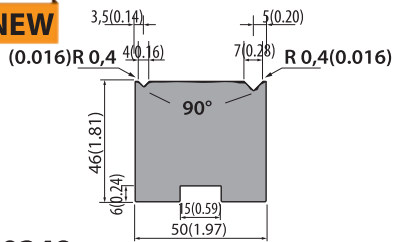
R1

ROLLERS TYPE R1 90° self-centering 2-V A-dies

30148

600 kN/m max.

NEW



835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

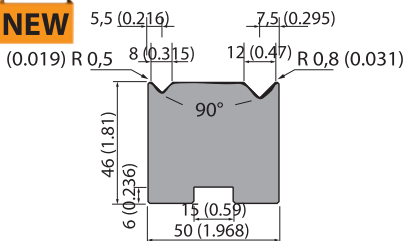
C45: 560-710 N/mm²



30348

700 kN/m max.

NEW



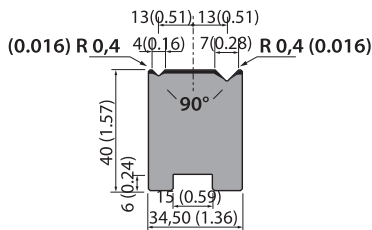
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

C45: 560-710 N/mm²



50190

600 kN/m max.



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

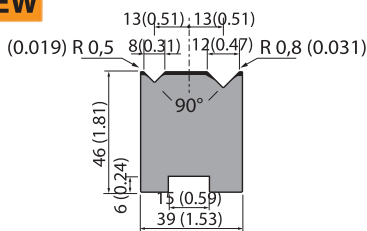
C45: 800-850 N/mm²



50390

700 kN/m max.

NEW



835 mm	32.87 in	10.7 kg
415 mm	16.34 in	5.4 kg
795 mm segmented	31.29 in segmented	10.2 kg
805 mm segmented	31.69 in segmented	10.3 kg

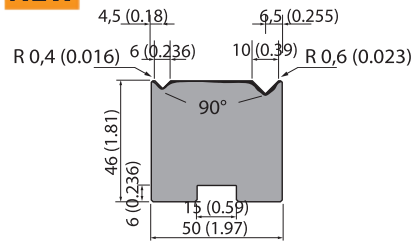
C45: 560-710 N/mm²



30248

700 kN/m max.

NEW



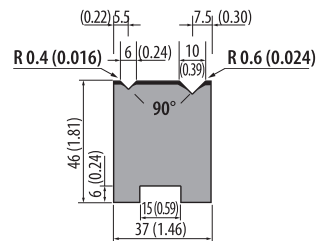
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

C45: 560-710 N/mm²



50290

700 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	31.69 in segmented	10.1 kg

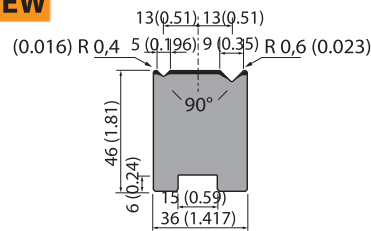
C45: 800-850 N/mm²



50790

600 kN/m max.

NEW



835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.7 kg

C45: 560-710 N/mm²

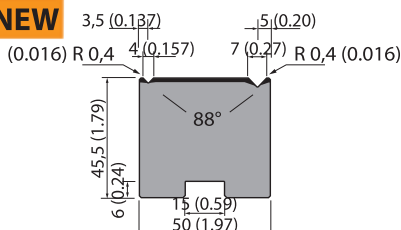


88° self-centering 2-V A-dies

30147

600 kN/m max.

NEW



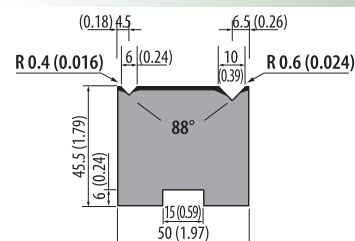
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

C45: 560-710 N/mm²



30247

700 kN/m max.



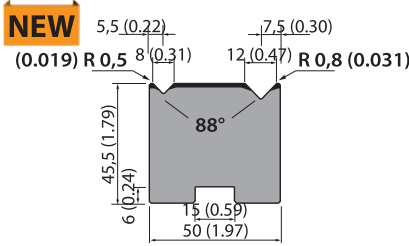
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg

C45: 800-850 N/mm²



30347

700 kN/m max.



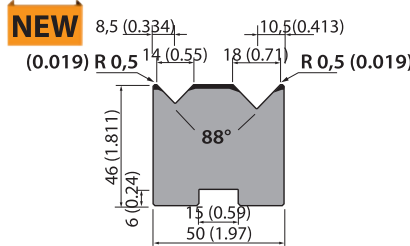
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in	13.5 kg
805 mm segmented	31.69 in	13.7 kg

C45: 560-710 N/mm²



30448

1000 kN/m max.



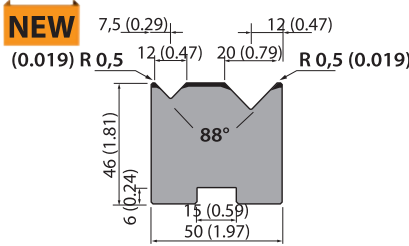
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in	13.5 kg
805 mm segmented	31.69 in	13.7 kg

C45: 560-710 N/mm²



30548

1000 kN/m max.



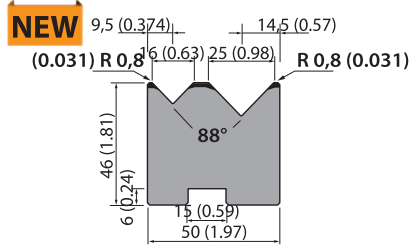
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in	13.5 kg
805 mm segmented	31.69 in	13.7 kg

C45: 560-710 N/mm²



30648

1000 kN/m max.



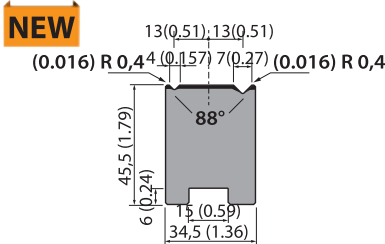
835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.1 kg
795 mm segmented	31.29 in	13.5 kg
805 mm segmented	31.69 in	13.7 kg

C45: 560-710 N/mm²



50196

600 kN/m max.



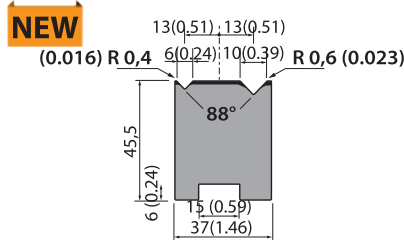
835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
795 mm segmented	31.29 in	9.2 kg
805 mm segmented	31.69 in	9.3 kg

C45: 560-710 N/mm²



50296

700 kN/m max.



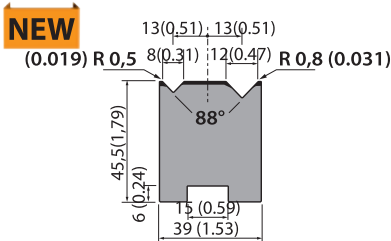
835 mm	32.87 in	10.4 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in	9.9 kg
805 mm segmented	31.69 in	10.1 kg

C45: 560-710 N/mm²



50396

700 kN/m max.



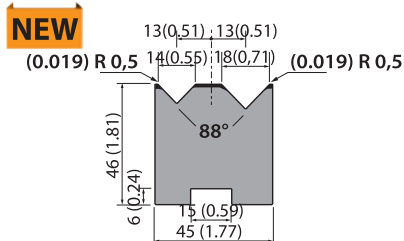
835 mm	32.87 in	10.8 kg
415 mm	16.34 in	5.4 kg
795 mm segmented	31.29 in	10.3 kg
805 mm segmented	31.69 in	10.4 kg

C45: 560-710 N/mm²



50490

1000 kN/m max.



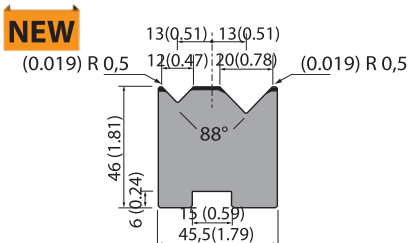
835 mm	32.87 in	10.8 kg
415 mm	16.34 in	5.4 kg
795 mm segmented	31.29 in	10.3 kg
805 mm segmented	31.69 in	10.4 kg

C45: 560-710 N/mm²



50590

700 kN/m max.



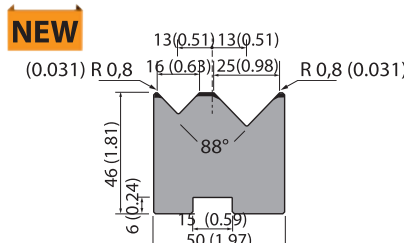
835 mm	32.87 in	12.2 kg
415 mm	16.34 in	6.1 kg
795 mm segmented	31.29 in	11.6 kg
805 mm segmented	31.69 in	11.8 kg

C45: 560-710 N/mm²



50690

1000 kN/m max.



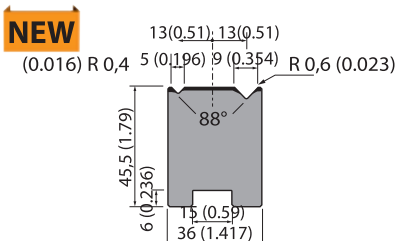
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in	12.4 kg
805 mm segmented	31.69 in	12.6 kg

C45: 560-710 N/mm²



50796

600 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	9.5 kg
805 mm segmented	31.69 in	9.5 kg

C45: 560-710 N/mm²



Please ask for delivery time!

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



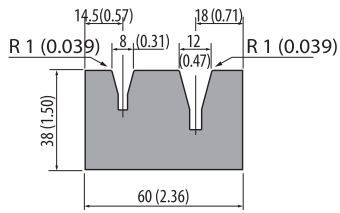
Articles on stock – Please note that delivery time depends on your location.

R1

ROLLERI TYPE R1 30° 2-V A-dies

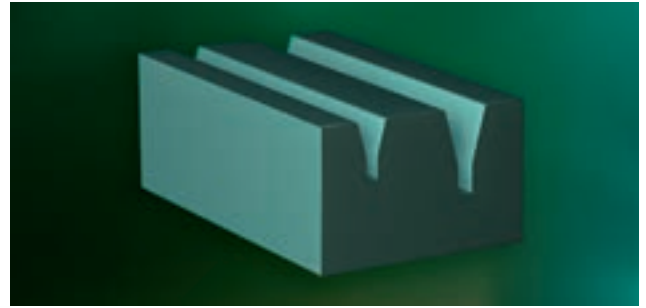
33700

300 kN/m max.



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

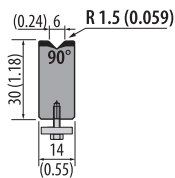
C42Cr: 900-1150 N/mm²



90° self-centering 1-V A-dies

32000

950 kN/m max.



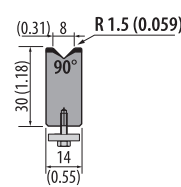
835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



32100

950 kN/m max.



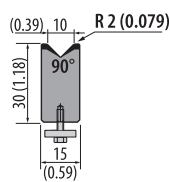
835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



32300

950 kN/m max.



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

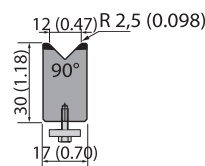
C45: 560-710 N/mm²



32600

1000 kN/m max.

NEW



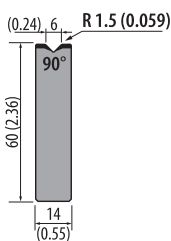
835 mm	32.87 in	2.9 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



07000

950 kN/m max.



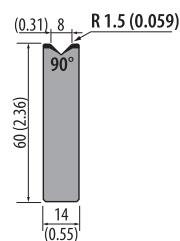
835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.2 kg
805 mm segmented	31.69 in segmented	5.3 kg

C45: 560-710 N/mm²



07100

950 kN/m max.



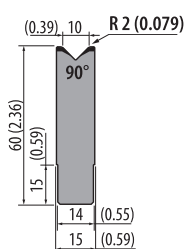
835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.2 kg
805 mm segmented	31.69 in segmented	5.3 kg

C45: 560-710 N/mm²



07300

950 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	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

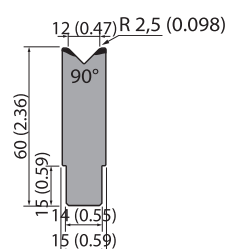
C45: 560-710 N/mm²



07500

950 kN/m max.

NEW



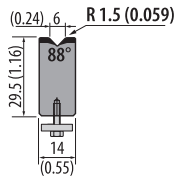
835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

C45: 560-710 N/mm²



32006

950 kN/m max.



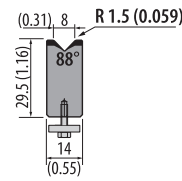
835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



32106

950 kN/m max.



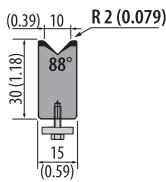
835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



32200

950 kN/m max.



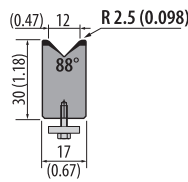
835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



32400

1000 kN/m max.



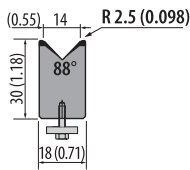
835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg

C45: 560-710 N/mm²



32500

1000 kN/m max.



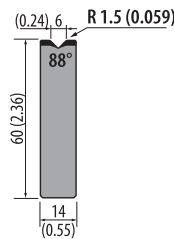
835 mm	32.87 in	3.3 kg
415 mm	16.34 in	1.6 kg

C45: 560-710 N/mm²



07006

950 kN/m max.



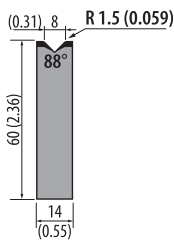
835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in	5.2 kg
805 mm segmented	31.69 in	5.3 kg

C45: 560-710 N/mm²



07106

950 kN/m max.



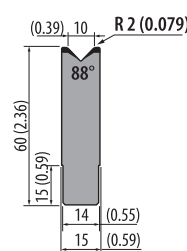
835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in	5.2 kg
805 mm segmented	31.69 in	5.3 kg

C45: 560-710 N/mm²



07200

950 kN/m max.



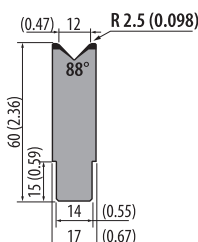
835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in	5.4 kg
805 mm segmented	31.69 in	5.5 kg

C45: 560-710 N/mm²



07400

950 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	5.8 kg
805 mm segmented	31.69 in	5.9 kg

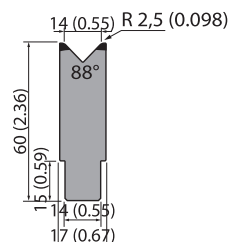
C45: 560-710 N/mm²



07600

950 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	5.8 kg
805 mm segmented	31.69 in	5.9 kg

C45: 560-710 N/mm²



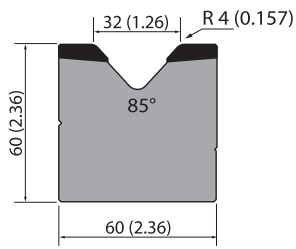
R1

ROLLERI TYPE R1 85°/45°/30° 1-V A-dies

03500

1000 kN/m max.

NEW



835 mm	32.87 in	27.7 kg
415 mm	16.34 in	10.8 kg
795 mm segmented	31.29 in segmented	20.7 kg
805 mm segmented	31.69 in segmented	20.9 kg

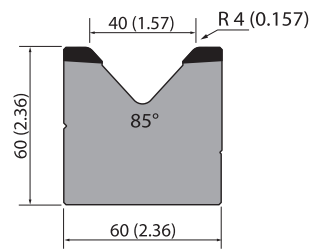
C45: 560-710 N/mm²



03600

1000 kN/m max.

NEW



835 mm	32.87 in	20.5 kg
415 mm	16.34 in	10.2 kg
795 mm segmented	31.29 in segmented	19.5 kg
805 mm segmented	31.69 in segmented	19.7 kg

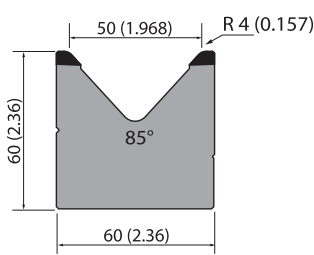
C45: 560-710 N/mm²



03700

1000 kN/m max.

NEW



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

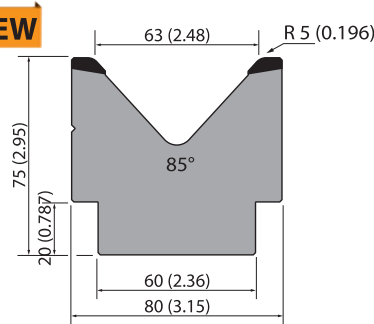
C45: 560-710 N/mm²



03800

1000 kN/m max.

NEW



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	28.2 kg

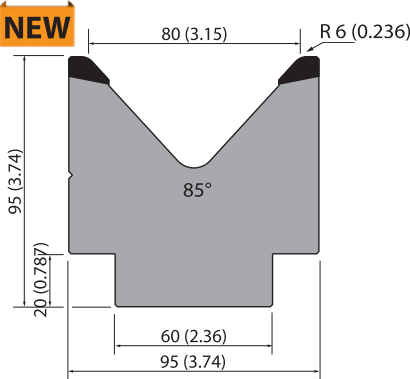
C45: 560-710 N/mm²



01360

700 kN/m max.

NEW



835 mm	32.87 in	42.6 kg
415 mm	16.34 in	21.2 kg
795 mm segmented	31.29 in segmented	40.5 kg
805 mm segmented	31.69 in segmented	41.0 kg

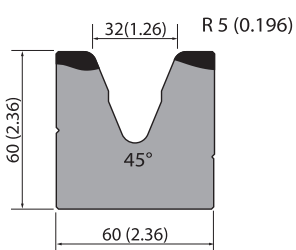
C45: 560-710 N/mm²



34200

400 kN/m max.

NEW



835 mm	32.87 in	19.3 kg
415 mm	16.34 in	9.6 kg
795 mm segmented	31.29 in segmented	18.4 kg
805 mm segmented	31.69 in segmented	18.6 kg

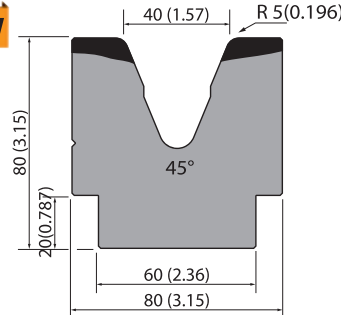
C45: 560-710 N/mm²



34300

700 kN/m max.

NEW



835 mm	32.87 in	32.7 kg
415 mm	16.34 in	16.2 kg
795 mm segmented	31.29 in segmented	31.1 kg
805 mm segmented	31.69 in segmented	31.5 kg

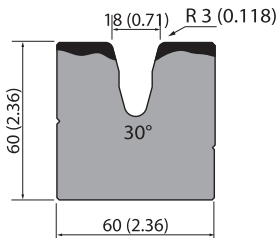
C45: 560-710 N/mm²



34000

800 kN/m max.

NEW



835 mm	32.87 in	21.5 kg
415 mm	16.34 in	10.7 kg
795 mm segmented	31.29 in segmented	20.4 kg
805 mm segmented	31.69 in segmented	20.7 kg

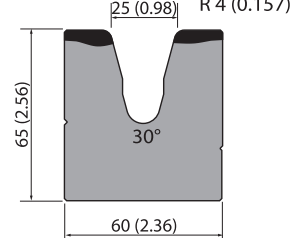
C45: 560-710 N/mm²



34100

600 kN/m max.

NEW



835 mm	32.87 in	21.7 kg
415 mm	16.34 in	10.8 kg
795 mm segmented	31.29 in segmented	20.7 kg
805 mm segmented	31.69 in segmented	20.9 kg

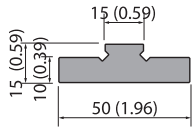
C45: 560-710 N/mm²



30000

1000 kN/m max.

NEW

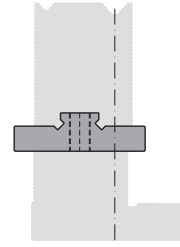


835 mm	32.87 in	3.7 kg
415 mm	16.34 in	1.9 kg

C45: 560-710 N/mm²

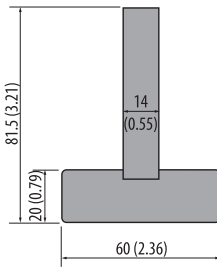


Example of Application



33000

1000 kN/m max.



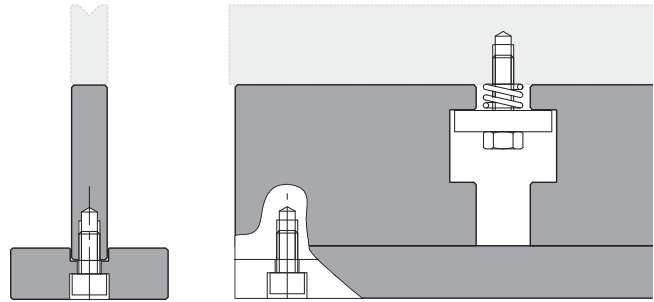
835 mm	32.87 in	12.7 kg
415 mm	16.34 in	6.3 kg

only for self centering, bolted 1-V Dies,
pages 74-75

C45: 560-710 N/mm²

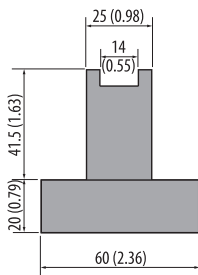


Example of Application



08000

950 kN/m max.



1050 mm	41.34 in	17.8 kg
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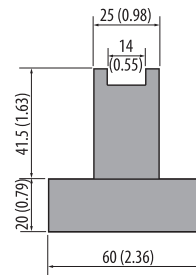
for self centering 1-V Dies,
pages 46-48, 74-75

C45: 560-710 N/mm²



08100

950 kN/m max.



1260 mm	49.61 in	21.4 kg
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for self centering 1-V Dies,
pages 46-48, 74-75

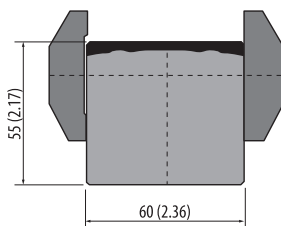
C45: 560-710 N/mm²



05500

1000 kN/m max.

NEW



835 mm	32.87 in	21.7 kg
415 mm	16.34 in	10.8 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

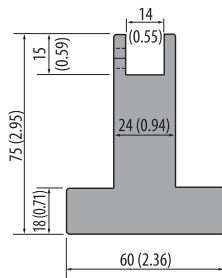
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

TN80.14

1000 kN/m max.



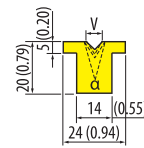
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg

C45: 560-710 N/mm²



INS14...

200 kN/m max.



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

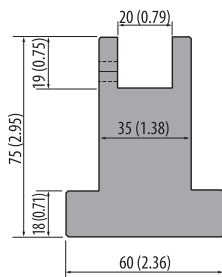


Model	α	V (mm)	V (in)
INS14.06.88	88°	6	0.24
INS14.08.88	88°	8	0.31
INS14.10.88	88°	10	0.39
INS14.06.60	60°	6	0.24
INS14.08.60	60°	8	0.31
INS14.10.60	60°	10	0.39

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

TN80.20

1000 kN/m max.



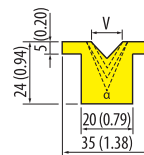
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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

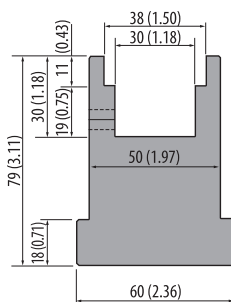


Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

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

TN80.30

1000 kN/m max.



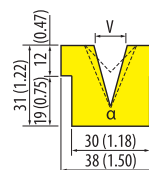
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

C45: 560-710 N/mm²



INS30...

200 kN/m max.



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

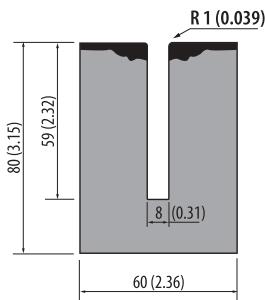


Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.47
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16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

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

For advantages and mounting examples see Mark-Free bending Chapter on pages 242-243

TOP.SM-134.28.8 / TOP.SM-134.24.8

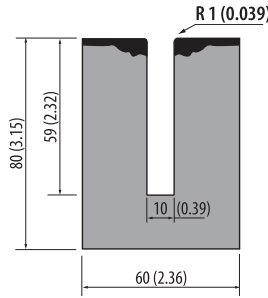


525 mm	20.67 in	17.5 kg
495 mm segmented	19.49 in segmented	16.5 kg

42Cr: 900-1150 N/mm²



TOP.SM-134.24.10

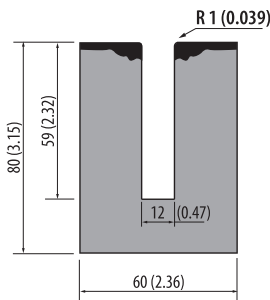


525 mm	20.67 in	18.0 kg
495 mm segmented	19.49 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



TOP.SM-134.24.12

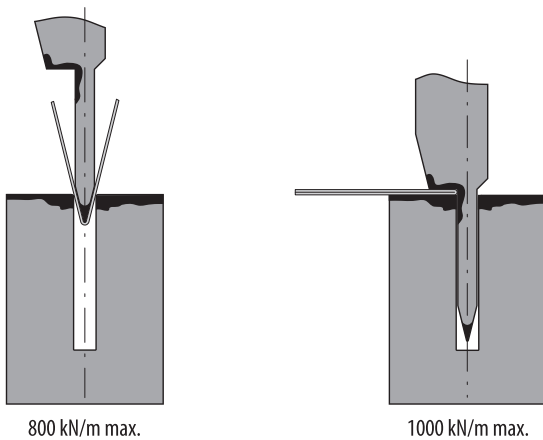


525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.9 kg

42Cr: 900-1150 N/mm²



Example of application



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	kN/mm ²	mm	in	mm	in	kN/mm ²	kN/mm ²
				t/m	t/m					t/m	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



Article on stock



Please ask for delivery time!

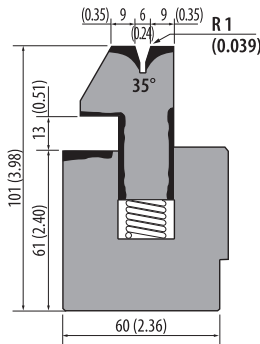
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

S101.35.06

600 kN/m max.



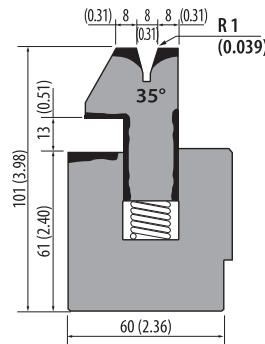
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.4 kg

C45: 800-850 N/mm²



S101.35.08

600 kN/m max.



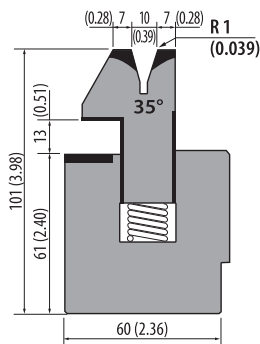
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²



S101.35.10

600 kN/m max.



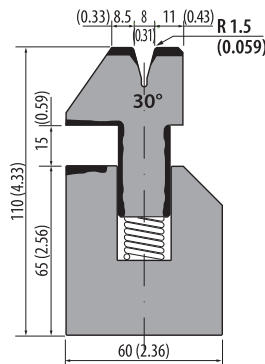
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 800-850 N/mm²



S110.30.08

800 kN/m max.



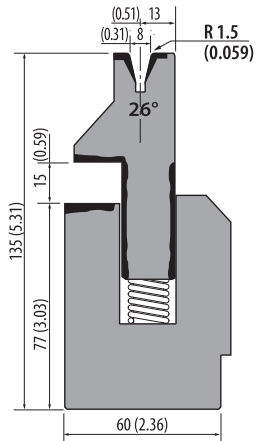
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²



S135.26.08

400 kN/m max.



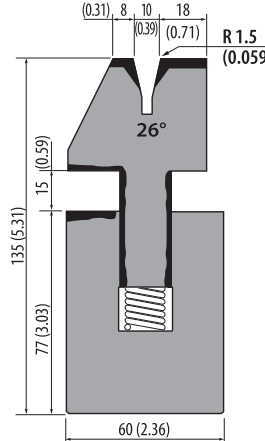
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

42Cr: 900-1150 N/mm²



S135.26.10

1000 kN/m max.



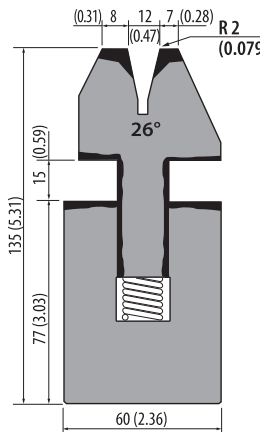
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

C45: 800-850 N/mm²



SA135.26.12

1000 kN/m max.



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

C45: 800-850 N/mm²



Our Advantage – Your Convenience

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



Rolleri Videos

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

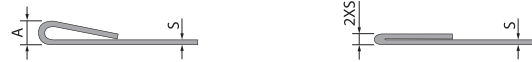


KPN



per piece 1.0 kg

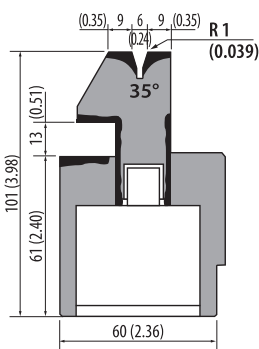
Accessories for pneumatic hemming dies



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

S101PN.35.06

600 kN/m max.



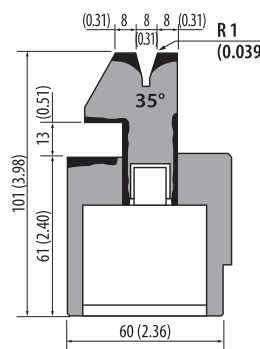
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S101PN.35.08

600 kN/m max.



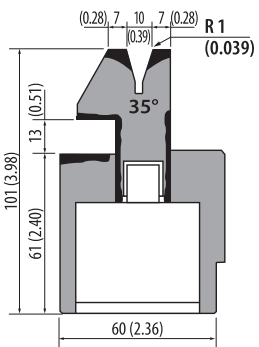
835 mm	32.87 in	31.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S101PN.35.10

600 kN/m max.



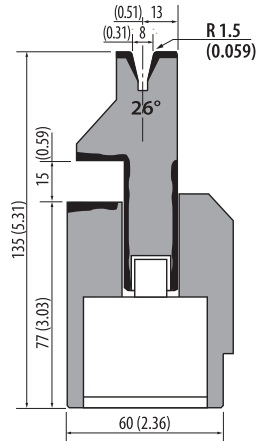
835 mm	32.87 in	29.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²



S135PN.26.08

400 kN/m max.



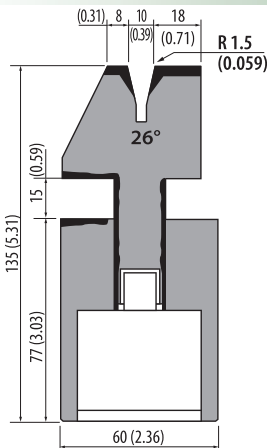
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

42Cr: 900-1150 N/mm²



S135PN.26.10

1000 kN/m max.



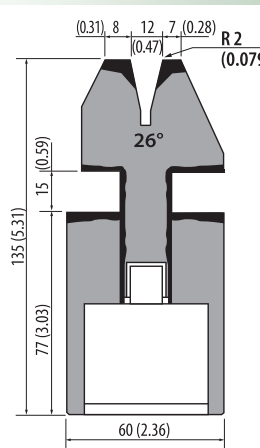
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

C45: 560-710 N/mm²



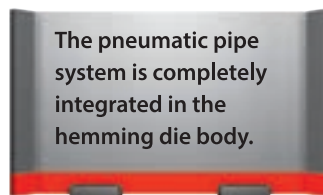
SA135PN.26.12

1000 kN/m max.



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

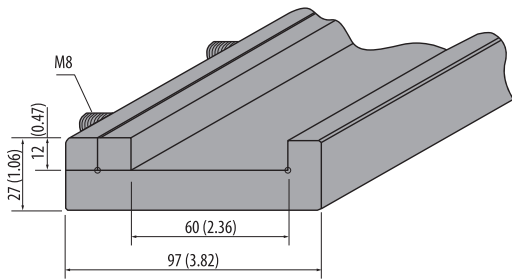
C45: 560-710 N/mm²



R1

ROLLERI TYPE R1 Die Holders

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

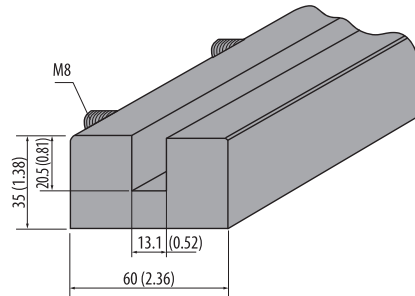


Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm²

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

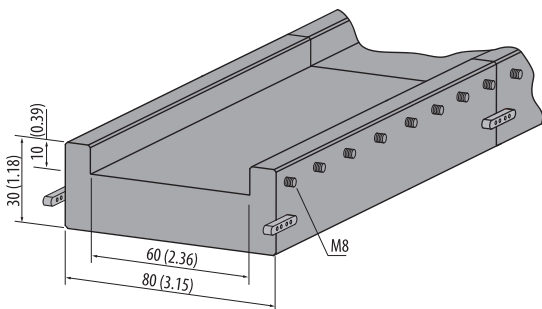


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm²

C 1050/R

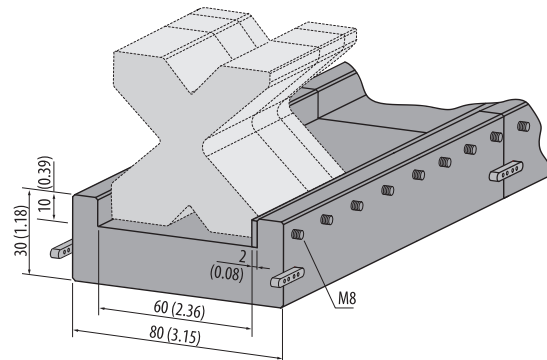


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg



C45: 560-710 N/mm²

C 1050/RS

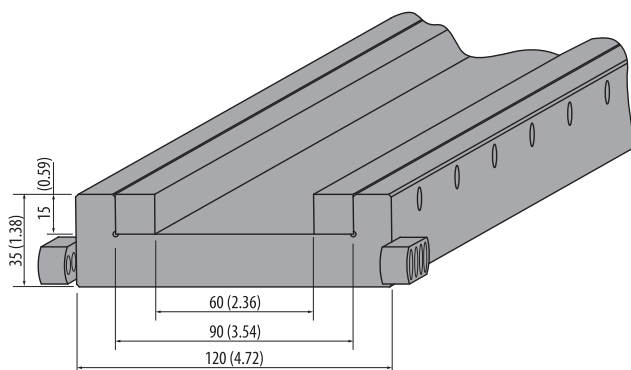


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



C45: 560-710 N/mm²

C 1050-90



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

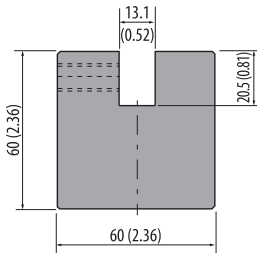


C45: 560-710 N/mm²

AD5

1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

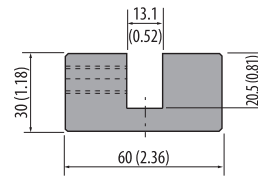
C45: 560-710 N/mm²



AD6

1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

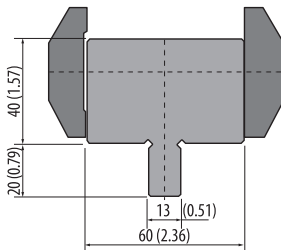
C45: 560-710 N/mm²



AD7

1000 kN/m max.

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



Rolleri Type R2/R3
→ Rolleri Type R1

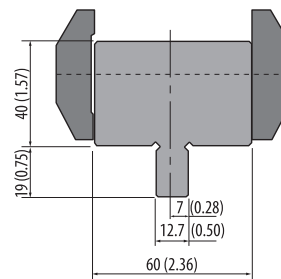
C45: 560-710 N/mm²



AD9-12.7

1000 kN/m max.

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



Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



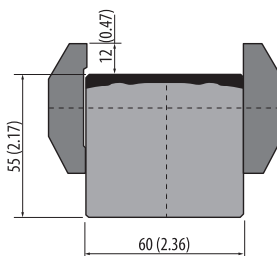
Do you have queries about
delivery times, visits from
one of our representatives,
and other possibilities?
Give us a call!

Die Extensions

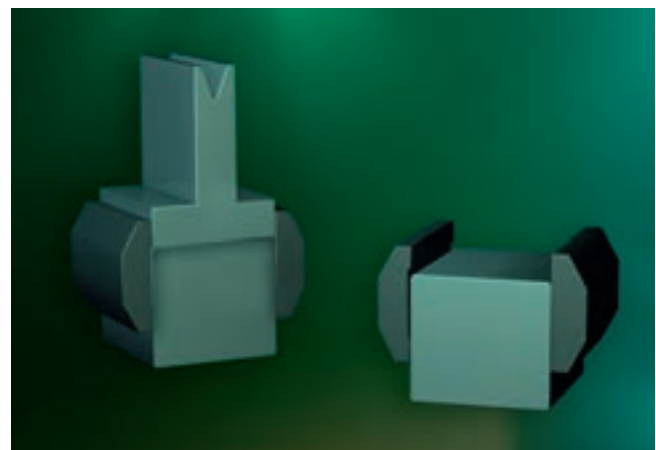
CTS60

1000 kN/m max.

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



C45: 560-710 N/mm²



Article
on stock

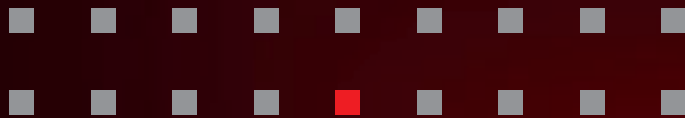


Please ask for
delivery time!

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



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



R2

Compatibility

Punches Rolleri Type R2 are **compatible** with press brakes:

- LVD
- Safan
- Trumpf
- press brake machines with System NSCL (New Standard Clamping)
- Darley

With the use of adapters Rolleri R2 type punches can be mounted in other press brake models.

PUNCHES ROLLER TYPE R2

Content Explanation	86 - 88
90° Punches	89
86° Punches	89 - 91
80° Punches	91
60° Punches	92
28° Punches	93 - 94
28°/24° Hemming Tools	95
Joggle Tools	96
Radius Tools	97 - 98
Punch Extensions	99
Punch Adapters	99

Compatibility

Punches Rolleri Type R2 are:

- **compatible** with press brakes: LVD, Trumpf, Darley, Safan or on press brakes with System NSCL (New Standard Clamping)
- also applicable on all other press brakes **with adapters** (see page 228)

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 264-265)
- very large stock availability

Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

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

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

Tang

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

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

ATTENTION:

QuickLock

By default, all tools are delivered with the QuickLock system, provided that these weigh less than 12.5 kg. This applies to most sectioned tools and to some standard length tools.

If you prefer the QuickLock-System on tools that weigh more than 12.5 kg, it is possible to section the tool for a small surcharge.

Safety Pins

All tools that weigh more than 12.5 kg, are delivered by default with safety pins. This applies to all standard tool lengths and some segmented tools.

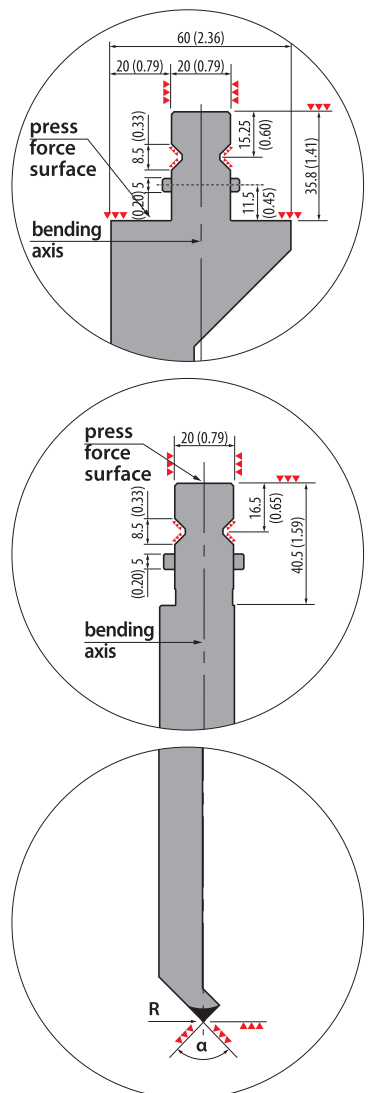
ROL1-System

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!

Rolleri punches are either head-bearing or shoulder-bearing.

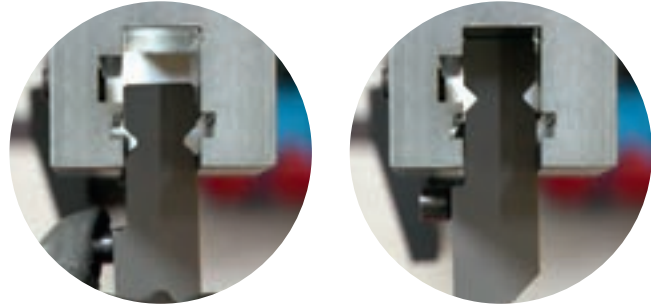
Indications of precision ground surfaces:



■ Clamping Systems

QuickLock (Standard)

- vertical tool change
- easy handling
- substantial improvement in time consumption and related costs
- applicable on tools < 12.5 kg
- applicable on tools > 12.5 kg through special sectioning



QuickLock



3
R2



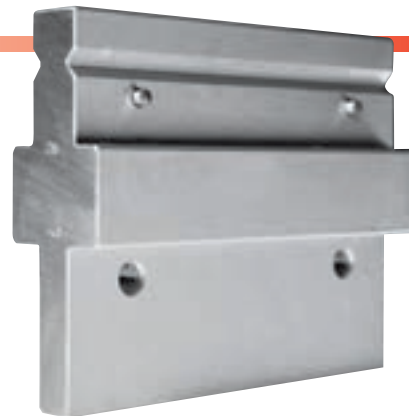
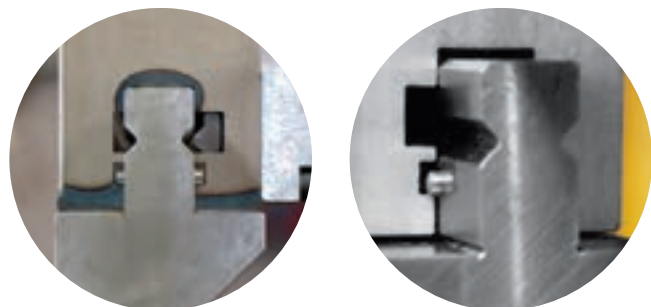
Rolleri Videos

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



Safety Pins (Standard)

- horizontal tool change



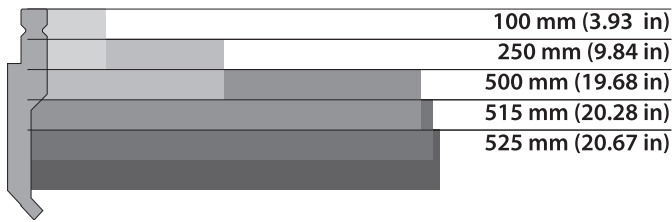
ROL1-System

- vertical tool change through spring-loaded ball bearings, which are mounted in the punch
- increased longevity
- easy handling
- to be used in hardened clamping systems only
- applicable on tools < 12.5 kg

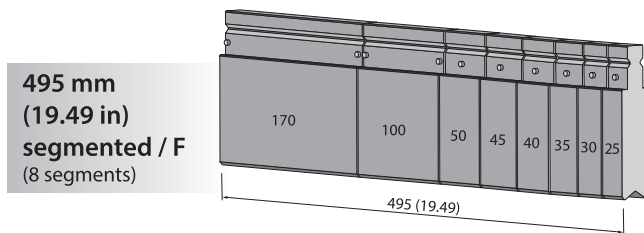
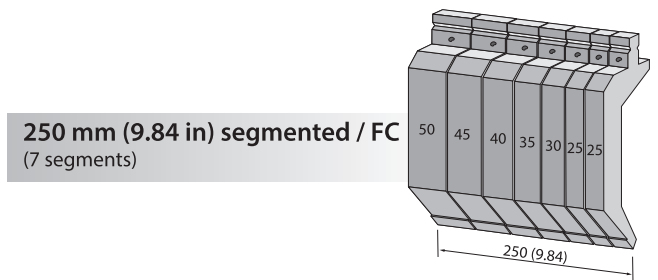
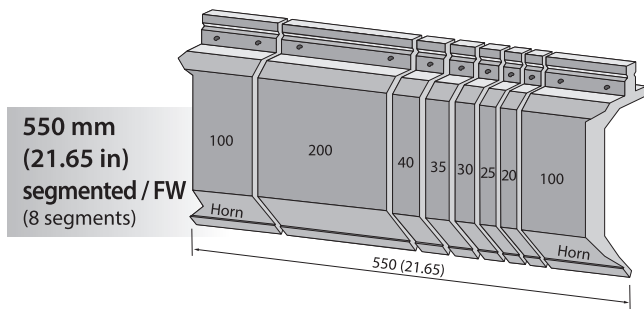


Tool Lengths and Sectioning

Standard



More lengths and sectionings are possible upon request.



Segmented tools are delivered in complete sets. More lengths and sectionings are possible upon request.

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

available on request

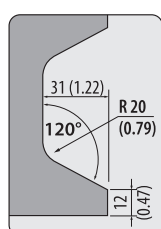
Sectioning FB

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

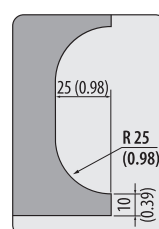
Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94) Horn l.	100 (3.94) Horn r.	100 (3.94)	200 (7.87)	300 (11.81)
1250 (49.21)	2	1	1	1	1	1	1	1	1	2	1
2050 (80.71)	2	1	1	1	1	1	1	1	1	3	3
2550 (100.39)	2	1	1	1	1	1	1	1	1	4	4
3050 (120.08)	2	1	1	1	1	1	1	1	1	5	5
4050 (159.45)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

available on request

Horn Types



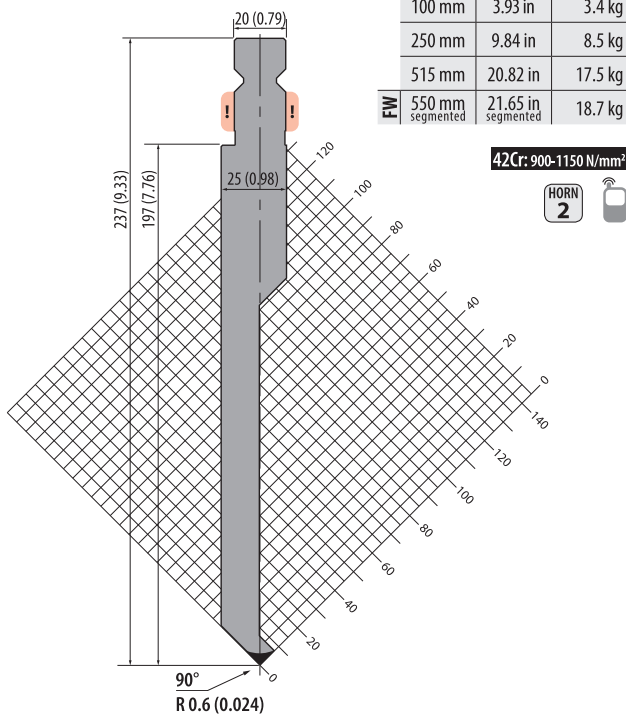
HORN 1 Horn 1
Standard for all segmented Punches Roller Type R2



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

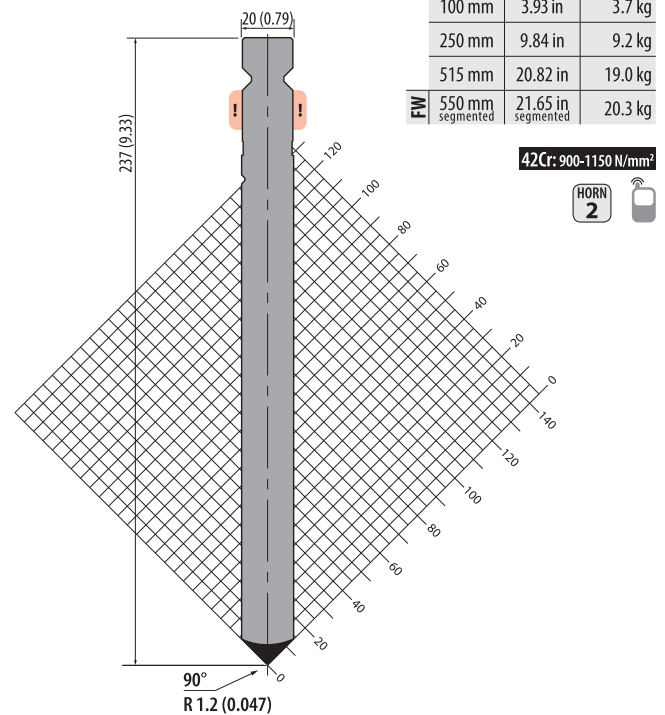
TPR237.90.R06

600 kN/m max.



TPR237.90.R12

1000 kN/m max.

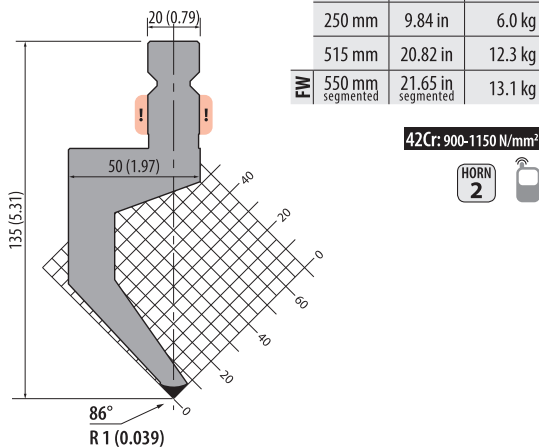


3
R2

86° Punches

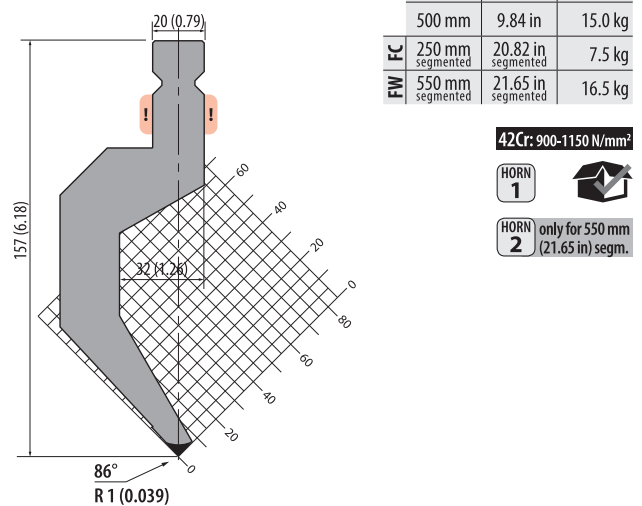
TPR135.86.R1

650 kN/m max.



TPR157.86.R1

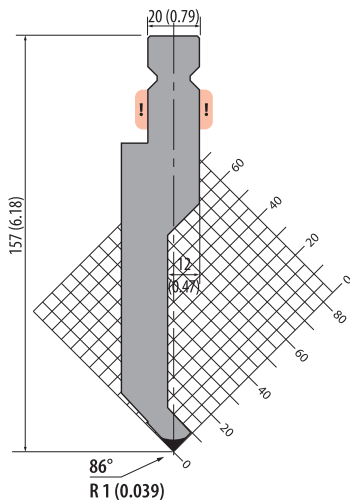
800 kN/m max.



Please choose the clamping system!
Standard equipment:
< 12.5 kg QuickLock
> 12.5 kg safety pins
Also available: ROL1-System see pages 86-87 for more information.

TPR157.86.R1-A

800 kN/m max.



	100 mm	3.93 in	2.5 kg
	500 mm	9.84 in	12.5 kg
FW	250 mm segmented	20.82 in segmented	6.3 kg
FC	550 mm segmented	21.65 in segmented	13.8 kg

42Cr: 900-1150 N/mm²

HORN 1

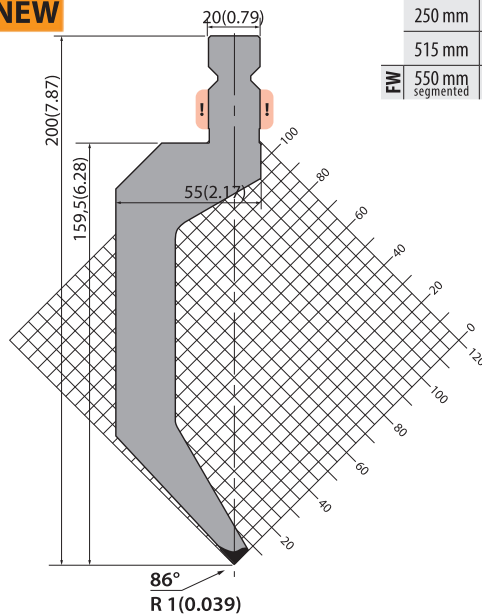


HORN 2 only for 550 mm (21.65 in) segm.

TPR200.86.R1

500 kN/m max.

NEW



	100 mm	3.93 in	3.7 kg
	250 mm	9.84 in	9.2 kg
	515 mm	20.82 in	19.1 kg
FW	550 mm segmented	21.65 in segmented	20.4 kg

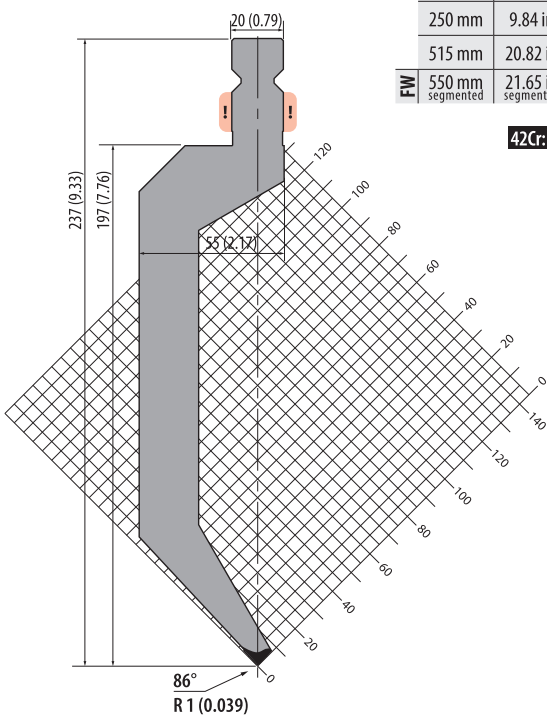
42Cr: 900-1150 N/mm²

HORN 2



TPR237.86.R1

500 kN/m max.



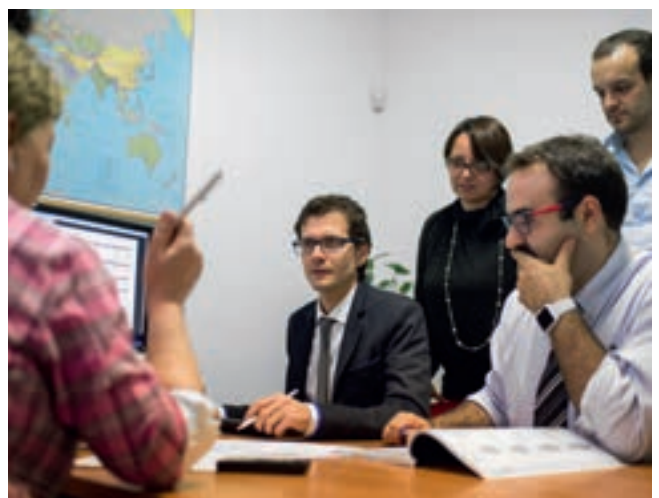
	100 mm	3.93 in	4.5 kg
	250 mm	9.84 in	11.2 kg
	515 mm	20.82 in	23.0 kg
FW	550 mm segmented	21.65 in segmented	24.6 kg

42Cr: 900-1150 N/mm²

HORN 2



Please choose the clamping system!
Standard equipment:
 < 12.5 kg QuickLock
 > 12.5 kg safety pins
 Also available: ROL1-System see pages 86-87 for more information.



TPR256.86.R1

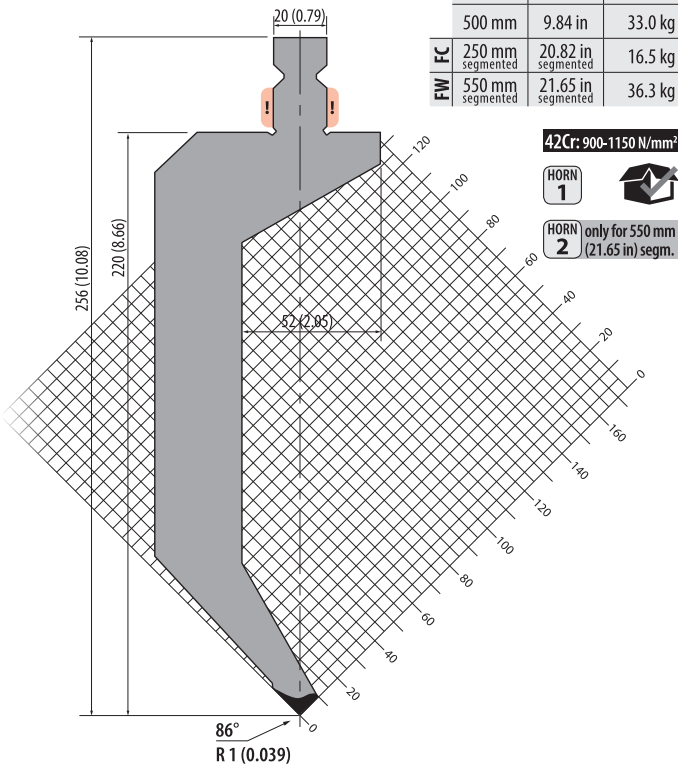
800 kN/m max.

	100 mm	3.93 in	6.6 kg
	500 mm	9.84 in	33.0 kg
FW FC	250 mm segmented	20.82 in segmented	16.5 kg
	550 mm segmented	21.65 in segmented	36.3 kg

42Cr: 900-1150 N/mm²



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



TPR256.86.R1-A

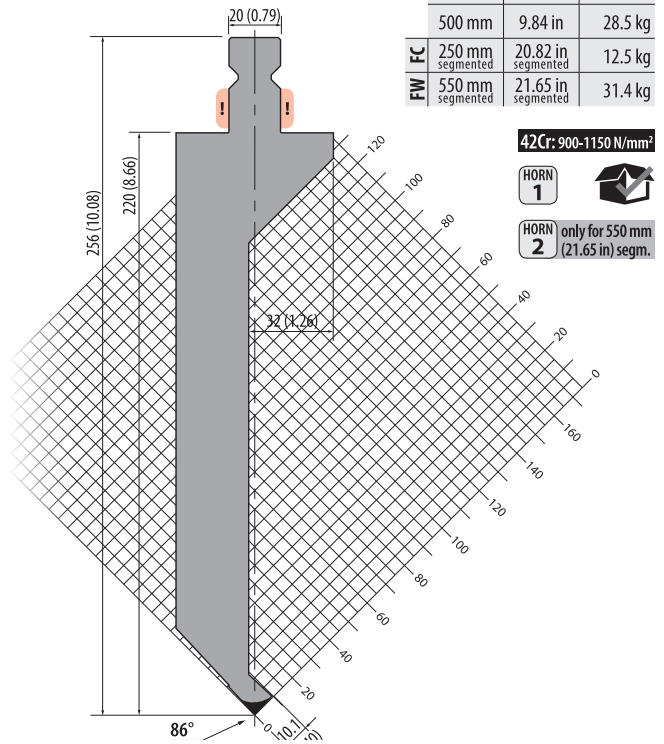
800 kN/m max.

	100 mm	3.93 in	4.7 kg
	500 mm	9.84 in	28.5 kg
FW FC	250 mm segmented	20.82 in segmented	12.5 kg
	550 mm segmented	21.65 in segmented	31.4 kg

42Cr: 900-1150 N/mm²



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



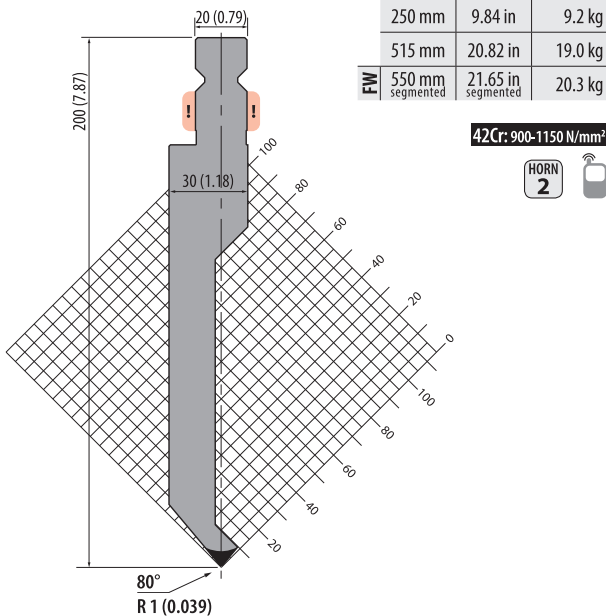
80° Punches

TPR200.80.R1

800 kN/m max.

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

42Cr: 900-1150 N/mm²

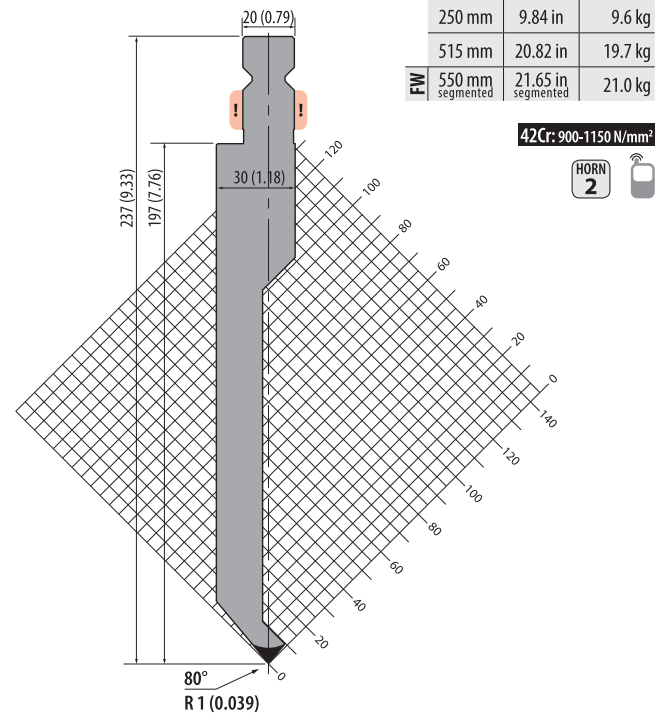


TPR237.80.R1

800 kN/m max.

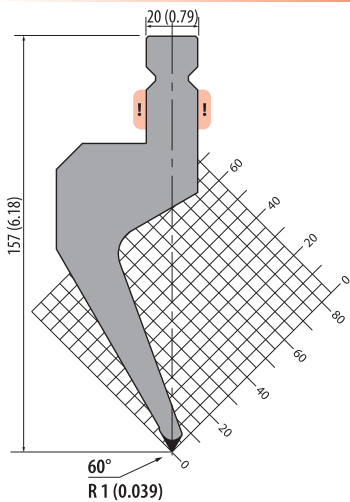
	100 mm	3.93 in	3.8 kg
	250 mm	9.84 in	9.6 kg
	515 mm	20.82 in	19.7 kg
FW	550 mm segmented	21.65 in segmented	21.0 kg

42Cr: 900-1150 N/mm²



TPR157.60.R1

700 kN/m max.



	100 mm	3.93 in	3.0 kg
	500 mm	9.84 in	15.0 kg
FW	250 mm segmented	20.82 in segmented	7.5 kg
FC	550 mm segmented	21.65 in segmented	16.5 kg

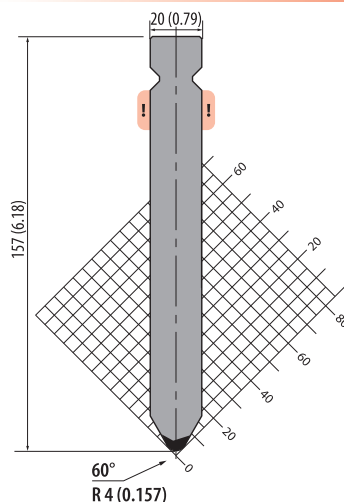
42Cr: 900-1150 N/mm²



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

TPR157.60.R4

1300 kN/m max.



	100 mm	3.93 in	2.4 kg
	500 mm	9.84 in	12.0 kg
FW	250 mm segmented	20.82 in segmented	6.0 kg
FC	550 mm segmented	21.65 in segmented	13.2 kg

42Cr: 900-1150 N/mm²

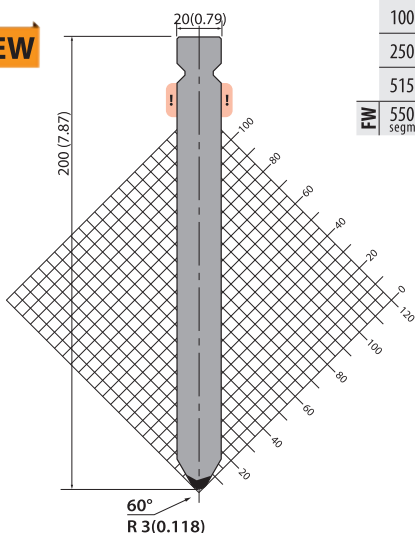


HORN 2 only for 550 mm (21.65 in) segm.

TPR200.60.R3

1300 kN/m max.

NEW



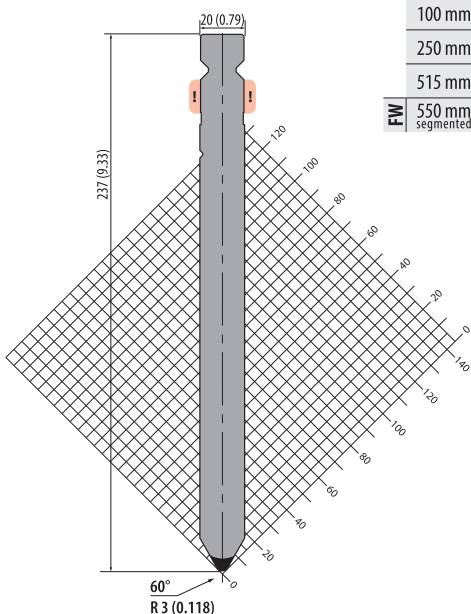
	100 mm	3.93 in	3.0 kg
	250 mm	9.84 in	7.6 kg
	515 mm	20.82 in	15.6 kg
FW	550 mm segmented	21.65 in segmented	16.7 kg

42Cr: 900-1150 N/mm²



TPR237.60.R3

1300 kN/m max.



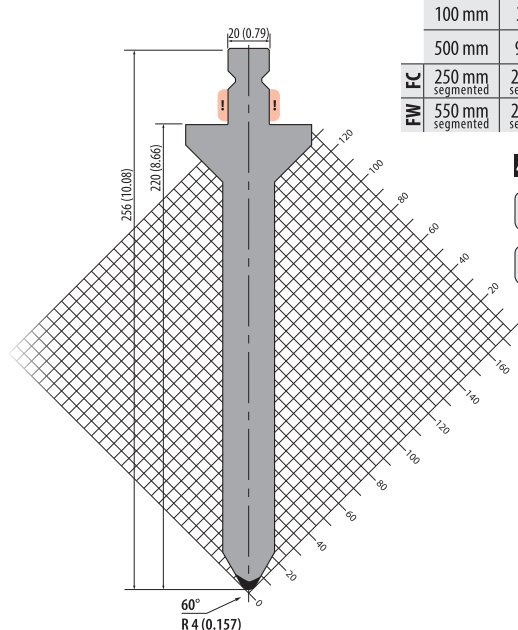
	100 mm	3.93 in	3.6 kg
	250 mm	9.84 in	9.1 kg
	515 mm	20.82 in	18.8 kg
FW	550 mm segmented	21.65 in segmented	20.1 kg

42Cr: 900-1150 N/mm²



TPR256.60.R4

1300 kN/m max.



	100 mm	3.93 in	5.2 kg
	500 mm	9.84 in	26.1 kg
FW	250 mm segmented	20.82 in segmented	13.5 kg
FC	550 mm segmented	21.65 in segmented	28.7 kg

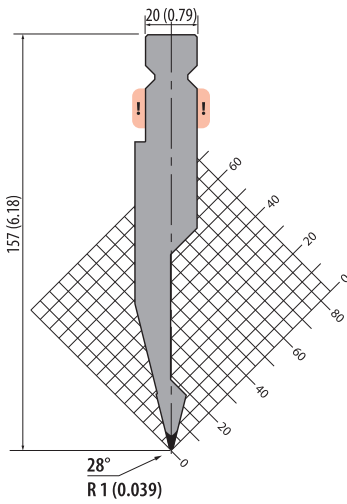
42Cr: 900-1150 N/mm²



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

TPR157.28.R1

600 kN/m max.



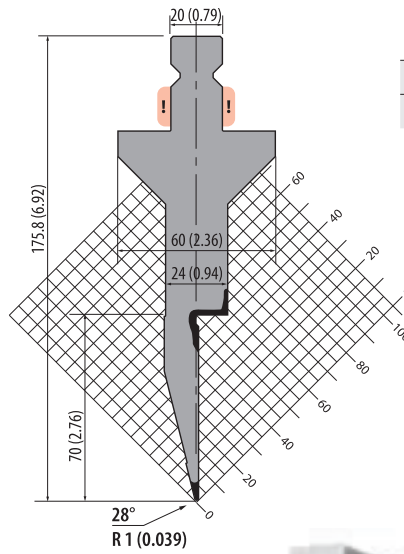
	100 mm	3.93 in	2.0 kg
	500 mm	9.84 in	10.0 kg
FW FC	250 mm segmented	20.82 in segmented	5.0 kg
FW FC	550 mm segmented	21.65 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

- HORN 1**
- HORN 2** only for 550 mm (21.65 in) segm.

TPR176.28.R1

400 kN/m max.



	100 mm	3.93 in	3.0 kg
	500 mm	9.84 in	15.0 kg
FW FC	250 mm segmented	20.82 in segmented	7.5 kg
FW FC	550 mm segmented	21.65 in segmented	16.5 kg

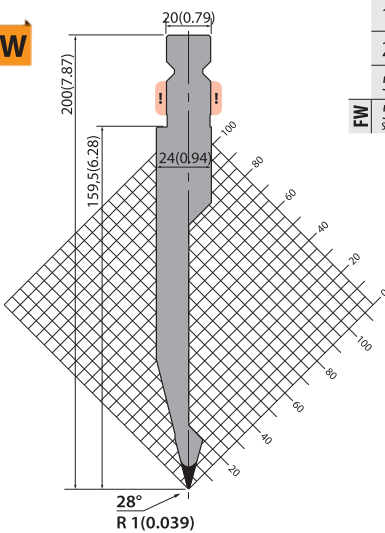
42Cr: 900-1150 N/mm²

- HORN 1**
- HORN 2** only for 550 mm (21.65 in) segm.

TPR200.28.R1

600 kN/m max.

NEW



	100 mm	3.93 in	2.4 kg
	250 mm	9.84 in	6.1 kg
	515 mm	20.82 in	12.6 kg
FW	550 mm segmented	21.65 in segmented	13.5 kg

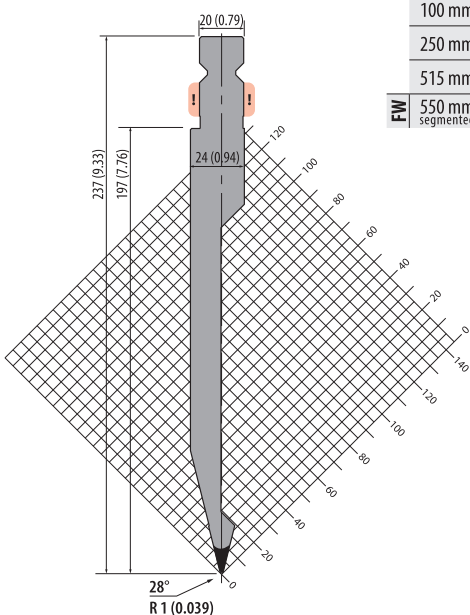
42Cr: 900-1150 N/mm²

- HORN 2**



TPR237.28.R1

600 kN/m max.



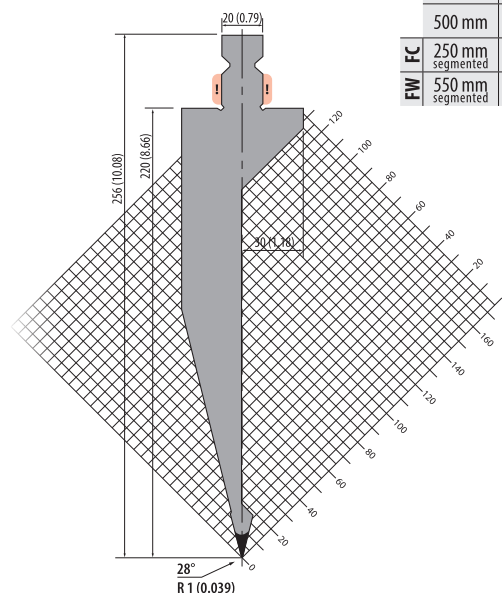
	100 mm	3.93 in	2.9 kg
	250 mm	9.84 in	7.3 kg
	515 mm	20.82 in	15.0 kg
FW	550 mm segmented	21.65 in segmented	16.0 kg

42Cr: 900-1150 N/mm²

- HORN 2**

TPR256.28.R1

600 kN/m max.



	100 mm	3.93 in	5.0 kg
	500 mm	9.84 in	25.0 kg
FW FC	250 mm segmented	20.82 in segmented	5.0 kg
FW FC	550 mm segmented	21.65 in segmented	27.5 kg

42Cr: 900-1150 N/mm²

- HORN 1**
- HORN 2** only for 550 mm (21.65 in) segm.



Article on stock



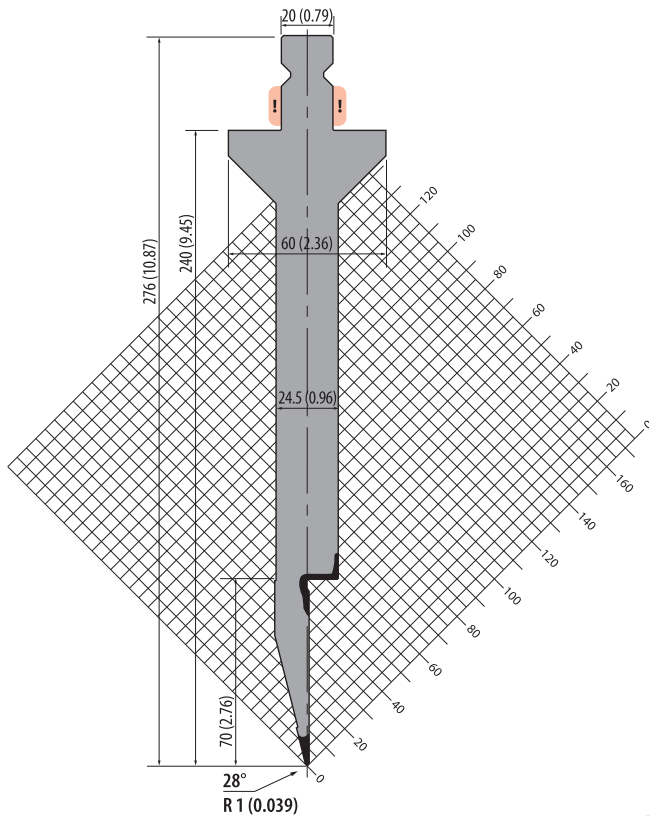
Please ask for delivery time!

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



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

TPR276.28.R1



400 kN/m max.

	100 mm	3.93 in	4.8 kg
	500 mm	9.84 in	24.0 kg
FW	250 mm segmented	20.82 in segmented	12.0 kg
FC	550 mm segmented	21.65 in segmented	26.4 kg

42Cr: 900-1150 N/mm²

HORN 1



HORN 2

only for 550 mm (21.65 in) segm.

Please choose the clamping system!
Standard equipment:
 < 12.5 kg QuickLock
 > 12.5 kg safety pins
 Also available: ROL1-System see pages 86-87 for more information.



Take advantage of the wide range of Rolleri R1 Type punches by using an adapter. See pages 226-231

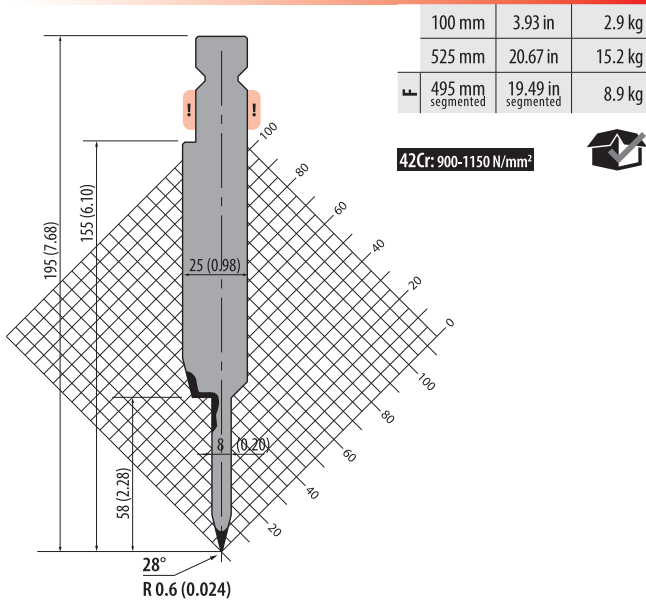


Rolleri Videos

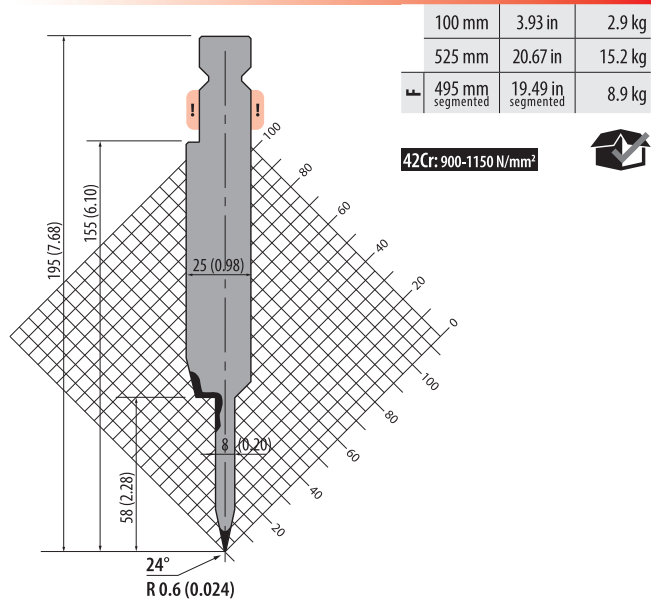
find updated and helpful videos at:
www.rolleritools.com/videos/overview



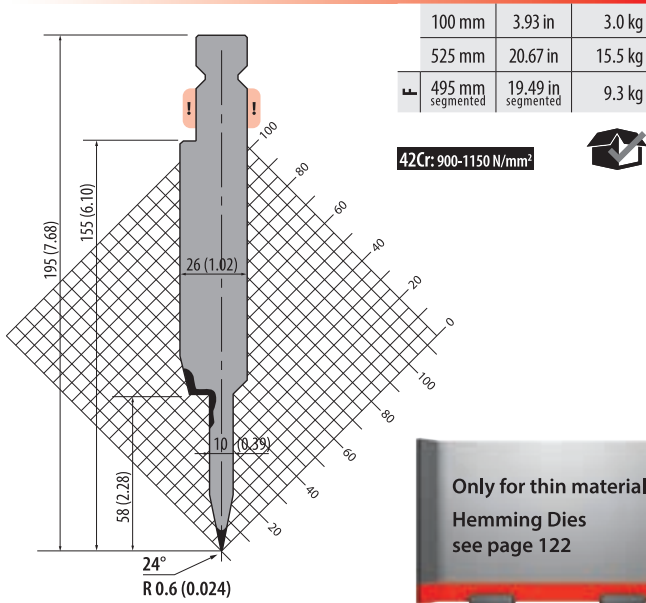
TPR.SP.195.28.8



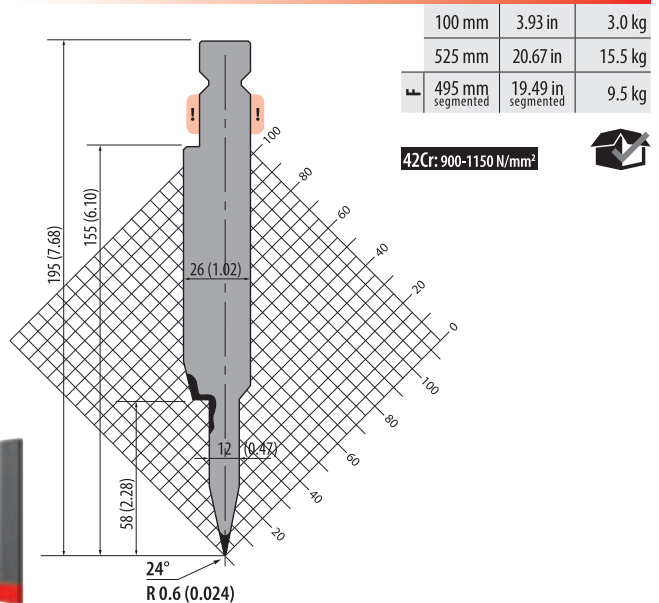
TPR.SP.195.24.8



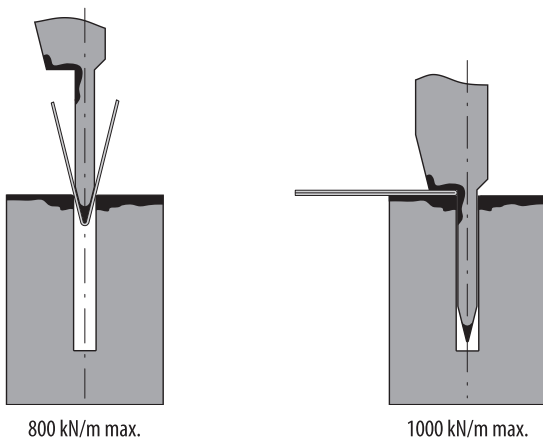
TPR.SP.195.24.10



TPR.SP.195.24.12



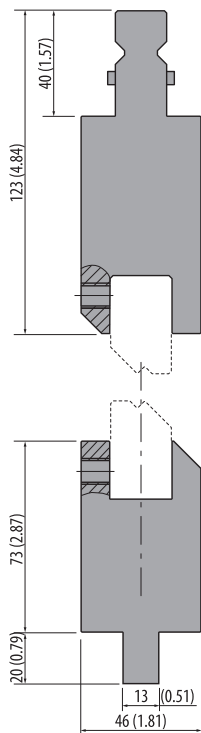
Example of application



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	kN/mm ²	mm	in	mm	in	kN/mm ²	kN/mm ²
				t/m	t/m					t/m	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

TPZ

1000 kN/m max.



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

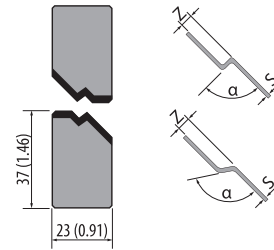
C45: 560-710 N/mm²



Joggle Tool Inserts 160° / 150° / 140° / 90°

1000 kN/m max.

C45: 560-710 N/mm²



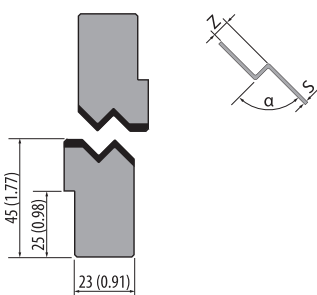
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°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

* Fe Rmax = 42 Kg/mm²

Please choose the clamping system!
Standard equipment:
< 12.5 kg QuickLock
> 12.5 kg safety pins
Also available: ROL1-System see pages 86-87 for more information.

Joggle Tool Inserts 90°

1000 kN/m max.



C45: 560-710 N/mm²



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



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

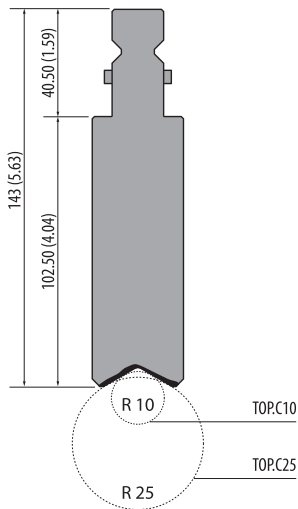
* Fe Rmax = 42 Kg/mm²

* Fe Rmax = 42 Kg/mm²



TPR143.10

1000 kN/m max.



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

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

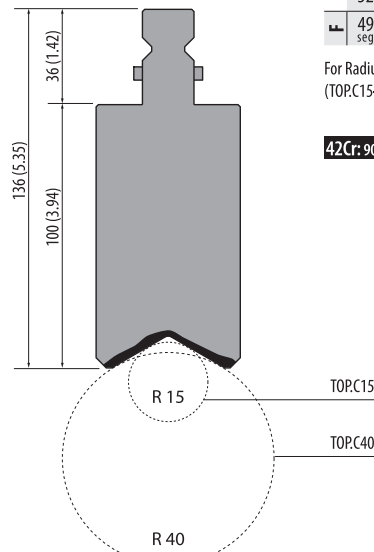
42Cr: 900-1150 N/mm²



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
F	495 mm segmented	19.49 in segmented	23.7 kg

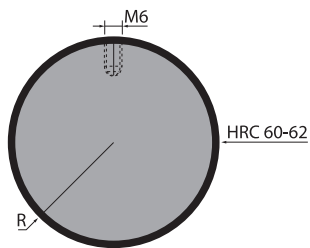
For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm²



Radius punches: R10-40

1000 kN/m max.



Material C53
induction hardened
60-62 HRC

Rolleri radius tools are on stock in sectioned version too! Take advantage of our tool availability!



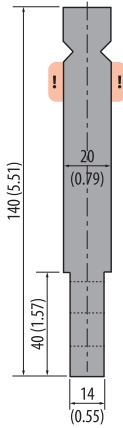
C53: 610-760 N/mm²

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.C22.5	22.5	0.88	6.6 kg	7.5 kg
TOP.C25	25	0.98	8.1 kg	11.3 kg
TOP.C27.5	27.5	1.08	9.8 kg	15.1 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C32.5	32.5	1.28	13.7 kg	12.9 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C37.5	37.5	1.47	18.2 kg	17.2 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg



TPR140-14

800 kN/m max.



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

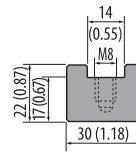
For Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see below

C45: 560-710 N/mm²



E30.22

800 kN/m max.



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

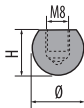
Hemming tool

C45: 560-710 N/mm²



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

800 kN/m max.



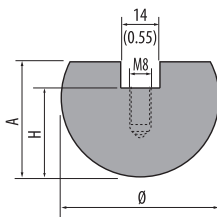
C45: 560-710 N/mm²



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

Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.



C45: 560-710 N/mm²



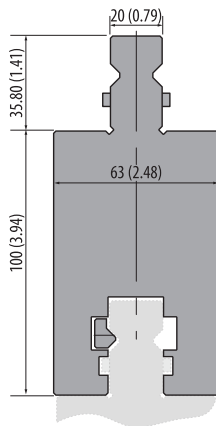
Model	Ø (mm)	H (mm)	A (mm)	Weight	Weight
C17.12	25	17	22	2.5 kg	1.2 kg
C20.15	30	20	27	3.7 kg	1.8 kg
C22.17	35	22	32	5.0 kg	2.4 kg
C24.20	40	24	34	7.0 kg	3.5 kg
C25.22	45	25	35	7.5 kg	3.8 kg
C29.25	50	29	39	10.0 kg	4.7 kg
C34.27	55	34	44	12.4 kg	6.2 kg
C34.30	60	34	44	13.5 kg	6.7 kg
C37.32	65	37	47	15.9 kg	7.9 kg
C45.35	70	45	55	20.3 kg	10.0 kg
C42.37	75	42	52	20.5 kg	10.3 kg
C45.40	80	45	55	23.0 kg	11.5 kg
C60.45	90	60	70	34.0 kg	17.0 kg
C70.50	100	70	80	43.5 kg	21.7 kg

AD21

1500 kN/m max.

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



3
R2

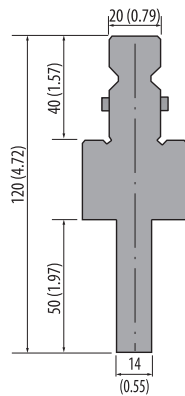
Punch Adapters

AD11

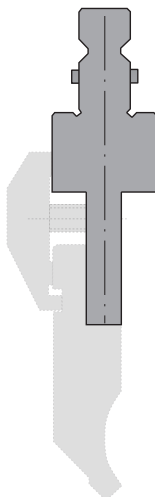
1000 kN/m max.

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



Example of application



For more Adapters
see pages 226-231



Article
on stock

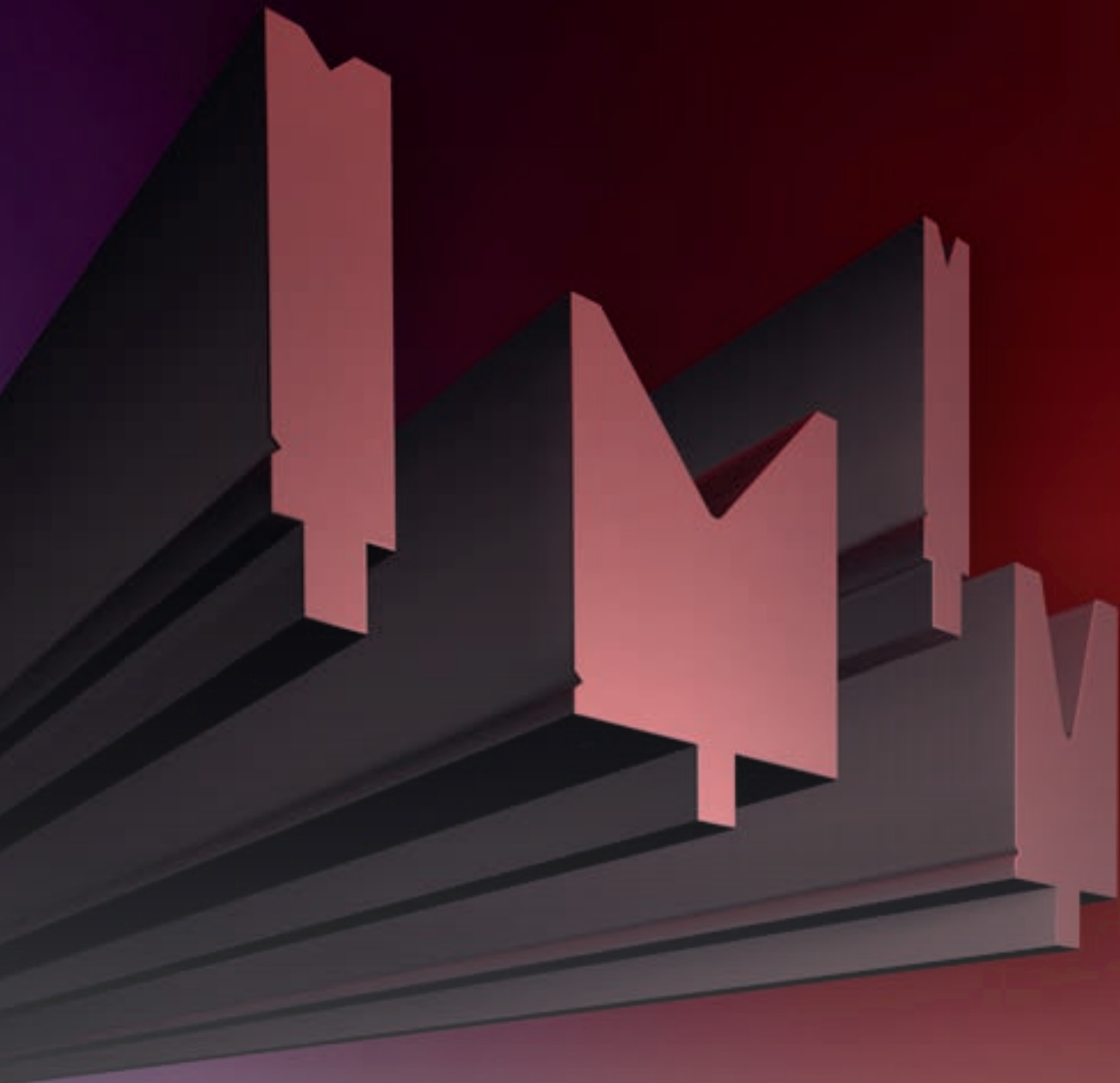
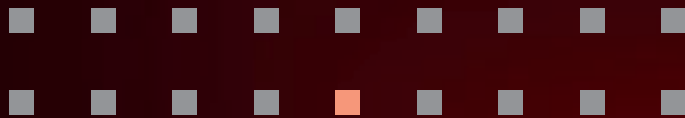


Please ask for
delivery time!

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



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



R2

Compatibility

Dies Rolleri Type R2 are **compatible** with press brakes:

- Bystronic-Beyeler
- Trumpf
- Safan
- Darley
- SMD
- Press brake machines with System NSCR

With the use of adapters Rolleri R2 type dies can be mounted in other press brake models.

DIES ROLLER TYPE R2

Content Explanation	102 - 103
Dies H=55 (2.17) - 85 (3.35)	104 - 105
90° dies, H=100 mm (3.94)	106
86° dies, H=100 mm (3.94)	106 - 108
84° dies, H=100 mm (3.94)	108 - 109
80° dies, H=100 mm (3.94)	110
60° dies, H=120 mm (4.72)	111
30° dies, H=100 mm (3.94)	111 - 113
86° dies, H=150 mm (5.91)	114 - 115
84° dies, H=150 mm (5.91)	115 - 116
80° dies, H=150 mm (5.91)	117
30° dies, H=150 mm (5.91)	118 - 119
Die adapters	120
Synthetic dies, H=100 mm (3.94)	121
Hemming dies	122 - 123

Compatibility

Dies Roller Type R2 are:

- **compatible** with press brakes with 13 x 20 mm (0.51 x 0.79 in) groove in the table:
Bystronic-Beyeler, Safan, SMD, Trumpf, Darley, press brake machines with System NSCR
- also applicable on all other press brake machines **with adapters and die holders** (see pages 232-235).

Material

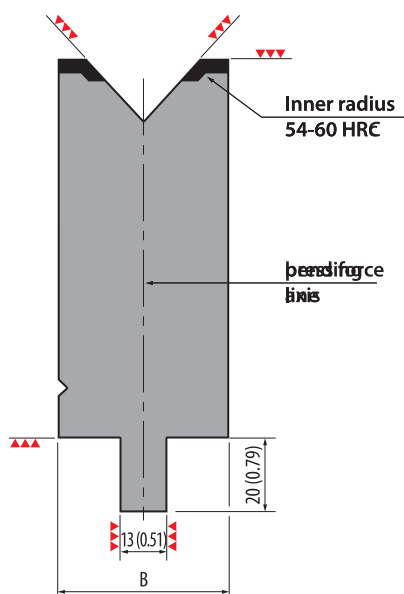
Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

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

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

Tang

All Roller Type R2 type dies are equipped with **13 x 20 mm (0.51 x 0.79 in) tang**



Indications of precision ground surfaces:



Our Advantages – Your Convenience

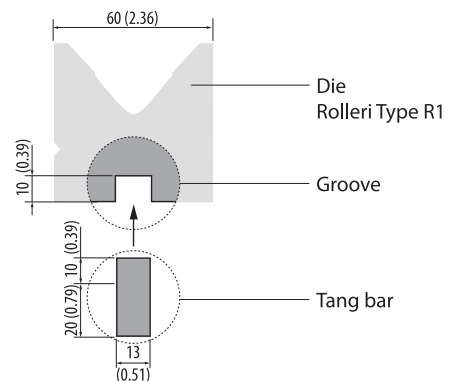
- own production facilities (no reseller or dealer)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 268-269)
- very large stock availability

Modification: tang bar

To use Roller Type R1 dies, a 10 mm (0.39 in) groove is milled where a ground bar is mounted.

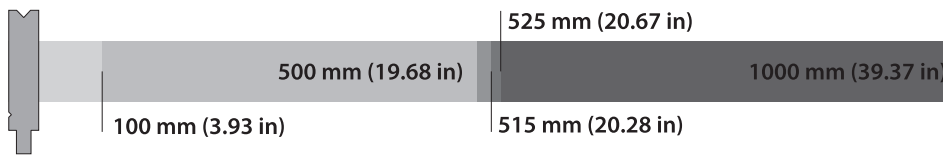
For more specific information and prices go to page 268 in the Modification Chapter.

A30 (Mounting example)



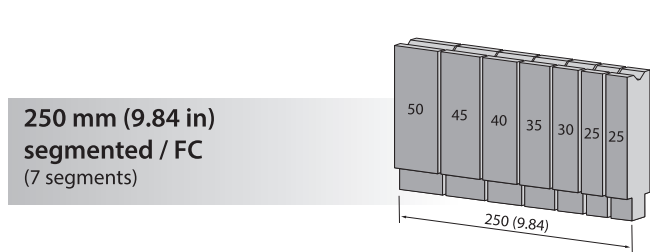
Tool lengths and sectioning

Standard

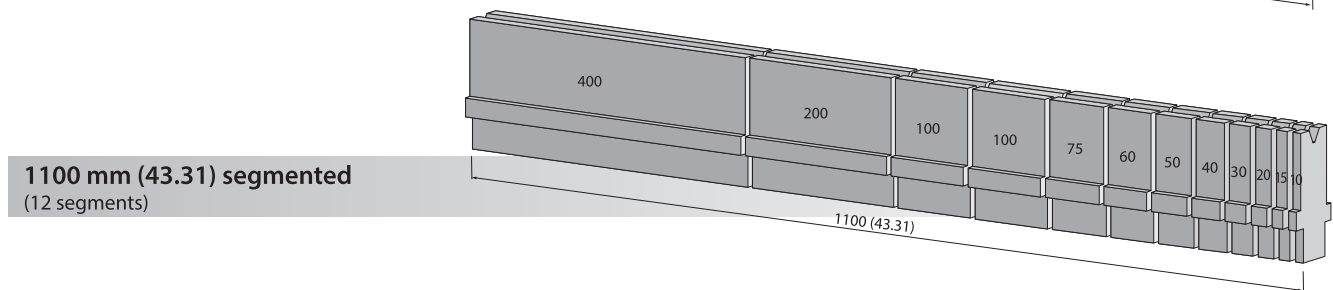


More lengths and sectionings are possible upon request.

4
R2



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



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

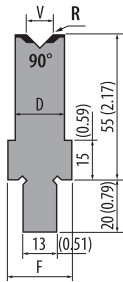
available on request

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

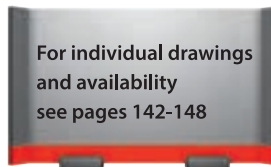
available on request

90° dies, H=55 (2.17)

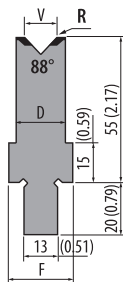


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in	Weight	500 mm / 19.68 in	Weight	1100 mm / 43.31 in segmented	Weight
BMR55.06.90	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg			
BMR55.08.90	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg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

42Cr: 900-1150 N/mm²



88° dies, H=55 (2.17)

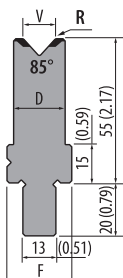


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in	Weight	500 mm / 19.68 in	Weight	1100 mm / 43.31 in segmented	Weight
BMR55.06.88	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg			
BMR55.08.88	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg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

42Cr: 900-1150 N/mm²



85° dies, H=55 (2.17)

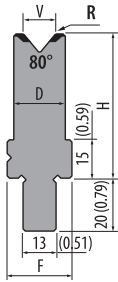


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in	Weight	500 mm / 19.68 in	Weight	1100 mm / 43.31 in segmented	Weight
BMR55.06.85	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg			
BMR55.08.85	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg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

42Cr: 900-1150 N/mm²



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



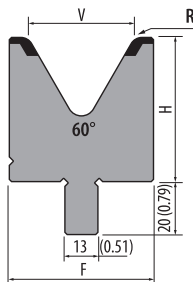
Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	H (mm)	H (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.06.80	6	0.24	0.4	0.02	15	0.59	55	2.17	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg
BMR55.08.80	8	0.31	0.5	0.02	15	0.59	55	2.17	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg
BMR55.10.80	10	0.39	1.0	0.04	20	0.79	55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

42Cr: 900-1150 N/mm²



4
R2

60° dies, H=55 (2.17) / H=65 (2.56)

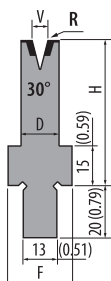


Model	V (mm)	V (in)	R (mm)	R (in)	H (mm)	H (in)	F (mm)	F (in)	kN/m max.	Weight	Weight	Weight
BMR55.40.60	40	1.57	5.0	0.20	55	2.17	55	2.17	1300	20.3 kg	10.5 kg	22.3 kg
BMR55.50.60	50	1.97	5.0	0.20	55	2.17	70	2.76	1200	25.0 kg	12.0 kg	21.0 kg
BMR65.60.60	60	2.36	7.0	0.28	65	2.56	80	3.15	1100	31.0 kg	15.5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

42Cr: 900-1150 N/mm²



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



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

42Cr: 900-1150 N/mm²

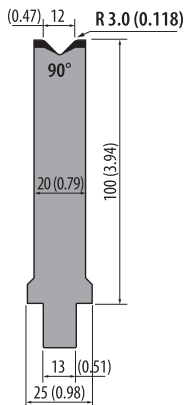


R2

ROLLERS TYPE R2 90° dies, H=100 (3.94)

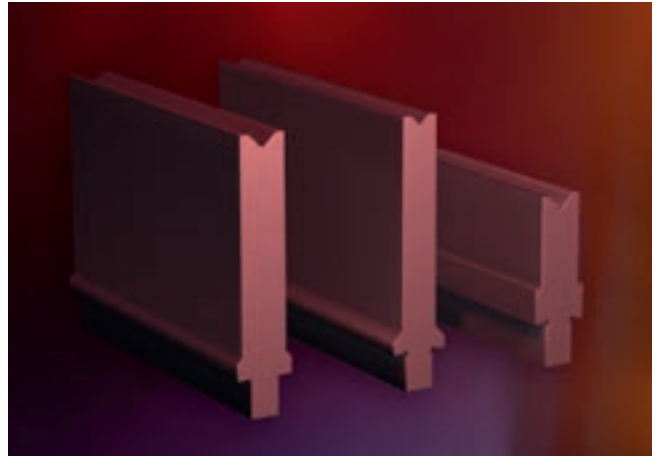
WMR100.12.90

1200 kN/m max.



	100 mm	3.94 in	1.7 kg
	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

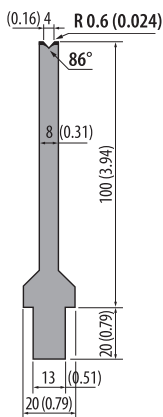
42Cr: 900-1150 N/mm²



86° dies, H=100 (3.94)

TMR100.04.86

250 kN/m max.



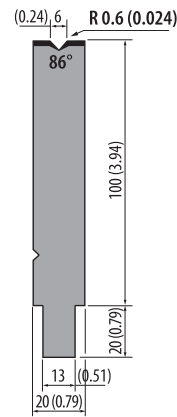
	100 mm	3.94 in	1.0 kg
	500 mm	19.68 in	4.8 kg
FW FC	250 mm segmented	9.84 in segmented	2.4 kg
FW	550 mm segmented	21.65 in segmented	5.2 kg

42Cr: 900-1150 N/mm²



TMR100.06.86

1200 kN/m max.



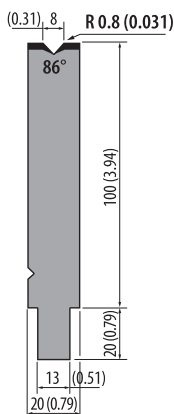
	100 mm	3.94 in	1.8 kg
	500 mm	19.68 in	8.9 kg
FW FC	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.7 kg

42Cr: 900-1150 N/mm²



TMR100.08.86

1150 kN/m max.



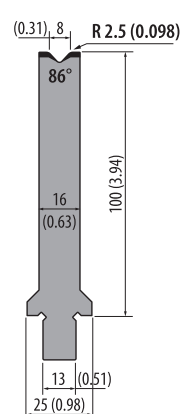
	100 mm	3.94 in	1.8 kg
	500 mm	19.68 in	8.8 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



WMR100.08.86

400 kN/m max.



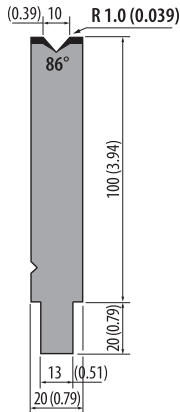
	100 mm	3.94 in	1.5 kg
	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



TMR100.10.86

1100 kN/m max.



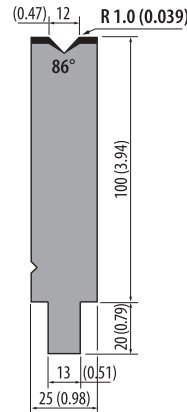
	100 mm	3.94 in	1.8 kg
	500 mm	19.68 in	8.8 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



TMR100.12.86

1200 kN/m max.



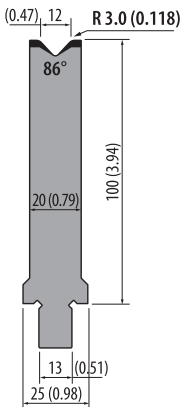
	100 mm	3.94 in	2.1 kg
	500 mm	19.68 in	10.7 kg
FC	250 mm segmented	9.84 in segmented	5.0 kg
FW	550 mm segmented	21.65 in segmented	11.7 kg

42Cr: 900-1150 N/mm²



WMR100.12.86

1200 kN/m max.



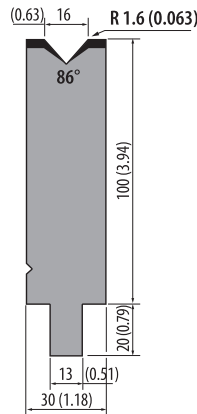
	100 mm	3.94 in	1.7 kg
	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



TMR100.16.86

1200 kN/m max.



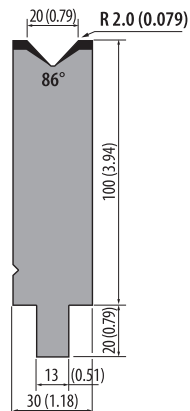
	100 mm	3.94 in	2.5 kg
	500 mm	19.68 in	12.5 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
FW	550 mm segmented	21.65 in segmented	13.8 kg

42Cr: 900-1150 N/mm²



TMR100.20.86

1150 kN/m max.



	100 mm	3.94 in	2.4 kg
	500 mm	19.68 in	12.2 kg
FC	250 mm segmented	9.84 in segmented	6.2 kg
FW	550 mm segmented	21.65 in segmented	13.5 kg

42Cr: 900-1150 N/mm²

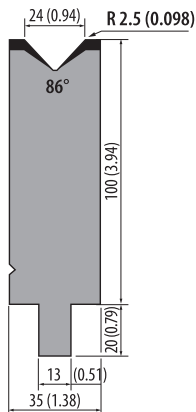


R2

ROLLERI TYPE R2 86° dies, H=100 (3.94)

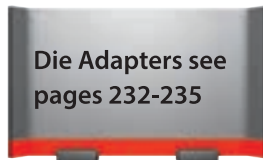
TMR100.24.86

1200 kN/m max.



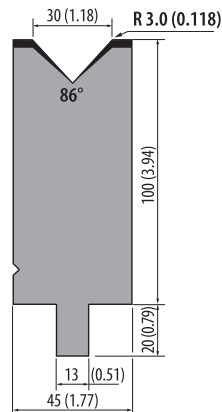
	100 mm	3.94 in	2.8 kg
	500 mm	19.68 in	14.0 kg
FC	250 mm segmented	9.84 in segmented	7.0 kg
FW	550 mm segmented	21.65 in segmented	15.5 kg

42Cr: 900-1150 N/mm²



TMR100.30.86

1200 kN/m max.



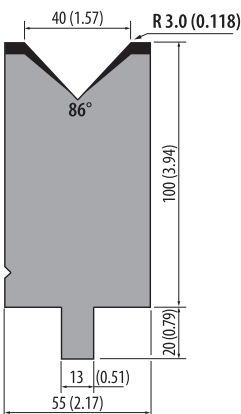
	100 mm	3.94 in	3.5 kg
	500 mm	19.68 in	17.6 kg
FC	250 mm segmented	9.84 in segmented	8.8 kg
FW	550 mm segmented	21.65 in segmented	19.4 kg

42Cr: 900-1150 N/mm²



TMR100.40.86

1200 kN/m max.



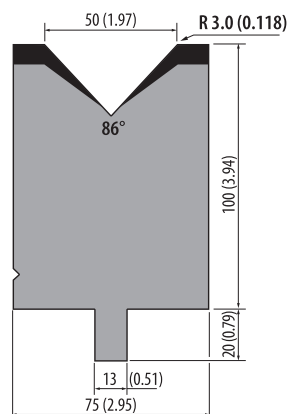
	100 mm	3.94 in	4.1 kg
	500 mm	19.68 in	20.8 kg
FC	250 mm segmented	9.84 in segmented	10.4 kg
FW	550 mm segmented	21.65 in segmented	22.8 kg

42Cr: 900-1150 N/mm²



TMR100.50.86

1500 kN/m max.



	100 mm	3.94 in	5.6 kg
	500 mm	19.68 in	27.8 kg
FC	250 mm segmented	9.84 in segmented	13.9 kg
FW	550 mm segmented	21.65 in segmented	30.5 kg

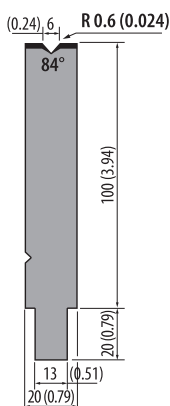
42Cr: 900-1150 N/mm²



84° dies, H=100 (3.94)

TMR100.06.84

1200 kN/m max.



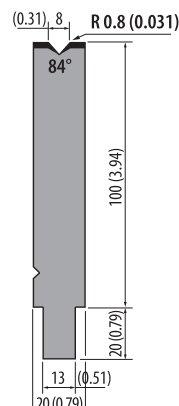
	100 mm	3.94 in	1.8 kg
	500 mm	19.68 in	8.8 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	8.8 kg

42Cr: 900-1150 N/mm²



TMR100.08.84

1150 kN/m max.



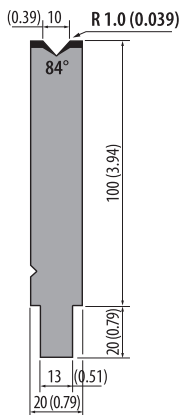
	100 mm	3.94 in	1.8 kg
	500 mm	19.68 in	8.8 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.7 kg

42Cr: 900-1150 N/mm²



TMR100.10.84

1100 kN/m max.



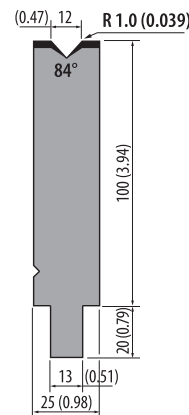
	100 mm	3.94 in	1.8 kg
	500 mm	19.68 in	8.8 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



TMR100.12.84

1200 kN/m max.



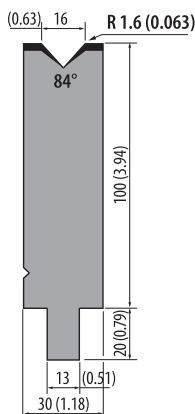
	100 mm	3.94 in	2.1 kg
	500 mm	19.68 in	10.7 kg
FC	250 mm segmented	9.84 in segmented	5.3 kg
FW	550 mm segmented	21.65 in segmented	11.7 kg

42Cr: 900-1150 N/mm²



TMR100.16.84

1200 kN/m max.



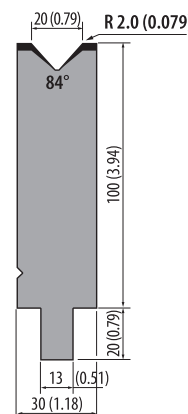
	100 mm	3.94 in	2.5 kg
	500 mm	19.68 in	12.5 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
FW	550 mm segmented	21.65 in segmented	13.8 kg

42Cr: 900-1150 N/mm²



TMR100.20.84

1150 kN/m max.



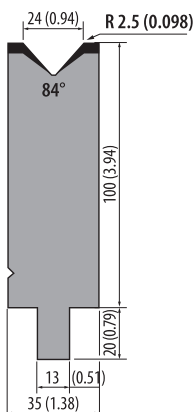
	100 mm	3.94 in	2.4 kg
	500 mm	19.68 in	12.2 kg
FC	250 mm segmented	9.84 in segmented	6.1 kg
FW	550 mm segmented	21.65 in segmented	13.4 kg

42Cr: 900-1150 N/mm²



TMR100.24.84

1200 kN/m max.



	100 mm	3.94 in	2.8 kg
	500 mm	19.68 in	14.0 kg
FC	250 mm segmented	9.84 in segmented	7.0 kg
FW	550 mm segmented	21.65 in segmented	15.4 kg

42Cr: 900-1150 N/mm²

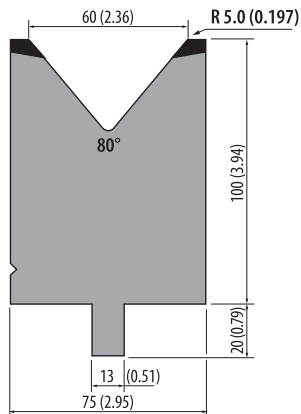


R2

ROLLERI TYPE R2 80° dies, H=100 (3.94)

TMR100.60.80

1500 kN/m max.



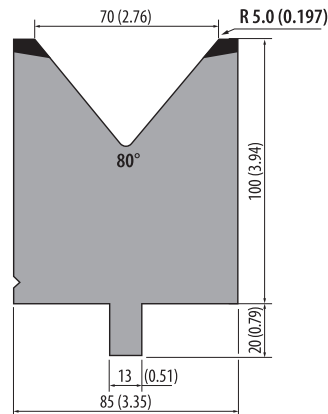
	100 mm	3.94 in	5.2 kg
	500 mm	19.68 in	25.8 kg
FW	250 mm segmented	9.84 in segmented	13.0 kg
FC	550 mm segmented	21.65 in segmented	28.4 kg

42Cr: 900-1150 N/mm²



TMR100.70.80

1500 kN/m max.



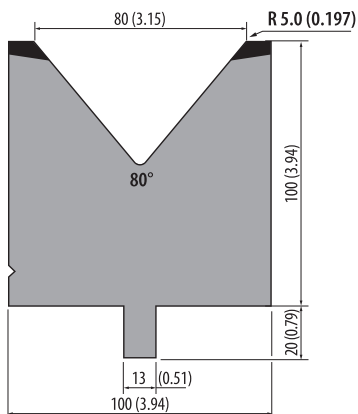
	100 mm	3.94 in	5.7 kg
	500 mm	19.68 in	28.2 kg
FW	250 mm segmented	9.84 in segmented	14.1 kg
FC	550 mm segmented	21.65 in segmented	31.0 kg

42Cr: 900-1150 N/mm²



TMR100.80.80

1500 kN/m max.



	100 mm	3.94 in	6.5 kg
	500 mm	19.68 in	32.3 kg
FW	250 mm segmented	9.84 in segmented	16.1 kg
FC	550 mm segmented	21.65 in segmented	35.5 kg

42Cr: 900-1150 N/mm²



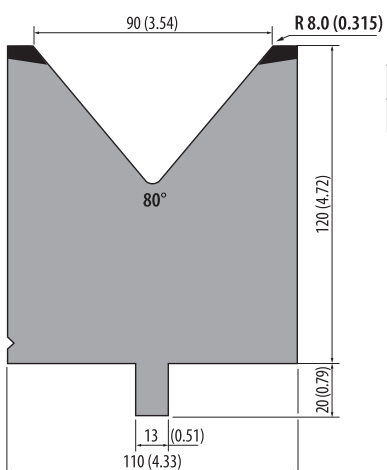
Rolleri Videos

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



TMR120.90.80

1500 kN/m max.



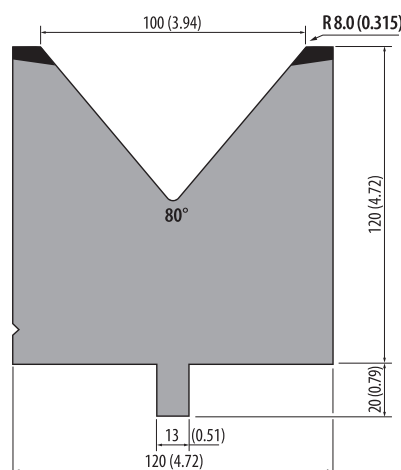
	100 mm	3.94 in	8.4 kg
	500 mm	19.68 in	42.1 kg
FW	250 mm segmented	9.84 in segmented	21.0 kg
FC	550 mm segmented	21.65 in segmented	46.3 kg

42Cr: 900-1150 N/mm²



TMR120.100.80

1500 kN/m max.

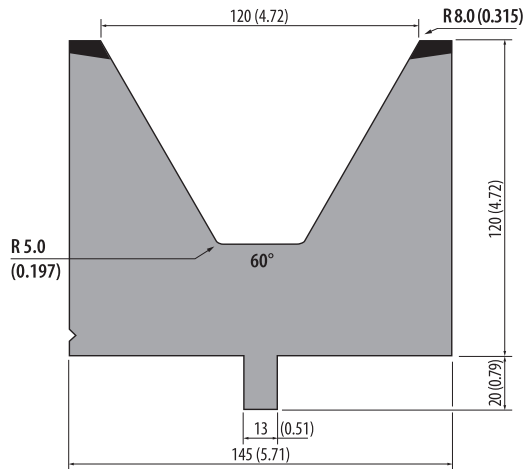


	100 mm	3.94 in	9.0 kg
	500 mm	19.68 in	44.7 kg
FW	250 mm segmented	9.84 in segmented	22.4 kg
FC	550 mm segmented	21.65 in segmented	49.2 kg

42Cr: 900-1150 N/mm²



TMR120.120.60



1600 kN/m max.

	100 mm	3.94 in	8.9 kg
	500 mm	19.68 in	44.5 kg
FC	250 mm segmented	9.84 in segmented	22.8 kg
FW	550 mm segmented	21.65 in segmented	49.0 kg

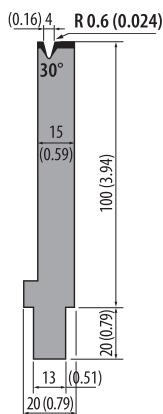
42Cr: 900-1150 N/mm²



30° dies, H=100 (3.94)

TMR100.04.30

150 kN/m max.



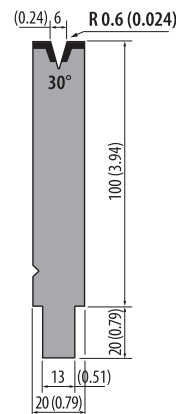
	100 mm	3.94 in	1.4 kg
	500 mm	19.68 in	7.0 kg
FC	250 mm segmented	9.84 in segmented	3.5 kg
FW	550 mm segmented	21.65 in segmented	7.7 kg

42Cr: 900-1150 N/mm²



TMR100.06.30

400 kN/m max.



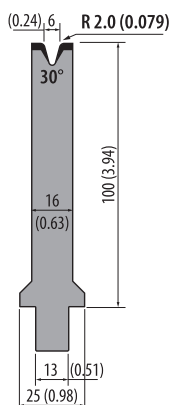
	100 mm	3.94 in	1.8 kg
	500 mm	19.68 in	8.8 kg
FC	250 mm segmented	9.84 in segmented	4.4 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



WMR100.06.30

400 kN/m max.



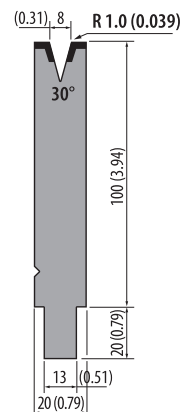
	100 mm	3.94 in	1.5 kg
	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



TMR100.08.30

400 kN/m max.



	100 mm	3.94 in	1.7 kg
	500 mm	19.68 in	8.5 kg
FC	250 mm segmented	9.84 in segmented	4.3 kg
FW	550 mm segmented	21.65 in segmented	9.5 kg

42Cr: 900-1150 N/mm²

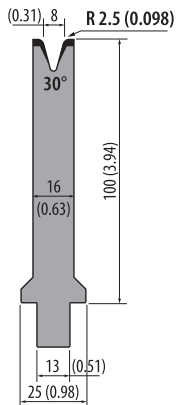


R2

ROLLERI TYPE R2 30° dies, H=100 (3.94)

WMR100.08.30

400 kN/m max.



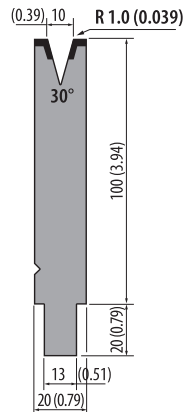
	100 mm	3.94 in	1.5 kg
	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



TMR100.10.30

400 kN/m max.



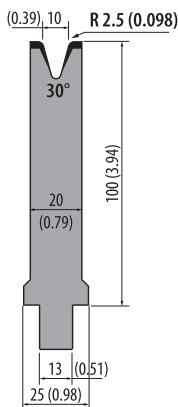
	100 mm	3.94 in	1.7 kg
	500 mm	19.68 in	8.5 kg
FW	250 mm segmented	9.84 in segmented	4.3 kg
FC	550 mm segmented	21.65 in segmented	9.4 kg

42Cr: 900-1150 N/mm²



WMR100.10.30

400 kN/m max.



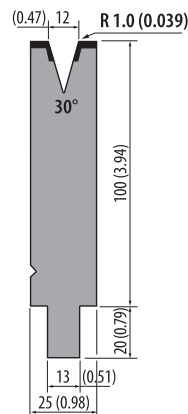
	100 mm	3.94 in	1.7 kg
	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²



TMR100.12.30

400 kN/m max.



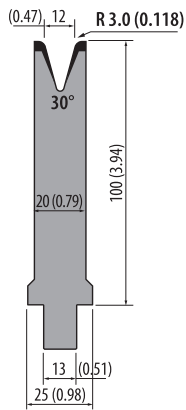
	100 mm	3.94 in	2.0 kg
	500 mm	19.68 in	10.3 kg
FW	250 mm segmented	9.84 in segmented	5.1 kg
FC	550 mm segmented	21.65 in segmented	11.3 kg

42Cr: 900-1150 N/mm²



WMR100.12.30

400 kN/m max.



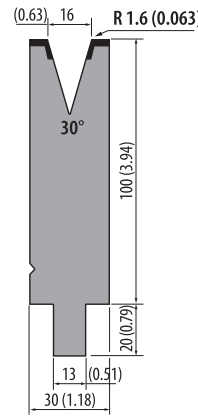
	100 mm	3.94 in	1.7 kg
	515 mm	20.28 in	8.9 kg
FW	550 mm segmented	21.65 in segmented	9.5 kg

42Cr: 900-1150 N/mm²



TMR100.16.30

500 kN/m max.



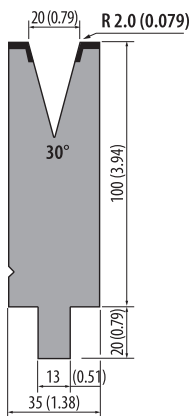
	100 mm	3.94 in	2.4 kg
	500 mm	19.68 in	11.8 kg
FW FC	250 mm segmented	9.84 in segmented	6.0 kg
FW	550 mm segmented	21.65 in segmented	13.0 kg

42Cr: 900-1150 N/mm²



TMR100.20.30

600 kN/m max.



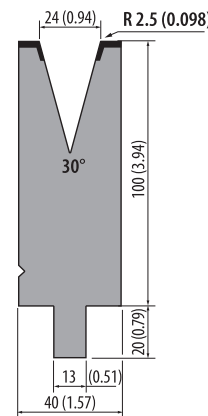
	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	13.2 kg
FW FC	250 mm segmented	9.84 in segmented	6.5 kg
FW	550 mm segmented	21.65 in segmented	14.5 kg

42Cr: 900-1150 N/mm²



TMR100.24.30

650 kN/m max.



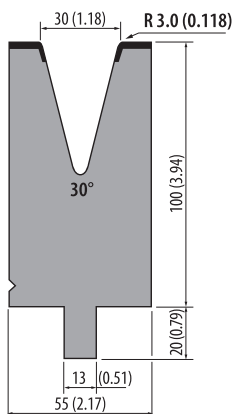
	100 mm	3.94 in	3.0 kg
	500 mm	19.68 in	14.8 kg
FW FC	250 mm segmented	9.84 in segmented	7.4 kg
FW	550 mm segmented	21.65 in segmented	16.2 kg

42Cr: 900-1150 N/mm²



TMR100.30.30

900 kN/m max.



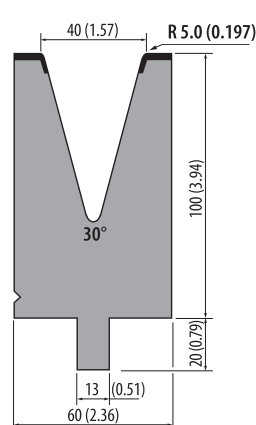
	100 mm	3.94 in	3.8 kg
	500 mm	19.68 in	19.0 kg
FW FC	250 mm segmented	9.84 in segmented	9.5 kg
FW	550 mm segmented	21.65 in segmented	21.0 kg

42Cr: 900-1150 N/mm²



TMR100.40.30

900 kN/m max.



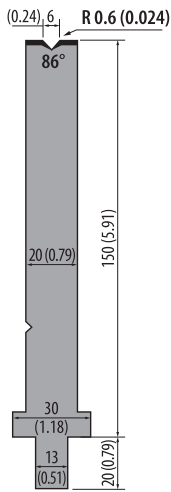
	100 mm	3.94 in	3.7 kg
	500 mm	19.68 in	18.3 kg
FW FC	250 mm segmented	9.84 in segmented	9.3 kg
FW	550 mm segmented	21.65 in segmented	20.1 kg

42Cr: 900-1150 N/mm²



TMR150.06.86

400 kN/m max.



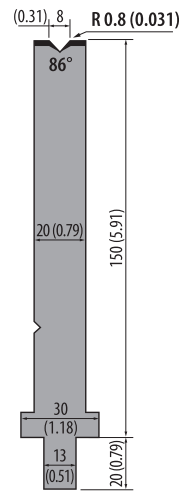
	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	13.1 kg
FW	250 mm segmented	9.84 in segmented	6.6 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



TMR150.08.86

400 kN/m max.



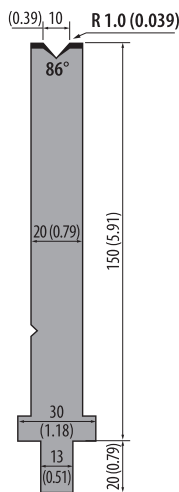
	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	13.1 kg
FW	250 mm segmented	9.84 in segmented	6.6 kg
FC	550 mm segmented	21.65 in segmented	14.4 kg

42Cr: 900-1150 N/mm²



TMR150.10.86

500 kN/m max.



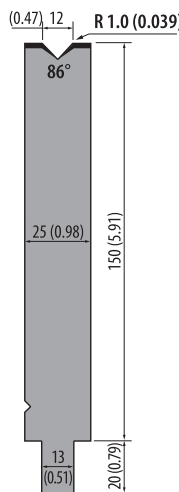
	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	13.0 kg
FW	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



TMR150.12.86

500 kN/m max.



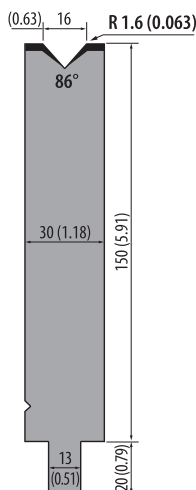
	100 mm	3.94 in	3.1 kg
	500 mm	19.68 in	15.5 kg
FW	250 mm segmented	9.84 in segmented	7.8 kg
FC	550 mm segmented	21.65 in segmented	17.0 kg

42Cr: 900-1150 N/mm²



TMR150.16.86

700 kN/m max.



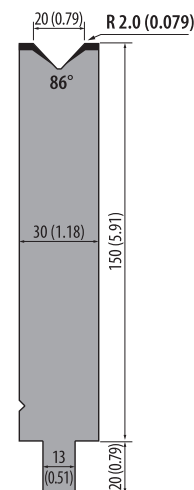
	100 mm	3.94 in	3.7 kg
	500 mm	19.68 in	18.4 kg
FW	250 mm segmented	9.84 in segmented	9.2 kg
FC	550 mm segmented	21.65 in segmented	20.2 kg

42Cr: 900-1150 N/mm²



TMR150.20.86

700 kN/m max.



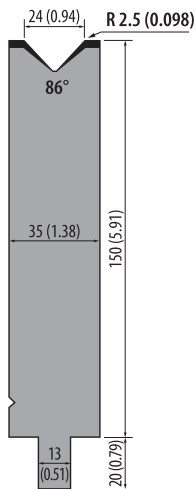
	100 mm	3.94 in	3.7 kg
	500 mm	19.68 in	18.3 kg
FW	250 mm segmented	9.84 in segmented	9.1 kg
FC	550 mm segmented	21.65 in segmented	20.0 kg

42Cr: 900-1150 N/mm²



TMR150.24.86

700 kN/m max.



	100 mm	3.94 in	4.2 kg
	500 mm	19.68 in	20.9 kg
FC	250 mm segmented	9.84 in segmented	10.5 kg
FW	550 mm segmented	21.65 in segmented	23.0 kg

42Cr: 900-1150 N/mm²



Rolleri Videos

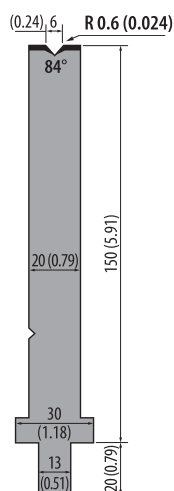
find updated and helpful videos at:
[www.rolleritools.com/
videos/overview](http://www.rolleritools.com/videos/overview)



84° dies, H=150 (5.91)

TMR150.06.84

400 kN/m max.



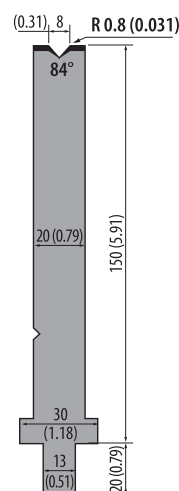
	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	13.1 kg
FC	250 mm segmented	9.84 in segmented	6.6 kg
FW	550 mm segmented	21.65 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



TMR150.08.84

400 kN/m max.



	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	13.1 kg
FC	250 mm segmented	9.84 in segmented	6.6 kg
FW	550 mm segmented	21.65 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



Article on stock



Please ask for delivery time!

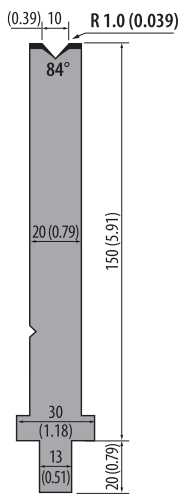
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

TMR150.10.84

500 kN/m max.



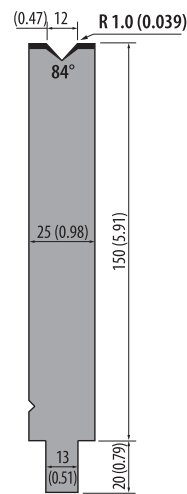
	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	13.0 kg
FW	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



TMR150.12.84

500 kN/m max.



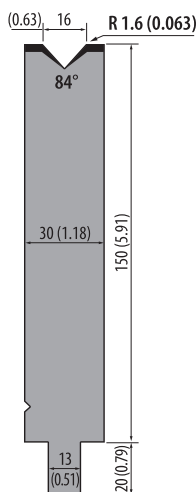
	100 mm	3.94 in	3.1 kg
	500 mm	19.68 in	15.5 kg
FW	250 mm segmented	9.84 in segmented	7.8 kg
FC	550 mm segmented	21.65 in segmented	17.0 kg

42Cr: 900-1150 N/mm²



TMR150.16.84

700 kN/m max.



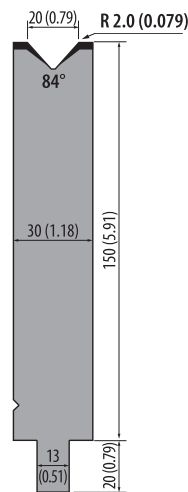
	100 mm	3.94 in	3.7 kg
	500 mm	19.68 in	18.4 kg
FW	250 mm segmented	9.84 in segmented	9.2 kg
FC	550 mm segmented	21.65 in segmented	20.2 kg

42Cr: 900-1150 N/mm²



TMR150.20.84

700 kN/m max.



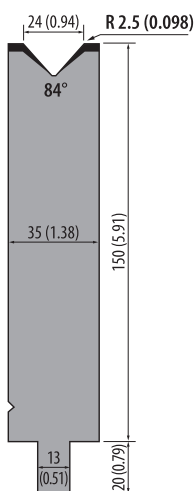
	100 mm	3.94 in	3.7 kg
	500 mm	19.68 in	18.3 kg
FW	250 mm segmented	9.84 in segmented	9.1 kg
FC	550 mm segmented	21.65 in segmented	20.0 kg

42Cr: 900-1150 N/mm²



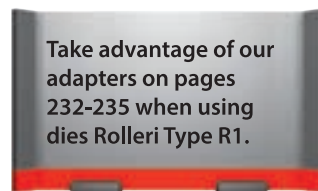
TMR150.24.84

700 kN/m max.



	100 mm	3.94 in	4.2 kg
	500 mm	19.68 in	20.9 kg
FW	250 mm segmented	9.84 in segmented	10.4 kg
FC	550 mm segmented	21.65 in segmented	22.9 kg

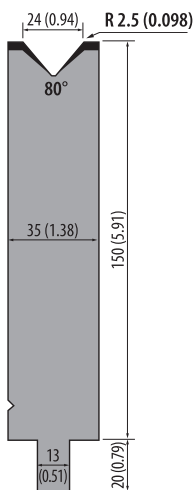
42Cr: 900-1150 N/mm²





TMR150.24.80

700 kN/m max.



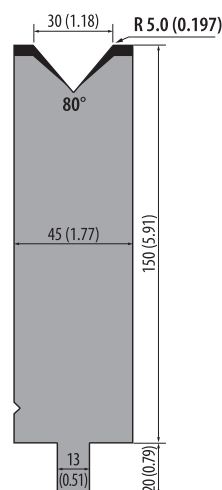
	100 mm	3.94 in	4.2 kg
	500 mm	19.68 in	20.9 kg
FW	250 mm segmented	9.84 in segmented	10.4 kg
FC	550 mm segmented	21.65 in segmented	22.9 kg

42Cr: 900-1150 N/mm²



TMR150.30.80

900 kN/m max.



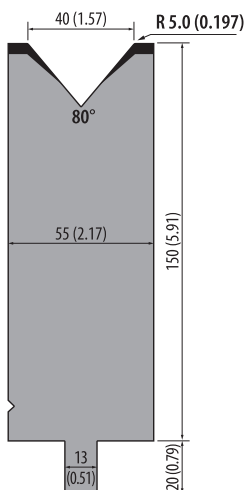
	100 mm	3.94 in	5.3 kg
	500 mm	19.68 in	26.3 kg
FW	250 mm segmented	9.84 in segmented	13.1 kg
FC	550 mm segmented	21.65 in segmented	28.9 kg

42Cr: 900-1150 N/mm²



TMR150.40.80

1200 kN/m max.



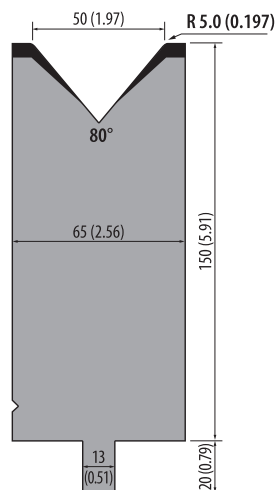
	100 mm	3.94 in	6.3 kg
	500 mm	19.68 in	31.3 kg
FW	250 mm segmented	9.84 in segmented	15.6 kg
FC	550 mm segmented	21.65 in segmented	34.4 kg

42Cr: 900-1150 N/mm²



TMR150.50.80

1500 kN/m max.



	100 mm	3.94 in	7.3 kg
	500 mm	19.68 in	36.0 kg
FW	250 mm segmented	9.84 in segmented	18.0 kg
FC	550 mm segmented	21.65 in segmented	39.6 kg

42Cr: 900-1150 N/mm²



Article on stock



Please ask for delivery time!

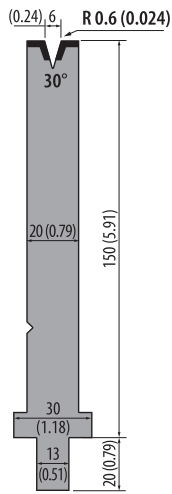
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

TMR150.06.30

400 kN/m max.



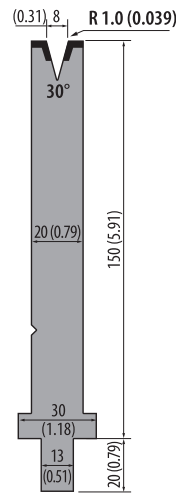
	100 mm	3.94 in	2.8 kg
	500 mm	19.68 in	13.0 kg
FW	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



TMR150.08.30

400 kN/m max.



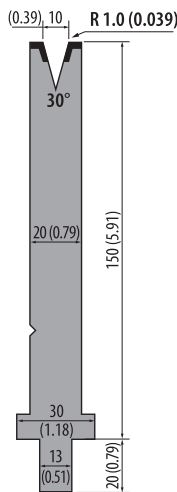
	100 mm	3.94 in	2.8 kg
	500 mm	19.68 in	13.0 kg
FW	250 mm segmented	9.84 in segmented	6.5 kg
FC	550 mm segmented	21.65 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



TMR150.10.30

400 kN/m max.



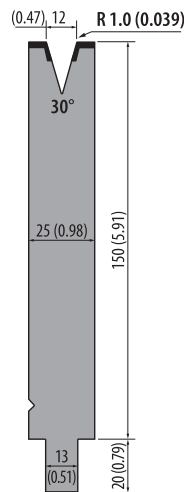
	100 mm	3.94 in	2.6 kg
	500 mm	19.68 in	12.8 kg
FW	250 mm segmented	9.84 in segmented	6.4 kg
FC	550 mm segmented	21.65 in segmented	13.9 kg

42Cr: 900-1150 N/mm²



TMR150.12.30

400 kN/m max.



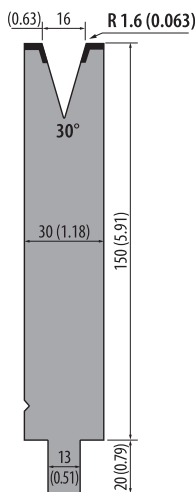
	100 mm	3.94 in	3.0 kg
	500 mm	19.68 in	15.2 kg
FW	250 mm segmented	9.84 in segmented	7.6 kg
FC	550 mm segmented	21.65 in segmented	16.7 kg

42Cr: 900-1150 N/mm²



TMR150.16.30

500 kN/m max.



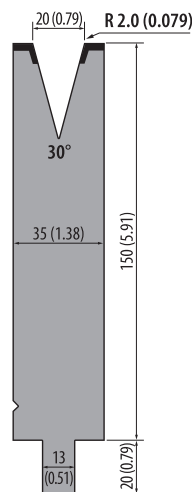
	100 mm	3.94 in	3.5 kg
	500 mm	19.68 in	17.7 kg
FW	250 mm segmented	9.84 in segmented	8.9 kg
FC	550 mm segmented	21.65 in segmented	19.5 kg

42Cr: 900-1150 N/mm²



TMR150.20.30

600 kN/m max.



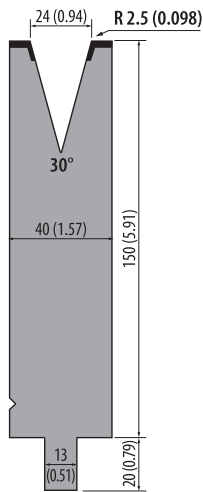
	100 mm	3.94 in	4.0 kg
	500 mm	19.68 in	20.1 kg
FW	250 mm segmented	9.84 in segmented	10.0 kg
FC	550 mm segmented	21.65 in segmented	22.0 kg

42Cr: 900-1150 N/mm²



TMR150.24.30

650 kN/m max.



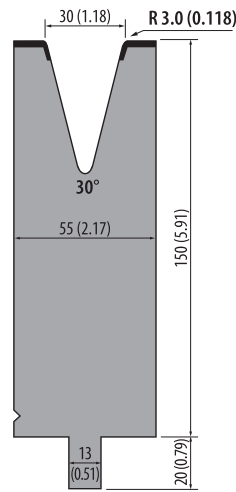
	100 mm	3.94 in	4.5 kg
	500 mm	19.68 in	22.3 kg
FW	250 mm segmented	9.84 in segmented	11.2 kg
FC	550 mm segmented	21.65 in segmented	24.5 kg

42Cr: 900-1150 N/mm²



TMR150.30.30

900 kN/m max.



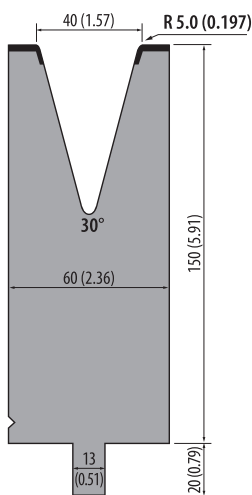
	100 mm	3.94 in	6.0 kg
	500 mm	19.68 in	30.0 kg
FW	250 mm segmented	9.84 in segmented	15.0 kg
FC	550 mm segmented	21.65 in segmented	33.0 kg

42Cr: 900-1150 N/mm²



TMR150.40.30

900 kN/m max.



	100 mm	3.94 in	6.0 kg
	500 mm	19.68 in	30.1 kg
FW	250 mm segmented	9.84 in segmented	15.1 kg
FC	550 mm segmented	21.65 in segmented	33.1 kg

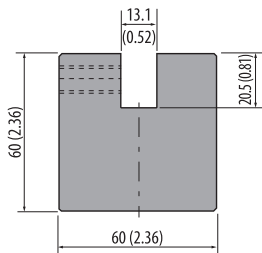
42Cr: 900-1150 N/mm²



AD5

1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

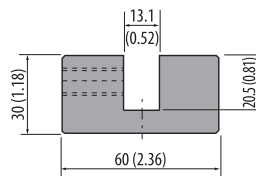
C45: 560-710 N/mm²



AD6

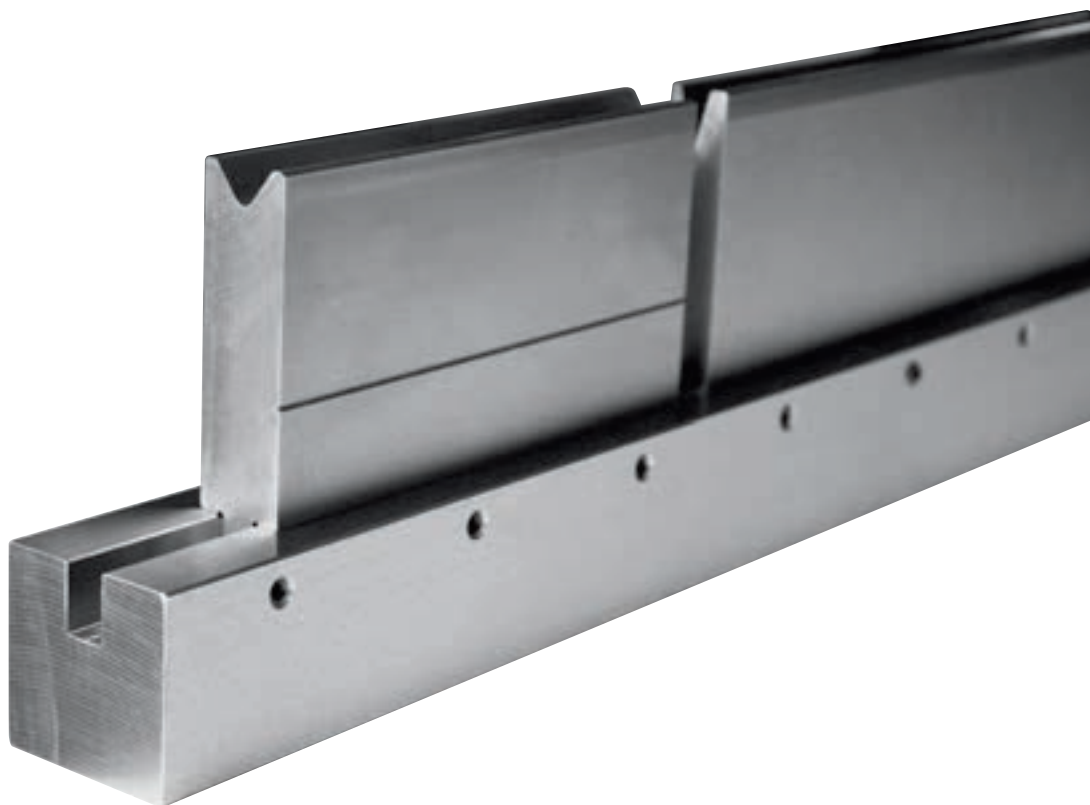
1000 kN/m max.

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



Rolleri Type R1
→ Rolleri Type R2/R3

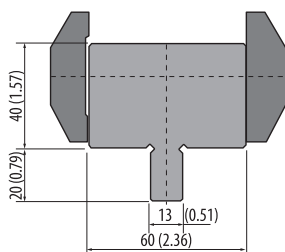
C45: 560-710 N/mm²



AD7

1000 kN/m max.

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



Rolleri Type R2/R3
→ Rolleri Type R1

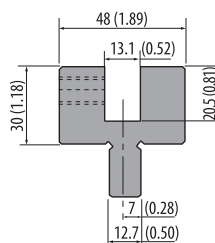
C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.

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



Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

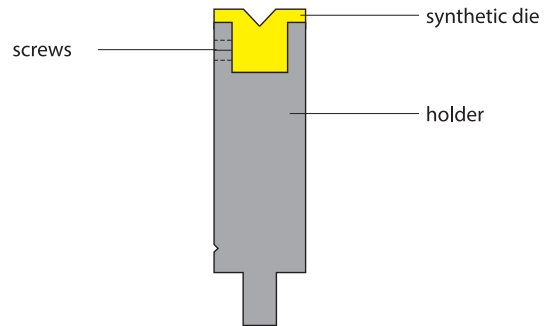


Our Advantages – Your Convenience

- No friction marks on the sheet metal
- Decrease of post-processing operations of bent profiles
- No material residues
- Better quality of the bent product
- Easy usage

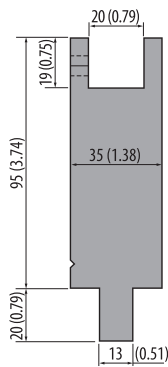
Mounting example

Synthetic dies are inserted into the holder and clamped with screws.



TMN95.20

1000 kN/m max.



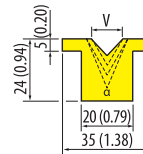
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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



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

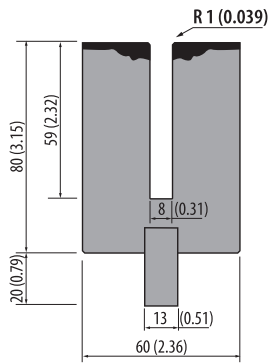
Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39



R2

ROLLERI TYPE R2 Hemming dies

TPR.SM.195.28.8 / TPR.SM.195.24.8

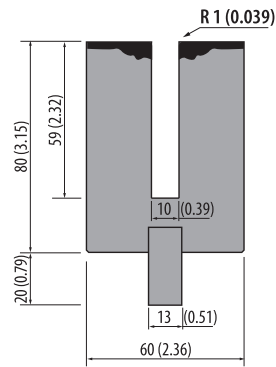


100 mm	3.94 in	2.3 kg
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



TPR.SM.195.24.10

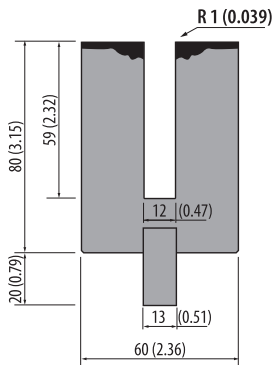


100 mm	3.94 in	2.2 kg
525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²



TPR.SM.195.24.12

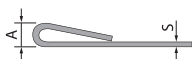


100 mm	3.94 in	2.2 kg
525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	11.0 kg

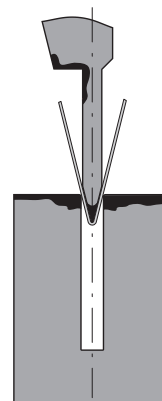
42Cr: 900-1150 N/mm²



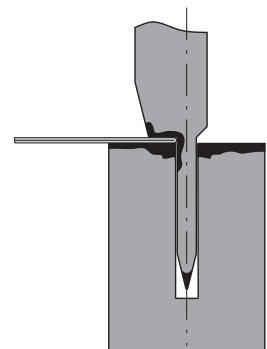
Example of application



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	kN/mm ²	mm	in	mm	in	kN/mm ²	kN/mm ²
				t/m	t/m					t/m	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



800 kN/m max.



1000 kN/m max.

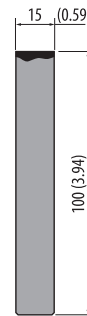
Application

- movable table necessary
- high flexibility
- easy mounting



TMI100

1300 kN/m max.



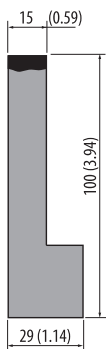
	100 mm	3.94 in	1.0 kg
	500 mm	19.68 in	5.0 kg
FW / FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg

C45: 560-710 N/mm²



TML100

1200 kN/m max.

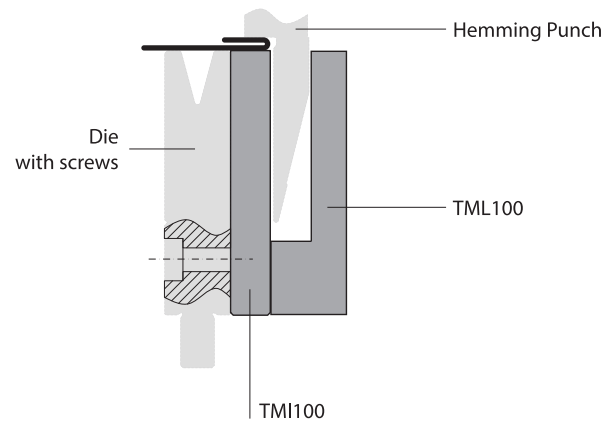


	100 mm	3.94 in	1.0 kg
	500 mm	19.68 in	5.0 kg
FW / FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg

C45: 560-710 N/mm²

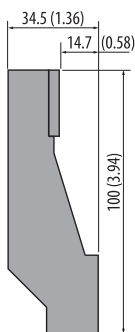


Example of application TMI100 + TML100



TMS100

1300 kN/m max.

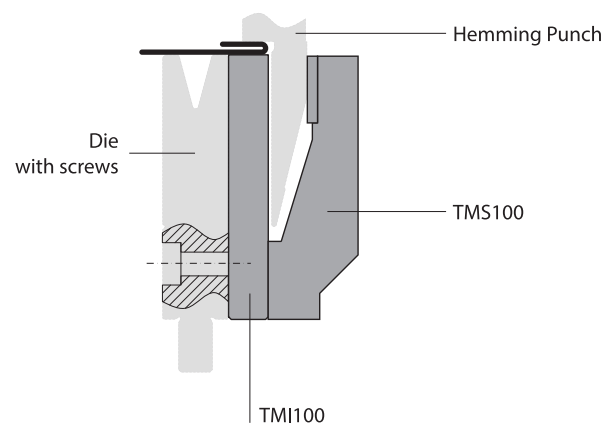


	100 mm	3.94 in	1.0 kg
	500 mm	19.68 in	5.0 kg
FW / FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg

C45: 560-710 N/mm²



Example of application TMI100 + TMS100





R3

Compatibility

Punches Rolleri Type R3 are compatible with press brake machines from:

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

With the use of adapters Rolleri R3 type punches can be mounted in other press brake models.

PUNCHES ROLLERI TYPE R3

Content Explanation	126 - 127
Bystronic-Beyeler RFA punches	128 - 129
Bystronic-Beyeler RF punches	129
Bystronic-Beyeler RFA hemming punches	130
Bystronic-Beyeler R punches	131
Bystronic-Beyeler S punches	132
Punch adapters	133
Joggle Tools	134 - 135
Radius Tools	136 - 137

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)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 264-265)
- very large stock availability

Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

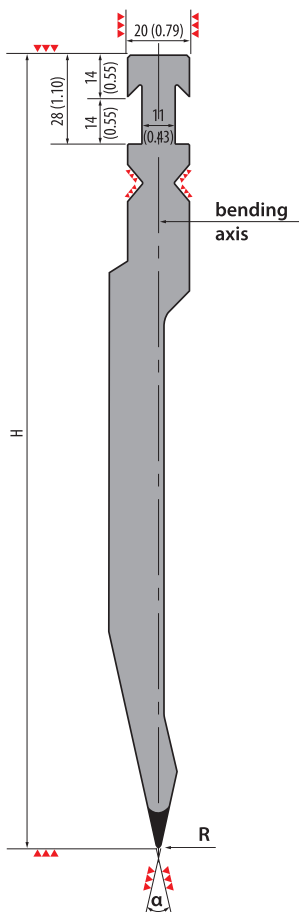
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRc	54 - 60 HRc
C45	560-710 N/mm ²	12 - 15.5 HRc	54 - 60 HRc

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

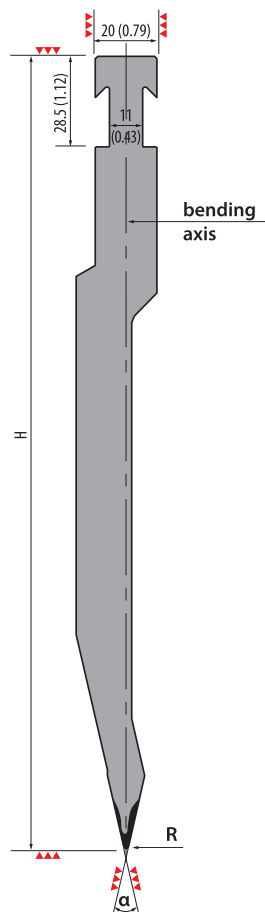
Tang

Punches Roller Type R3 have the following tangs:

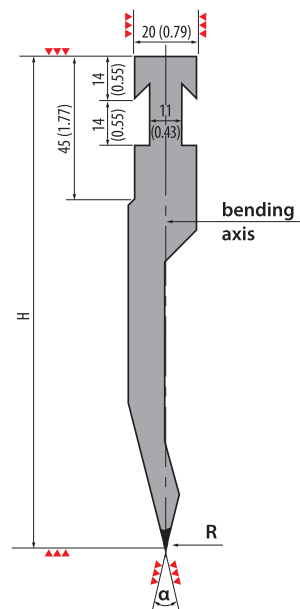
Bystronic-Beyeler RFA



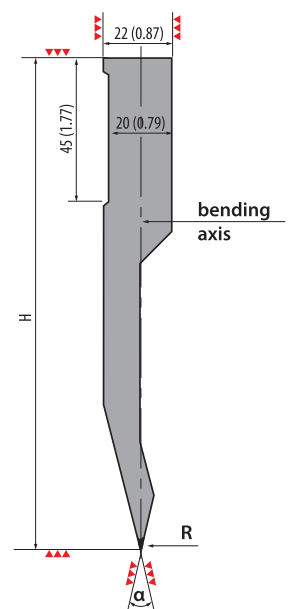
Bystronic-Beyeler RF



Bystronic-Beyeler R



Bystronic-Beyeler S

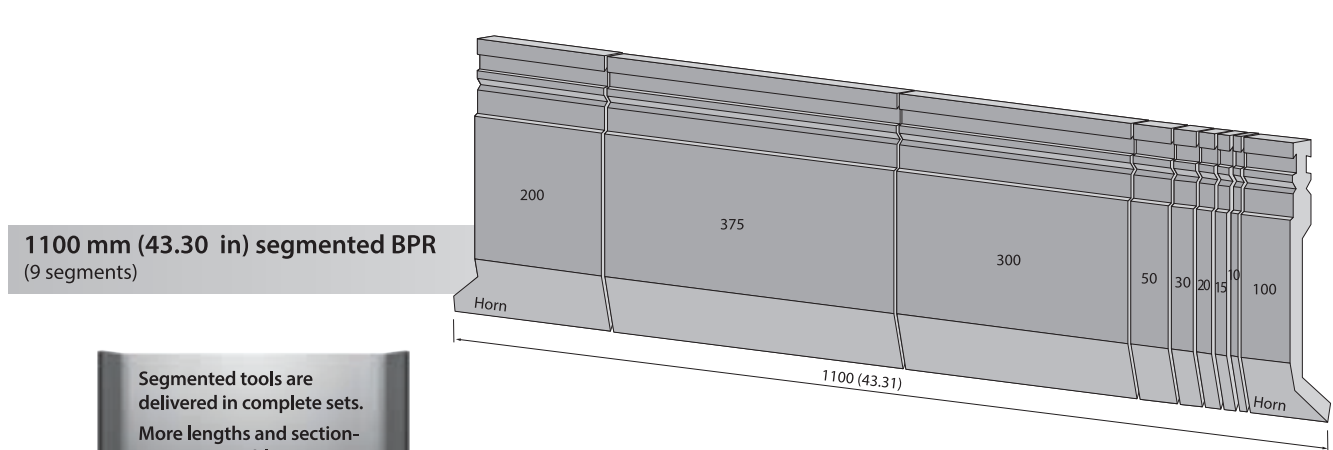
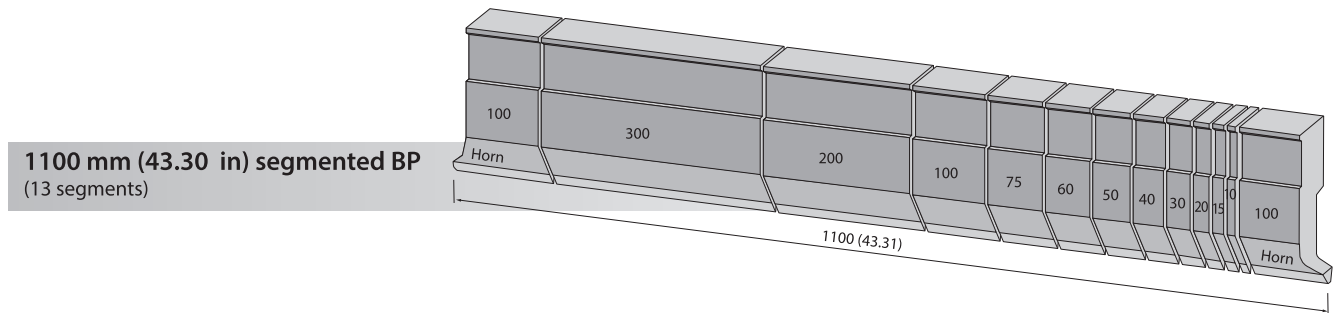
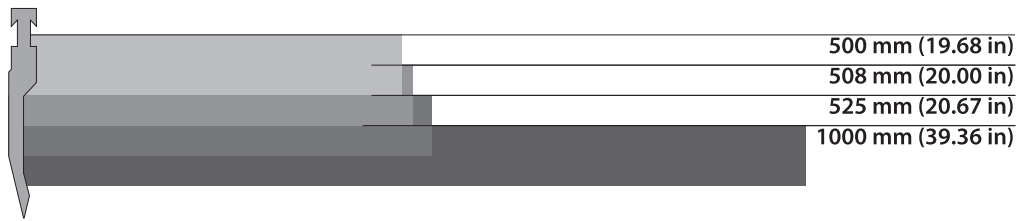


Indications of precision ground surfaces:



Tool lengths and sectioning

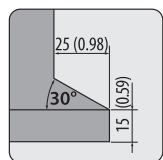
Standard



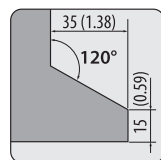
Segmented tools are delivered in complete sets. More lengths and sectionings are possible upon request.



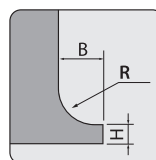
Horn Types



HORN 1 Horn 1 Standard BP for all segm. Punches BP Rolleri Type R3



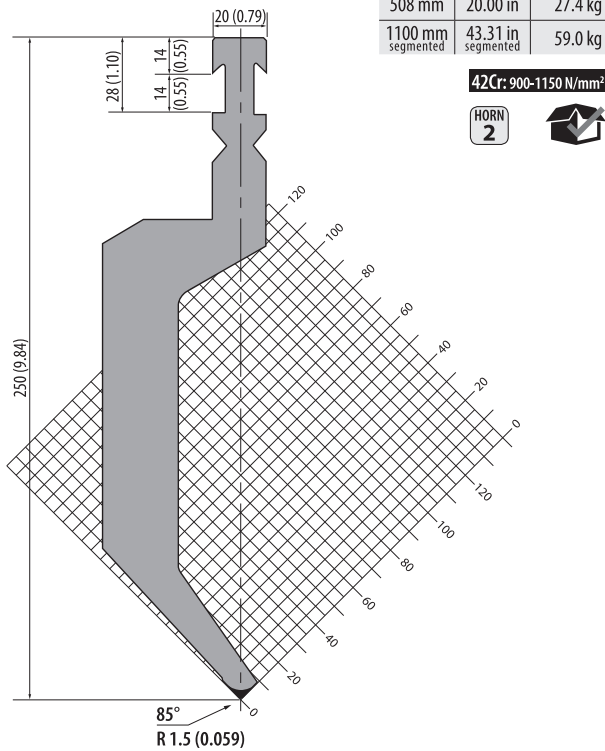
HORN 2 Horn 2 Standard BPR for all segm. Punches BPR Rolleri Type R3



Individual Horn production according to your specifications

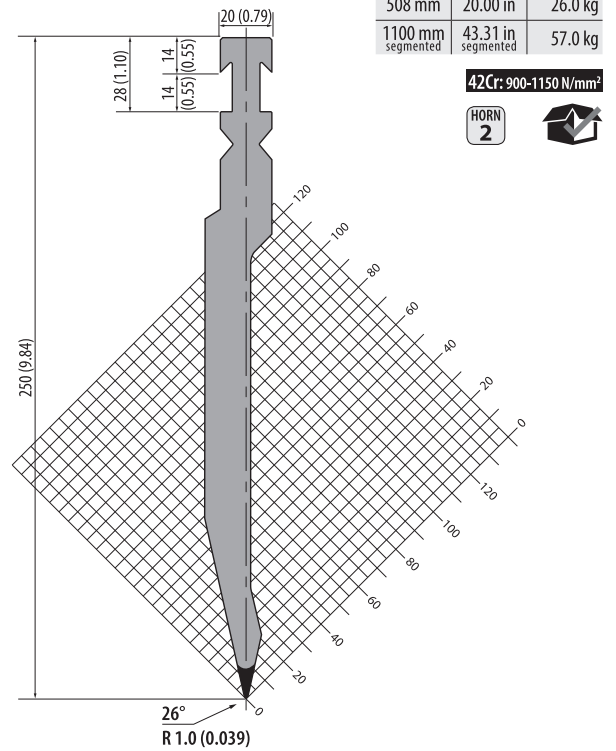
BPR250.P4-RFA

900 kN/m max.



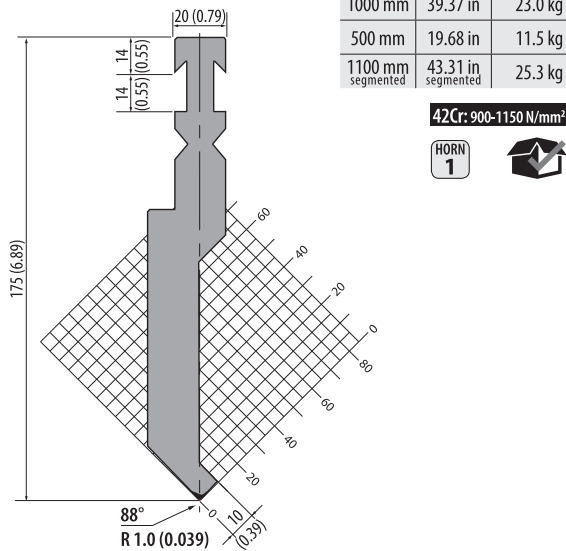
BPR250.P5-RFA

1000 kN/m max.



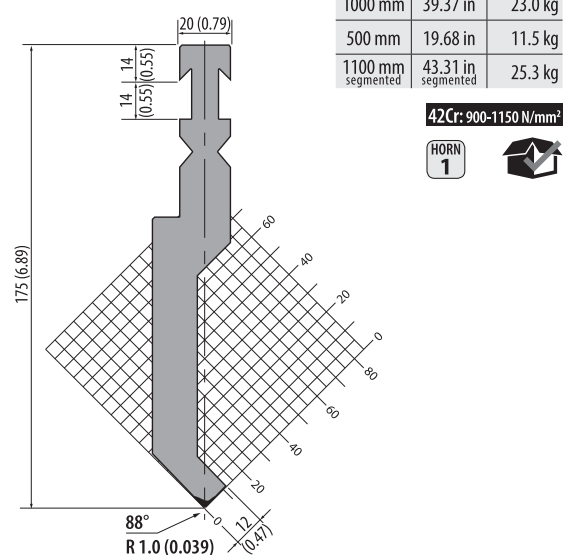
BP175.88.R1-A-RFA

1000 kN/m max.



BP175.88.R1-B-RFA

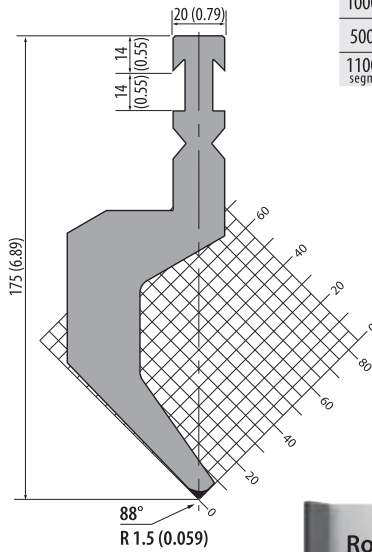
1000 kN/m max.



Take advantage of the wide range of Rollerli R1 Type punches by using an adapter.
See pages 226-231

BP175.88.R15-RFA

500 kN/m max.



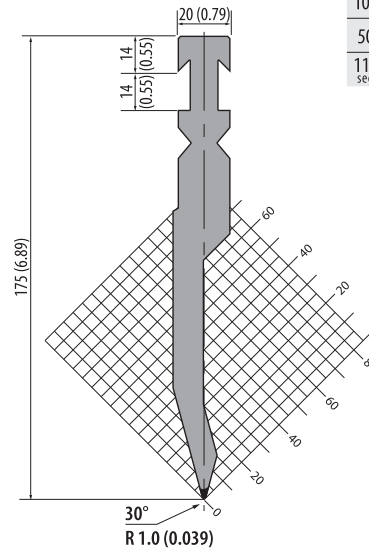
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	23.0 kg

42Cr: 900-1150 N/mm²



BP175.30.R1-RFA

800 kN/m max.



1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	16.0 kg

42Cr: 900-1150 N/mm²

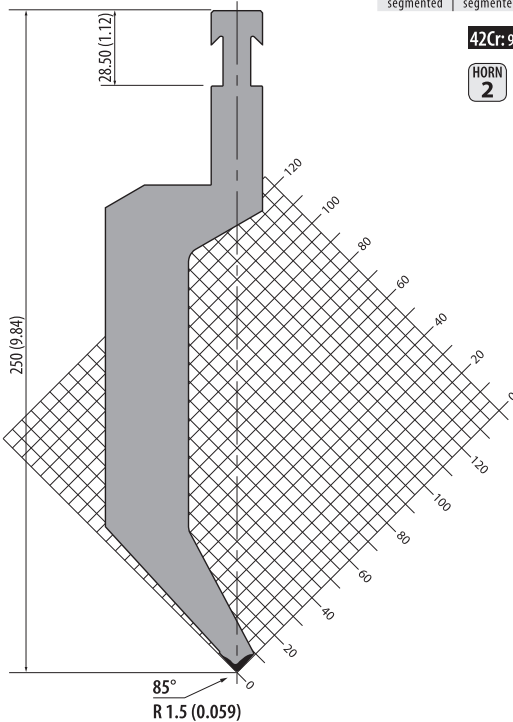


Rolleri R3 type punches are manufactured of 42CrMo4 to have higher capacity!

Bystronic-Beyeler RF punches

BPR250.P4-RF

1000 kN/m max.



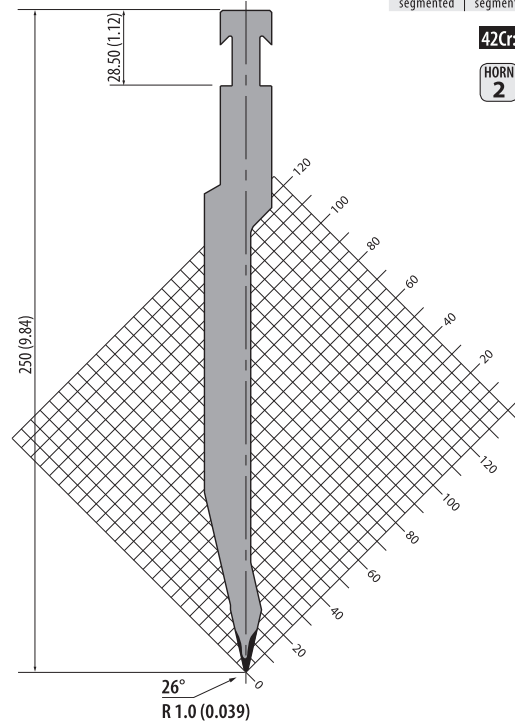
508 mm	20.00 in	27.6 kg
1100 mm segmented	43.31 in segmented	51.0 kg

42Cr: 900-1150 N/mm²



BPR250.P5-RF

900 kN/m max.



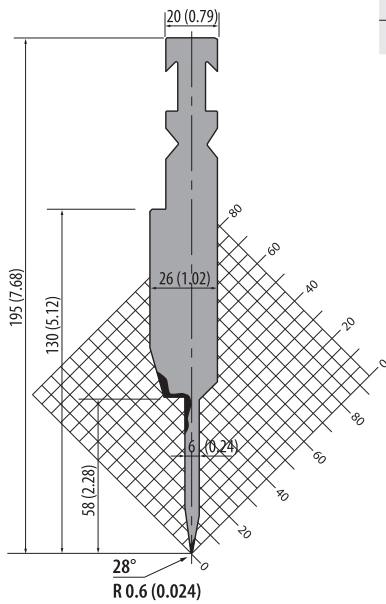
508 mm	20.00 in	16.0 kg
1100 mm segmented	43.31 in segmented	35.0 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.28.6

500 kN/m max.

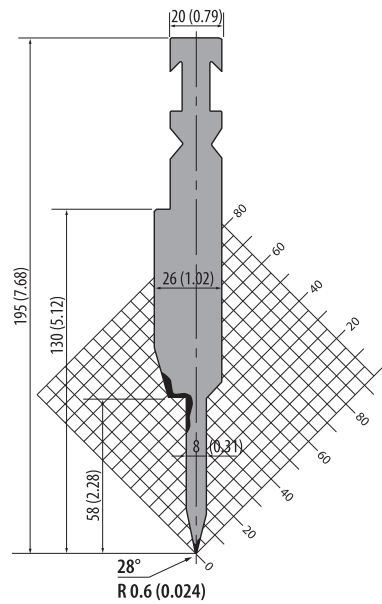


525 mm	20.67 in	8.7 kg
495 mm segmented	19.49 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.28.8

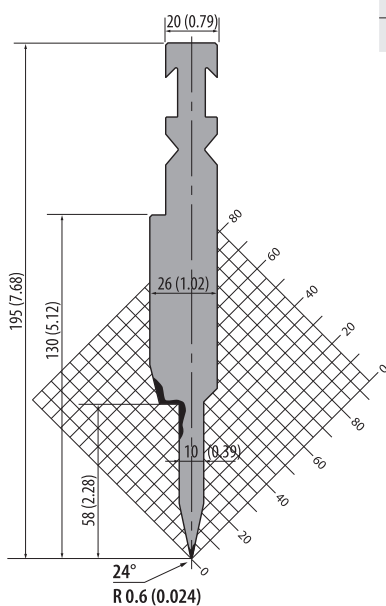


525 mm	20.67 in	8.7 kg
495 mm segmented	19.49 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.24.10

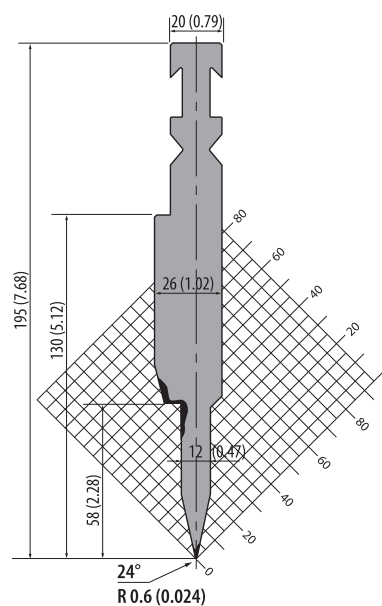


525 mm	20.67 in	8.9 kg
495 mm segmented	19.49 in segmented	8.4 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.24.12

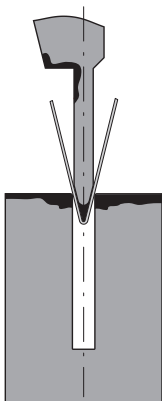


525 mm	20.67 in	9.2 kg
495 mm segmented	19.49 in segmented	8.6 kg

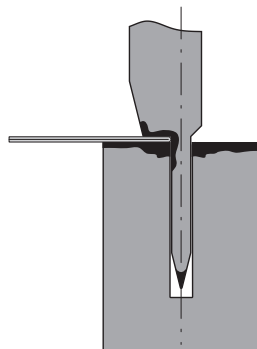
42Cr: 900-1150 N/mm²



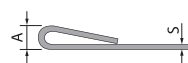
Example of Application



800 kN/m max.



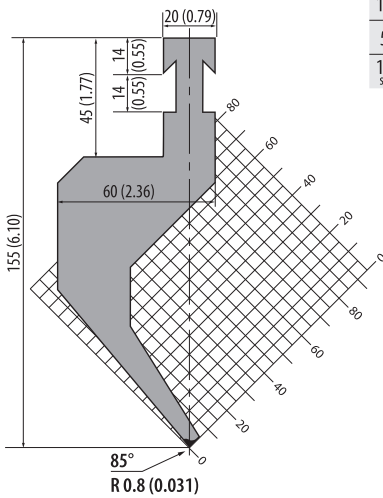
1000 kN/m max.



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	t/m	mm	in	mm	in	kN/mm ²	t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

BP155.85.R08-R

500 kN/m max.



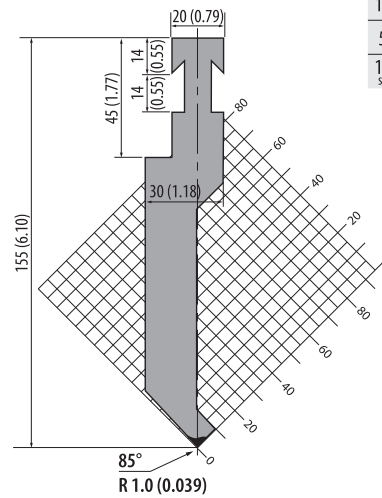
1000 mm	39.37 in	30.5 kg
500 mm	19.68 in	15.0 kg
1100 mm segmented	43.31 in segmented	32.5 kg

42Cr: 900-1150 N/mm²



BP155.85.R1-R

1000 kN/m max.



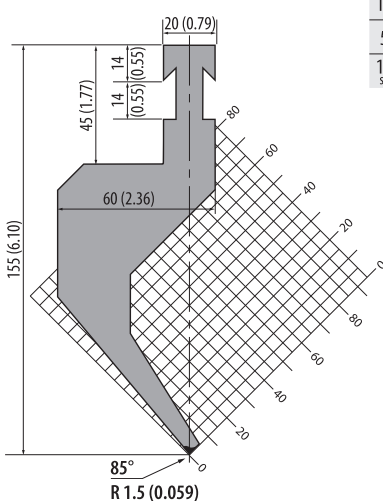
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	23.0 kg

42Cr: 900-1150 N/mm²



BP155.85.R15-R

500 kN/m max.



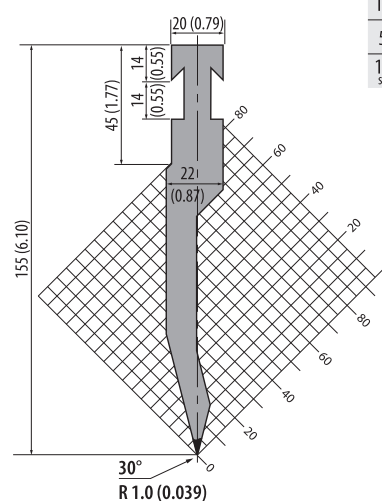
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	32.0 kg

42Cr: 900-1150 N/mm²



BP155.30.R1-R

800 kN/m max.



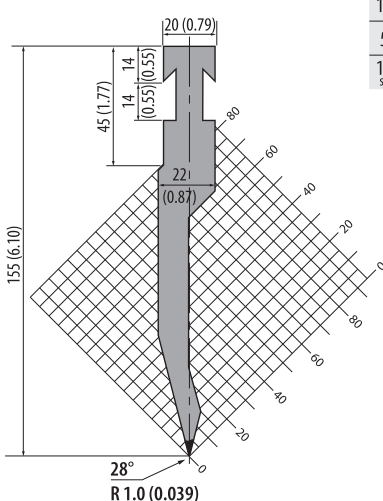
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



BP155.28.R1-R

800 kN/m max.



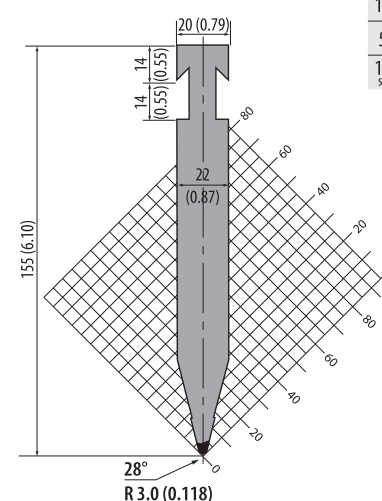
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²



BP155.28.R3-R

1000 kN/m max.



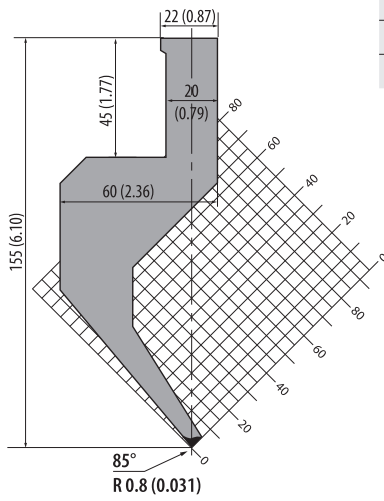
1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	11.0 kg
1100 mm segmented	43.31 in segmented	23.5 kg

C45: 560-710 N/mm²



BP155.85.R08-S

500 kN/m max.



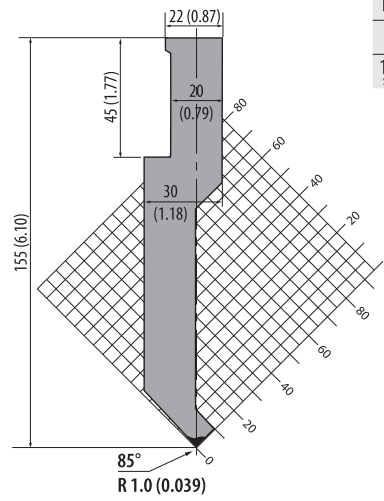
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	34.0 kg

42Cr: 900-1150 N/mm²



BP155.85.R1-S

1000 kN/m max.



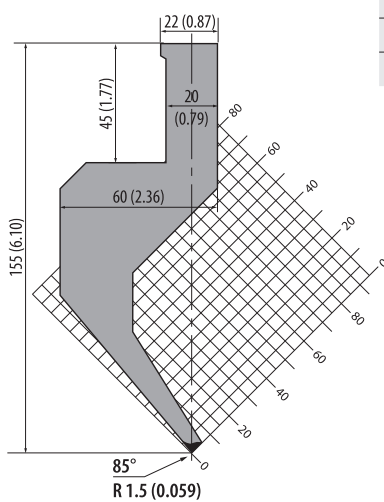
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	35.2 kg

42Cr: 900-1150 N/mm²



BP155.85.R15-S

500 kN/m max.



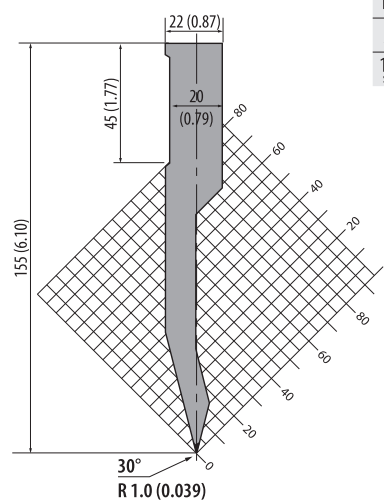
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.5 kg
1100 mm segmented	43.31 in segmented	32.0 kg

42Cr: 900-1150 N/mm²



BP155.30.R1-S

800 kN/m max.



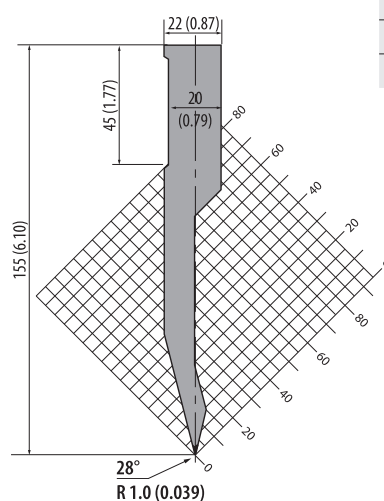
1000 mm	39.37 in	17.5 kg
500 mm	19.68 in	9.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²



BP155.28.R1-S

800 kN/m max.



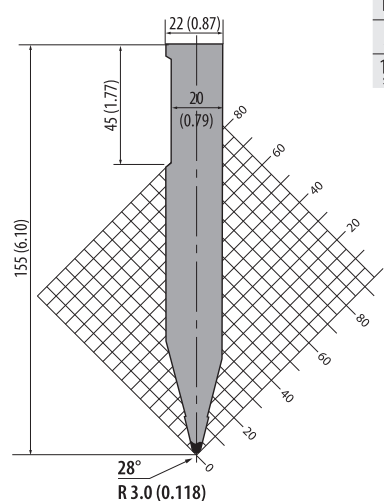
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²



BP155.28.R3-S

1000 kN/m max.



1000 mm	39.37 in	23.5 kg
500 mm	19.68 in	12.0 kg
1100 mm segmented	43.31 in segmented	23.5 kg

C45: 560-710 N/mm²



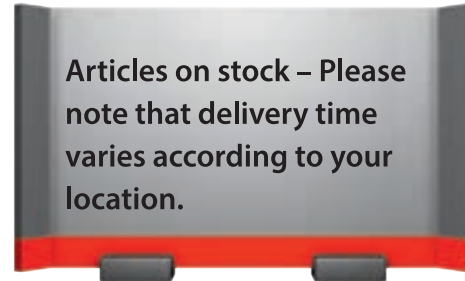
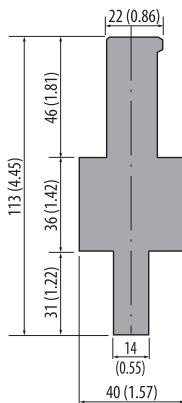
AD3

1000 kN/m max.

150 mm	5.90 in	3.3 kg
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Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



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

5
R3

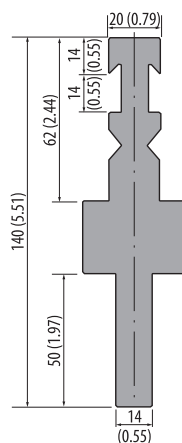
AD10

1000 kN/m max.

150 mm	5.90 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler RFA → Rolleri Type R1

C45: 560-710 N/mm²



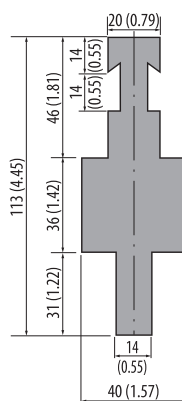
AD22

1000 kN/m max.

150 mm	5.90 in	3.4 kg
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Rolleri Type R3 Beyeler R
→ Rolleri Type R1

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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



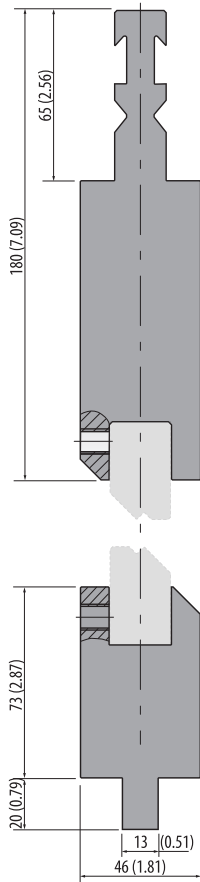
Articles on stock – Please note that delivery time depends on your location.

BPZ-RFA

1000 kN/m max.

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

C45: 560-710 N/mm²

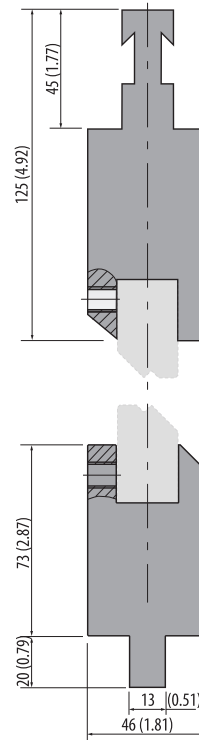


BPZ-R

1000 kN/m max.

835 mm	32.87 in	24.7 kg
415 mm	16.34 in	12.3 kg

C45: 560-710 N/mm²

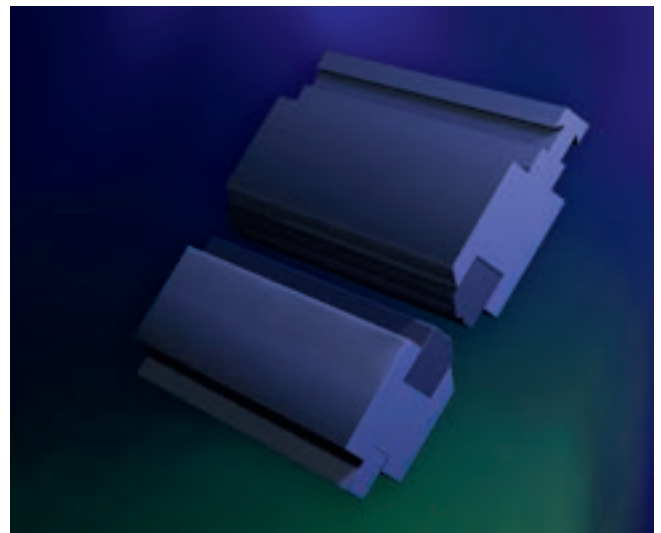
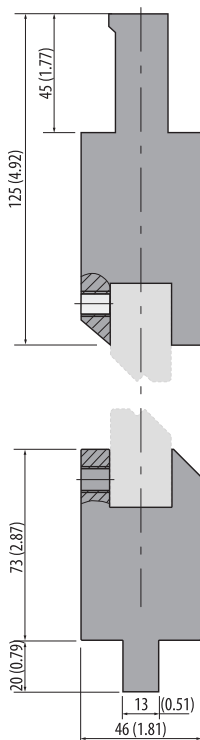


BPZ-S

1000 kN/m max.

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.5 kg

C45: 560-710 N/mm²



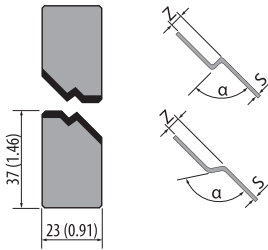
Rolleri Videos

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



Joggle Tool Inserts 160° / 150° / 140° / 90°

1000 kN/m max.



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

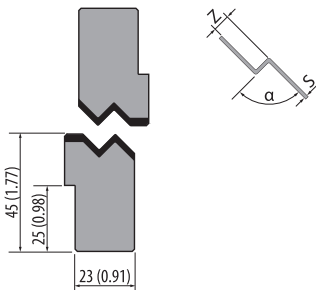
C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

5
R3

Joggle Tool Inserts 90°

1000 kN/m max.



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



C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²



Article on stock



Please ask for delivery time!

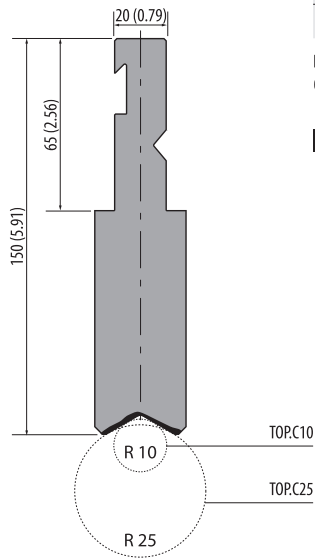
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

BPR150.P10.10-RFA

1000 kN/m max.



522 mm	20.55 in	16.5 kg
495 mm segmented	19.49 in segmented	16.0 kg

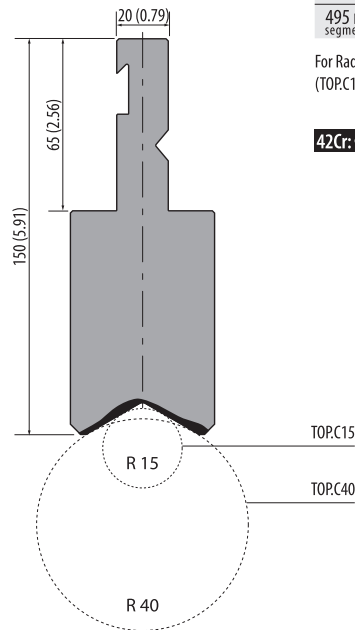
For Radius tools with R10-R25 (TOP.C10-TOP.C25) see below

42Cr: 900-1150 N/mm²



BPR150.P10.15-RFA

1000 kN/m max.



522 mm	20.55 in	23.0 kg
495 mm segmented	19.49 in segmented	21.7 kg

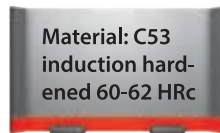
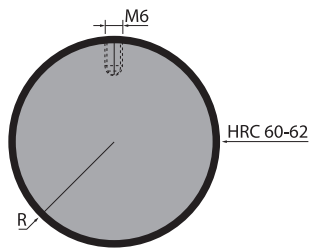
For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm²



Radius Tools: R10-40

1000 kN/m max.



Material: C53
induction hard-
ened 60-62 HRC



C53: 610-760 N/mm²

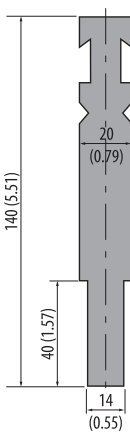
Model	R (mm)	R in	525 mm	Weight	495 mm segmented	Weight
TOP.C10	10	0.39		1.3 kg		2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg		
TOP.C15	15	0.59	3.0 kg	3.8 kg		
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg		
TOP.C20	20	0.79	5.2 kg	6.6 kg		
TOP.C22.5	22.5	0.88	6.6 kg	6.6 kg		
TOP.C25	25	0.98	8.1 kg	7.5 kg		
TOP.C27.5	27.5	1.08	9.8 kg	9.2 kg		
TOP.C30	30	0.98	11.7 kg	11.3 kg		
TOP.C32.5	32.5	1.28	13.7 kg	12.9 kg		
TOP.C35	35	1.38	16.0 kg	15.1 kg		
TOP.C37.5	37.5	1.47	18.2 kg	17.2 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.



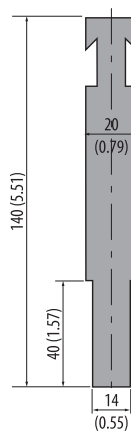
830 mm	32.68 in	15.3 kg
410 mm	16.14 in	7.6 kg

C45: 560-710 N/mm²



BPU-R

800 kN/m max.



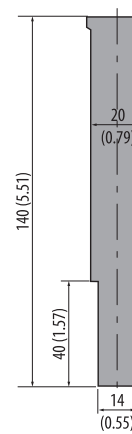
830 mm	32.68 in	15.8 kg
410 mm	16.14 in	7.8 kg

C45: 560-710 N/mm²



BPU-S

800 kN/m max.



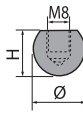
830 mm	32.68 in	16.8 kg
410 mm	16.14 in	8.3 kg

C45: 560-710 N/mm²



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

800 kN/m max.



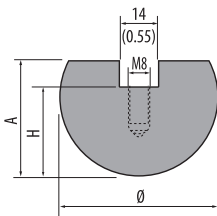
C45: 560-710 N/mm²



Model	Ø mm	Ø in	H mm	H in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	Weight
C13.08	16	0.63	13	0.51		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 in)

800 kN/m max.



C45: 560-710 N/mm²

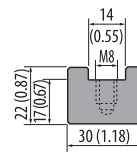


Model	Ø (mm)	Ø in	H (mm)	H in	A (mm)	A in	835 mm	Weight	415 mm	Weight
C17.12	25	0.98	17	0.67	22	0.87		2.5 kg		1.2 kg
C20.15	30	1.18	20	0.79	27	1.06		3.7 kg		1.8 kg
C22.17	35	1.38	22	0.87	32	1.26		5.0 kg		2.4 kg
C24.20	40	1.57	24	0.94	34	1.34		7.0 kg		3.5 kg
C25.22	45	1.77	25	0.98	35	1.38		7.5 kg		3.8 kg
C29.25	50	1.97	29	1.14	39	1.54		10.0 kg		4.7 kg
C34.27	55	2.16	34	1.33	44	1.73		12.4 kg		6.2 kg
C34.30	60	2.36	34	1.34	44	1.73		13.5 kg		6.7 kg
C37.32	65	2.55	37	1.45	47	1.85		15.9 kg		7.9 kg
C45.35	70	2.76	45	1.77	55	2.17		20.3 kg		10.0 kg
C42.37	75	2.95	42	1.65	52	2.04		20.5 kg		10.3 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

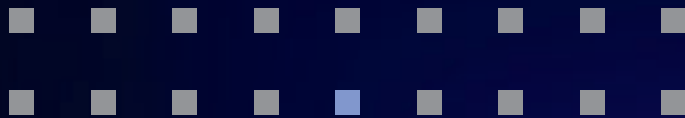
800 kN/m max.



C45: 560-710 N/mm²



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



R3

Compatibility

Dies Roller Type R3 are **compatible** with press brakes:

- Bystronic-Beyeler
- Safan
- SMD
- Trumpf
- Darley
- Press brake machines with System NSCR

With the use of adapters Rolleri R3 type dies can be mounted in other press brake models.

DIES ROLLER TYPE R3

Content Explanation	140 - 141
90° dies, H=55 mm (2.17)	142
88° dies, H=55 mm (2.17)	142 - 143
85° dies, H=55 mm (2.17)	143 - 144
80° dies, H=55 mm (2.17)	145 - 146
80° dies, H=55 mm (2.17) / H=65 mm (2.56) / H=85 mm (3.35)	146
60° dies, H=55 mm (2.17) / H=65 mm (2.56)	146
30° dies, H=55 mm (2.17) / H=60 mm (2.36)	147
30° dies, H=70 mm (2.76)	148
Dies, H=100 mm (3.94) / H=120 mm (4.72) / H=150 mm (5.91)	149 - 151
Hemming dies	152
Synthetic dies, H=100 mm (3.94)	153
Die adapters	153

Compatibility

Dies Roller Type R3 are:

- **compatible** with press brakes with a table groove 13 x 20 mm (0.51 x 0.79 in):
Bystronic-Beyeler, Safan, SMD, Trumpf, Darley, press brake machines with System NSCR
- also applicable on all other press brakes **with adapters and die holders** (see pages 232-235).

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 266-269)
- very large stock availability

Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

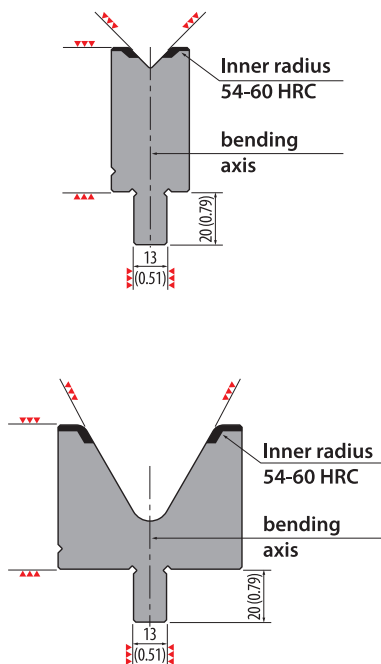
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

All Roller R3 type dies have got **13 x 20 mm tang (0.51 x 0.79 in)**

Indications of precision ground surfaces:

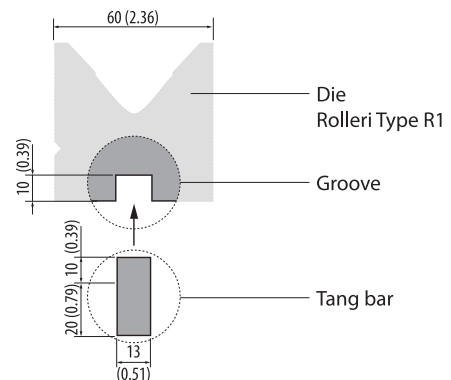


Modification: tang bar

To use Roller Type R1 dies, a 10 mm groove is milled where a ground bar is mounted.

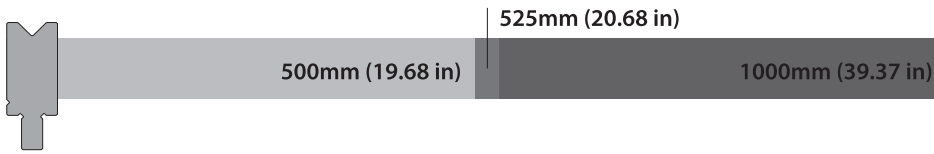
For more specific information and prices go to page 268 in the Modification Chapter.

Example of Application

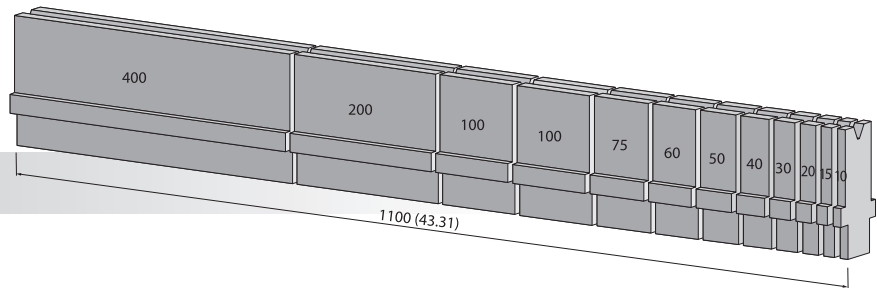


Tool lengths and sectioning

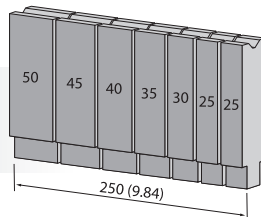
Standard



1100 mm (43.31 in) segmented
(12 segments)

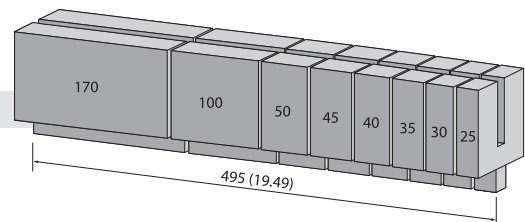


250 mm (9.84 in) segmented / FC
(7 segments)

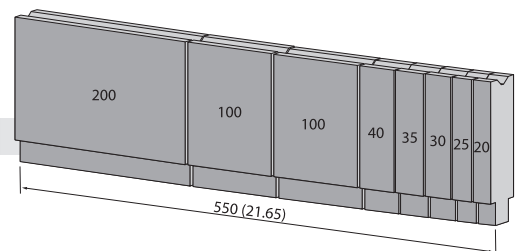


Segmented tools are delivered in complete sets. More lengths and sectionings are possible upon request.

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



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



Article on stock



Please ask for delivery time!

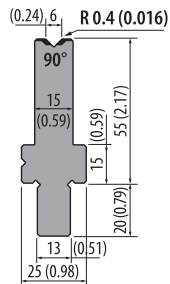
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

BMR55.06.90

1150 kN/m max.



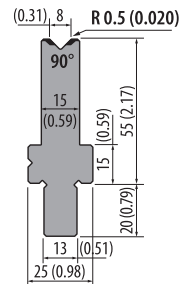
1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.08.90

1100 kN/m max.



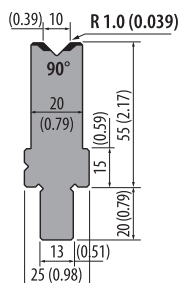
1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.10.90

1100 kN/m max.



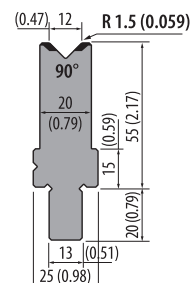
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.90

1200 kN/m max.



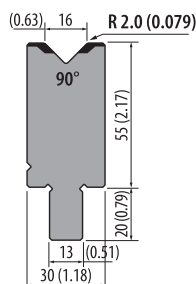
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.90

1200 kN/m max.



1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

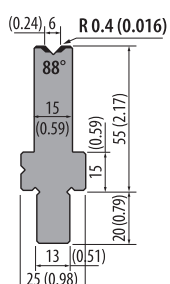
42Cr: 900-1150 N/mm²



88° dies, H=55 (2.17)

BMR55.06.88

1150 kN/m max.



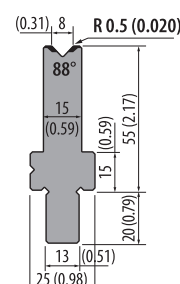
1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.08.88

1100 kN/m max.



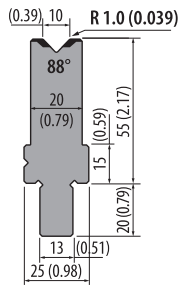
1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.10.88

1100 kN/m max.



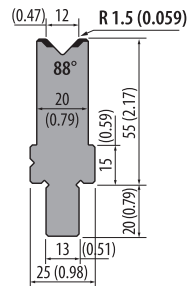
1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	12.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.88

1200 kN/m max.



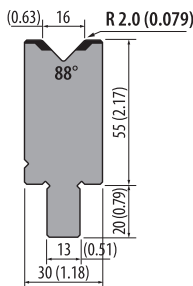
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.88

1200 kN/m max.



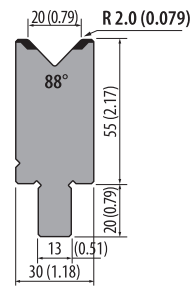
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR55.20.88

1100 kN/m max.



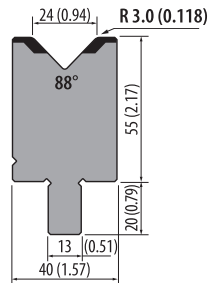
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR55.24.88

1200 kN/m max.



1000 mm	39.37 in	18.5 kg
500 mm	19.68 in	9.2 kg
1100 mm segmented	43.31 in segmented	18.0 kg

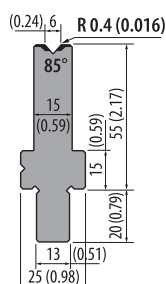
42Cr: 900-1150 N/mm²



85° dies, H=55 (2.17)

BMR55.06.85

1150 kN/m max.



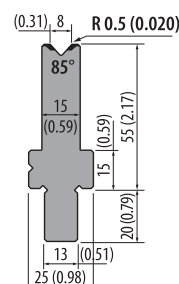
1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.08.85

1100 kN/m max.



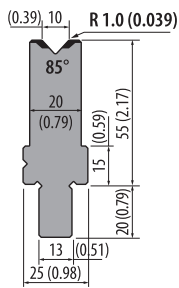
1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.10.85

1100 kN/m max.



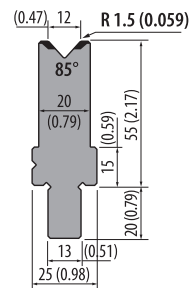
1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	12.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.85

1200 kN/m max.



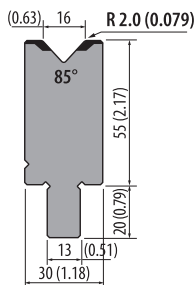
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.85

1200 kN/m max.



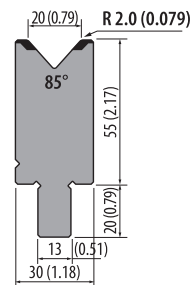
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR55.20.85

1100 kN/m max.



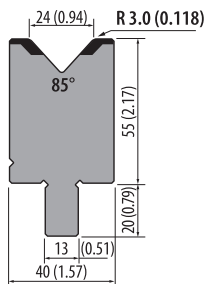
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR55.24.85

1200 kN/m max.



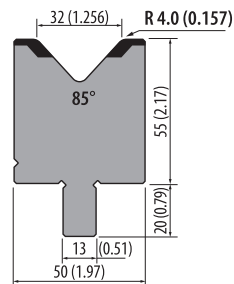
1000 mm	39.37 in	18.5 kg
500 mm	19.68 in	9.2 kg
1100 mm segmented	43.31 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



BMR55.32.85

1200 kN/m max.



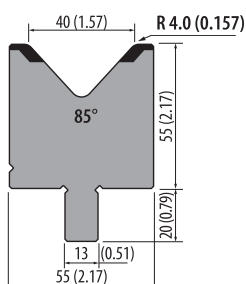
1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	20.5 kg

42Cr: 900-1150 N/mm²



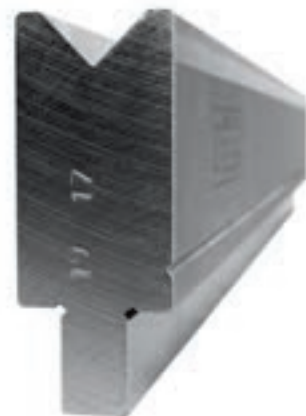
BMR55.40.85

1200 kN/m max.



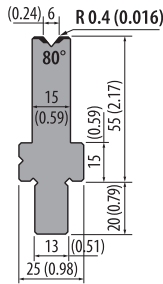
1000 mm	39.37 in	21.5 kg
500 mm	19.68 in	10.7 kg
1100 mm segmented	43.31 in segmented	25.0 kg

42Cr: 900-1150 N/mm²



BMR55.06.80

1150 kN/m max.



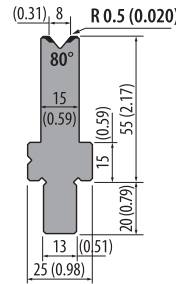
1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.08.80

1100 kN/m max.



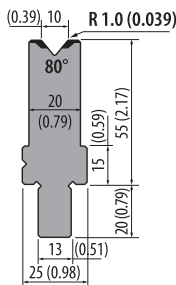
1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²



BMR55.10.80

1100 kN/m max.



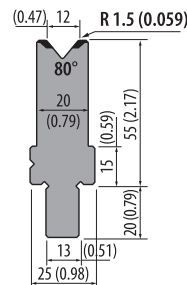
1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	12.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.80

1200 kN/m max.



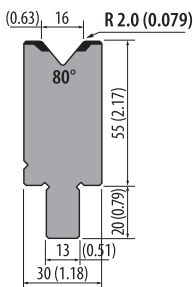
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.80

1200 kN/m max.



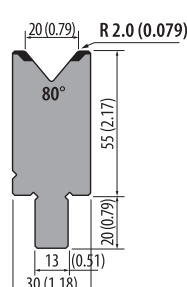
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR55.20.80

1100 kN/m max.



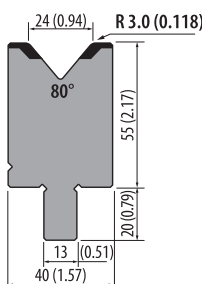
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR55.24.80

1200 kN/m max.



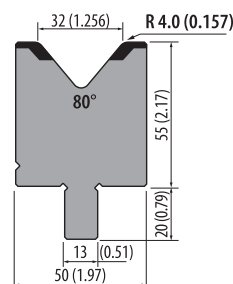
1000 mm	39.37 in	18.5 kg
500 mm	19.68 in	9.2 kg
1100 mm segmented	43.31 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



BMR55.32.80

1200 kN/m max.



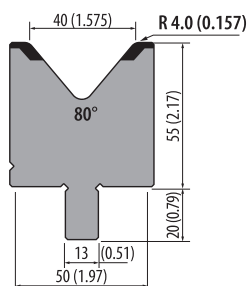
1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	20.5 kg

42Cr: 900-1150 N/mm²



BMR55.40.80

1200 kN/m max.



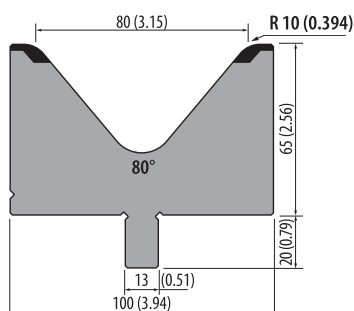
1000 mm	39.37 in	21.5 kg
500 mm	19.68 in	10.7 kg
1100 mm segmented	43.31 in segmented	25.0 kg

42Cr: 900-1150 N/mm²



BMR65.80.80

1700 kN/m max.



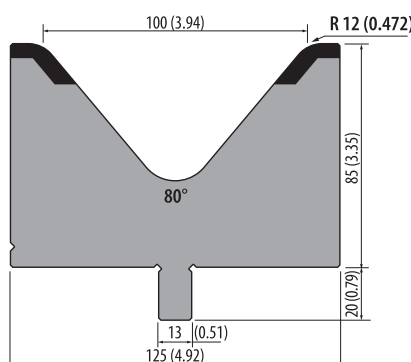
1000 mm	39.37 in	39.0 kg
500 mm	19.68 in	20.0 kg
1100 mm segmented	43.31 in segmented	43.0 kg

42Cr: 900-1150 N/mm²



BMR85.100.80

2300 kN/m max.



1000 mm	39.37 in	62.0 kg
500 mm	19.68 in	31.0 kg
1100 mm segmented	43.31 in segmented	69.0 kg

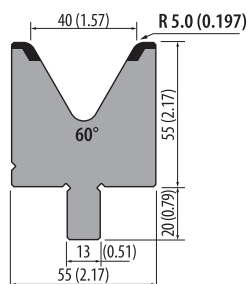
42Cr: 900-1150 N/mm²



Dies 60°, H=55 (2.17), H=65 (2.56)

BMR55.40.60

1300 kN/m max.



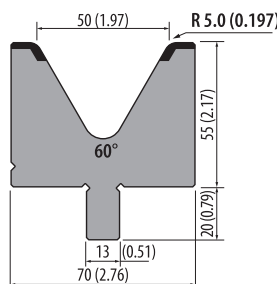
1000 mm	39.37 in	20.3 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	22.3 kg

42Cr: 900-1150 N/mm²



BMR55.50.60

1200 kN/m max.



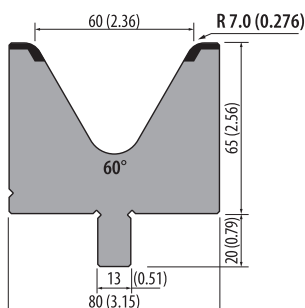
1000 mm	39.37 in	25.0 kg
500 mm	19.68 in	12.0 kg
1100 mm segmented	43.31 in segmented	21.0 kg

42Cr: 900-1150 N/mm²



BMR65.60.60

1100 kN/m max.



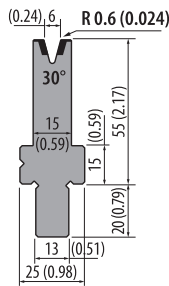
1000 mm	39.37 in	31.0 kg
500 mm	19.68 in	15.5 kg
1100 mm segmented	43.31 in segmented	34.1 kg

42Cr: 900-1150 N/mm²



BMR55.06.30

350 kN/m max.



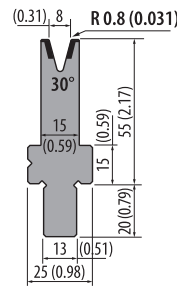
1000 mm	39.37 in	8.0 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	9.0 kg

42Cr: 900-1150 N/mm²



BMR55.08.30

200 kN/m max.



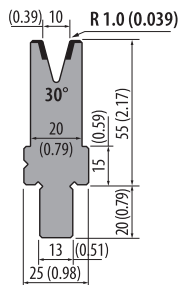
1000 mm	39.37 in	9.2 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	10.1 kg

42Cr: 900-1150 N/mm²



BMR55.10.30

350 kN/m max.



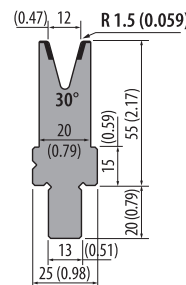
1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BMR55.12.30

300 kN/m max.



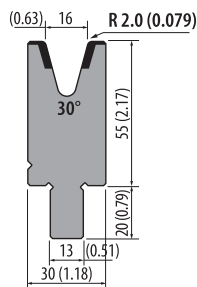
1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BMR55.16.30

450 kN/m max.



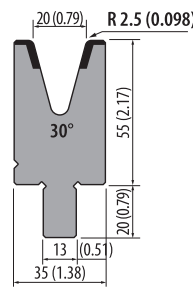
1000 mm	39.37 in	13.5 kg
500 mm	19.68 in	6.7 kg
1100 mm segmented	43.31 in segmented	14.9 kg

42Cr: 900-1150 N/mm²



BMR55.20.30

500 kN/m max.



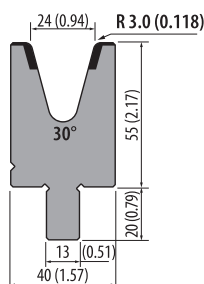
1000 mm	39.37 in	14.0 kg
500 mm	19.68 in	7.0 kg
1100 mm segmented	43.31 in segmented	13.5 kg

42Cr: 900-1150 N/mm²



BMR55.24.30

550 kN/m max.



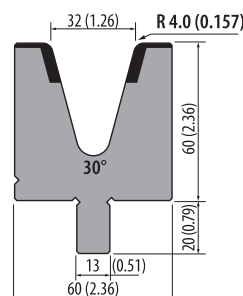
1000 mm	39.37 in	15.5 kg
500 mm	19.68 in	7.8 kg
1100 mm segmented	43.31 in segmented	17.0 kg

42Cr: 900-1150 N/mm²



BMR60.32.30

650 kN/m max.



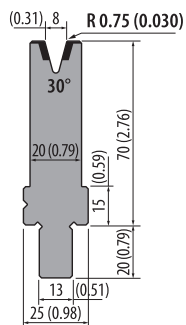
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	22.5 kg

42Cr: 900-1150 N/mm²



BMR70.08.30

200 kN/m max.



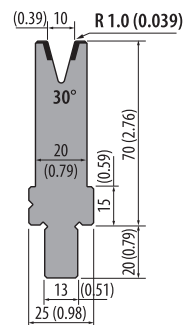
1000 mm	39.37 in	13.1 kg
500 mm	19.68 in	6.5 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



BMR70.10.30

350 kN/m max.



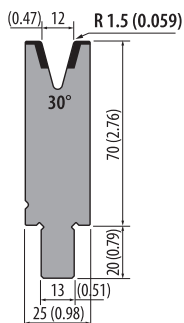
1000 mm	39.37 in	12.8 kg
500 mm	19.68 in	6.4 kg
1100 mm segmented	43.31 in segmented	12.4 kg

42Cr: 900-1150 N/mm²



BMR70.12.30

300 kN/m max.



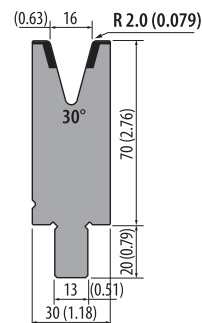
1000 mm	39.37 in	14.7 kg
500 mm	19.68 in	7.3 kg
1100 mm segmented	43.31 in segmented	14.3 kg

42Cr: 900-1150 N/mm²



BMR70.16.30

450 kN/m max.

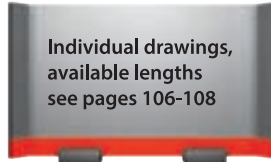
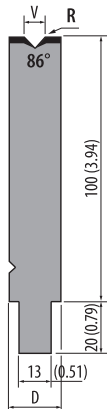


1000 mm	39.37 in	16.7 kg
500 mm	19.68 in	8.3 kg
1100 mm segmented	43.31 in segmented	16.2 kg

42Cr: 900-1150 N/mm²



86° dies, H=100 (3.94)

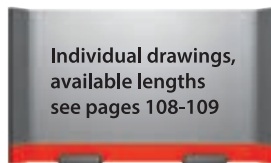
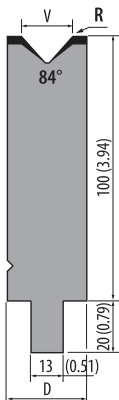


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.86	4	0.16	0.6	0.02	20	0.79	450
TMR100.06.86	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.86	8	0.31	0.8	0.03	20	0.79	1150
WMR100.08.86	8	0.31	2.5	0.10	25	0.98	400
TMR100.10.86	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.86	12	0.47	1.0	0.04	25	0.98	1200
WMR100.12.86	12	0.47	2.5	0.10	25	0.98	500
TMR100.16.86	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.86	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.86	24	0.94	2.5	0.10	35	1.38	1200
TMR100.30.86	30	1.18	3.0	0.12	45	1.77	1200
TMR100.40.86	40	1.57	3.0	0.12	55	2.17	1200
TMR100.50.86	50	1.97	3.0	0.12	75	2.95	1500



42Cr: 900-1150 N/mm²

84° dies, H=100 (3.94)

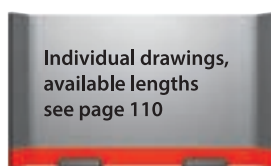
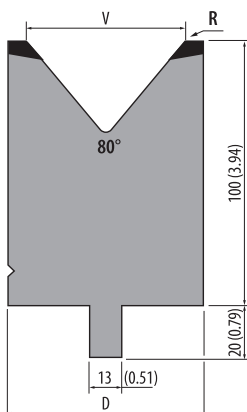


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.06.84	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.84	8	0.31	0.8	0.03	20	0.79	1150
TMR100.10.84	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.84	12	0.47	1.0	0.04	25	0.98	1200
TMR100.16.84	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.84	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.84	24	0.94	2.5	0.10	35	1.38	1200

42Cr: 900-1150 N/mm²



80° dies, H=100 (3.94) / H=120 (4.72)

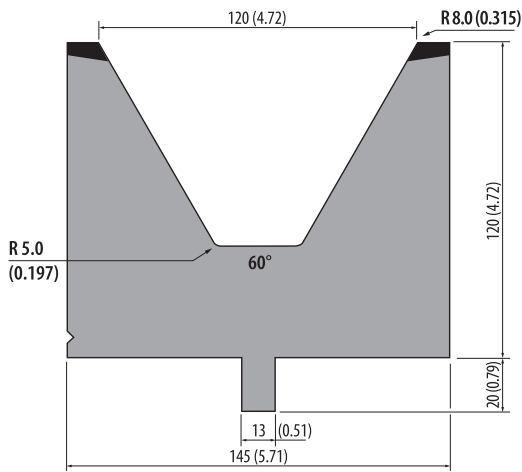


Model	V (mm)	V (in)	H (mm)	H (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.60.80	60	2.36	100	3.94	5.0	0.20	75	2.95	1500
TMR100.70.80	70	2.76	100	3.94	5.0	0.20	85	3.35	1500
TMR100.80.80	80	3.15	100	3.94	5.0	0.20	100	3.94	1500
TMR120.90.80	90	3.54	120	4.72	8.0	0.31	110	4.33	1500
TMR120.100.80	100	3.94	120	4.72	8.0	0.31	120	4.72	1500

42Cr: 900-1150 N/mm²

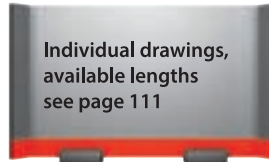


60° die, H=120 (4.72)

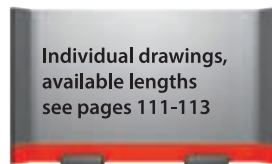
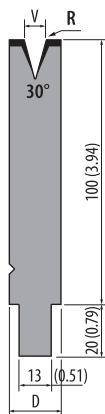


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR120.120.60	120	4.72	8.0	0.31	145	5.71	1000

42Cr: 900-1150 N/mm²



30° dies, H=100 (3.94)

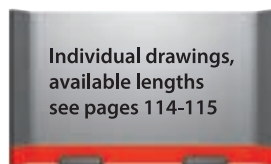
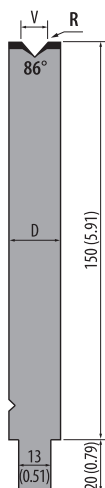


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.30	4	0.16	0.6	0.02	20	0.79	150
TMR100.06.30	6	0.24	0.6	0.02	20	0.79	400
WMR100.06.30	6	0.24	2.0	0.08	20	0.79	400
TMR100.08.30	8	0.31	1.0	0.04	20	0.79	400
WMR100.08.30	8	0.31	2.5	0.10	20	0.79	400
TMR100.10.30	10	0.39	1.0	0.04	20	0.79	400
WMR100.10.30	10	0.39	2.5	0.10	25	0.98	400
TMR100.12.30	12	0.47	1.0	0.04	25	0.98	400
WMR100.12.30	12	0.47	3.0	0.12	25	0.98	400
TMR100.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR100.20.30	20	0.79	2.0	0.08	30	1.18	600
TMR100.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR100.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR100.40.30	40	1.57	5.0	0.20	60	2.36	900

42Cr: 900-1150 N/mm²



86° dies, H=150 (5.91)

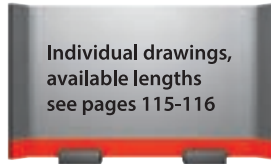
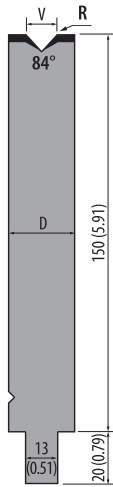


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.86	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.86	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.86	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.86	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.86	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.86	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.86	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm²



84° dies, H=150 (5.91)

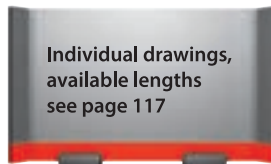
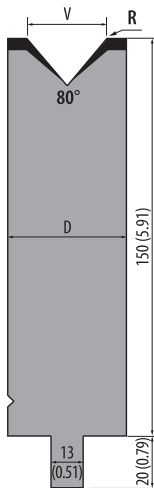


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.84	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.84	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.84	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.84	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.84	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.84	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.84	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm²



80° dies, H=150 (5.91)

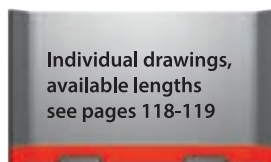
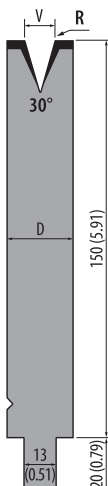


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.24.80	24	0.94	2.5	0.10	35	1.38	700
TMR150.30.80	30	1.18	5.0	0.20	45	1.77	900
TMR150.40.80	40	1.57	5.0	0.20	55	2.17	1200
TMR150.50.80	50	1.97	5.0	0.20	65	2.56	1500

42Cr: 900-1150 N/mm²



30° dies, H=150 (5.91)

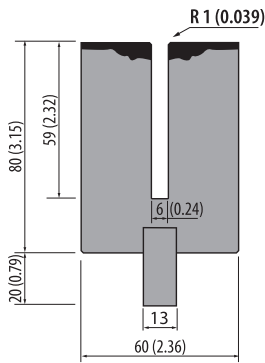


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.30	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.30	8	0.31	1.0	0.04	20	0.79	400
TMR150.10.30	10	0.39	1.0	0.04	20	0.79	400
TMR150.12.30	12	0.47	1.0	0.04	25	0.98	400
TMR150.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR150.20.30	20	0.79	2.0	0.08	35	1.38	600
TMR150.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR150.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR150.40.30	40	1.57	5.0	0.20	55	2.17	900

42Cr: 900-1150 N/mm²



BPR.SM.195.28.6



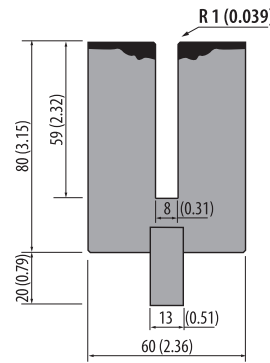
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



Only for thin material!
Hemming punches
see page 130

BPR.SM.195.28.8

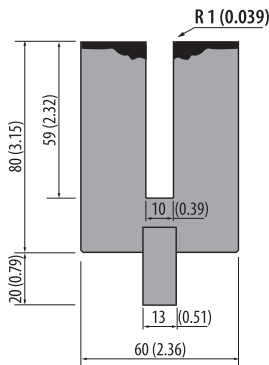


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.10

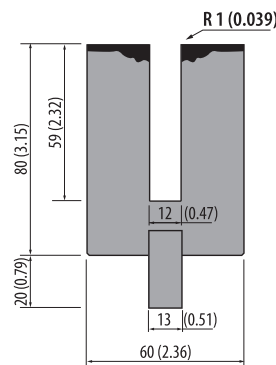


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.12

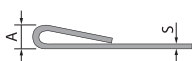


525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	10.8 kg

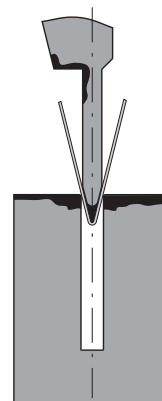
42Cr: 900-1150 N/mm²



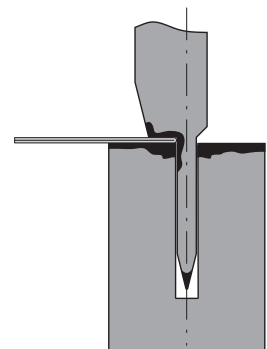
Example of Application



S mm	S in	A mm	A in	R.420 kN/mm ² t/m	R.700 kN/mm ² t/m	S mm	S in	A mm	A in	R.420 kN/mm ² t/m	R.700 kN/mm ² t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80



800 kN/m max.



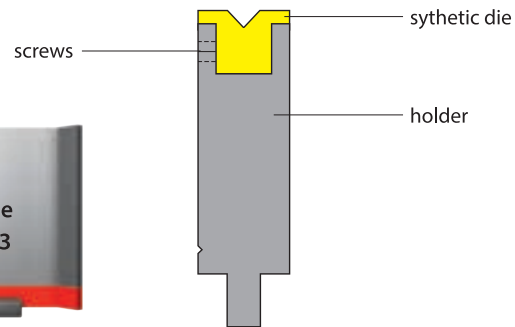
1000 kN/m max.

Our Advantages – Your Convenience

- No friction marks on the sheet metal
- Decrease of post-processing operations of bent profiles
- No material residues
- Better quality of the bent product
- Easy usage

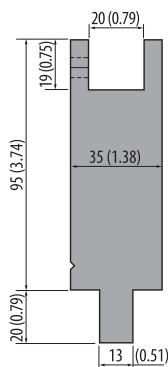
Mounting example

Synthetic dies are inserted into the holder and clamped with screws.



TMN95.20

1000 kN/m max.



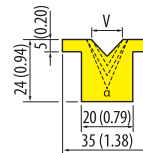
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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



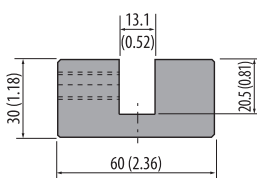
Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

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

Die adapters

AD6

1000 kN/m max.



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

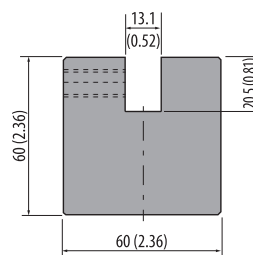
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD5

1000 kN/m max.



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

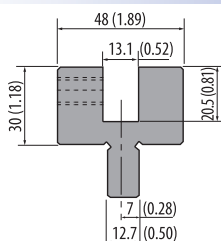
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.



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

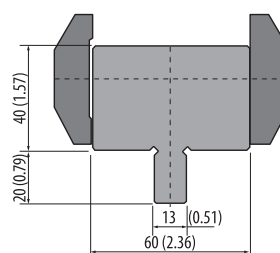
Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD7

1000 kN/m max.

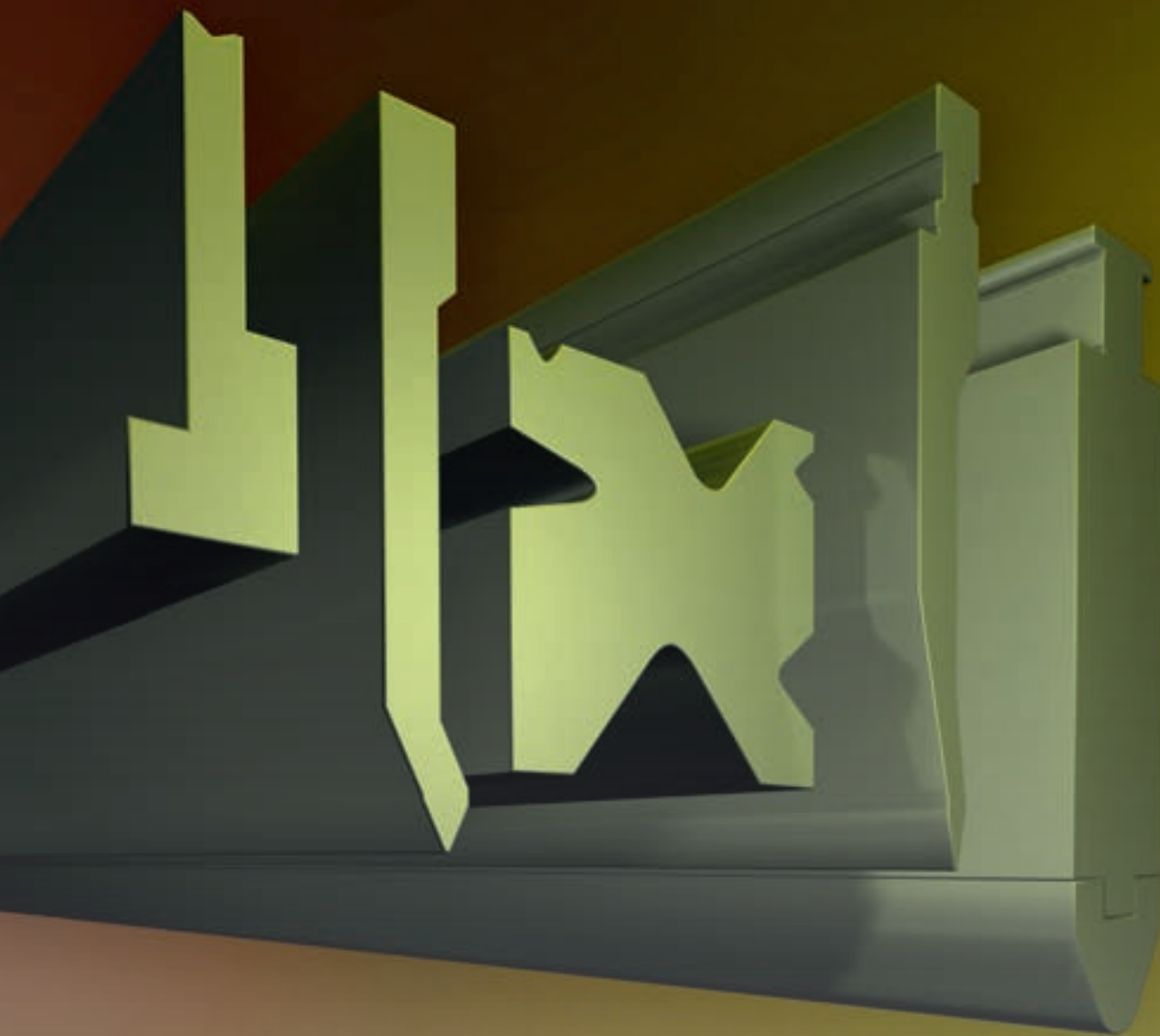
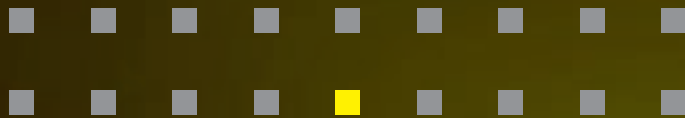


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²





RX

Compatibility

Tools Rolleri Type RX are **compatible** with the following press brakes:

- LVD
- Hämmerle-Bystronic
- Colgar
- EHT
- Colly
- Ajial-Axial
- Weinbrenner
- Gasparini
- American, etc.

With the use of adapters Rolleri RX type punches can be mounted in other press brake models.

TOOLS ROLLER TYPE RX

Content Explanation	156
LVD: Explanation	157
LVD: Punches	158 - 159
LVD: Dies	160
LVD: Multi-V-Dies	161 - 168
LVD: Hemming Tools	169
LVD: Adapters	170
EHT: Explanation	171
Weinbrenner: Explanation	171
Hämmerle-Bystronic: Explanation	172
Hämmerle-Bystronic: Punches	172 - 177
Hämmerle-Bystronic: Punch Holders	178 - 179
Hämmerle-Bystronic: Radius Tools	180
Hämmerle-Bystronic: Die Holders	181
Hämmerle-Bystronic: Dies	182 - 185
Colly: Explanation	186
Colly: Punches	186 - 188
Colly: Dies	189 - 190
Gasparini: Explanation	191
Gasparini: Radius Tools and Punches	191 - 193
Colgar: Explanation	194
Colgar: Punches and Radius Tools	194
Ajial-Axial: Explanation	195
Ajial-Axial: Punches and Adapters	195
American: Explanation	196
American: Punches and Dies	196 - 199

Compatibility

Tools Roller Type RX are:

- **compatible** with the following press brakes: LVD, EHT, Weinbrenner, Hämmerle-Bystronic, Colly, Gasparini, Colgar, Ajial-Axial, American, etc.
- **with adapters** (see pages 226-235) also applicable on all other press brakes

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modification possible (see pages 264-269)
- very large stock availability

Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

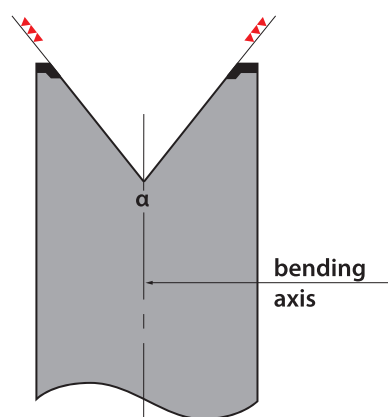
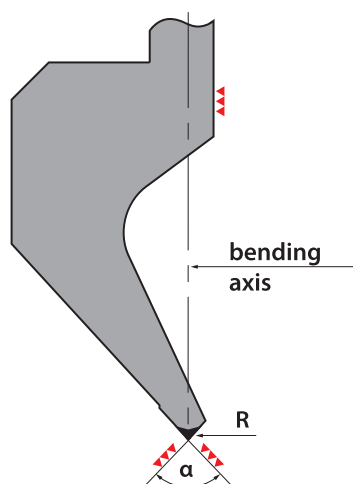
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

Rolleri RX type tools can have different tangs.

Indications of precision ground areas:



Tool lengths, sectionings and horn types

- tools Roller type RX are available in different lengths
- customized sectioning available upon your request
- customized horn pieces available upon request

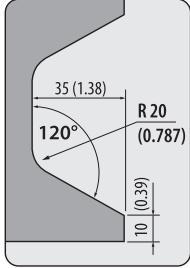
Tool lengths, sectionings and horn types

Punches:

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented
9 segments
(100 Horn left, 25, 30, 35, 40, 45, 50, 125, 100 Horn right)
- 2x 250 mm (9.84 in) segmented

Dies:

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented
9 segments (25, 30, 35, 40, 45, 50, 100, 100, 125)
- 2x 250 mm (9.84 in) segmented



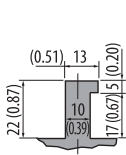
Standard horns
for all segmented
Rolleri RX LVD type
punches

Hemming Tools:

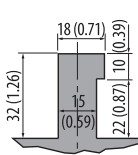
- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 2x 250 mm (9.84 in) segmented

Punch Tangs

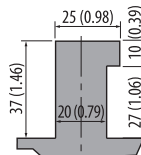
LVD punches have the following
5 different tangs



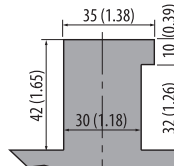
Tang A



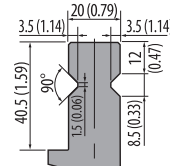
Tang B



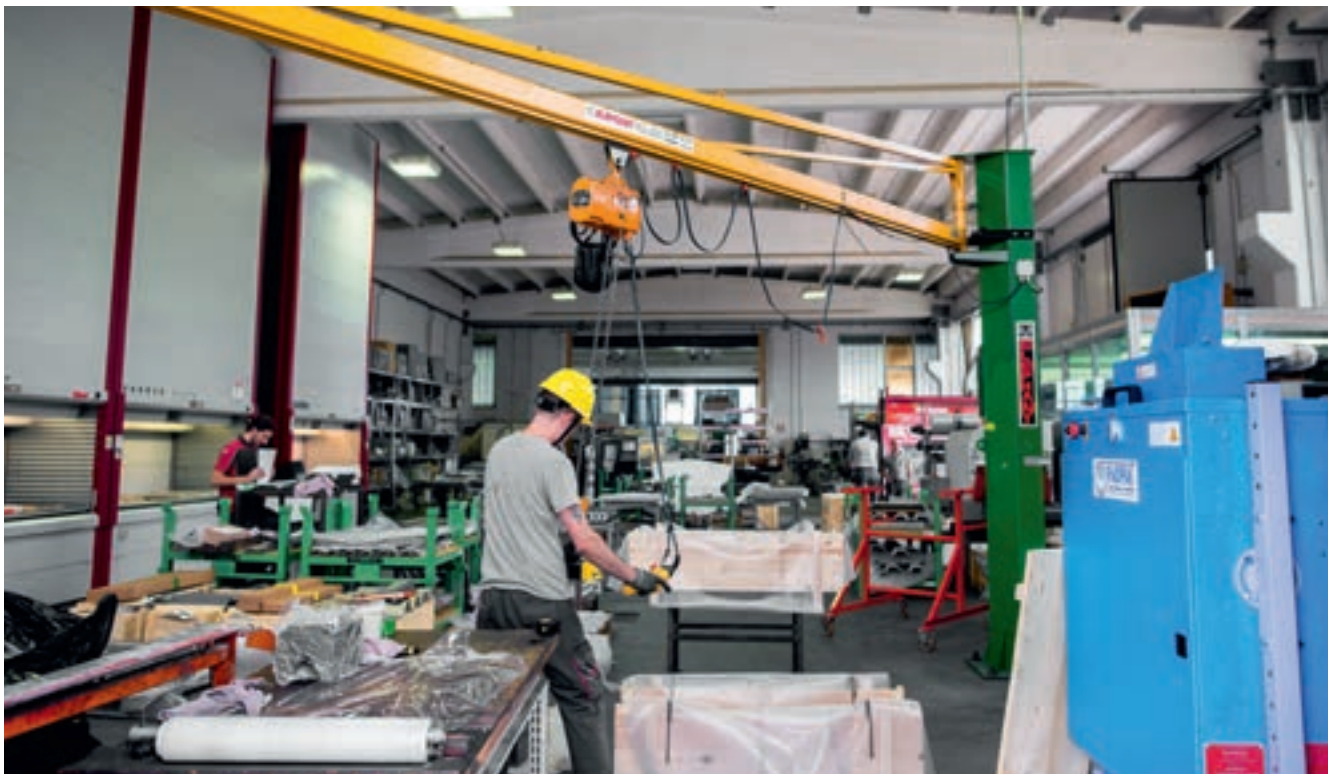
Tang C



Tang D



Tang W



Article
on stock



Please ask for
delivery time!

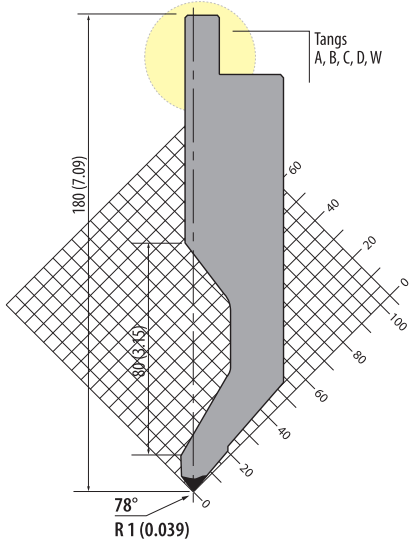
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

LP180.78.R1-A

700 kN/m max.



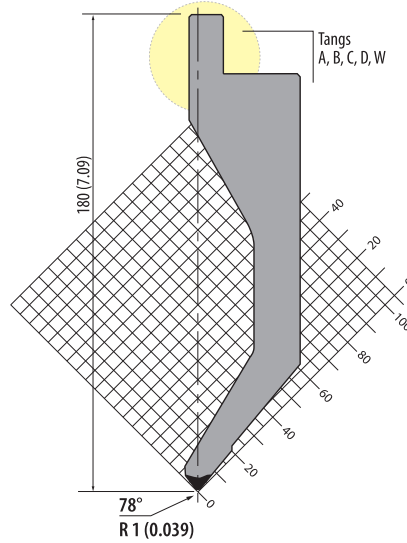
Tang A: LPA180.78.R1-A		
Tang B: LPB180.78.R1-A		
Tang C: LPC180.78.R1-A		
Tang D: LPD180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg
Tang W: LPW196.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg

42Cr: 900-1150 N/mm²



LP180.78.R1-B

450 kN/m max.



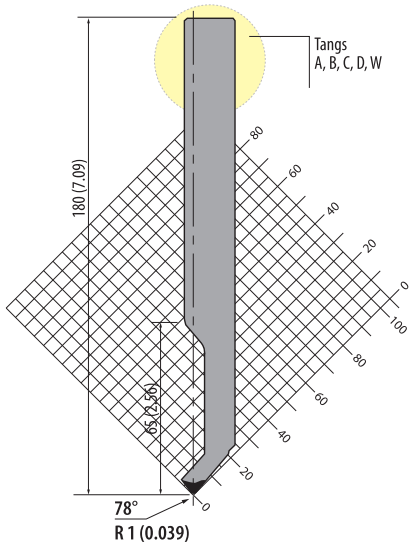
Tang A: LPA180.78.R1-B		
Tang B: LPB180.78.R1-B		
Tang C: LPC180.78.R1-B		
Tang D: LPD180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg
Tang W: LPW196.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg
2x250 mm segmented	2x9.84 in segmented	21.7 kg

42Cr: 900-1150 N/mm²



LP180.78.R1-C

500 kN/m max.



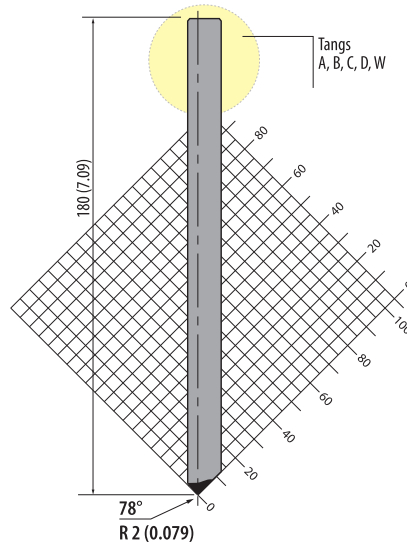
Tang A: LPA180.78.R1-C		
Tang B: LPB180.78.R1-C		
Tang C: LPC180.78.R1-C		
Tang D: LPD180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg
2x250 mm segmented	2x9.84 in segmented	10.9 kg
Tang W: LPW196.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg
2x250 mm segmented	2x9.84 in segmented	10.9 kg

42Cr: 900-1150 N/mm²



LP180.78-R2

1000 kN/m max.



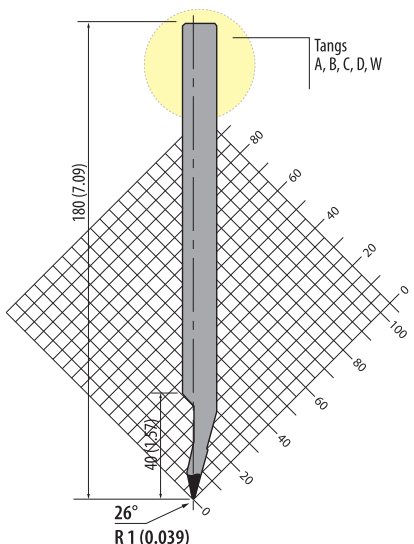
Tang A: LPA180.78-R2		
Tang B: LPB180.78-R2		
Tang C: LPC180.78-R2		
Tang D: LPD180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg
Tang W: LPW196.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



LP180.26-R1

500 kN/m max.



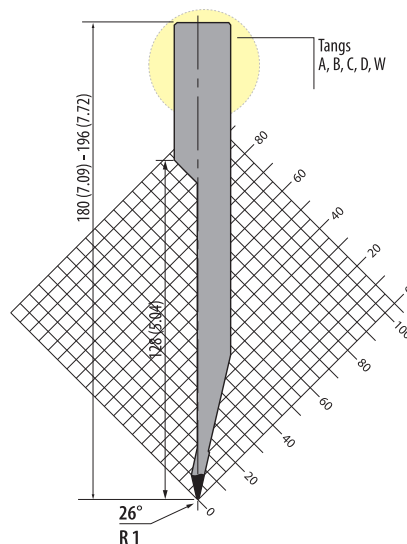
Tang A: LPA180.26-R1		
Tang B: LPB180.26-R1		
Tang C: LPC180.26-R1		
Tang D: LPD180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg
Tang W: LPW196.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



LP180.26.R1-A

400 kN/m max.



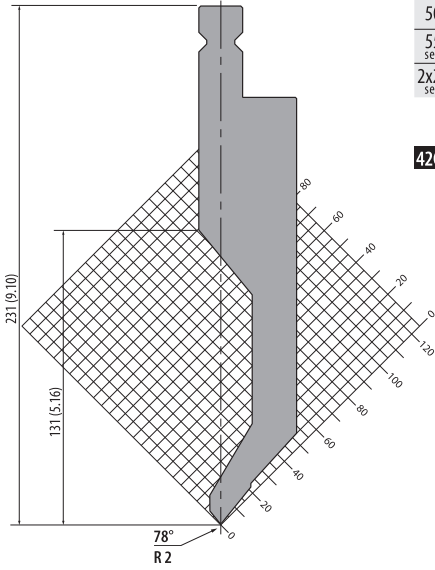
Tang A: LPA180.26.R1-A		
Tang B: LPB180.26.R1-A		
Tang C: LPC180.26.R1-A		
Tang D: LPD180.26.R1-A		
508 mm	20.00 in	12.5 kg
550 mm segmented	21.65 in segmented	13.5 kg
2x250 mm segmented	2x9.84 in segmented	12.3 kg
Tang W: LPW196.26.R1-A		
508 mm	20.00 in	12.5 kg
550 mm segmented	21.65 in segmented	13.5 kg
2x250 mm segmented	2x9.84 in segmented	12.3 kg

42Cr: 900-1150 N/mm²



LPW231.78.R2-A

800 kN/m max.



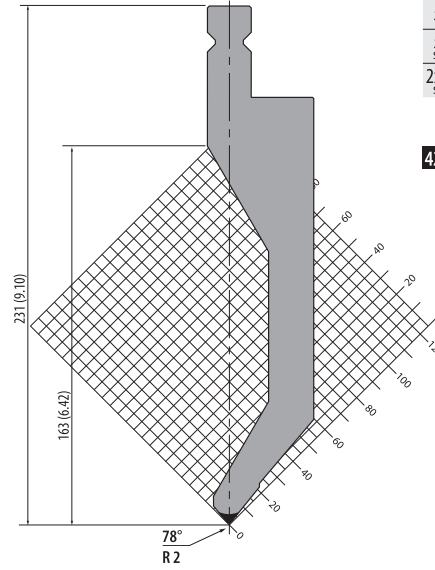
508 mm	20.00 in	27.6 kg
550 mm segmented	21.65 in segmented	29.9 kg
2x250 mm segmented	2x9.84 in segmented	27.2 kg

42Cr: 900-1150 N/mm²



LPW231.78.R2-B

750 kN/m max.



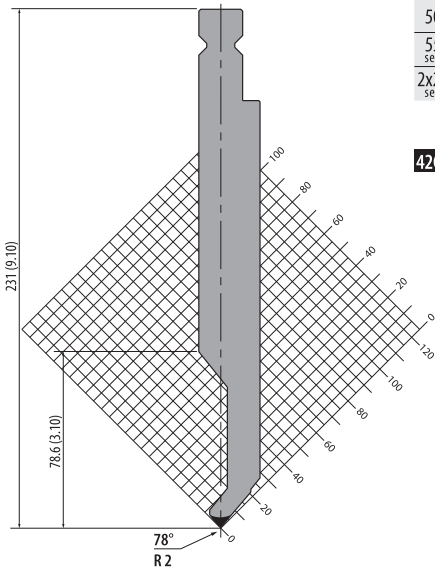
508 mm	20.00 in	23.4 kg
550 mm segmented	21.65 in segmented	25.4 kg
2x250 mm segmented	2x9.84 in segmented	23.1 kg

42Cr: 900-1150 N/mm²



LPW231.78.R2-C

500 kN/m max.



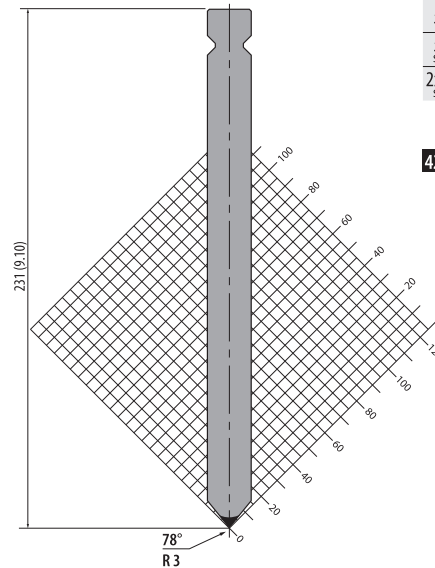
508 mm	20.00 in	19.1 kg
550 mm segmented	21.65 in segmented	20.7 kg
2x250 mm segmented	2x9.84 in segmented	18.8 kg

42Cr: 900-1150 N/mm²



LPW231.78-R3

1200 kN/m max.



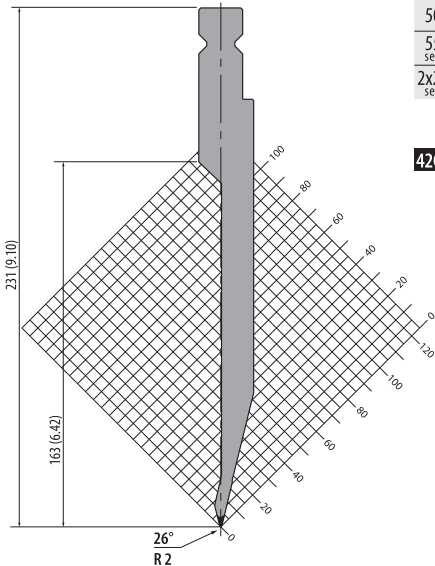
508 mm	20.00 in	18.3 kg
550 mm segmented	21.65 in segmented	19.8 kg
2x250 mm segmented	2x9.84 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



LPW231.26.R2-A

500 kN/m max.



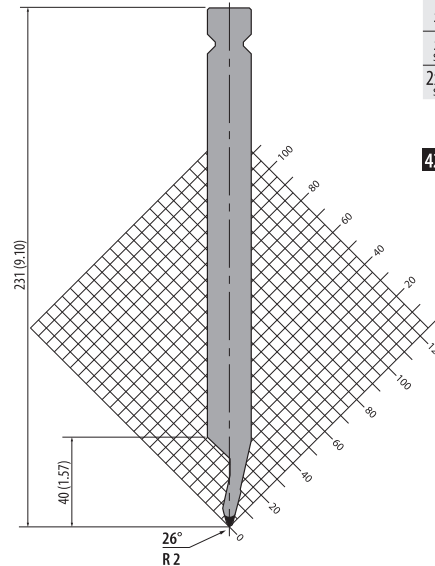
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg
2x250 mm segmented	2x9.84 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



LPW231.26.R2

500 kN/m max.



508 mm	20.00 in	16.3 kg
550 mm segmented	21.65 in segmented	17.6 kg
2x250 mm segmented	2x9.84 in segmented	16.0 kg

42Cr: 900-1150 N/mm²



7
RX



Article on stock



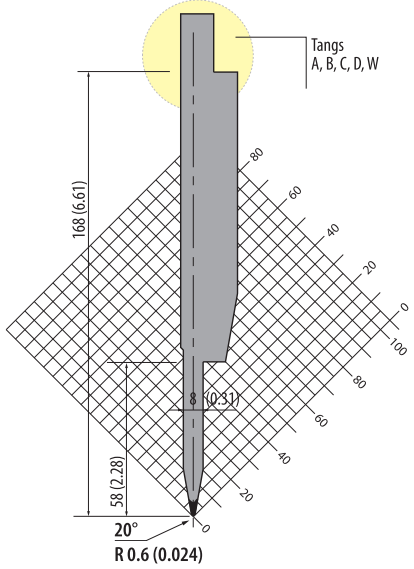
Please ask for delivery time!

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



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

LP.SP-190.20.8

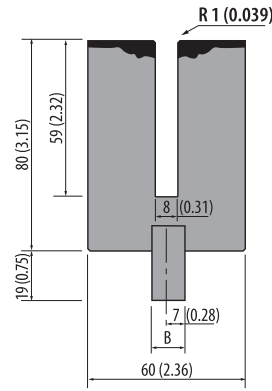


Tang A: LPA.SP-190.20.8		
Tang B: LPB.SP-190.20.8		
Tang C: LPC.SP-190.20.8		
Tang D: LPD.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg
Tang W: LPW.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg

42Cr: 900-1150 N/mm²



LP.SM-190.20.8-12.7 / -12

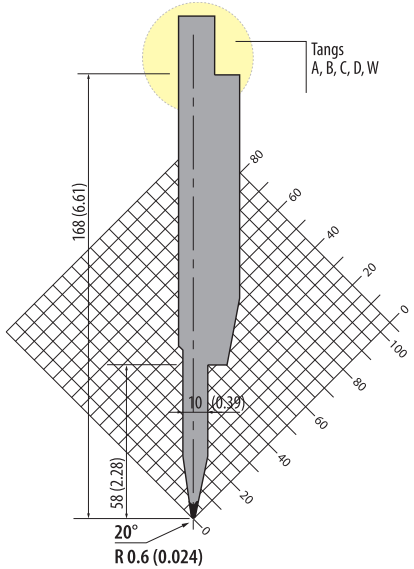


B=12.7 mm		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg
2x250 mm segmented	2x9.84 in segmented	17.8 kg
B=12 mm		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg
2x250 mm segmented	2x9.84 in segmented	17.8 kg

42Cr: 900-1150 N/mm²



LP.SP-190.20.10

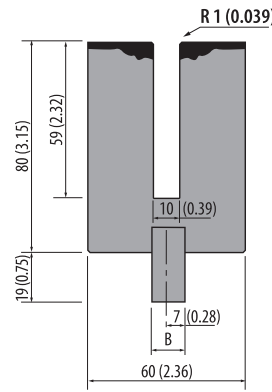


Tang A: LPA.SP-190.20.10		
Tang B: LPB.SP-190.20.10		
Tang C: LPC.SP-190.20.10		
Tang D: LPD.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg
2x250 mm segmented	2x9.84 in segmented	12.5 kg
Tang W: LPW.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg
2x250 mm segmented	2x9.84 in segmented	12.5 kg

42Cr: 900-1150 N/mm²



LP.SM-190.20.10-12.7 / -12

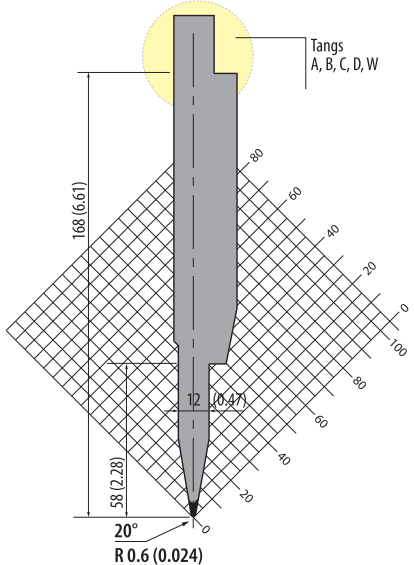


B=12.7 mm		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg
2x250 mm segmented	2x9.84 in segmented	17.4 kg
B=12 mm		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg
2x250 mm segmented	2x9.84 in segmented	17.4 kg

42Cr: 900-1150 N/mm²



LP.SP-190.20.12

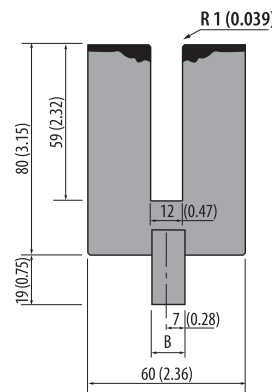


Tang A: LPA.SP-190.20.12		
Tang B: LPB.SP-190.20.12		
Tang C: LPC.SP-190.20.12		
Tang D: LPD.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg
2x250 mm segmented	2x9.84 in segmented	13.0 kg
Tang W: LPW.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg
2x250 mm segmented	2x9.84 in segmented	13.0 kg

42Cr: 900-1150 N/mm²



LP.SM-190.20.12-12.7 / -12

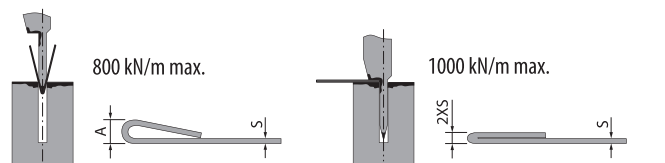


B=12.7 mm		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg
2x250 mm segmented	2x9.84 in segmented	16.9 kg
B=12 mm		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg
2x250 mm segmented	2x9.84 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



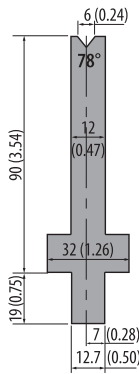
Example of Application



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	kN/mm ²	mm	in	mm	in	kN/mm ²	kN/mm ²
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

LM90.06.78

400 kN/m max.



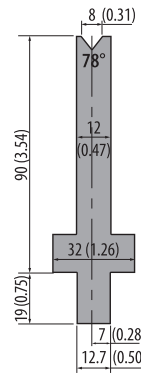
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.08.78

400 kN/m max.



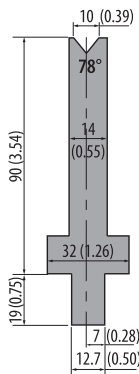
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.10.78

500 kN/m max.



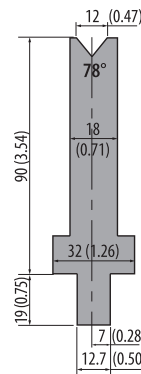
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.5 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.12.78

600 kN/m max.



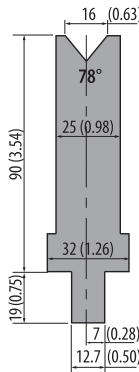
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.7 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.16.78

800 kN/m max.



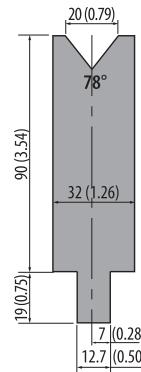
508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg
2x250 mm segmented	2x9.84 in segmented	9.9 kg

42Cr: 900-1150 N/mm²



LM90.20.78

1000 kN/m max.



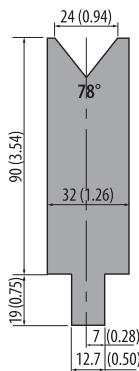
508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.8 kg
2x250 mm segmented	2x9.84 in segmented	11.8 kg

42Cr: 900-1150 N/mm²



LM90.24.78

1000 kN/m max.



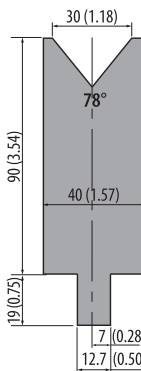
508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg
2x250 mm segmented	2x9.84 in segmented	9.9 kg

42Cr: 900-1150 N/mm²



LM90.30.78

1100 kN/m max.



508 mm	20.00 in	12.0 kg
550 mm segmented	21.65 in segmented	13.0 kg
2x250 mm segmented	2x9.84 in segmented	11.8 kg

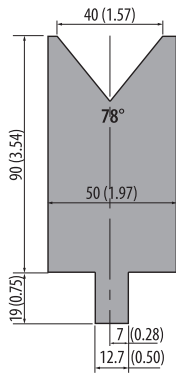
42Cr: 900-1150 N/mm²



7
RX

LM90.40.78

1300 kN/m max.



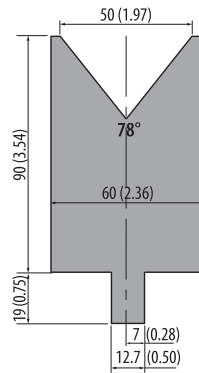
508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg

42Cr: 900-1150 N/mm²



LM90.50.78

1500 kN/m max.



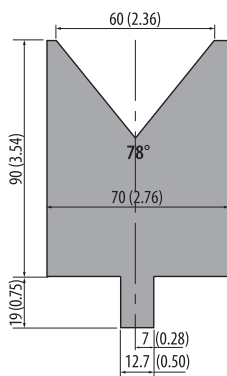
508 mm	20.00 in	19.5 kg
550 mm segmented	21.65 in segmented	21.0 kg
2x250 mm segmented	2x9.84 in segmented	19.2 kg

42Cr: 900-1150 N/mm²



LM90.60.78

1500 kN/m max.



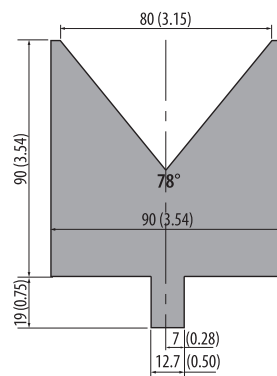
508 mm	20.00 in	23.0 kg
550 mm segmented	21.65 in segmented	24.9 kg
2x250 mm segmented	2x9.84 in segmented	22.7 kg

42Cr: 900-1150 N/mm²



LM90.80.78

1500 kN/m max.



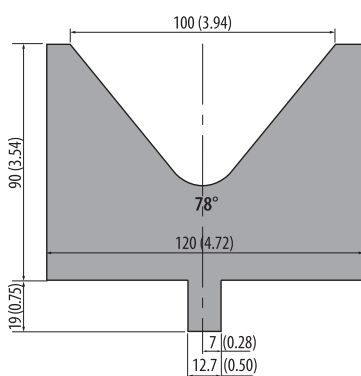
508 mm	20.00 in	25.5 kg
550 mm segmented	21.65 in segmented	27.6 kg
2x250 mm segmented	2x9.84 in segmented	25.1 kg

42Cr: 900-1150 N/mm²



LM90.100.78

1200 kN/m max.



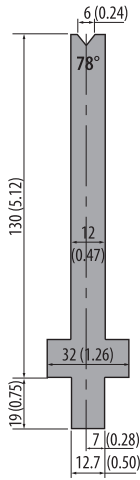
508 mm	20.00 in	31.0 kg
550 mm segmented	21.65 in segmented	33.5 kg
2x250 mm segmented	2x9.84 in segmented	30.6 kg

42Cr: 900-1150 N/mm²



LM130.06.78

400 kN/m max.



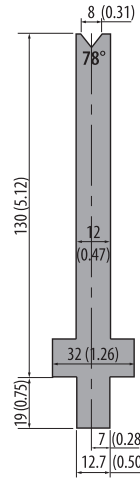
508 mm	20.00 in	8.3 kg
550 mm segmented	21.65 in segmented	9.0 kg
2x250 mm segmented	2x9.84 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



LM130.08.78

400 kN/m max.



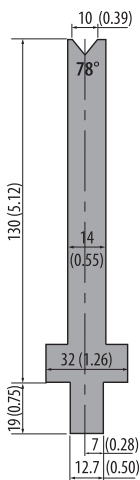
508 mm	20.00 in	8.4 kg
550 mm segmented	21.65 in segmented	9.1 kg
2x250 mm segmented	2x9.84 in segmented	8.3 kg

42Cr: 900-1150 N/mm²



LM130.10.78

500 kN/m max.



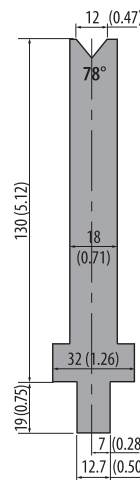
508 mm	20.00 in	10.1 kg
550 mm segmented	21.65 in segmented	11.0 kg
2x250 mm segmented	2x9.84 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



LM130.12.78

600 kN/m max.



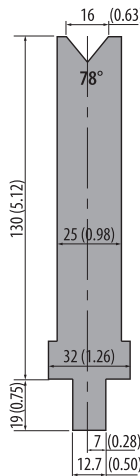
508 mm	20.00 in	11.1 kg
550 mm segmented	21.65 in segmented	12.0 kg
2x250 mm segmented	2x9.84 in segmented	10.9 kg

42Cr: 900-1150 N/mm²



LM130.16.78

800 kN/m max.



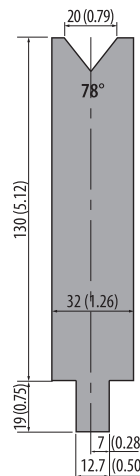
508 mm	20.00 in	14.3 kg
550 mm segmented	21.65 in segmented	15.5 kg
2x250 mm segmented	2x9.84 in segmented	14.1 kg

42Cr: 900-1150 N/mm²



LM130.20.78

1000 kN/m max.



508 mm	20.00 in	17.5 kg
550 mm segmented	21.65 in segmented	19.0 kg
2x250 mm segmented	2x9.84 in segmented	17.2 kg

42Cr: 900-1150 N/mm²



7
RX



Article on stock



Please ask for delivery time!

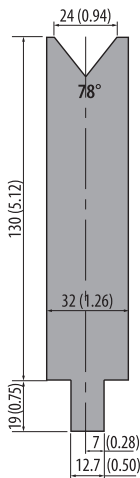
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

LM130.24.78

1000 kN/m max.



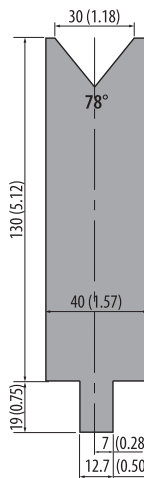
508 mm	20.00 in	17.0 kg
550 mm segmented	21.65 in segmented	18.5 kg
2x250 mm segmented	2x9.84 in segmented	16.8 kg

42Cr: 900-1150 N/mm²



LM130.30.78

1100 kN/m max.



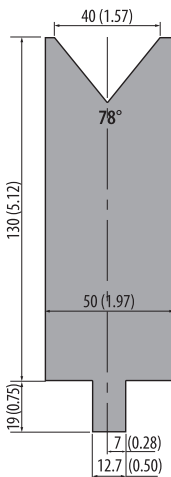
508 mm	20.00 in	20.7 kg
550 mm segmented	21.65 in segmented	22.4 kg
2x250 mm segmented	2x9.84 in segmented	20.4 kg

42Cr: 900-1150 N/mm²



LM130.40.78

1300 kN/m max.



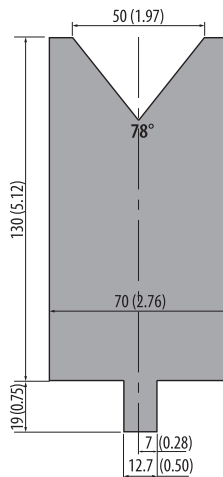
508 mm	20.00 in	26.6 kg
550 mm segmented	21.65 in segmented	28.9 kg
2x250 mm segmented	2x9.84 in segmented	26.2 kg

42Cr: 900-1150 N/mm²



LM130.50.78

1500 kN/m max.



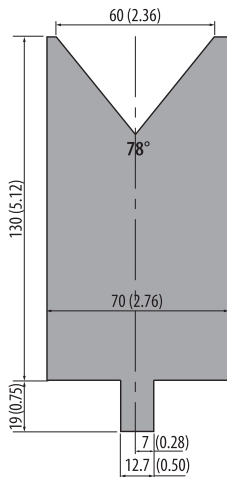
508 mm	20.00 in	34.2 kg
550 mm segmented	21.65 in segmented	37.0 kg
2x250 mm segmented	2x9.84 in segmented	33.6 kg

42Cr: 900-1150 N/mm²



LM130.60.78

1500 kN/m max.



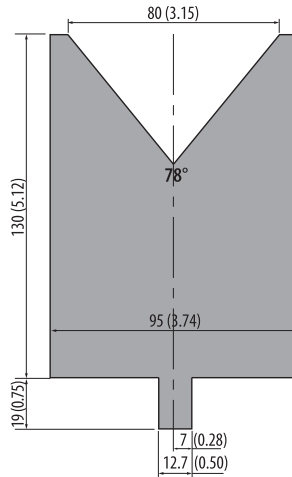
508 mm	20.00 in	34.2 kg
550 mm segmented	21.65 in segmented	37.0 kg
2x250 mm segmented	2x9.84 in segmented	33.6 kg

42Cr: 900-1150 N/mm²



LM130.80.78

1500 kN/m max.



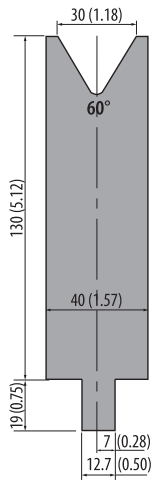
508 mm	20.00 in	42.3 kg
550 mm segmented	21.65 in segmented	45.8 kg
2x250 mm segmented	2x9.84 in segmented	41.6 kg

42Cr: 900-1150 N/mm²



LM130.30.60

500 kN/m max.



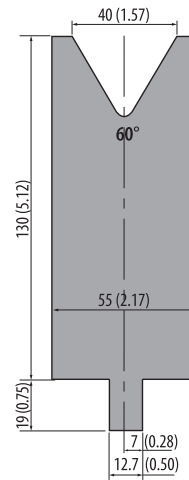
508 mm	20.00 in	20.4 kg
550 mm segmented	21.65 in segmented	22.1 kg
2x250 mm segmented	2x9.84 in segmented	20.1 kg

42Cr: 900-1150 N/mm²



LM130.40.60

660 kN/m max.



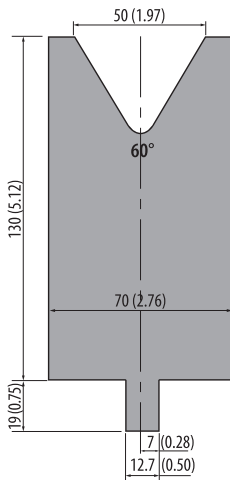
508 mm	20.00 in	26.8 kg
550 mm segmented	21.65 in segmented	29.1 kg
2x250 mm segmented	2x9.84 in segmented	26.4 kg

42Cr: 900-1150 N/mm²



LM130.50.60

1050 kN/m max.



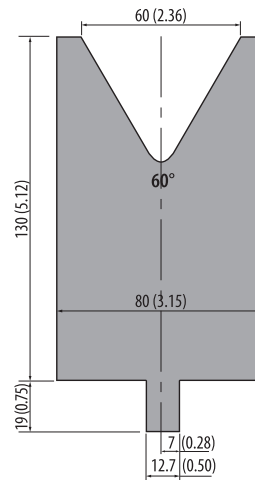
508 mm	20.00 in	33.0 kg
550 mm segmented	21.65 in segmented	35.7 kg
2x250 mm segmented	2x9.84 in segmented	32.5 kg

42Cr: 900-1150 N/mm²



LM130.60.60

1200 kN/m max.



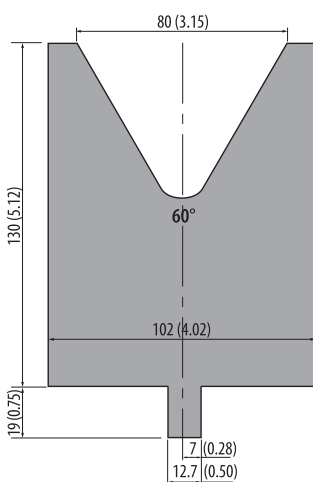
508 mm	20.00 in	36.5 kg
550 mm segmented	21.65 in segmented	39.6 kg
2x250 mm segmented	2x9.84 in segmented	36.0 kg

42Cr: 900-1150 N/mm²



LM130.80.60

1750 kN/m max.



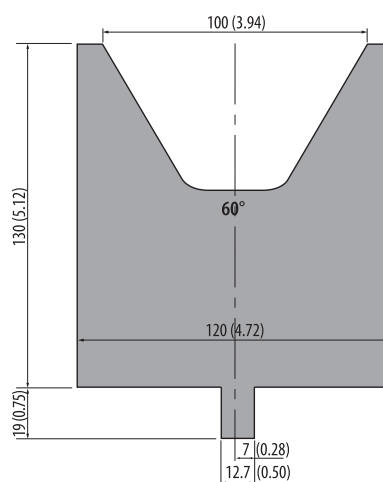
508 mm	20.00 in	43.0 kg
550 mm segmented	21.65 in segmented	46.6 kg
2x250 mm segmented	2x9.84 in segmented	42.4 kg

42Cr: 900-1150 N/mm²



LM130.100.60

1600 kN/m max.



508 mm	20.00 in	47.6 kg
550 mm segmented	21.65 in segmented	51.5 kg
2x250 mm segmented	2x9.84 in segmented	46.8 kg

42Cr: 900-1150 N/mm²



7
RX



Article on stock



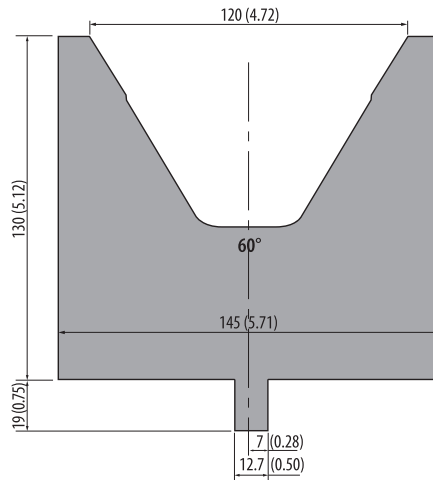
Please ask for delivery time!

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



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

LM130.120.60



1300 kN/m max.

508 mm	20.00 in	51.0 kg
550 mm segmented	21.65 in segmented	55.2 kg
2x250 mm segmented	2x9.84 in segmented	50.2 kg

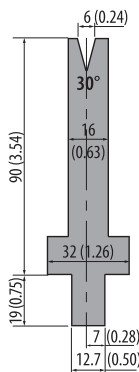
42Cr: 900-1150 N/mm²



30° LVD dies, H=90 (3.54)

LM90.06.30

200 kN/m max.



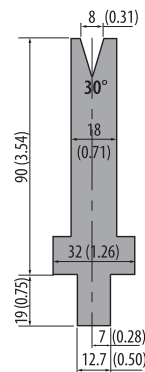
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.08.30

220 kN/m max.



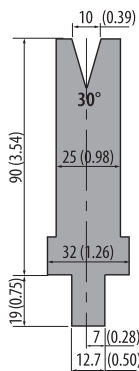
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.10.30

300 kN/m max.



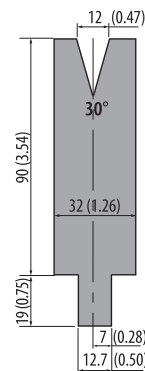
508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg
2x250 mm segmented	2x9.84 in segmented	7.9 kg

42Cr: 900-1150 N/mm²



LM90.12.30

380 kN/m max.



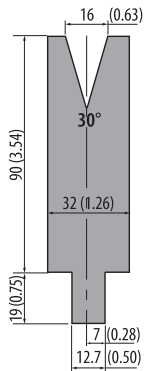
508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.6 kg
2x250 mm segmented	2x9.84 in segmented	11.8 kg

42Cr: 900-1150 N/mm²



LM90.16.30

380 kN/m max.



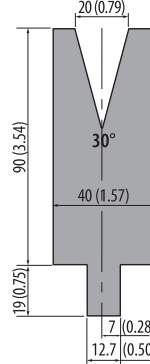
508 mm	20.00 in	11.5 kg
550 mm segmented	21.65 in segmented	12.4 kg
2x250 mm segmented	2x9.84 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



LM90.20.30

380 kN/m max.



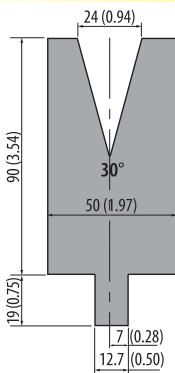
508 mm	20.00 in	13.8 kg
550 mm segmented	21.65 in segmented	15.0 kg
2x250 mm segmented	2x9.84 in segmented	13.6 kg

42Cr: 900-1150 N/mm²



LM90.24.30

550 kN/m max.



508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg
2x250 mm segmented	2x9.84 in segmented	12.8 kg

42Cr: 900-1150 N/mm²

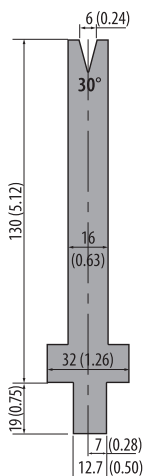


7
RX

30° LVD dies, H=130 (5.12)

LM130.06.30

200 kN/m max.



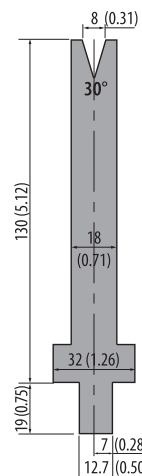
508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg
2x250 mm segmented	2x9.84 in segmented	9.8 kg

42Cr: 900-1150 N/mm²



LM130.08.30

220 kN/m max.



508 mm	20.00 in	10.9 kg
550 mm segmented	21.65 in segmented	11.8 kg
2x250 mm segmented	2x9.84 in segmented	10.7 kg

42Cr: 900-1150 N/mm²



Article on stock



Please ask for delivery time!

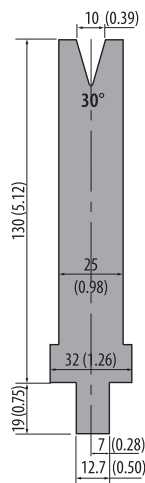
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

LM130.10.30

300 kN/m max.



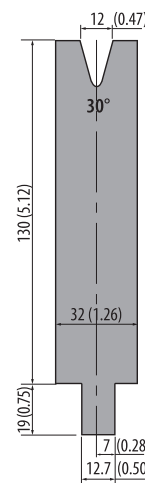
508 mm	20.00 in	14.0 kg
550 mm segmented	21.65 in segmented	15.1 kg
2x250 mm segmented	2x9.84 in segmented	13.8 kg

42Cr: 900-1150 N/mm²



LM130.12.30

380 kN/m max.



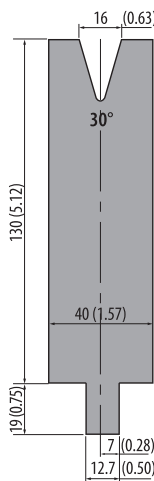
508 mm	20.00 in	17.1 kg
550 mm segmented	21.65 in segmented	18.5 kg
2x250 mm segmented	2x9.84 in segmented	16.9 kg

42Cr: 900-1150 N/mm²



LM130.16.30

380 kN/m max.



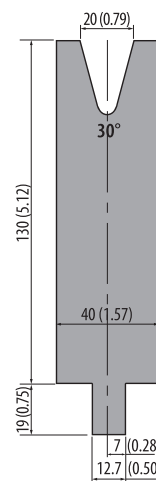
508 mm	20.00 in	20.8 kg
550 mm segmented	21.65 in segmented	22.6 kg
2x250 mm segmented	2x9.84 in segmented	20.5 kg

42Cr: 900-1150 N/mm²



LM130.20.30

380 kN/m max.



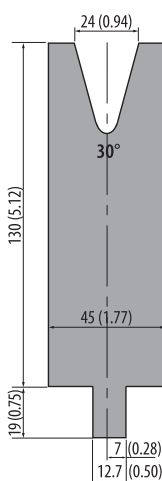
508 mm	20.00 in	20.3 kg
550 mm segmented	21.65 in segmented	22.0 kg
2x250 mm segmented	2x9.84 in segmented	20.0 kg

42Cr: 900-1150 N/mm²



LM130.24.30

550 kN/m max.

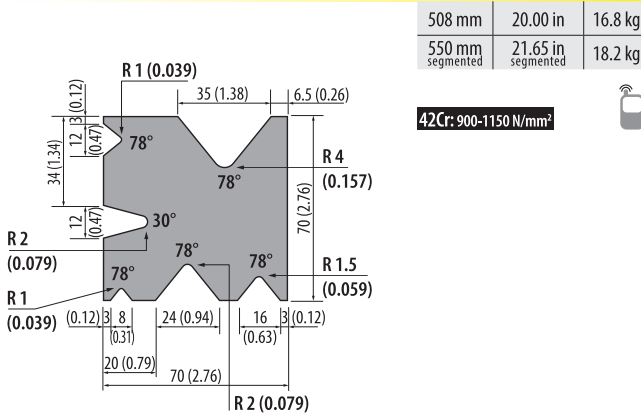


508 mm	20.00 in	24.4 kg
550 mm segmented	21.65 in segmented	26.4 kg
2x250 mm segmented	2x9.84 in segmented	24.0 kg

42Cr: 900-1150 N/mm²



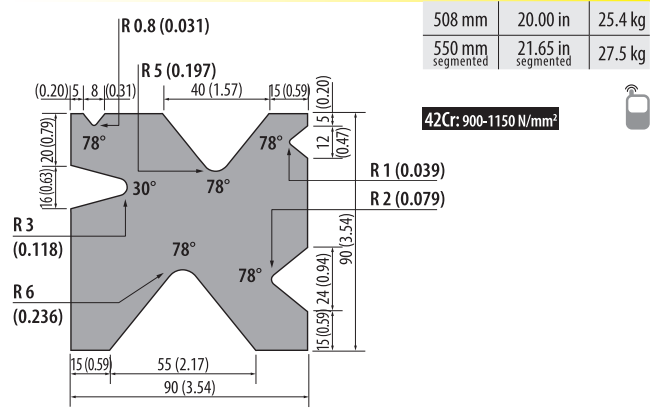
LM70



508 mm	20.00 in	16.8 kg
550 mm segmented	21.65 in segmented	18.2 kg

	V1	V2	V3	V4	V5	V6
V mm (in)	12 (0.47)	12 (0.47)	35 (1.38)	24 (0.94)	16 (0.63)	8 (0.31)
Angle	30°	78°	78°	78°	78°	78°
kN/m max.	1300	600	1300	1200	950	500

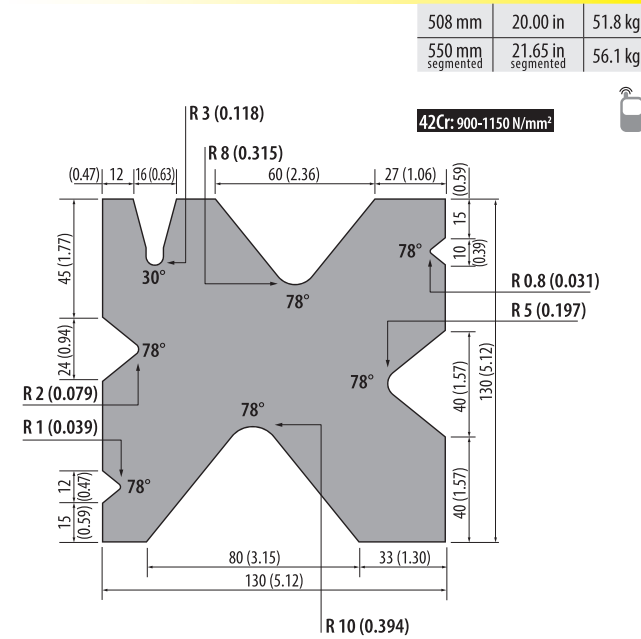
LM90



508 mm	20.00 in	25.4 kg
550 mm segmented	21.65 in segmented	27.5 kg

	V1	V2	V3	V4	V5	V6
V mm (in)	8 (0.31)	40 (1.57)	12 (0.47)	24 (0.94)	55 (2.17)	16 (0.63)
Angle	78°	78°	78°	78°	78°	30°
kN/m max.	550	1400	550	650	1000	1000

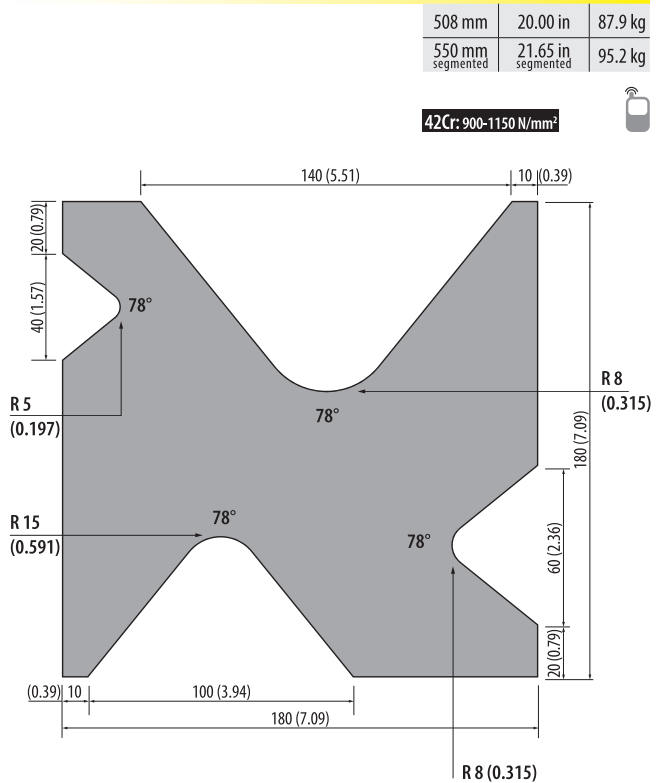
LM130



508 mm	20.00 in	51.8 kg
550 mm segmented	21.65 in segmented	56.1 kg

	V1	V2	V3	V4	V5	V6	V7
V mm (in)	16 (0.63)	60 (2.36)	10 (0.39)	80 (3.15)	40 (1.57)	12 (0.47)	24 (0.94)
Angle	30°	78°	78°	78°	78°	78°	78°
kN/m max.	650	1500	650	1250	1500	480	1500

LM180



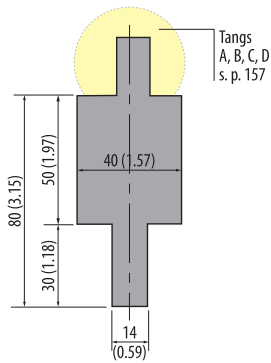
508 mm	20.00 in	87.9 kg
550 mm segmented	21.65 in segmented	95.2 kg

	V1	V2	V3	V4
V mm (in)	140 (5.51)	60 (2.36)	100 (3.94)	40 (1.57)
Angle	78°	78°	78°	78°
kN/m max.	550	650	700	320

7
RX

AD1

1000 kN/m max.



Tang A: AD1-A		
150 mm	5.91 in	3.1 kg
Tang B: AD1-B		
150 mm	5.91 in	3.1 kg
Tang C: AD1-C		
150 mm	5.91 in	3.1 kg
Tang D: AD1-D		
150 mm	5.91 in	3.1 kg

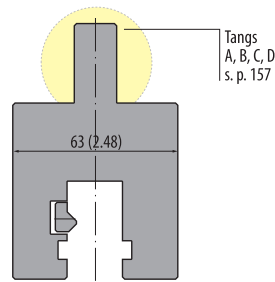
Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



AD20 LVD

1000 kN/m max.



Tang A: AD20 LVD-A		
150 mm	5.91 in	3.6 kg
Tang B: AD20 LVD-B		
150 mm	5.91 in	3.8 kg
Tang C: AD20 LVD-C		
150 mm	5.91 in	4.0 kg
Tang D: AD20 LVD-D		
150 mm	5.91 in	4.0 kg

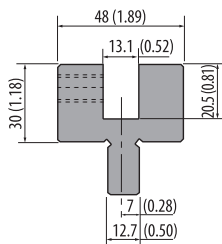
Rolleri Type RX LVD
→ Rolleri Type R2

C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.



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

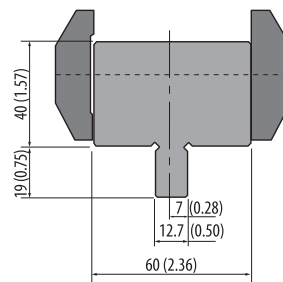
Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD9-12.7

1000 kN/m max.



835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.5 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²

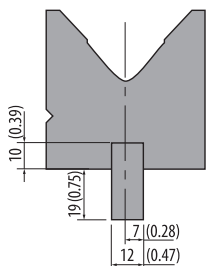


Modification: tang bar

To use Rolleri Type R1 dies, a 10 mm groove is milled where a ground bar is mounted.

A31

Tang bar:
12 x 29 mm (0.47 x 1.14) for
• Rolleri Type RX LVD

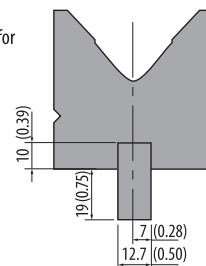


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A32

Tang bar:
12.7 x 29 mm (0.50 x 1.14) for
• Rolleri Type RX LVD

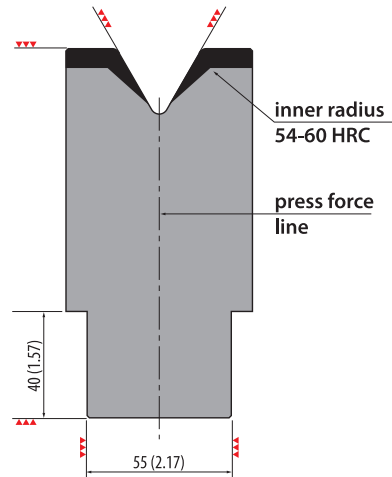
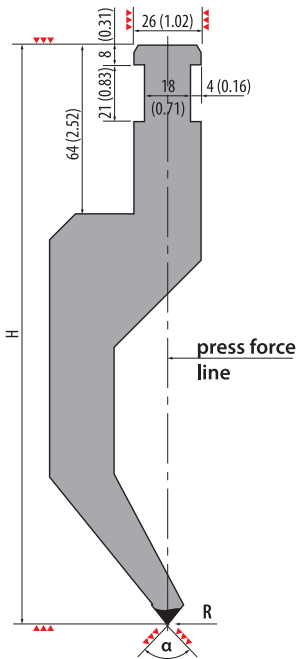


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



Explanation

We produce Rolleri RX EHT type tools in a vast variety. They are custom made, convenient and precise.

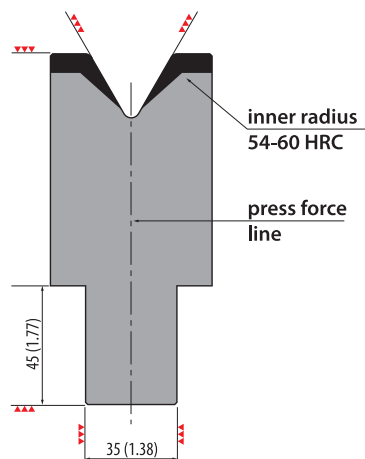
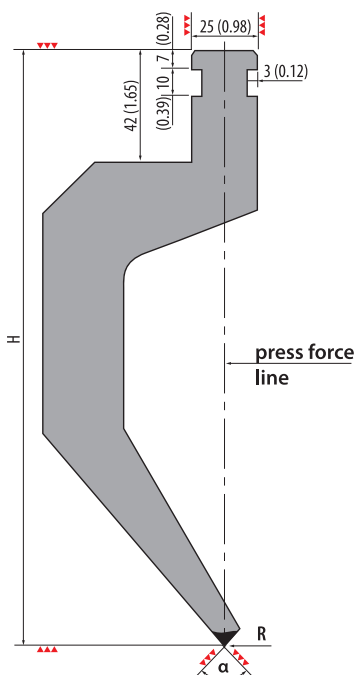


Adapters for Rolleri
Type RX EHT
see pages 227-234

Weinbrenner

Explanation

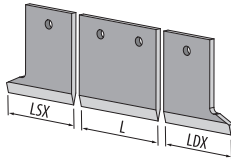
We produce Rolleri RX Weinbrenner type tools in a vast variety. They are custom made, convenient and precise.



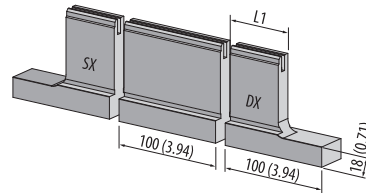
Adapters for Rolleri
Type RX Weinbrenner
see pages 227-235

Tool lengths, sectionings and horn types

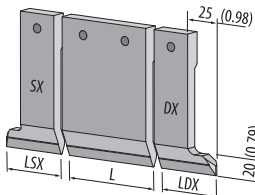
Punches H11:



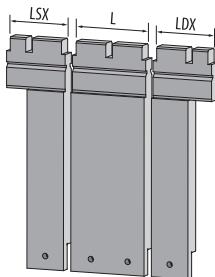
Dies H31, H41:



Punches H12:



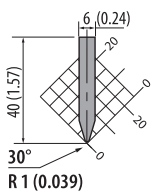
Punches H21:



Hämmerle-Bystronic Punches

H11.010.0

600 kN/m max.



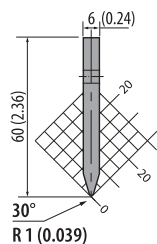
Model	Length	Weight
H11.010.01.01	100 3.94	0.17 kg
H11.010.02.01	50 1.97	0.09 kg
H11.010.02.02	55 2.17	0.09 kg
H11.010.02.03	60 2.36	0.10 kg
H11.010.02.04	65 2.56	0.11 kg
H11.010.02.05	70 2.76	0.12 kg
H11.010.02.06	75 2.95	0.13 kg
H11.010.02.07	80 3.15	0.14 kg
H11.010.02.08	85 3.35	0.14 kg
H11.010.02.09	90 3.54	0.15 kg
H11.010.02.10	95 3.74	0.16 kg
H11.010.04.01	75 DX 2.95 DX	0.12 kg
H11.010.04.02	85 DX 3.35 DX	0.14 kg
H11.010.04.03	95 DX 3.74 DX	0.15 kg
H11.010.04.04	105 DX 4.13 DX	0.17 kg
H11.010.04.05	115 DX 4.53 DX	0.19 kg
H11.010.04.06	80 SX 3.15 SX	0.13 kg
H11.010.05.01	75 SX 2.95 SX	0.12 kg
H11.010.05.02	85 SX 3.35 SX	0.14 kg
H11.010.05.03	95 SX 3.74 SX	0.15 kg
H11.010.05.04	105 SX 4.13 SX	0.17 kg
H11.010.05.05	115 SX 4.53 SX	0.19 kg
H11.010.05.06	80 DX 3.15 DX	0.13 kg



HRc 58-60

H11.007.0

1000 kN/m max.



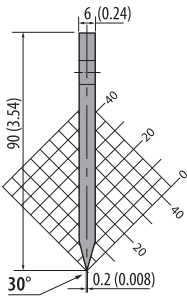
Model	Length	Weight
H11.007.01.01	100 3.94	0.26 kg
H11.007.02.01	50 1.97	0.13 kg
H11.007.02.02	55 2.17	0.14 kg
H11.007.02.03	60 2.36	0.16 kg
H11.007.02.04	65 2.56	0.17 kg
H11.007.02.05	70 2.76	0.18 kg
H11.007.02.06	75 2.95	0.20 kg
H11.007.02.07	80 3.15	0.21 kg
H11.007.02.08	85 3.35	0.22 kg
H11.007.02.09	90 3.54	0.23 kg
H11.007.02.10	95 3.74	0.25 kg
H11.007.04.01	75 DX 2.95 DX	0.18 kg
H11.007.04.02	85 DX 3.35 DX	0.21 kg
H11.007.04.03	95 DX 3.74 DX	0.23 kg
H11.007.04.04	105 DX 4.13 DX	0.25 kg
H11.007.04.05	115 DX 4.53 DX	0.29 kg
H11.007.04.06	80 SX 3.15 SX	0.20 kg
H11.007.05.01	75 SX 2.95 SX	0.18 kg
H11.007.05.02	85 SX 3.35 SX	0.21 kg
H11.007.05.03	95 SX 3.74 SX	0.23 kg
H11.007.05.04	105 SX 4.13 SX	0.25 kg
H11.007.05.05	115 SX 4.53 SX	0.29 kg
H11.007.05.06	80 DX 3.15 DX	0.20 kg



HRc 58-60

H11.002.0

1000 kN/m max.

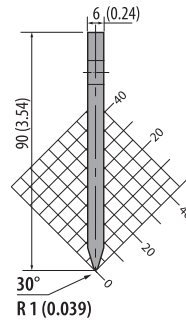


Model	Length	Weight
H11.002.01.01	100	3.94
H11.002.02.01	50	1.97
H11.002.02.02	55	2.17
H11.002.02.03	60	2.36
H11.002.02.04	65	2.56
H11.002.02.05	70	2.76
H11.002.02.06	75	2.95
H11.002.02.07	80	3.15
H11.002.02.08	85	3.35
H11.002.02.09	90	3.54
H11.002.02.10	95	3.74
H11.002.04.01	75 DX	2.95 DX
H11.002.04.02	85 DX	3.35 DX
H11.002.04.03	95 DX	3.74 DX
H11.002.04.04	105 DX	4.13 DX
H11.002.04.05	115 DX	4.53 DX
H11.002.04.06	80 SX	3.15 SX
H11.002.05.01	75 SX	2.95 SX
H11.002.05.02	85 SX	3.35 SX
H11.002.05.03	95 SX	3.74 SX
H11.002.05.04	105 SX	4.13 SX
H11.002.05.05	115 SX	4.53 SX
H11.002.05.06	80 DX	3.15 DX

HRc 58-60

H11.001.0

1000 kN/m max.

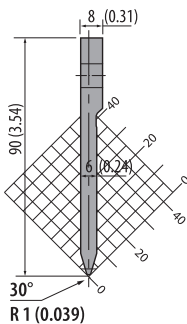


Model	Length	Weight
H11.001.01.01	100	3.94
H11.001.02.01	50	1.97
H11.001.02.02	55	2.17
H11.001.02.03	60	2.36
H11.001.02.04	65	2.56
H11.001.02.05	70	2.76
H11.001.02.06	75	2.95
H11.001.02.07	80	3.15
H11.001.02.08	85	3.35
H11.001.02.09	90	3.54
H11.001.02.10	95	3.74
H11.001.04.01	75 DX	2.95 DX
H11.001.04.02	85 DX	3.35 DX
H11.001.04.03	95 DX	3.74 DX
H11.001.04.04	105 DX	4.13 DX
H11.001.04.05	115 DX	4.53 DX
H11.001.04.06	80 SX	3.15 SX
H11.001.05.01	75 SX	2.95 SX
H11.001.05.02	85 SX	3.35 SX
H11.001.05.03	95 SX	3.74 SX
H11.001.05.04	105 SX	4.13 SX
H11.001.05.05	115 SX	4.53 SX
H11.001.05.06	80 DX	3.15 DX

HRc 58-60

H11.008.0

1000 kN/m max.

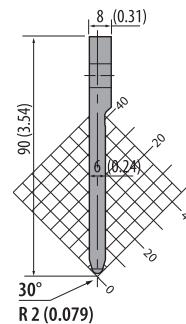


Model	Length	Weight
H11.008.01.01	100	3.94
H11.008.02.01	50	1.97
H11.008.02.02	55	2.17
H11.008.02.03	60	2.36
H11.008.02.04	65	2.56
H11.008.02.05	70	2.76
H11.008.02.06	75	2.95
H11.008.02.07	80	3.15
H11.008.02.08	85	3.35
H11.008.02.09	90	3.54
H11.008.02.10	95	3.74
H11.008.04.01	75 DX	2.95 DX
H11.008.04.02	85 DX	3.35 DX
H11.008.04.03	95 DX	3.74 DX
H11.008.04.04	105 DX	4.13 DX
H11.008.04.05	115 DX	4.53 DX
H11.008.04.06	80 SX	3.15 SX
H11.008.05.01	75 SX	2.95 SX
H11.008.05.02	85 SX	3.35 SX
H11.008.05.03	95 SX	3.74 SX
H11.008.05.04	105 SX	4.13 SX
H11.008.05.05	115 SX	4.53 SX
H11.008.05.06	80 DX	3.15 DX

HRc 58-60

H11.006.0

1000 kN/m max.

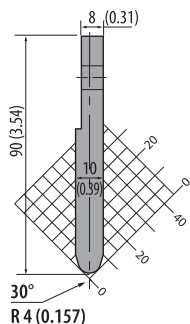


Model	Length	Weight
H11.006.01.01	100	3.94
H11.006.02.01	50	1.97
H11.006.02.02	55	2.17
H11.006.02.03	60	2.36
H11.006.02.04	65	2.56
H11.006.02.05	70	2.76
H11.006.02.06	75	2.95
H11.006.02.07	80	3.15
H11.006.02.08	85	3.35
H11.006.02.09	90	3.54
H11.006.02.10	95	3.74
H11.006.04.01	75 DX	2.95 DX
H11.006.04.02	85 DX	3.35 DX
H11.006.04.03	95 DX	3.74 DX
H11.006.04.04	105 DX	4.13 DX
H11.006.04.05	115 DX	4.53 DX
H11.006.04.06	80 SX	3.15 SX
H11.006.05.01	75 SX	2.95 SX
H11.006.05.02	85 SX	3.35 SX
H11.006.05.03	95 SX	3.74 SX
H11.006.05.04	105 SX	4.13 SX
H11.006.05.05	115 SX	4.53 SX
H11.006.05.06	80 DX	3.15 DX

HRc 58-60

H11.034.0

1000 kN/m max.



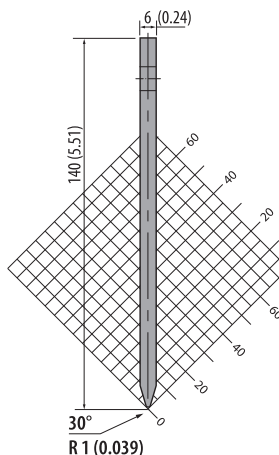
Model	Length	Weight
H11.034.01.01	100	3.94
H11.034.02.01	50	1.97
H11.034.02.02	55	2.17
H11.034.02.03	60	2.36
H11.034.02.04	65	2.56
H11.034.02.05	70	2.76
H11.034.02.06	75	2.95
H11.034.02.07	80	3.15
H11.034.02.08	85	3.35
H11.034.02.09	90	3.54
H11.034.02.10	95	3.74
H11.034.04.01	75 DX	2.95 DX
H11.034.04.02	85 DX	3.35 DX
H11.034.04.03	95 DX	3.74 DX
H11.034.04.04	105 DX	4.13 DX
H11.034.04.05	115 DX	4.53 DX
H11.034.04.06	80 SX	3.15 SX
H11.034.05.01	75 SX	2.95 SX
H11.034.05.02	85 SX	3.35 SX
H11.034.05.03	95 SX	3.74 SX
H11.034.05.04	105 SX	4.13 SX
H11.034.05.05	115 SX	4.53 SX
H11.034.05.06	80 DX	3.15 DX



HRc 58-60

H11.003.0

1000 kN/m max.



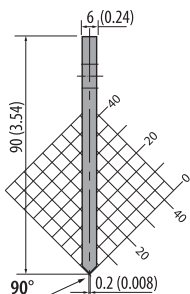
Model	Length	Weight
H11.003.01.01	100	3.94
H11.003.02.01	50	1.97
H11.003.02.02	55	2.17
H11.003.02.03	60	2.36
H11.003.02.04	65	2.56
H11.003.02.05	70	2.76
H11.003.02.06	75	2.95
H11.003.02.07	80	3.15
H11.003.02.08	85	3.35
H11.003.02.09	90	3.54
H11.003.02.10	95	3.74
H11.003.04.01	75 DX	2.95 DX
H11.003.04.02	85 DX	3.35 DX
H11.003.04.03	95 DX	3.74 DX
H11.003.04.04	105 DX	4.13 DX
H11.003.04.05	115 DX	4.53 DX
H11.003.04.06	80 SX	3.15 SX
H11.003.05.01	75 SX	2.95 SX
H11.003.05.02	85 SX	3.35 SX
H11.003.05.03	95 SX	3.74 SX
H11.003.05.04	105 SX	4.13 SX
H11.003.05.05	115 SX	4.53 SX
H11.003.05.06	80 DX	3.15 DX



HRc 58-60

H11.005.0

1000 kN/m max.



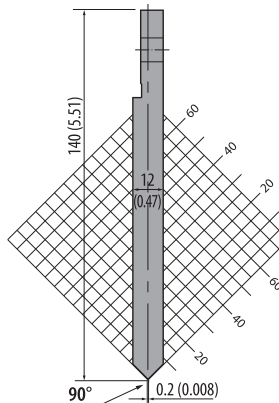
Model	Length	Weight
H11.005.01.01	100	3.94
H11.005.02.01	50	1.97
H11.005.02.02	55	2.17
H11.005.02.03	60	2.36
H11.005.02.04	65	2.56
H11.005.02.05	70	2.76
H11.005.02.06	75	2.95
H11.005.02.07	80	3.15
H11.005.02.08	85	3.35
H11.005.02.09	90	3.54
H11.005.02.10	95	3.74
H11.005.04.01	75 DX	2.95 DX
H11.005.04.02	85 DX	3.35 DX
H11.005.04.03	95 DX	3.74 DX
H11.005.04.04	105 DX	4.13 DX
H11.005.04.05	115 DX	4.53 DX
H11.005.04.06	80 SX	3.15 SX
H11.005.05.01	75 SX	2.95 SX
H11.005.05.02	85 SX	3.35 SX
H11.005.05.03	95 SX	3.74 SX
H11.005.05.04	105 SX	4.13 SX
H11.005.05.05	115 SX	4.53 SX
H11.005.05.06	80 DX	3.15 DX



HRc 58-60

H11.009.1

1000 kN/m max.



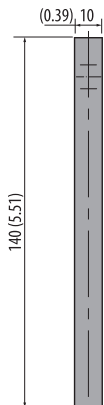
Model	Length	Weight
H11.009.10.01	100	3.94
H11.009.12.01	50	1.97
H11.009.12.02	55	2.17
H11.009.12.03	60	2.36
H11.009.12.04	65	2.56
H11.009.12.05	70	2.76
H11.009.12.06	75	2.95
H11.009.12.07	80	3.15
H11.009.12.08	85	3.35
H11.009.12.09	90	3.54
H11.009.12.10	95	3.74
H11.009.14.01	75 DX	2.95 DX
H11.009.14.02	85 DX	3.35 DX
H11.009.14.03	95 DX	3.74 DX
H11.009.14.04	105 DX	4.13 DX
H11.009.14.05	115 DX	4.53 DX
H11.009.14.06	80 SX	3.15 SX
H11.009.15.01	75 SX	2.95 SX
H11.009.15.02	85 SX	3.35 SX
H11.009.15.03	95 SX	3.74 SX
H11.009.15.04	105 SX	4.13 SX
H11.009.15.05	115 SX	4.53 SX
H11.009.15.06	80 DX	3.15 DX



HRc 58-60

H14.021.0

1000 kN/m max.



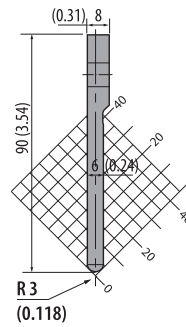
Model	Length	Weight
H14.021.01.01	100	3.94
H14.021.02.01	50	1.97
H14.021.02.02	55	2.17
H14.021.02.03	60	2.36
H14.021.02.04	65	2.56
H14.021.02.05	70	2.76
H14.021.02.06	75	2.95
H14.021.02.07	80	3.15
H14.021.02.08	85	3.35
H14.021.02.09	90	3.54
H14.021.02.10	95	3.74

HRc 58-60



H11.033.1

1000 kN/m max.



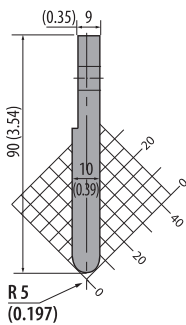
Model	Length	Weight
H11.033.11.01	100	3.94
H11.033.12.01	50	1.97
H11.033.12.02	55	2.17
H11.033.12.03	60	2.36
H11.033.12.04	65	2.56
H11.033.12.05	70	2.76
H11.033.12.06	75	2.95
H11.033.12.07	80	3.15
H11.033.12.08	85	3.35
H11.033.12.09	90	3.54
H11.033.12.10	95	3.74
H11.033.14.01	75 DX	2.95 DX
H11.033.14.02	85 DX	3.35 DX
H11.033.14.03	95 DX	3.74 DX
H11.033.14.04	105 DX	4.13 DX
H11.033.14.05	115 DX	4.53 DX
H11.033.14.06	80 SX	3.15 SX
H11.033.15.01	75 SX	2.95 SX
H11.033.15.02	85 SX	3.35 SX
H11.033.15.03	95 SX	3.74 SX
H11.033.15.04	105 SX	4.13 SX
H11.033.15.05	115 SX	4.53 SX
H11.033.15.06	80 DX	3.15 DX

HRc 58-60



H11.035.0

1000 kN/m max.



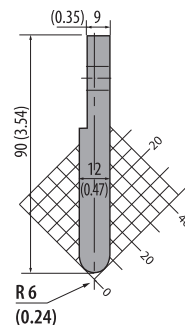
Model	Length	Weight
H11.035.01.01	100	3.94
H11.035.02.01	50	1.97
H11.035.02.02	55	2.17
H11.035.02.03	60	2.36
H11.035.02.04	65	2.56
H11.035.02.05	70	2.76
H11.035.02.06	75	2.95
H11.035.02.07	80	3.15
H11.035.02.08	85	3.35
H11.035.02.09	90	3.54
H11.035.02.10	95	3.74
H11.035.04.01	75 DX	2.95 DX
H11.035.04.02	85 DX	3.35 DX
H11.035.04.03	95 DX	3.74 DX
H11.035.04.04	105 DX	4.13 DX
H11.035.04.05	115 DX	4.53 DX
H11.035.04.06	80 SX	3.15 SX
H11.035.05.01	75 SX	2.95 SX
H11.035.05.02	85 SX	3.35 SX
H11.035.05.03	95 SX	3.74 SX
H11.035.05.04	105 SX	4.13 SX
H11.035.05.05	115 SX	4.53 SX
H11.035.05.06	80 DX	3.15 DX

HRc 58-60



H11.036.0

1000 kN/m max.



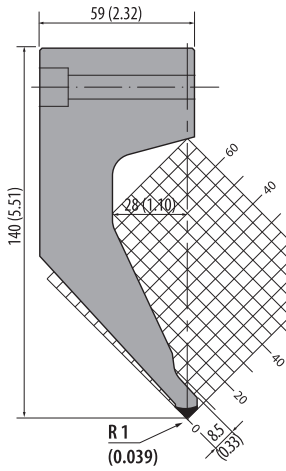
Model	Length	Weight
H11.036.01.01	100	3.94
H11.036.02.01	50	1.97
H11.036.02.02	55	2.17
H11.036.02.03	60	2.36
H11.036.02.04	65	2.56
H11.036.02.05	70	2.76
H11.036.02.06	75	2.95
H11.036.02.07	80	3.15
H11.036.02.08	85	3.35
H11.036.02.09	90	3.54
H11.036.02.10	95	3.74
H11.036.04.01	75 DX	2.95 DX
H11.036.04.02	85 DX	3.35 DX
H11.036.04.03	95 DX	3.74 DX
H11.036.04.04	105 DX	4.13 DX
H11.036.04.05	115 DX	4.53 DX
H11.036.04.06	80 SX	3.15 SX
H11.036.05.01	75 SX	2.95 SX
H11.036.05.02	85 SX	3.35 SX
H11.036.05.03	95 SX	3.74 SX
H11.036.05.04	105 SX	4.13 SX
H11.036.05.05	115 SX	4.53 SX
H11.036.05.06	80 DX	3.15 DX

HRc 58-60



H12.014.0

975 kN/m max.

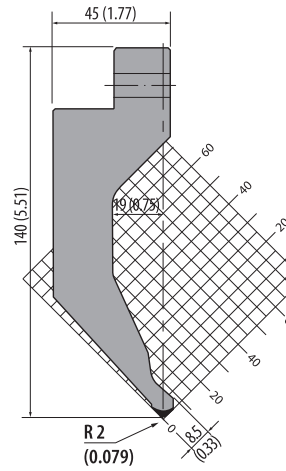


Model	Length	Weight
H12.014.01.01	100	3.94
H12.014.02.01	50	1.97
H12.014.02.02	55	2.17
H12.014.02.03	60	2.36
H12.014.02.04	65	2.56
H12.014.02.05	70	2.76
H12.014.02.06	75	2.95
H12.014.02.07	80	3.15
H12.014.02.08	85	3.35
H12.014.02.09	90	3.54
H12.014.02.10	95	3.74
H12.014.04.01	75 DX	2.95 DX
H12.014.04.02	85 DX	3.35 DX
H12.014.04.03	95 DX	3.74 DX
H12.014.04.04	105 DX	4.13 DX
H12.014.04.05	115 DX	4.53 DX
H12.014.04.06	80 SX	3.15 SX
H12.014.05.01	75 SX	2.95 SX
H12.014.05.02	85 SX	3.35 SX
H12.014.05.03	95 SX	3.74 SX
H12.014.05.04	105 SX	4.13 SX
H12.014.05.05	115 SX	4.53 SX
H12.014.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.052.0

975 kN/m max.

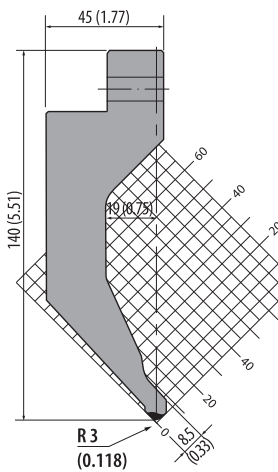


Model	Length	Weight
H12.052.01.01	100	3.94
H12.052.02.01	50	1.97
H12.052.02.02	55	2.17
H12.052.02.03	60	2.36
H12.052.02.04	65	2.56
H12.052.02.05	70	2.76
H12.052.02.06	75	2.95
H12.052.02.07	80	3.15
H12.052.02.08	85	3.35
H12.052.02.09	90	3.54
H12.052.02.10	95	3.74
H12.052.04.01	75 DX	2.95 DX
H12.052.04.02	85 DX	3.35 DX
H12.052.04.03	95 DX	3.74 DX
H12.052.04.04	105 DX	4.13 DX
H12.052.04.05	115 DX	4.53 DX
H12.052.04.06	80 SX	3.15 SX
H12.052.05.01	75 SX	2.95 SX
H12.052.05.02	85 SX	3.35 SX
H12.052.05.03	95 SX	3.74 SX
H12.052.05.04	105 SX	4.13 SX
H12.052.05.05	115 SX	4.53 SX
H12.052.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.053.0

975 kN/m max.

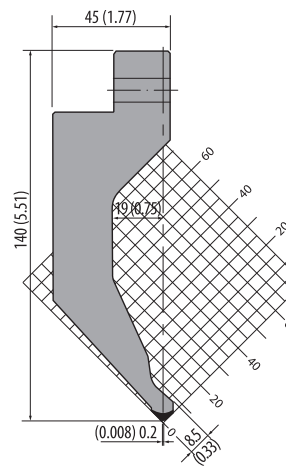


Model	Length	Weight
H12.053.01.01	100	3.94
H12.053.02.01	50	1.97
H12.053.02.02	55	2.17
H12.053.02.03	60	2.36
H12.053.02.04	65	2.56
H12.053.02.05	70	2.76
H12.053.02.06	75	2.95
H12.053.02.07	80	3.15
H12.053.02.08	85	3.35
H12.053.02.09	90	3.54
H12.053.02.10	95	3.74
H12.053.04.01	75 DX	2.95 DX
H12.053.04.02	85 DX	3.35 DX
H12.053.04.03	95 DX	3.74 DX
H12.053.04.04	105 DX	4.13 DX
H12.053.04.05	115 DX	4.53 DX
H12.053.04.06	80 SX	3.15 SX
H12.053.05.01	75 SX	2.95 SX
H12.053.05.02	85 SX	3.35 SX
H12.053.05.03	95 SX	3.74 SX
H12.053.05.04	105 SX	4.13 SX
H12.053.05.05	115 SX	4.53 SX
H12.053.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.019.0

975 kN/m max.

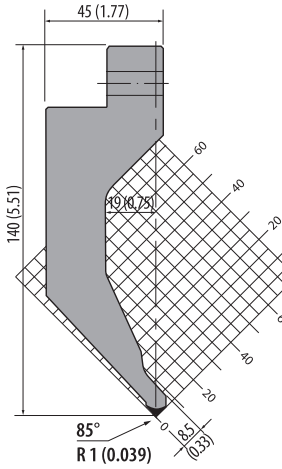


Model	Length	Weight
H12.019.01.01	100	3.94
H12.019.02.01	50	1.97
H12.019.02.02	55	2.17
H12.019.02.03	60	2.36
H12.019.02.04	65	2.56
H12.019.02.05	70	2.76
H12.019.02.06	75	2.95
H12.019.02.07	80	3.15
H12.019.02.08	85	3.35
H12.019.02.09	90	3.54
H12.019.02.10	95	3.74
H12.019.04.01	75 DX	2.95 DX
H12.019.04.02	85 DX	3.35 DX
H12.019.04.03	95 DX	3.74 DX
H12.019.04.04	105 DX	4.13 DX
H12.019.04.05	115 DX	4.53 DX
H12.019.04.06	80 SX	3.15 SX
H12.019.05.01	75 SX	2.95 SX
H12.019.05.02	85 SX	3.35 SX
H12.019.05.03	95 SX	3.74 SX
H12.019.05.04	105 SX	4.13 SX
H12.019.05.05	115 SX	4.53 SX
H12.019.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.015.0

975 kN/m max.

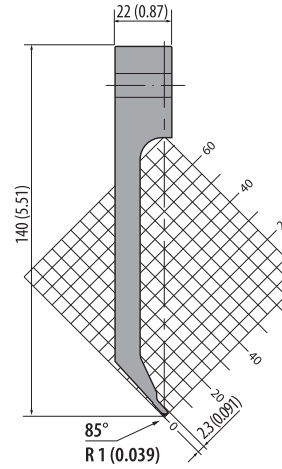


Model	Length	Weight
H12.015.01.01	100	3.94
H12.015.02.01	50	1.97
H12.015.02.02	55	2.17
H12.015.02.03	60	2.36
H12.015.02.04	65	2.56
H12.015.02.05	70	2.76
H12.015.02.06	75	2.95
H12.015.02.07	80	3.15
H12.015.02.08	85	3.35
H12.015.02.09	90	3.54
H12.015.02.10	95	3.74
H12.015.04.01	75 DX	2.95 DX
H12.015.04.02	85 DX	3.35 DX
H12.015.04.03	95 DX	3.74 DX
H12.015.04.04	105 DX	4.13 DX
H12.015.04.05	115 DX	4.53 DX
H12.015.04.06	80 SX	3.15 SX
H12.015.05.01	75 SX	2.95 SX
H12.015.05.02	85 SX	3.35 SX
H12.015.05.03	95 SX	3.74 SX
H12.015.05.04	105 SX	4.13 SX
H12.015.05.05	115 SX	4.53 SX
H12.015.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.025.0

250 kN/m max.

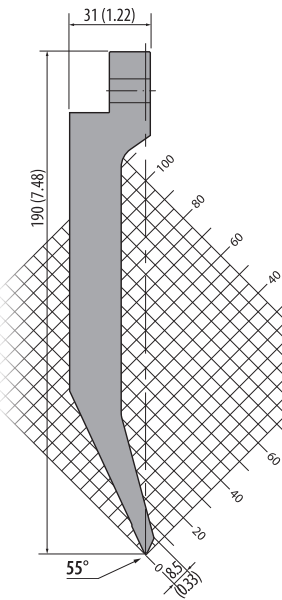


Model	Length	Weight
H12.025.01.01	100	3.94
H12.025.02.01	50	1.97
H12.025.02.02	55	2.17
H12.025.02.03	60	2.36
H12.025.02.04	65	2.56
H12.025.02.05	70	2.76
H12.025.02.06	75	2.95
H12.025.02.07	80	3.15
H12.025.02.08	85	3.35
H12.025.02.09	90	3.54
H12.025.02.10	95	3.74
H12.025.04.01	75 DX	2.95 DX
H12.025.04.02	85 DX	3.35 DX
H12.025.04.03	95 DX	3.74 DX
H12.025.04.04	105 DX	4.13 DX
H12.025.04.05	115 DX	4.53 DX
H12.025.04.06	80 SX	3.15 SX
H12.025.05.01	75 SX	2.95 SX
H12.025.05.02	85 SX	3.35 SX
H12.025.05.03	95 SX	3.74 SX
H12.025.05.04	105 SX	4.13 SX
H12.025.05.05	115 SX	4.53 SX
H12.025.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.017.0

750 kN/m max.

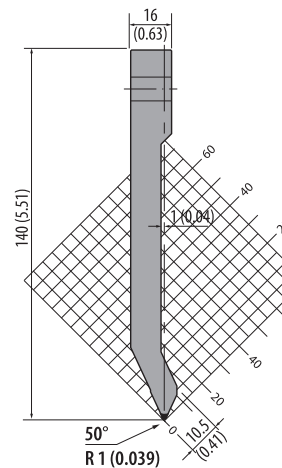


Model	Length	Weight
H12.017.01.01	100	3.94
H12.017.02.01	50	1.97
H12.017.02.02	55	2.17
H12.017.02.03	60	2.36
H12.017.02.04	65	2.56
H12.017.02.05	70	2.76
H12.017.02.06	75	2.95
H12.017.02.07	80	3.15
H12.017.02.08	85	3.35
H12.017.02.09	90	3.54
H12.017.02.10	95	3.74
H12.017.04.01	75 DX	2.95 DX
H12.017.04.02	85 DX	3.35 DX
H12.017.04.03	95 DX	3.74 DX
H12.017.04.04	105 DX	4.13 DX
H12.017.04.05	115 DX	4.53 DX
H12.017.04.06	80 SX	3.15 SX
H12.017.05.01	75 SX	2.95 SX
H12.017.05.02	85 SX	3.35 SX
H12.017.05.03	95 SX	3.74 SX
H12.017.05.04	105 SX	4.13 SX
H12.017.05.05	115 SX	4.53 SX
H12.017.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H12.065.0

1000 kN/m max.

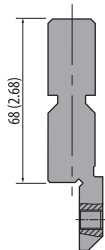


Model	Length	Weight
H12.065.01.01	100	3.94
H12.065.02.01	50	1.97
H12.065.02.02	55	2.17
H12.065.02.03	60	2.36
H12.065.02.04	65	2.56
H12.065.02.05	70	2.76
H12.065.02.06	75	2.95
H12.065.02.07	80	3.15
H12.065.02.08	85	3.35
H12.065.02.09	90	3.54
H12.065.02.10	95	3.74
H12.065.04.01	75 DX	2.95 DX
H12.065.04.02	85 DX	3.35 DX
H12.065.04.03	95 DX	3.74 DX
H12.065.04.04	105 DX	4.13 DX
H12.065.04.05	115 DX	4.53 DX
H12.065.04.06	80 SX	3.15 SX
H12.065.05.01	75 SX	2.95 SX
H12.065.05.02	85 SX	3.35 SX
H12.065.05.03	95 SX	3.74 SX
H12.065.05.04	105 SX	4.13 SX
H12.065.05.05	115 SX	4.53 SX
H12.065.05.06	80 DX	3.15 DX

42Cr: 900-1150 N/mm²

H21.003.0

1000 kN/m max.



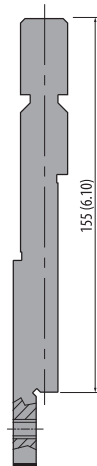
Model	Length	Weight
H21.003.01.01	100	3.94
H21.003.01.03	200	7.87
H21.003.02.01	50	1.97
H21.003.02.02	55	2.17
H21.003.02.03	60	2.36
H21.003.02.04	65	2.56
H21.003.02.05	70	2.76
H21.003.02.06	75	2.95
H21.003.02.07	80	3.15
H21.003.02.08	85	3.35
H21.003.02.09	90	3.54
H21.003.02.10	95	3.74
H21.003.04.01	75 DX	2.95 DX
H21.003.04.02	85 DX	3.35 DX
H21.003.04.03	95 DX	3.74 DX
H21.003.04.04	105 DX	4.13 DX
H21.003.04.05	115 DX	4.53 DX
H21.003.04.06	80 SX	3.15 SX
H21.003.05.01	75 SX	2.95 SX
H21.003.05.02	85 SX	3.35 SX
H21.003.05.03	95 SX	3.74 SX
H21.003.05.04	105 SX	4.13 SX
H21.003.05.05	115 SX	4.53 SX
H21.003.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



H21.002.0

1000 kN/m max.



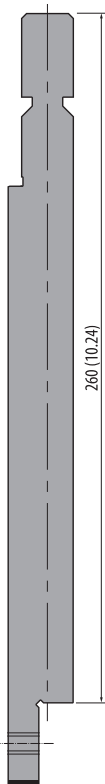
Model	Length	Weight
H21.002.01.01	100	3.94
H21.002.01.03	200	7.87
H21.002.02.01	50	1.97
H21.002.02.02	55	2.17
H21.002.02.03	60	2.36
H21.002.02.04	65	2.56
H21.002.02.05	70	2.76
H21.002.02.06	75	2.95
H21.002.02.07	80	3.15
H21.002.02.08	85	3.35
H21.002.02.09	90	3.54
H21.002.02.10	95	3.74
H21.002.04.01	75 DX	2.95 DX
H21.002.04.02	85 DX	3.35 DX
H21.002.04.03	95 DX	3.74 DX
H21.002.04.04	105 DX	4.13 DX
H21.002.04.05	115 DX	4.53 DX
H21.002.04.06	80 SX	3.15 SX
H21.002.05.01	75 SX	2.95 SX
H21.002.05.02	85 SX	3.35 SX
H21.002.05.03	95 SX	3.74 SX
H21.002.05.04	105 SX	4.13 SX
H21.002.05.05	115 SX	4.53 SX
H21.002.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



H21.005.0

1000 kN/m max.



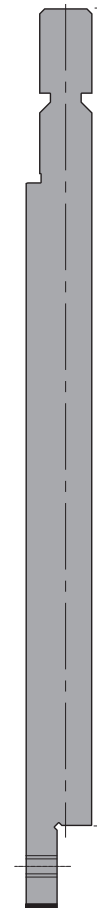
Model	Length	Weight
H21.005.01.01	100	3.94
H21.005.01.03	200	7.87
H21.005.02.01	50	1.97
H21.005.02.02	55	2.17
H21.005.02.03	60	2.36
H21.005.02.04	65	2.56
H21.005.02.05	70	2.76
H21.005.02.06	75	2.95
H21.005.02.07	80	3.15
H21.005.02.08	85	3.35
H21.005.02.09	90	3.54
H21.005.02.10	95	3.74
H21.005.04.01	75 DX	2.95 DX
H21.005.04.02	85 DX	3.35 DX
H21.005.04.03	95 DX	3.74 DX
H21.005.04.04	105 DX	4.13 DX
H21.005.04.05	115 DX	4.53 DX
H21.005.04.06	80 SX	3.15 SX
H21.005.05.01	75 SX	2.95 SX
H21.005.05.02	85 SX	3.35 SX
H21.005.05.03	95 SX	3.74 SX
H21.005.05.04	105 SX	4.13 SX
H21.005.05.05	115 SX	4.53 SX
H21.005.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



H21.010.0

1000 kN/m max.



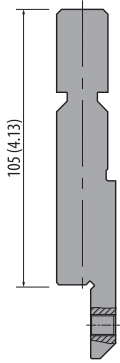
Model	Length	Weight
H21.010.01.01	100	3.94
H21.010.01.03	200	7.87
H21.010.02.01	50	1.97
H21.010.02.02	55	2.17
H21.010.02.03	60	2.36
H21.010.02.04	65	2.56
H21.010.02.05	70	2.76
H21.010.02.06	75	2.95
H21.010.02.07	80	3.15
H21.010.02.08	85	3.35
H21.010.02.09	90	3.54
H21.010.02.10	95	3.74
H21.010.04.01	75 DX	2.95 DX
H21.010.04.02	85 DX	3.35 DX
H21.010.04.03	95 DX	3.74 DX
H21.010.04.04	105 DX	4.13 DX
H21.010.04.05	115 DX	4.53 DX
H21.010.04.06	80 SX	3.15 SX
H21.010.05.01	75 SX	2.95 SX
H21.010.05.02	85 SX	3.35 SX
H21.010.05.03	95 SX	3.74 SX
H21.010.05.04	105 SX	4.13 SX
H21.010.05.05	115 SX	4.53 SX
H21.010.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



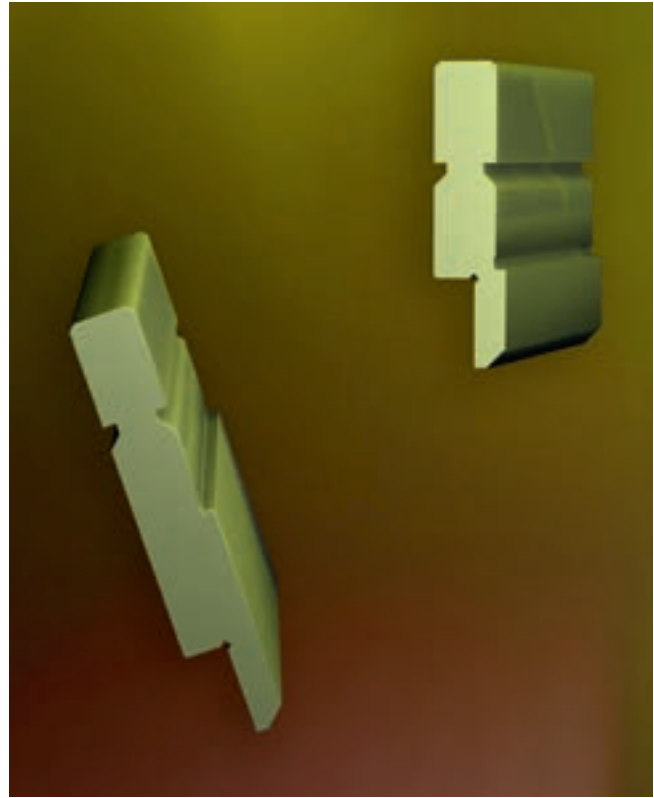
H21.004.0

1000 kN/m max.



Model	Length	Weight
H21.004.01.01	100	3.94
H21.004.01.03	200	7.87
H21.004.02.01	50	1.97
H21.004.02.02	55	2.17
H21.004.02.03	60	2.36
H21.004.02.04	65	2.56
H21.004.02.05	70	2.76
H21.004.02.06	75	2.95
H21.004.02.07	80	3.15
H21.004.02.08	85	3.35
H21.004.02.09	90	3.54
H21.004.02.10	95	3.74
H21.004.04.01	75 DX	2.95 DX
H21.004.04.02	85 DX	3.35 DX
H21.004.04.03	95 DX	3.74 DX
H21.004.04.04	105 DX	4.13 DX
H21.004.04.05	115 DX	4.53 DX
H21.004.04.06	80 SX	3.15 SX
H21.004.05.01	75 SX	2.95 SX
H21.004.05.02	85 SX	3.35 SX
H21.004.05.03	95 SX	3.74 SX
H21.004.05.04	105 SX	4.13 SX
H21.004.05.05	115 SX	4.53 SX
H21.004.05.06	80 DX	3.15 DX

C45: 560-710 N/mm²



7
RX

H22.006.0

600 kN/m max.



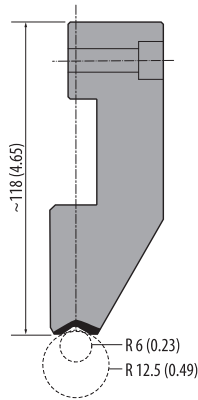
Model	Length	Weight
H22.006.01.01	100	3.94
H22.006.02.01	50	1.97
H22.006.02.02	55	2.17
H22.006.02.03	60	2.36
H22.006.02.04	65	2.56
H22.006.02.05	70	2.76
H22.006.02.06	75	2.95
H22.006.02.07	80	3.15
H22.006.02.08	85	3.35
H22.006.02.09	90	3.54
H22.006.02.10	95	3.74

42Cr: 900-1150 N/mm²



H22.013.0

1000 kN/m max.



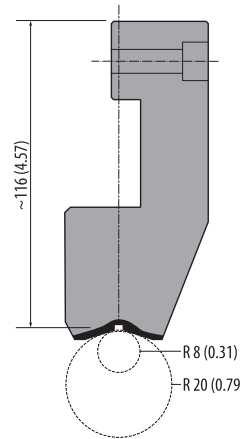
Model	Length	Weight
H22.013.01.01	100	3.94
H22.013.02.01	50	1.97
H22.013.02.02	55	2.17
H22.013.02.03	60	2.36
H22.013.02.04	65	2.56
H22.013.02.05	70	2.76
H22.013.02.06	75	2.95
H22.013.02.07	80	3.15
H22.013.02.08	85	3.35
H22.013.02.09	90	3.54
H22.013.02.10	95	3.74

C45: 560-710 N/mm²



H22.014.0

1000 kN/m max.



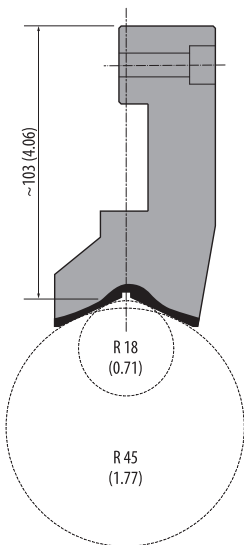
Model	Length	Weight
H22.014.01.01	100	3.94
H22.014.02.01	50	1.97
H22.014.02.02	55	2.17
H22.014.02.03	60	2.36
H22.014.02.04	65	2.56
H22.014.02.05	70	2.76
H22.014.02.06	75	2.95
H22.014.02.07	80	3.15
H22.014.02.08	85	3.35
H22.014.02.09	90	3.54
H22.014.02.10	95	3.74

C45: 560-710 N/mm²



H22.015.0

1000 kN/m max.

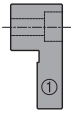


Model	Length	Weight
H22.015.01.01	100	3.94
H22.015.02.01	50	1.97
H22.015.02.02	55	2.17
H22.015.02.03	60	2.36
H22.015.02.04	65	2.56
H22.015.02.05	70	2.76
H22.015.02.06	75	2.95
H22.015.02.07	80	3.15
H22.015.02.08	85	3.35
H22.015.02.09	90	3.54
H22.015.02.10	95	3.74

C45: 560-710 N/mm²



H61.100.01 / H61.500.01

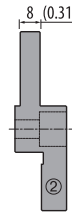


Model	Length	Weight
H61.100.01	100	0.63 kg
H61.500.01	500	3.15 kg

C45: 560-710 N/mm²



H61.100.02 / H61.500.02

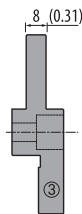


Model	Length	Weight
H61.100.02	100	0.70 kg
H61.500.02	500	3.50 kg

C45: 560-710 N/mm²



H61.100.03 / H61.500.03

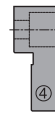


Model	Length	Price	Weight
H61.100.03	100	3.94	0.70 kg
H61.500.03	500	19.68	3.50 kg

C45: 560-710 N/mm²



H61.100.04 / H61.500.04



Model	Length	Weight
H61.100.04	100	0.63 kg
H61.500.04	500	3.15 kg

C45: 560-710 N/mm²



H61.100.05 / H61.500.05



Model	Length	Weight
H61.100.05	100	0.30 kg
H61.500.05	500	1.50 kg

C45: 560-710 N/mm²



H61.100.06 / H61.500.06

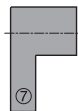


Model	Length	Weight
H61.100.06	100	0.63 kg
H61.500.06	500	3.15 kg

C45: 560-710 N/mm²



H61.100.07

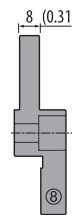


Model	Length	Weight
H61.100.07	100	0.65 kg

C45: 560-710 N/mm²



H61.100.08 / H61.500.08



Model	Length	Weight
H61.100.08	100	0.70 kg
H61.500.08	500	3.50 kg

C45: 560-710 N/mm²



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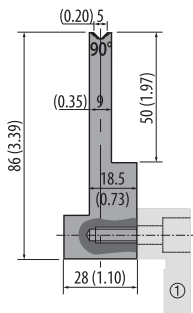


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H41.005.0

1000 kN/m max.

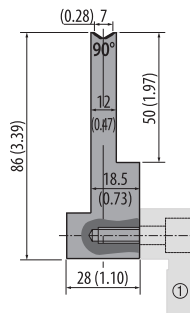


42Cr: 900-1150 N/mm²

Model	Length	Weight
H41.005.01.01	100	3.94
H41.005.02.01	50 SX	1.97 SX
H41.005.02.02	55 DX	2.17 DX
H41.005.02.03	60 DX	2.36 DX
H41.005.02.04	65 DX	2.56 DX
H41.005.02.05	70 DX	2.76 DX
H41.005.02.06	75 DX	2.95 DX
H41.005.02.07	80 DX	3.15 DX
H41.005.02.08	85 DX	3.35 DX
H41.005.02.09	90 DX	3.54 DX
H41.005.02.10	95 DX	3.74 DX
H41.005.03.01	50 DX	1.97 DX
H41.005.03.02	55 SX	2.17 SX
H41.005.03.03	60 SX	2.36 SX
H41.005.03.04	65 SX	2.56 SX
H41.005.03.05	70 SX	2.76 SX
H41.005.03.06	75 SX	2.95 SX
H41.005.03.07	80 SX	3.15 SX
H41.005.03.08	85 SX	3.35 SX
H41.005.03.09	90 SX	3.54 SX
H41.005.03.10	95 SX	3.74 SX

H41.007.0

1000 kN/m max.

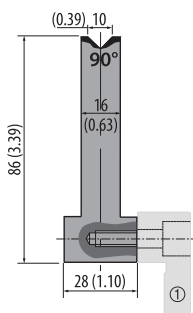


42Cr: 900-1150 N/mm²

Model	Length	Weight
H41.007.01.01	100	3.94
H41.007.02.01	50 SX	1.97 SX
H41.007.02.02	55 DX	2.17 DX
H41.007.02.03	60 DX	2.36 DX
H41.007.02.04	65 DX	2.56 DX
H41.007.02.05	70 DX	2.76 DX
H41.007.02.06	75 DX	2.95 DX
H41.007.02.07	80 DX	3.15 DX
H41.007.02.08	85 DX	3.35 DX
H41.007.02.09	90 DX	3.54 DX
H41.007.02.10	95 DX	3.74 DX
H41.007.03.01	50 DX	1.97 DX
H41.007.03.02	55 SX	2.17 SX
H41.007.03.03	60 SX	2.36 SX
H41.007.03.04	65 SX	2.56 SX
H41.007.03.05	70 SX	2.76 SX
H41.007.03.06	75 SX	2.95 SX
H41.007.03.07	80 SX	3.15 SX
H41.007.03.08	85 SX	3.35 SX
H41.007.03.09	90 SX	3.54 SX
H41.007.03.10	95 SX	3.74 SX

H41.010.0

1000 kN/m max.

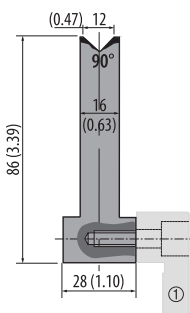


42Cr: 900-1150 N/mm²

Model	Length	Weight
H41.010.01.01	100	3.94
H41.010.02.01	50 SX	1.97 SX
H41.010.02.02	55 DX	2.17 DX
H41.010.02.03	60 DX	2.36 DX
H41.010.02.04	65 DX	2.56 DX
H41.010.02.05	70 DX	2.76 DX
H41.010.02.06	75 DX	2.95 DX
H41.010.02.07	80 DX	3.15 DX
H41.010.02.08	85 DX	3.35 DX
H41.010.02.09	90 DX	3.54 DX
H41.010.02.10	95 DX	3.74 DX
H41.010.03.01	50 DX	1.97 DX
H41.010.03.02	55 SX	2.17 SX
H41.010.03.03	60 SX	2.36 SX
H41.010.03.04	65 SX	2.56 SX
H41.010.03.05	70 SX	2.76 SX
H41.010.03.06	75 SX	2.95 SX
H41.010.03.07	80 SX	3.15 SX
H41.010.03.08	85 SX	3.35 SX
H41.010.03.09	90 SX	3.54 SX
H41.010.03.10	95 SX	3.74 SX

H41.012.0

1000 kN/m max.

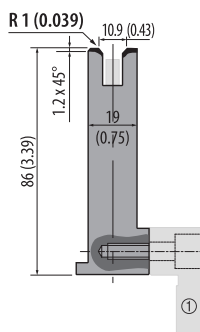


42Cr: 900-1150 N/mm²

Model	Length	Weight
H41.012.01.01	100	3.94
H41.012.02.01	50 SX	1.97 SX
H41.012.02.02	55 DX	2.17 DX
H41.012.02.03	60 DX	2.36 DX
H41.012.02.04	65 DX	2.56 DX
H41.012.02.05	70 DX	2.76 DX
H41.012.02.06	75 DX	2.95 DX
H41.012.02.07	80 DX	3.15 DX
H41.012.02.08	85 DX	3.35 DX
H41.012.02.09	90 DX	3.54 DX
H41.012.02.10	95 DX	3.74 DX
H41.012.03.01	50 DX	1.97 DX
H41.012.03.02	55 SX	2.17 SX
H41.012.03.03	60 SX	2.36 SX
H41.012.03.04	65 SX	2.56 SX
H41.012.03.05	70 SX	2.76 SX
H41.012.03.06	75 SX	2.95 SX
H41.012.03.07	80 SX	3.15 SX
H41.012.03.08	85 SX	3.35 SX
H41.012.03.09	90 SX	3.54 SX
H41.012.03.10	95 SX	3.74 SX

H31.010.2

550 kN/m max.

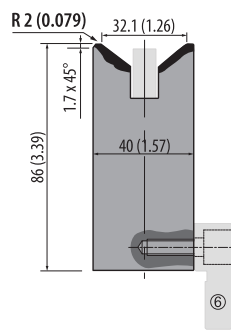


42Cr: 900-1150 N/mm²

Model	Length	Weight
H31.010.21.01	100	3.94
H31.010.22.01	50 SX	1.97 SX
H31.010.22.02	55 DX	2.17 DX
H31.010.22.03	60 DX	2.36 DX
H31.010.22.04	65 DX	2.56 DX
H31.010.22.05	70 DX	2.76 DX
H31.010.22.06	75 DX	2.95 DX
H31.010.22.07	80 DX	3.15 DX
H31.010.22.08	85 DX	3.35 DX
H31.010.22.09	90 DX	3.54 DX
H31.010.22.10	95 DX	3.74 DX
H31.010.23.01	50 DX	1.97 DX
H31.010.23.02	55 SX	2.17 SX
H31.010.23.03	60 SX	2.36 SX
H31.010.23.04	65 SX	2.56 SX
H31.010.23.05	70 SX	2.76 SX
H31.010.23.06	75 SX	2.95 SX
H31.010.23.07	80 SX	3.15 SX
H31.010.23.08	85 SX	3.35 SX
H31.010.23.09	90 SX	3.54 SX
H31.010.23.10	95 SX	3.74 SX

H31.032.1

1200 kN/m max.

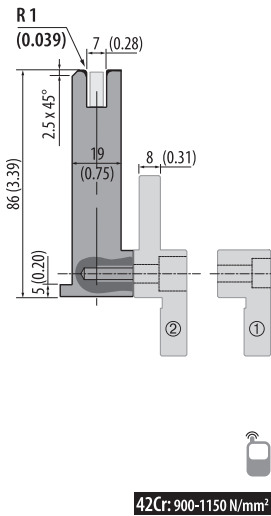


C45: 560-710 N/mm²

Model	Length	Weight
H31.032.11.01	100	3.94
H31.032.12.01	50 SX	1.97 SX
H31.032.12.02	55 DX	2.17 DX
H31.032.12.03	60 DX	2.36 DX
H31.032.12.04	65 DX	2.56 DX
H31.032.12.05	70 DX	2.76 DX
H31.032.12.06	75 DX	2.95 DX
H31.032.12.07	80 DX	3.15 DX
H31.032.12.08	85 DX	3.35 DX
H31.032.12.09	90 DX	3.54 DX
H31.032.12.10	95 DX	3.74 DX
H31.032.13.01	50 DX	1.97 DX
H31.032.13.02	55 SX	2.17 SX
H31.032.13.03	60 SX	2.36 SX
H31.032.13.04	65 SX	2.56 SX
H31.032.13.05	70 SX	2.76 SX
H31.032.13.06	75 SX	2.95 SX
H31.032.13.07	80 SX	3.15 SX
H31.032.13.08	85 SX	3.35 SX
H31.032.13.09	90 SX	3.54 SX
H31.032.13.10	95 SX	3.74 SX

H31.007.0

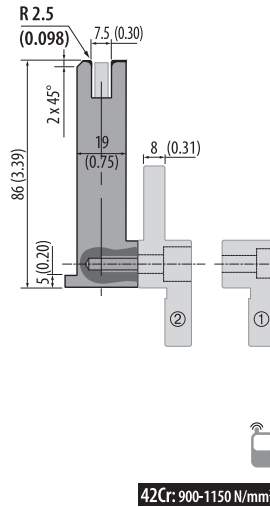
500 kN/m max.



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

H31.007.2

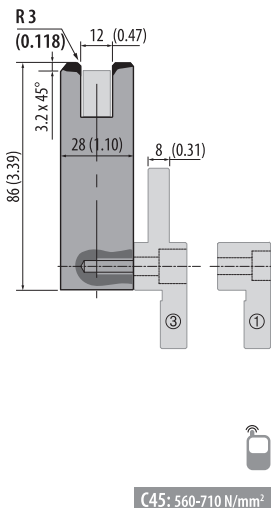
500 kN/m max.



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

H31.013.0

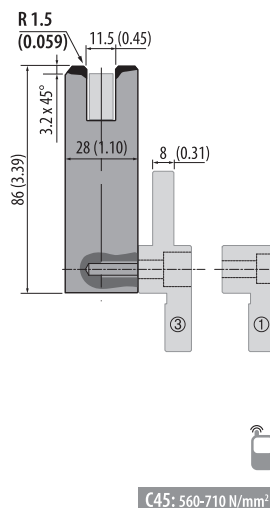
500 kN/m max.



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

H31.012.0

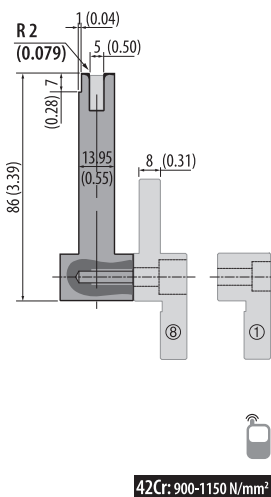
500 kN/m max.



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

H31.006.0

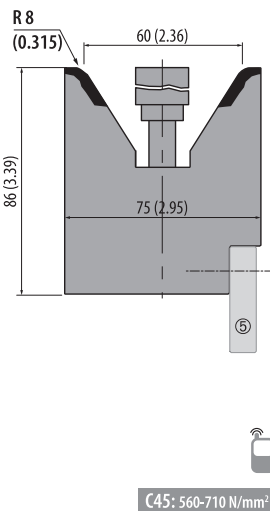
350 kN/m max.



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

H31.060.0

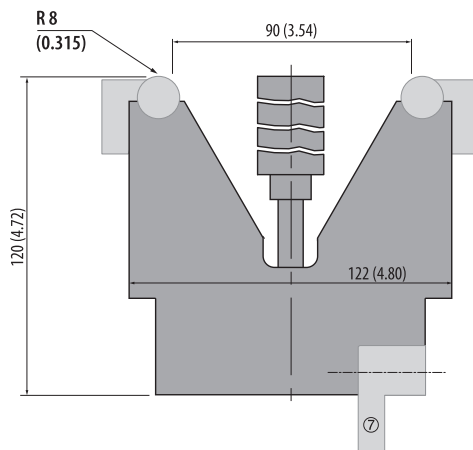
1500 kN/m max.



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

H31.090.01.01

1500 kN/m max.



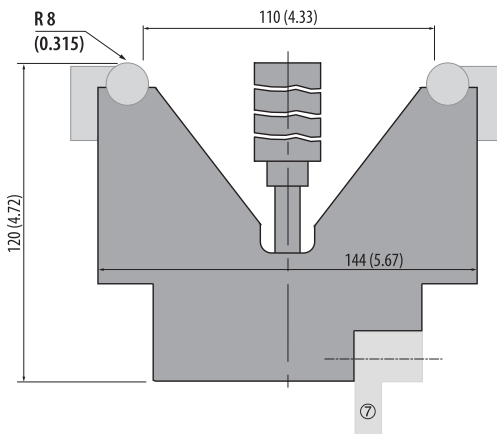
Model	Length	Weight
H31.090.01.01	100	8.15 kg

C45: 560-710 N/mm²



H31.110.01.01

1500 kN/m max.



Model	Length	Weight
H31.110.01.01	100	8.83 kg

C45: 560-710 N/mm²



7
RX



Article on stock



Please ask for delivery time!

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



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

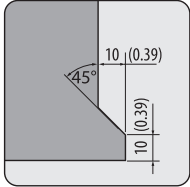
Tool lengths, sectionings and horn types

Punches:

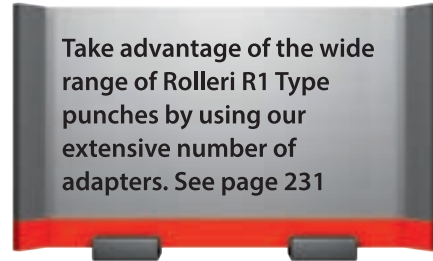
- 1020 mm (40.16 in)
- 1250 mm (49.21 in) segmented
15 segments (100 Horn left, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 100, 100 Horn right)

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)



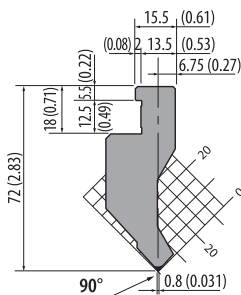
Standard horns
for all segmented
Rolleri RX Colly type
punches



Colly Punches

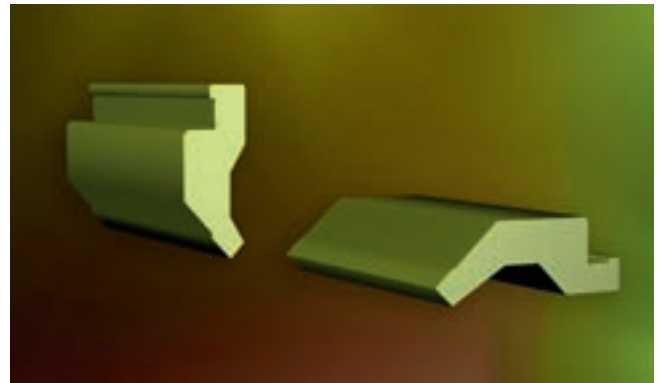
CP72.90.08

700 kN/m max.



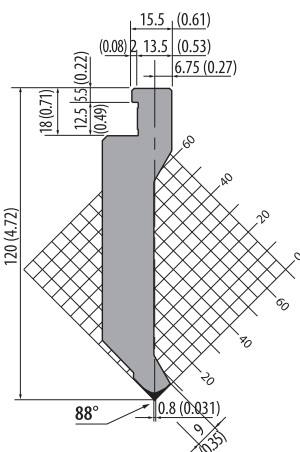
1020 mm	40.16 in	10.2 kg
1250 mm segmented	49.21 in segmented	12.5 kg

C45: 560-710 N/mm²



CP120.88.08

700 kN/m max.



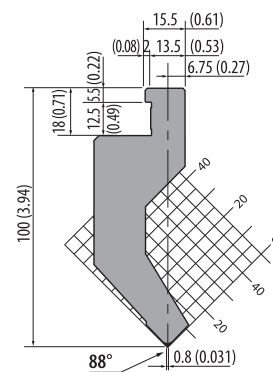
1020 mm	40.16 in	18.5 kg
1250 mm segmented	49.21 in segmented	22.6 kg

C45: 560-710 N/mm²



CP100.88.08-A

500 kN/m max.



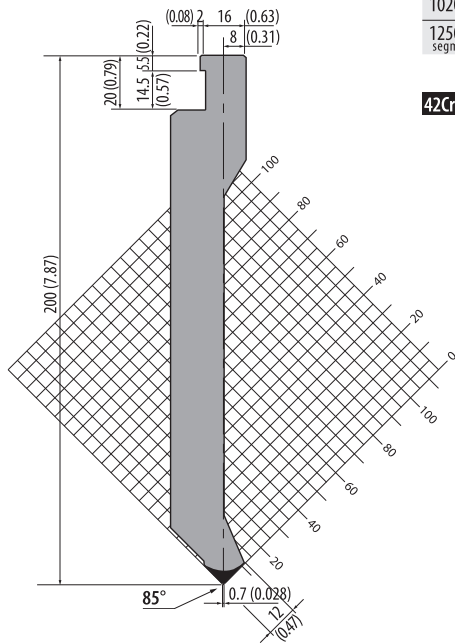
1020 mm	40.16 in	16.7 kg
1250 mm segmented	49.21 in segmented	20.4 kg

C45: 560-710 N/mm²



CP200.85.07

1000 kN/m max.



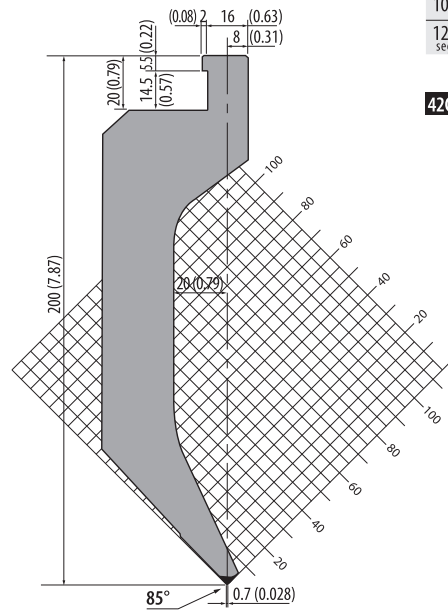
1020 mm	40.16 in	31.6 kg
1250 mm segmented	49.21 in segmented	49.0 kg

C42Cr: 900-1150 N/mm²



CP200.85.07-A

750 kN/m max.



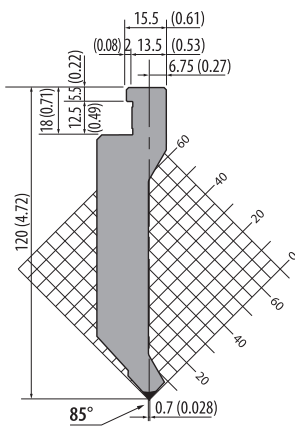
1020 mm	40.16 in	49.0 kg
1250 mm segmented	49.21 in segmented	60.0 kg

C42Cr: 900-1150 N/mm²



CP120.85.07

700 kN/m max.



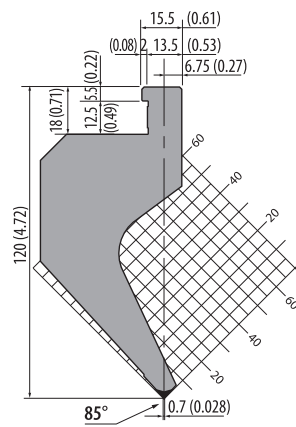
1020 mm	40.16 in	17.9 kg
1250 mm segmented	49.21 in segmented	21.9 kg

C45: 560-710 N/mm²



CP120.85.07-A

450 kN/m max.



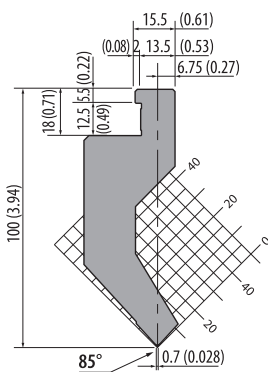
1020 mm	40.16 in	25.5 kg
1250 mm segmented	49.21 in segmented	31.3 kg

C45: 560-710 N/mm²



CP100.85.07-A

500 kN/m max.



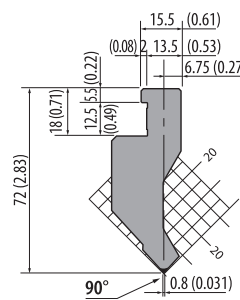
1020 mm	40.16 in	16.7 kg
1250 mm segmented	49.21 in segmented	20.4 kg

C45: 560-710 N/mm²



CP72.85.07

700 kN/m max.



1020 mm	40.16 in	10.0 kg
1250 mm segmented	49.21 in segmented	12.3 kg

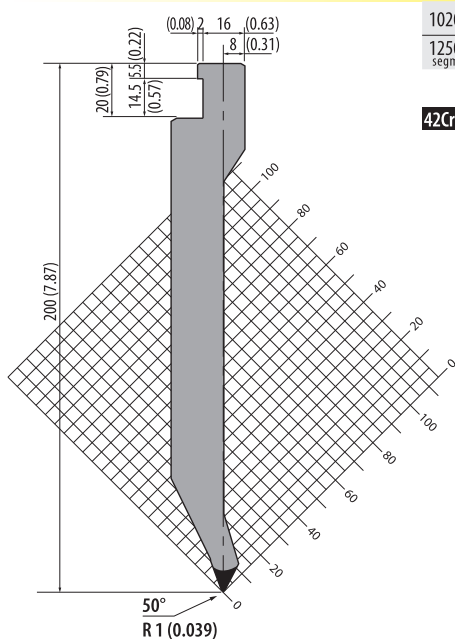
C45: 560-710 N/mm²



7
RX

CP200.50.R1

1000 kN/m max.



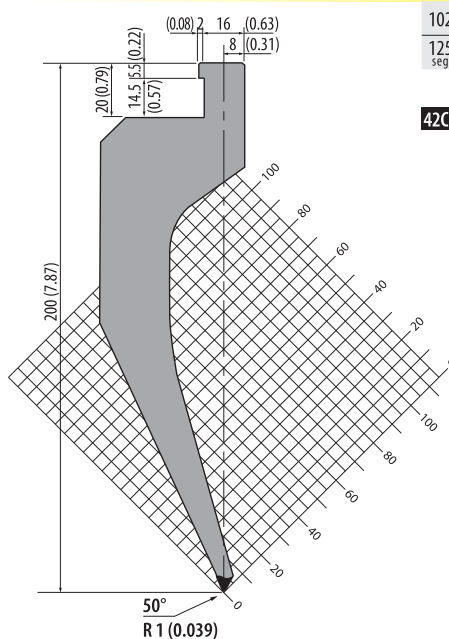
1020 mm	40.16 in	31.0 kg
1250 mm segmented	49.21 in segmented	38.0 kg

42Cr: 900-1150 N/mm²



CP200.50.R1-A

550 kN/m max.



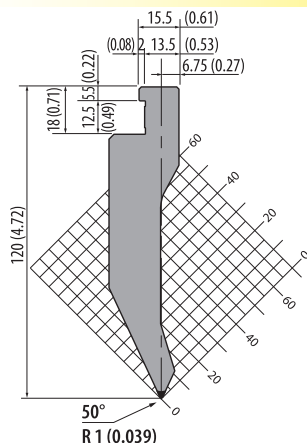
1020 mm	40.16 in	52.0 kg
1250 mm segmented	49.21 in segmented	63.7 kg

42Cr: 900-1150 N/mm²



CP120.50.R1

1000 kN/m max.



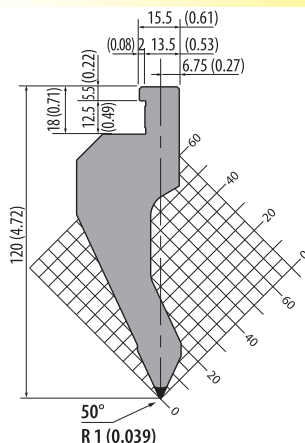
1020 mm	40.16 in	17.0 kg
1250 mm segmented	49.21 in segmented	20.8 kg

C45: 560-710 N/mm²



CP120.50.R1-A

550 kN/m max.



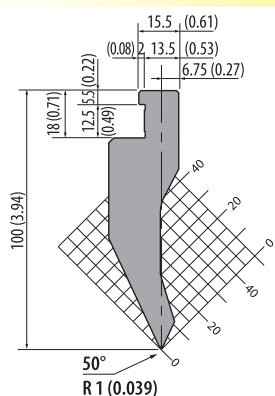
1020 mm	40.16 in	31.0 kg
1250 mm segmented	49.21 in segmented	38.0 kg

42Cr: 900-1150 N/mm²



CP100.50.R1

1000 kN/m max.



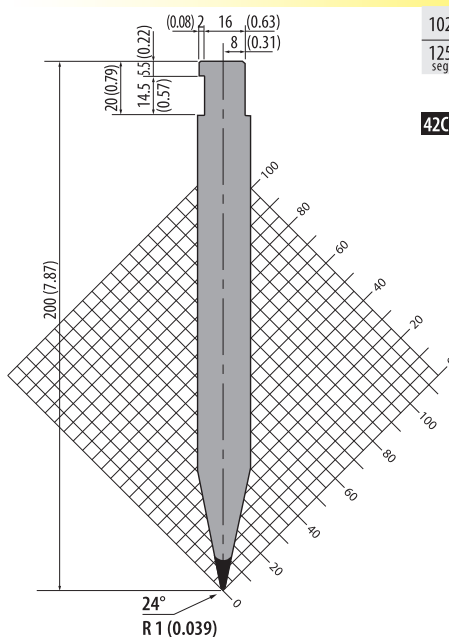
1020 mm	40.16 in	13.0 kg
1250 mm segmented	49.21 in segmented	16.0 kg

42Cr: 900-1150 N/mm²



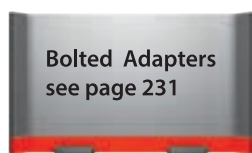
CP200.24.R1

1300 kN/m max.



1020 mm	40.16 in	22.0 kg
1250 mm segmented	49.21 in segmented	26.9 kg

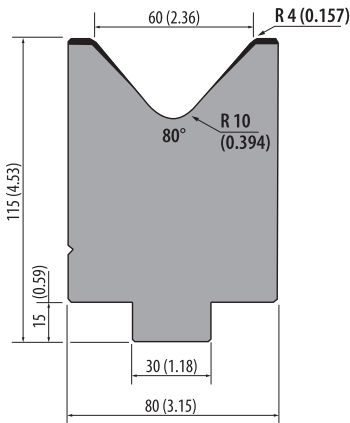
42Cr: 900-1150 N/mm²



Bolted Adapters
see page 231

M115.80.60

1200 kN/m max.



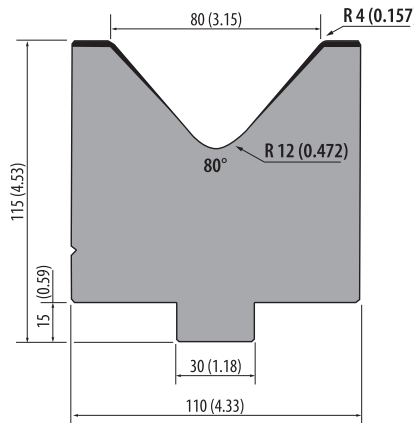
1020 mm	40.16 in	60.0 kg
1250 mm segmented	49.21 in segmented	73.6 kg

C45: 560-710 N/mm²



M115.80.80

1000 kN/m max.



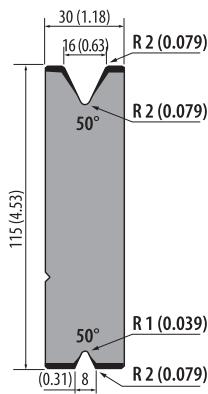
1020 mm	40.16 in	80.0 kg
1250 mm segmented	49.21 in segmented	98.0 kg

C45: 560-710 N/mm²



M115.50.16

600 kN/m max.



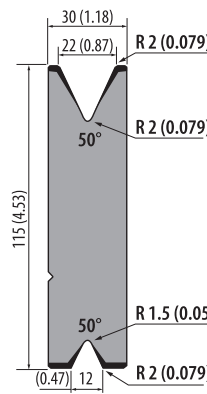
1020 mm	40.16 in	26.5 kg
1250 mm segmented	49.21 in segmented	32.4 kg

C45: 560-710 N/mm²



M115.50.22

500 kN/m max.



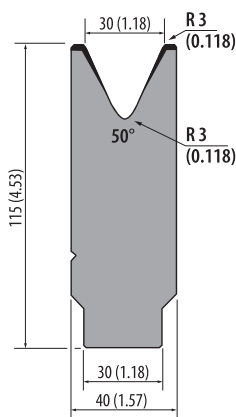
1020 mm	40.16 in	25.5 kg
1250 mm segmented	49.21 in segmented	31.2 kg

C45: 560-710 N/mm²



M115.50.30

400 kN/m max.



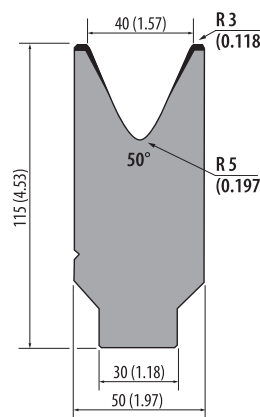
1020 mm	40.16 in	34.5 kg
1250 mm segmented	49.21 in segmented	43.0 kg

C45: 560-710 N/mm²



M115.50.40

400 kN/m max.



1020 mm	40.16 in	36.0 kg
1250 mm segmented	49.21 in segmented	44.0 kg

C45: 560-710 N/mm²



7
RX



Article on stock



Please ask for delivery time!

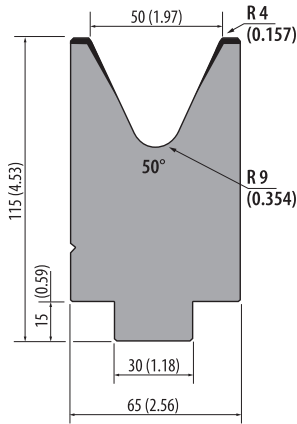
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

M115.50.50

600 kN/m max.

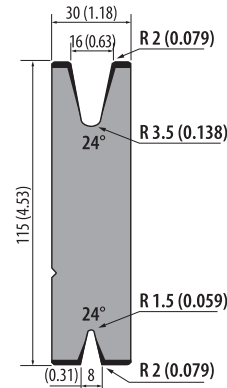


1020 mm	40.16 in	45.5 kg
1250 mm segmented	49.21 in segmented	55.7 kg

C45: 560-710 N/mm²



M115.24.16



1020 mm	40.16 in	24.9 kg
1250 mm segmented	49.21 in segmented	31.0 kg

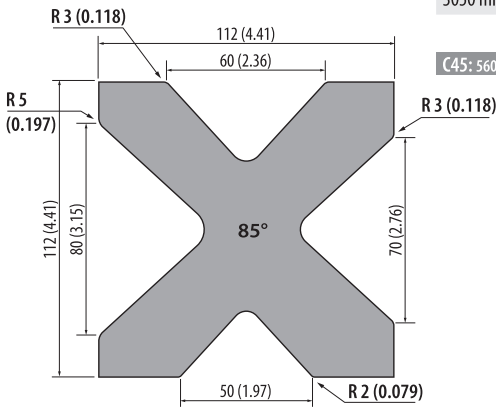
C45: 560-710 N/mm²



	V1	V2
V mm	8	16
Angle	24°	24°
kN/m max.	700	300

MC112.3050

3050 mm 120.08 in 188.0 kg



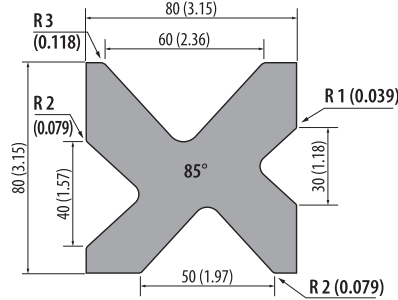
C45: 560-710 N/mm²



	V1	V2	V3	V4
V mm	60	70	50	80
Angle	85°	85°	85°	85°
R mm	3,0	3,0	2,0	5,0
kN/m max.	850	900	800	800

MC80.2050 / MC80.3050

750 kN/m max.



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

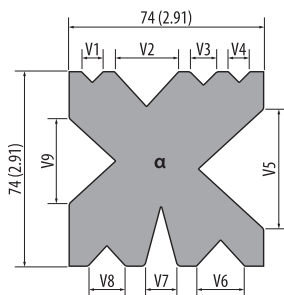
C45: 560-710 N/mm²



	V1	V2	V3	V4
V mm	60	30	50	40
Angle	85°	85°	85°	85°
R mm	3,0	2,0	2,0	1,0
kN/m max.	750	750	750	750

MC74.2050 / MC74.3050

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



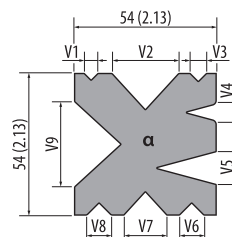
C45: 560-710 N/mm²



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

MC54.2050 / MC54.3050

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



C45: 560-710 N/mm²

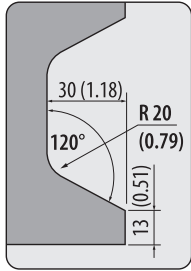


	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm (in)	6 (0.24)	25 (0.98)	6 (0.24)	6 (0.24)	12 (0.47)	9 (0.35)	16 (0.63)	9 (0.35)	32 (1.26)
Angle	90°	85°	90°	30°	30°	90°	85°	90°	85°
R mm (in)	0.5 (0.020)	1.0 (0.039)	0.5 (0.020)	2.0 (0.079)	0.5 (0.020)	1.0 (0.039)	0.5 (0.020)	1.5 (0.059)	1.0 (0.039)
kN/m max.	250	600	250	400	500	250	700	250	550

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 horns
for all segmented
Rolleri RX Gasparini type
punches

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:

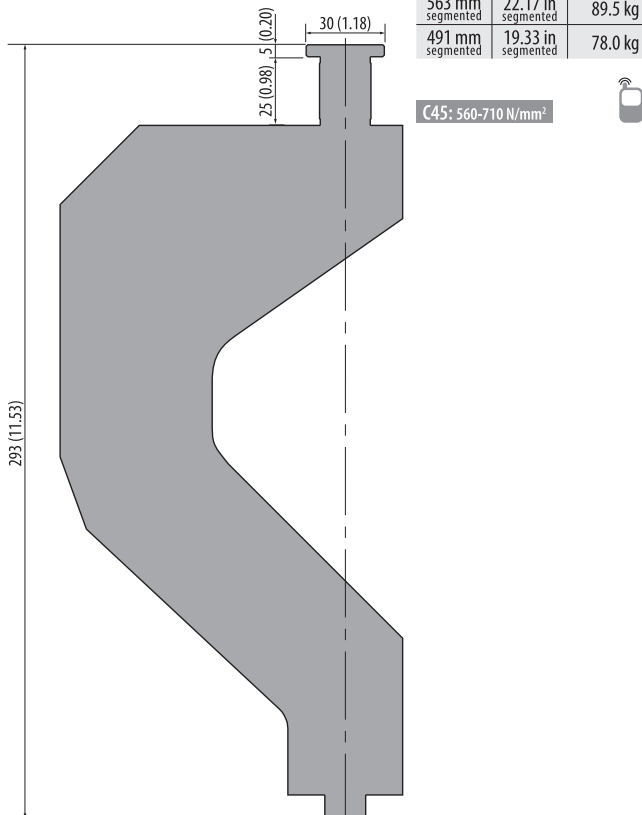
- 525 mm (20.67 in)
- 590 mm (23.23 in) segmented
9 segments (45, 50, 55, 60, 65, 70, 75, 80, 90)
- 500 mm (19.68 in) segmented
3 segments (100, 300, 100)

Gasparini Radius Tools

GASP293-16

1000 kN/m max.

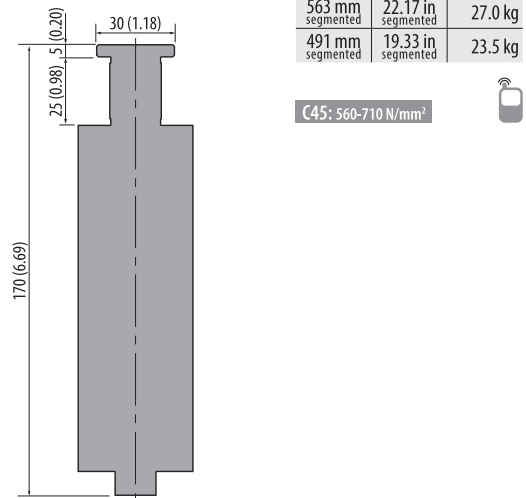
522 mm	20.55 in	83.0 kg
563 mm segmented	22.17 in segmented	89.5 kg
491 mm segmented	19.33 in segmented	78.0 kg



GASP170-16

1800 kN/m max.

522 mm	20.55 in	25.0 kg
563 mm segmented	22.17 in segmented	27.0 kg
491 mm segmented	19.33 in segmented	23.5 kg



Article
on stock



Please ask for
delivery time!

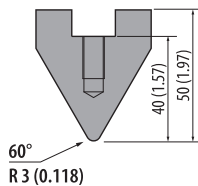
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

GASP40.60.03

1000 kN/m max.



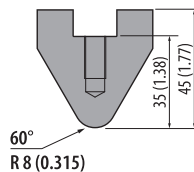
525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²



GASP35.60.08

1000 kN/m max.



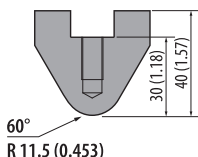
525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²



GASP30.60.11.5

1000 kN/m max.



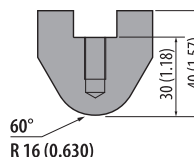
525 mm	20.67 in	4.2 kg
590 mm segmented	23.23 in segmented	4.7 kg
500 mm segmented	19.68 in segmented	4.0 kg

C45: 560-710 N/mm²



GASP30.60.16

1000 kN/m max.



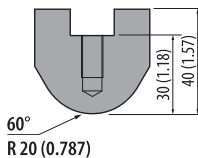
525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²



GASP30.60.20

1000 kN/m max.



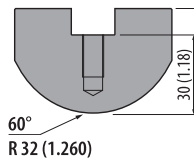
525 mm	20.67 in	5.0 kg
590 mm segmented	23.23 in segmented	5.6 kg
500 mm segmented	19.68 in segmented	4.3 kg

C45: 560-710 N/mm²



GASP30.60.32

1000 kN/m max.



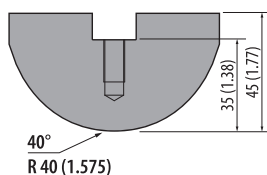
525 mm	20.67 in	7.0 kg
590 mm segmented	23.23 in segmented	7.8 kg
500 mm segmented	19.68 in segmented	6.7 kg

C45: 560-710 N/mm²



GASP35.40.40

1500 kN/m max.



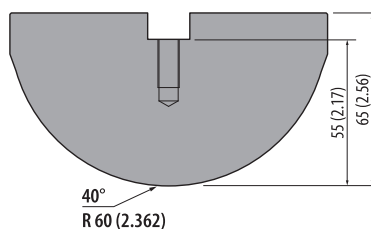
525 mm	20.67 in	10.5 kg
590 mm segmented	23.23 in segmented	11.8 kg
500 mm segmented	19.68 in segmented	10.0 kg

C45: 560-710 N/mm²



GASP55.40.60

1800 kN/m max.



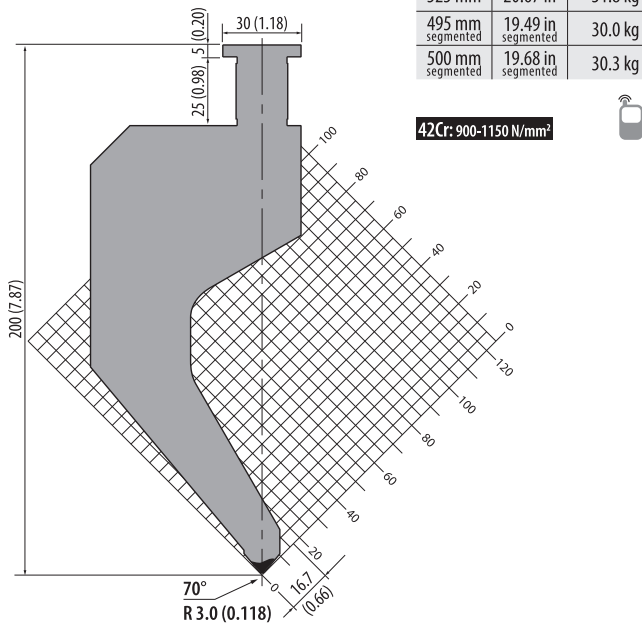
525 mm	20.67 in	24.4 kg
590 mm segmented	23.23 in segmented	27.4 kg
500 mm segmented	19.68 in segmented	23.2 kg

C45: 560-710 N/mm²



GASP200.70.R3-30

1000 kN/m max.

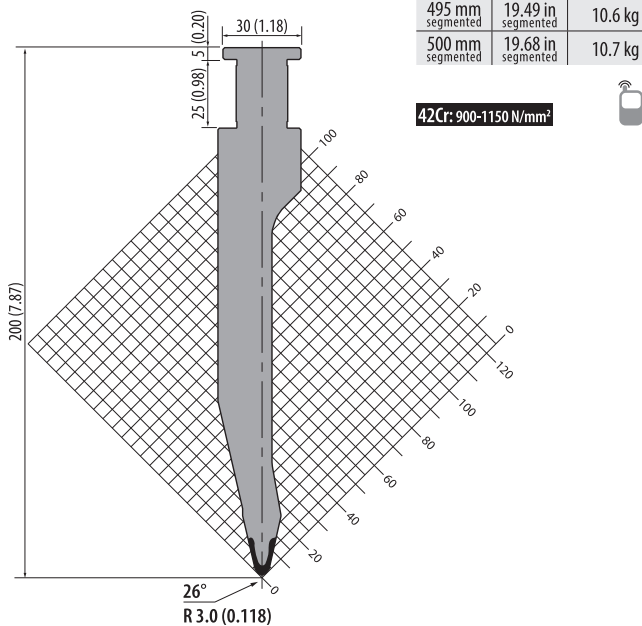


Many more tools available for heavy duty on pages 248-249

7
RX

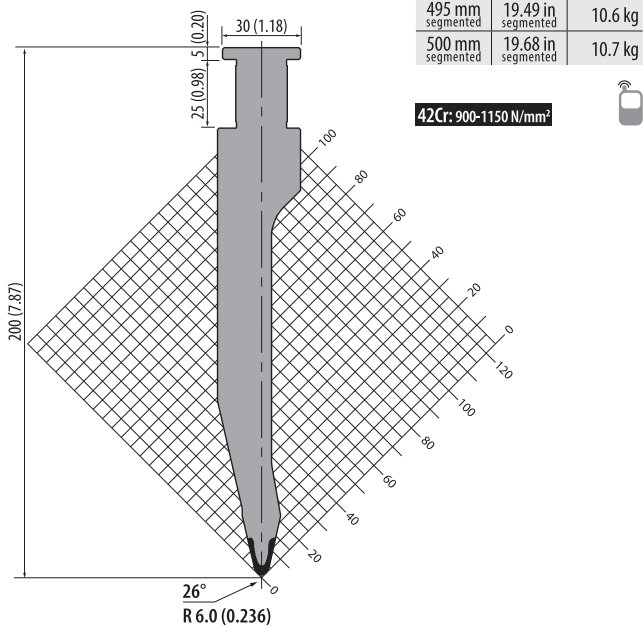
GASP200.26.R3-30

1300 kN/m max.



GASP200.26.R6-30

1300 kN/m max.



Many more tools available upon request.
Compatible adapters see pages 227 and 231



Article on stock



Please ask for delivery time!

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

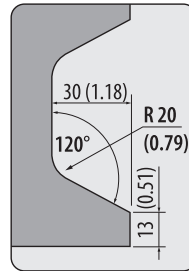


Articles on stock – Please note that delivery time depends on your location.

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)

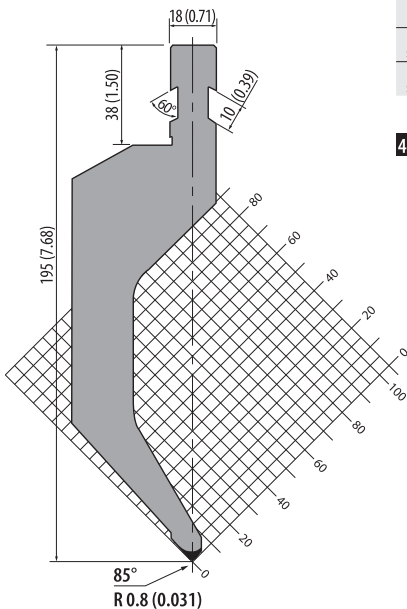


Standard horns
for all segmented
Rolleri RX Colgar type
punches

Colgar Punches and Radius Tools

PAC195.85.R08

1000 kN/m max.



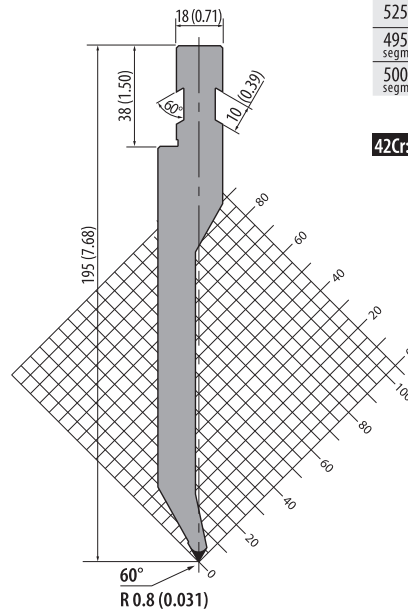
525 mm	20.67 in	20.6 kg
495 mm segmented	19.49 in segmented	19.4 kg
500 mm segmented	19.68 in segmented	19.6 kg

42Cr: 900-1150 N/mm²



PAC195.60.R08

1000 kN/m max.



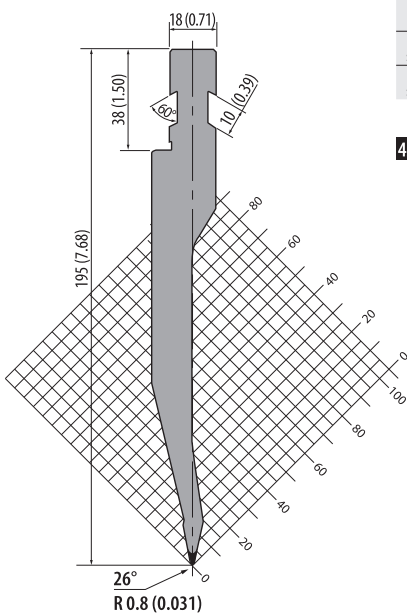
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



PAC195.26.R08

1000 kN/m max.



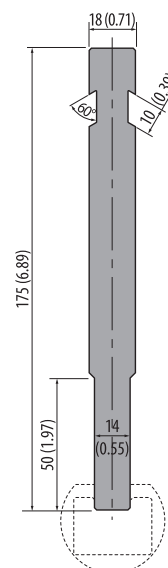
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



PAC175.14

1000 kN/m max.



830 mm	32.68 in	18.0 kg
412 mm	16.22 in	9.0 kg

C45: 560-710 N/mm²



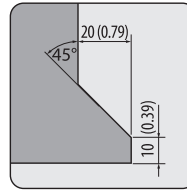
Compatible
radius holders
see page 33

More punches and dies
available upon request.
Compatible adapter
see pages 227, 230

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)

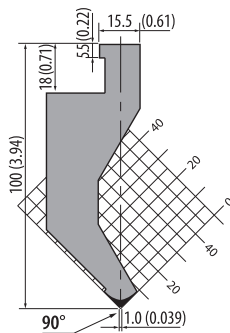


Standard horns
for all segmented
Rolleri RX Ajial-Axial type
punches

Ajial-Axial Punches

AXP.100.90.1

1000 kN/m max.



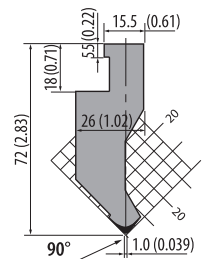
1020 mm	40.16 in	16.3 kg
990 mm segmented	38.98 in segmented	15.8 kg

C45: 560-710 N/mm²



AXP.72.90.1

1000 kN/m max.



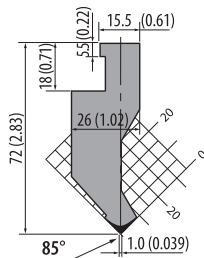
1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm²



AXP.72.85.1

1000 kN/m max.



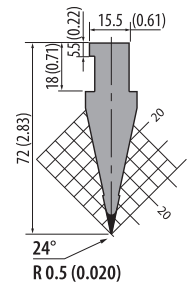
1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm²



AXP.72.24.R05

1000 kN/m max.



1020 mm	40.16 in	7.1 kg
990 mm segmented	38.98 in segmented	6.9 kg

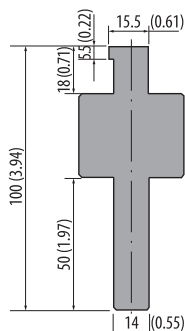
C45: 560-710 N/mm²



Ajial-Axial Adapters

AD15

1000 kN/m max.



150 mm	5.91 in	4.0 kg
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Rolleri Type RX Ajial-Axial
→ Rolleri Type R1

C45: 560-710 N/mm²



More punches and dies
available upon request.
Compatible Adapter
see pages 231

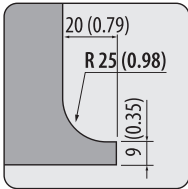
Tool lengths, sectionings and horn types

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)

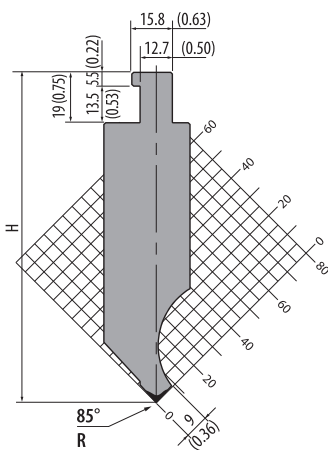


Standard horns
for all segmented
Rolleri RX American type
punches

American Punches

ASP-135

900 kN/m max.



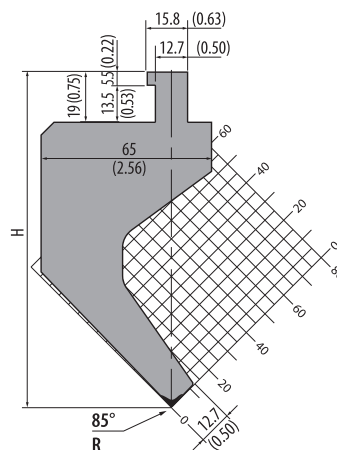
C45: 560-710 N/mm²



ASP-135-16	H=125 (4.92) / R=0.4 (0.016)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-31	H=125 (4.92) / R=0.8 (0.031)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-62	H=124.5 (4.90) / R=1.6 (0.062)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-125	H=123.8 (4.87) / R=3.2 (0.125)	
838 mm	33.00 in	21.0 kg
415 mm	16.34 in	10.4 kg
805 mm segmented	31.69 in segmented	20.1 kg

ASP-24

700 kN/m max.



42Cr: 900-1150 N/mm²

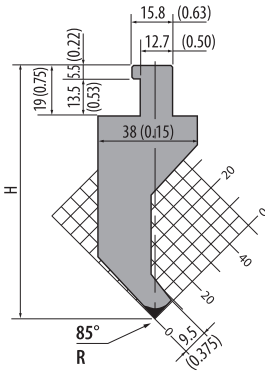


ASP-24-16	H=127 (5.00) / R=0.4 (0.016)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
ASP-24-31	H=127 (5.00) / R=0.8 (0.031)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
ASP-24-62	H=126.5 (4.98) / R=1.6 (0.062)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg
ASP-24-125	H=125.9 (4.96) / R=3.2 (0.125)	
838 mm	33.00 in	31.8 kg
415 mm	16.34 in	15.8 kg
805 mm segmented	31.69 in segmented	30.6 kg



ASP-9

660 kN/m max.



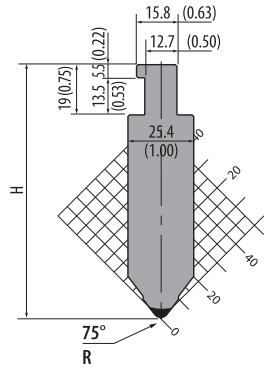
42Cr: 900-1150 N/mm²



ASP-9-16		H=96 (3.78) / R=0.4 (0.016)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	
ASP-9-31		H=96 (3.78) / R=0.8 (0.031)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	
ASP-9-63		H=95.5 (3.76) / R=1.6 (0.062)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	
ASP-9-125		H=94.8 (3.73) / R=3.2 (0.125)	
838 mm	33.00 in	12.8 kg	
415 mm	16.34 in	6.2 kg	
805 mm segmented	31.69 in segmented	12.1 kg	

ASP-15

1000 kN/m max.



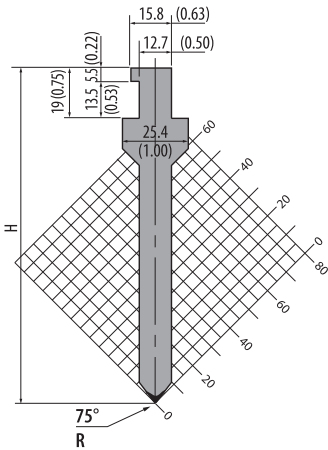
42Cr: 900-1150 N/mm²



ASP-15-16		H=95.9 (3.78) / R=0.4 (0.016)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-31		H=95.9 (3.78) / R=0.8 (0.031)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-63		H=95.9 (3.78) / R=1.6 (0.063)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-98		H=95.9 (3.78) / R=2.5 (0.098)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-15-125		H=96 (3.78) / R=3.2 (0.125)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	

ASP-14

1000 kN/m max.



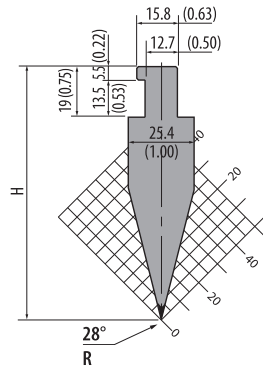
42Cr: 900-1150 N/mm²



ASP-14-16		H=127 (5.00) / R=0.4 (0.016)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-14-31		H=127 (5.00) / R=0.8 (0.031)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-14-62		H=126.5 (4.98) / R=1.6 (0.062)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	
ASP-14-125		H=126 (4.96) / R=3.2 (0.125)	
838 mm	33.00 in	13.4 kg	
415 mm	16.34 in	6.6 kg	
805 mm segmented	31.69 in segmented	12.9 kg	

ASP-18

1000 kN/m max.



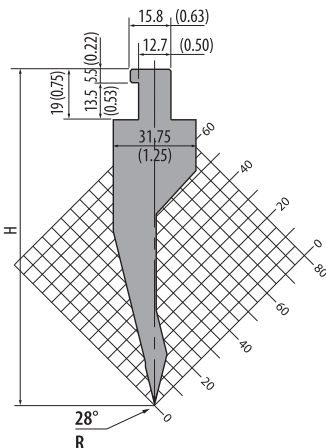
42Cr: 900-1150 N/mm²



ASP-18-31		H=96 (3.78) / R=0.8 (0.031)	
838 mm	33.00 in	10.9 kg	
415 mm	16.34 in	5.4 kg	
805 mm segmented	31.69 in segmented	10.5 kg	
ASP-18-62		H=93.4 (3.68) / R=1.6 (0.062)	
838 mm	33.00 in	10.9 kg	
415 mm	16.34 in	5.4 kg	
805 mm segmented	31.69 in segmented	10.5 kg	
ASP-18-125		H=87.5 (3.44) / R=3.2 (0.125)	
838 mm	33.00 in	10.9 kg	
415 mm	16.34 in	5.4 kg	
805 mm segmented	31.69 in segmented	10.5 kg	

ASP-19

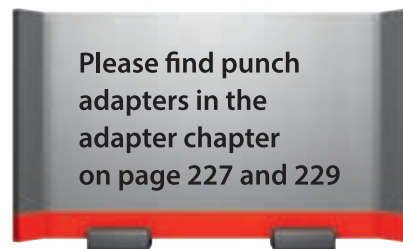
860 kN/m max.



42Cr: 900-1150 N/mm²

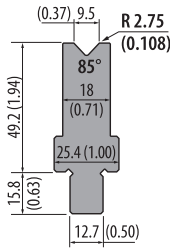


ASP-19-31		H=127 (5.00) / R=0.8 (0.031)	
838 mm	33.00 in	13.8 kg	
415 mm	16.34 in	6.8 kg	
805 mm segmented	31.69 in segmented	13.3 kg	
ASP-19-62		H=124.5 (4.90) / R=1.6 (0.062)	
838 mm	33.00 in	13.8 kg	
415 mm	16.34 in	6.8 kg	
805 mm segmented	31.69 in segmented	13.3 kg	
ASP-19-125		H=118.5 (4.67) / R=3.2 (0.125)	
838 mm	33.00 in	13.8 kg	
415 mm	16.34 in	6.8 kg	
805 mm segmented	31.69 in segmented	13.3 kg	



ASD-85-375

1000 kN/m max.



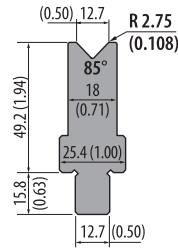
838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm²



ASD-85-500

1000 kN/m max.



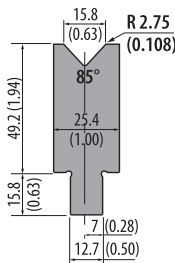
838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm²



ASD-85-625

1000 kN/m max.



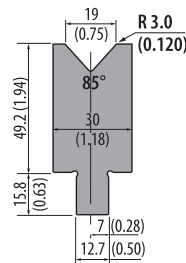
838 mm	33.00 in	9.2 kg
415 mm	16.34 in	4.6 kg
805 mm segmented	31.69 in segmented	8.9 kg

42Cr: 900-1150 N/mm²



ASD-85-750

1080 kN/m max.



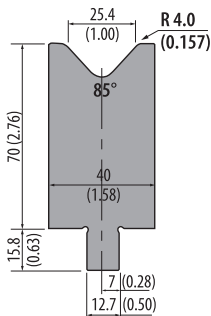
838 mm	33.00 in	10.5 kg
415 mm	16.34 in	5.2 kg
805 mm segmented	31.69 in segmented	10.1 kg

42Cr: 900-1150 N/mm²



ASD-85-100

950 kN/m max.



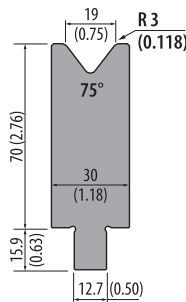
838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	19.9 kg

42Cr: 900-1150 N/mm²



ASD-75-750

1000 kN/m max.



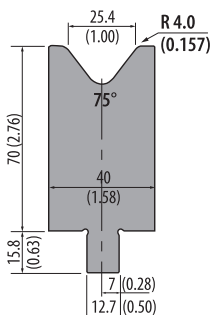
838 mm	33.00 in	14.7 kg
415 mm	16.34 in	7.3 kg
805 mm segmented	31.69 in segmented	14.1 kg

C45: 560-710 N/mm²



ASD-75-100

950 kN/m max.



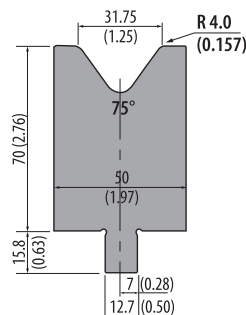
838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

C45: 560-710 N/mm²



ASD-75-125

1000 kN/m max.



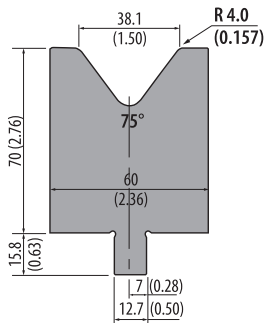
838 mm	33.00 in	22.2 kg
415 mm	16.34 in	11.0 kg
805 mm segmented	31.69 in segmented	21.3 kg

C45: 560-710 N/mm²



ASD-75-150

1000 kN/m max.



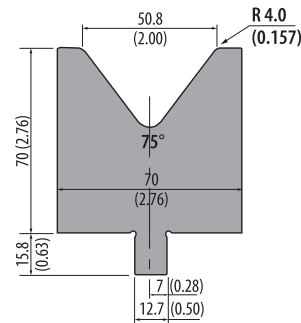
838 mm	33.00 in	25.6 kg
415 mm	16.34 in	12.7 kg
805 mm segmented	31.69 in segmented	24.6 kg

C45: 560-710 N/mm²



ASD-75-200

1000 kN/m max.



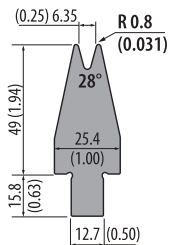
838 mm	33.00 in	27.7 kg
415 mm	16.34 in	13.7 kg
805 mm segmented	31.69 in segmented	25.6 kg

C45: 560-710 N/mm²



ASD-28-250

450 kN/m max.



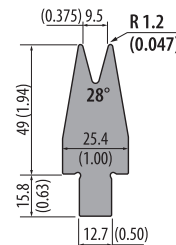
838 mm	33.00 in	7.2 kg
415 mm	16.34 in	3.6 kg
805 mm segmented	31.69 in segmented	6.9 kg

42Cr: 900-1150 N/mm²



ASD-28-375

600 kN/m max.



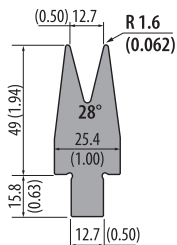
838 mm	33.00 in	7.8 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.5 kg

42Cr: 900-1150 N/mm²



ASD-28-500

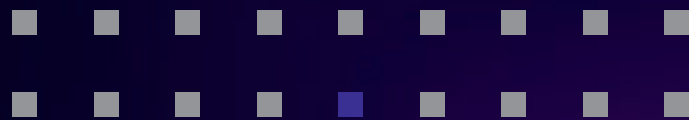
860 kN/m max.



838 mm	33.00 in	8.4 kg
415 mm	16.34 in	4.2 kg
805 mm segmented	31.69 in segmented	8.1 kg

42Cr: 900-1150 N/mm²





V

ROLLERI ROLLA-V ONYX DIES

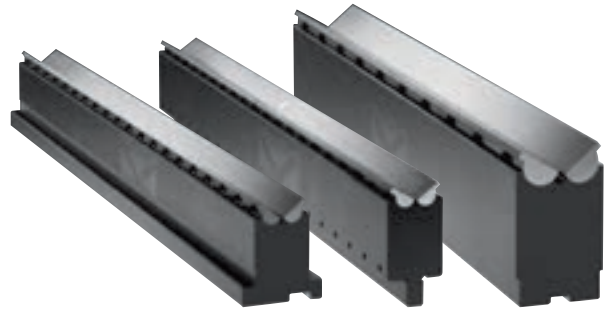
Content Explanation	202 - 203
Model 1	204
Model 2	205
Model 2.5	205
Model 3	206
Model 4	206
Adjustable Dies	207
Hemming and Joggle Tools	207

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, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, 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 tang) 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 tang) 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 tang) from: LVD
- **RVM Dies (Models 2.5, 3, 4)** are compatible with all press brake machines (various die holders)
- all dies can be mounted in other press brakes by using adapters or customized die holders.

Our Advantages – Your Convenience

- no corrosion
- fast and easy tool change
- new design
- longer operational life
- high precision
- interchangeability guaranteed
- reduction of bending marks on the sheet metal
- small flanges bent without marks
- No metal residue left on tools during bending of galvanized sheet metal
- ideal for profiles with oblique sides



Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4	1100-1200 N/mm ²	55 HRc
Inserts	1 / 2 / 2.5	Toolox 44	1450 N/mm ²	through hardened 44 HRc
Inserts	3 / 4	Toolox 33	1100 N/mm ²	55 HRc

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

	Equivalent V size mm (in)	max. tool load (kN/m)	Material Thickness mm (in)	min. bending angle	needed press force (kN)	min. outside flange mm (in)	max. outside radius mm (in)
Model 1 Max. recommended thickness =1.5 mm (0.06 in) (2.0 mm / 0.08 in possible)	8 (0.31)	1000	0.70 (0.03)	40°	50	3.0 (0.12)	3.0 (0.12)
		1000	1.10 (0.04)	35°	130	3.9 (0.15)	2.6 (0.10)
		1000	1.50 (0.06)	35°	270	4.2 (0.17)	2.2 (0.09)
Model 2 Max. recommended thickness =3.0 mm (0.12 in) (4.0 mm / 0.15 in possible)	15 (0.59)	1500	2.00 (0.08)	59°	210	8.5 (0.33)	6.0 (0.24)
		1500	3.00 (0.12)	47°	550	9.3 (0.37)	5.0 (0.20)
		1500	3.20 (0.13)	47°	650	9.3 (0.37)	4.8 (0.19)
Model 2.5 Max. recommended thickness =5.0 mm (0.20 in) (6.35 mm / 0.24 in possible)	28 (1.10)	2500	2.00 (0.08)	46°	100	18.6 (0.73)	13.2 (0.52)
		2500	4.00 (0.16)	46°	470	18.6 (0.73)	12.0 (0.47)
		2500	6.00 (0.24)	55°	1270	18.6 (0.73)	9.8 (0.39)
Model 3 Max. recommended thickness =6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)	38 (1.50)	2500	2.00 (0.08)	68°	70	22.5 (0.89)	13.9 (0.55)
		2500	4.00 (0.16)	47°	340	22.5 (0.89)	11.9 (0.47)
		2500	6.00 (0.24)	50°	900	22.5 (0.89)	9.9 (0.39)
Model 4 Max. recommended thickness =16.0 mm (0.63 in)	85 (3.35)	3000	6.00 (0.24)	78°	260	56.6 (2.23)	36.4 (1.43)
		3000	8.00 (0.31)	76°	500	56.6 (2.23)	36.4 (1.43)
		3000	12.00 (0.47)	73°	1290	56.6 (2.23)	36.4 (1.43)

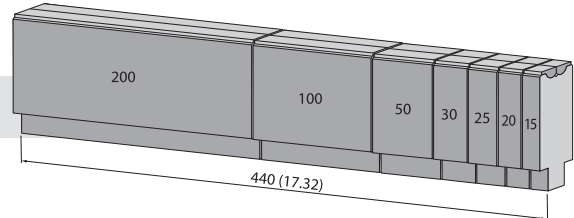
Tool lengths and sectioning

Standard

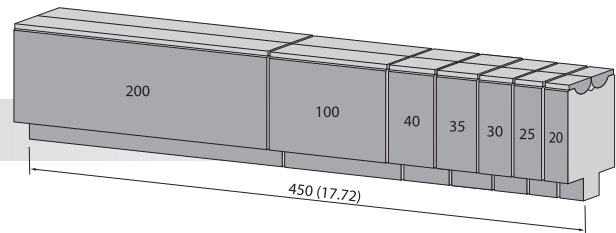
Segmented tools are delivered in complete sets. More lengths and sectionings are possible upon request.



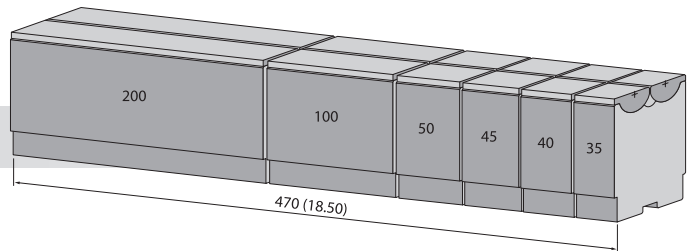
Model 1, 440 mm (17.32 in) segmented
(7 segments)



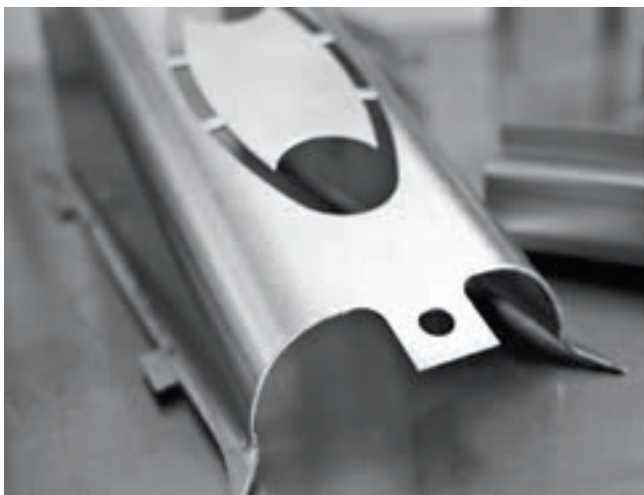
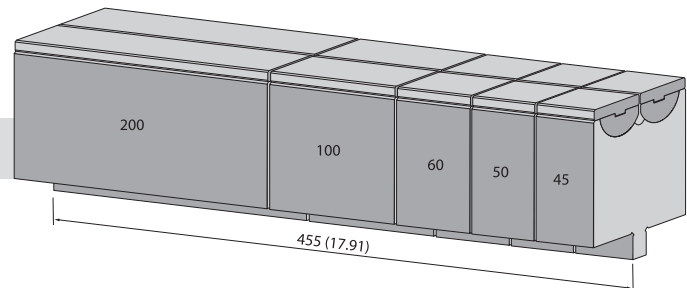
Model 2, 450 mm (17.72 in) segmented
(7 segments)



Model 2.5, 470 mm (18.50 in) segmented
(6 segments)



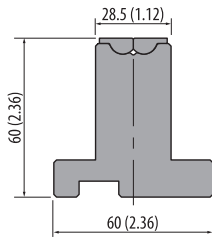
Model 3, 455 mm (17.91 in) segmented
(5 segments)



8

RVP60-1

1000 kN/m max.



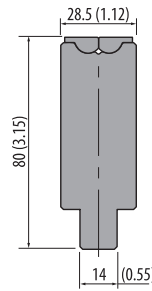
500 mm	16.68 in	6.9 kg
440 mm segmented	17.32 in segmented	6.1 kg

42Cr: 1100-1200 N/mm²



RVS80-1

1000 kN/m max.



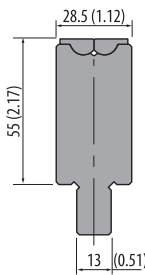
500 mm	16.68 in	6.3 kg
440 mm segmented	17.32 in segmented	5.8 kg

42Cr: 1100-1200 N/mm²



RVT55-1

1000 kN/m max.



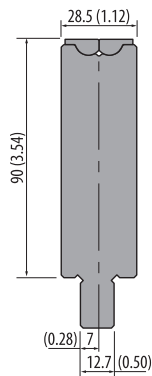
500 mm	16.68 in	5.5 kg
440 mm segmented	17.32 in segmented	5.0 kg

42Cr: 1100-1200 N/mm²



RVT90-1

1000 kN/m max.



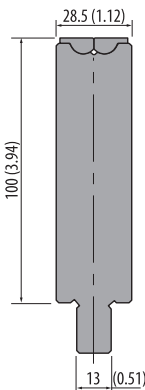
500 mm	16.68 in	8.5 kg
440 mm segmented	17.32 in segmented	7.8 kg

42Cr: 1100-1200 N/mm²



RVT100-1

1000 kN/m max.



500 mm	16.68 in	9.4 kg
440 mm segmented	17.32 in segmented	8.6 kg

42Cr: 1100-1200 N/mm²

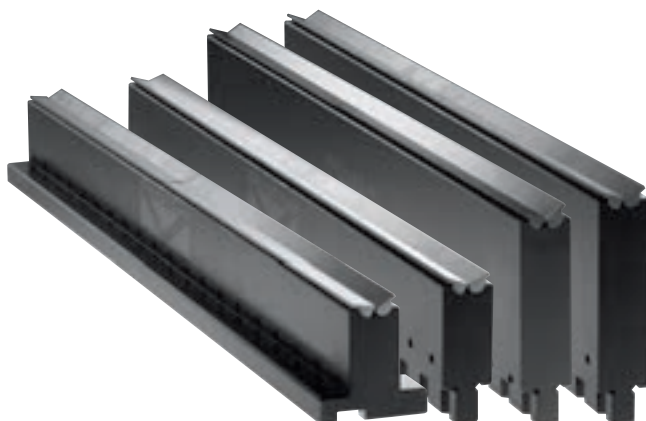


Rolleri Videos



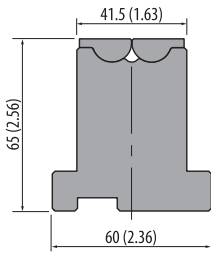
Use and application of Rolla-V dies

www.rolleritools.com/videos/rolla-v



RVP65-2

1500 kN/m max.



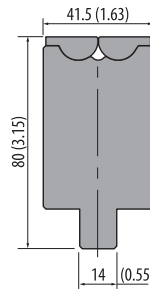
500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm²



RVS80-2

1500 kN/m max.



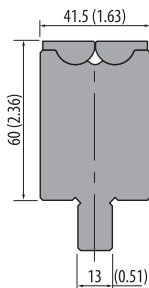
500 mm	16.68 in	8.3 kg
450 mm segmented	17.72 in segmented	7.8 kg

42Cr: 1100-1200 N/mm²



RVT60-2

1500 kN/m max.



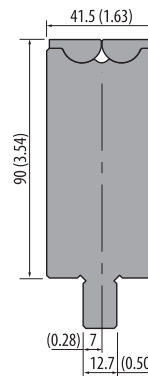
500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm²



RVT90-2

1500 kN/m max.



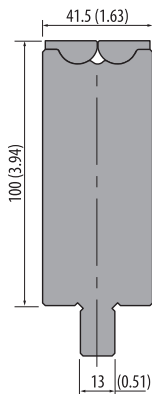
500 mm	16.68 in	11.3 kg
450 mm segmented	17.72 in segmented	10.6 kg

42Cr: 1100-1200 N/mm²



RVT100-2

1500 kN/m max.



500 mm	16.68 in	12.4 kg
450 mm segmented	17.72 in segmented	11.7 kg

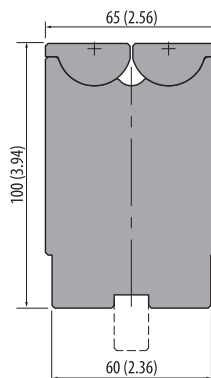
42Cr: 1100-1200 N/mm²



Model 2.5

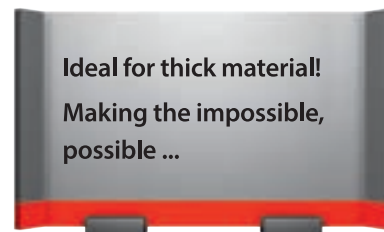
RVM2.5

2000 kN/m max.



without tang		
500 mm	16.68 in	22.0 kg
470 mm segmented	18.50 in segmented	21.0 kg
with tang 0.51x0.79 in		
500 mm	16.68 in	23.5 kg
470 mm segmented	18.50 in segmented	22.4 kg
with tang 0.5x0.75 in		
500 mm	16.68 in	23.5 kg
470 mm segmented	18.50 in segmented	22.4 kg

42Cr: 1100-1200 N/mm²



Article on stock



Please ask for delivery time!

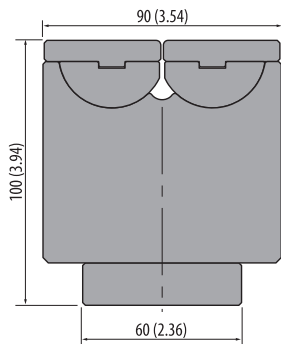
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

RVP100-3

2500 kN/m max.



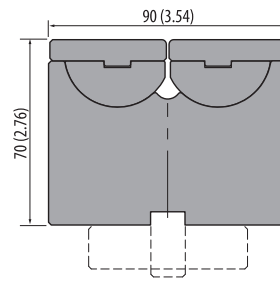
500 mm	16.68 in	28.8 kg
455 mm segmented	17.91 in segmented	26.2 kg

42Cr: 1100-1200 N/mm²



RVM70-3

2500 kN/m max.



without tang		
500 mm	16.68 in	20.6 kg
455 mm segmented	17.91 in segmented	18.7 kg

with base 2.36 in		
500 mm	16.68 in	23.5 kg
455 mm segmented	17.91 in segmented	23.0 kg

with tang 0.51 in		
500 mm	16.68 in	22.1 kg
455 mm segmented	17.91 in segmented	20.1 kg

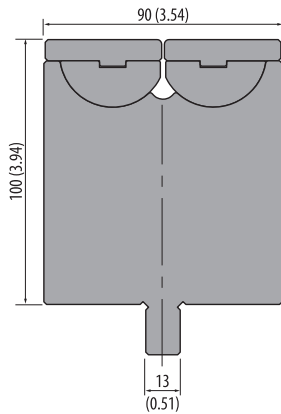
with offset tang 0.5 in		
500 mm	16.68 in	22.1 kg
455 mm segmented	17.91 in segmented	20.1 kg

42Cr: 1100-1200 N/mm²



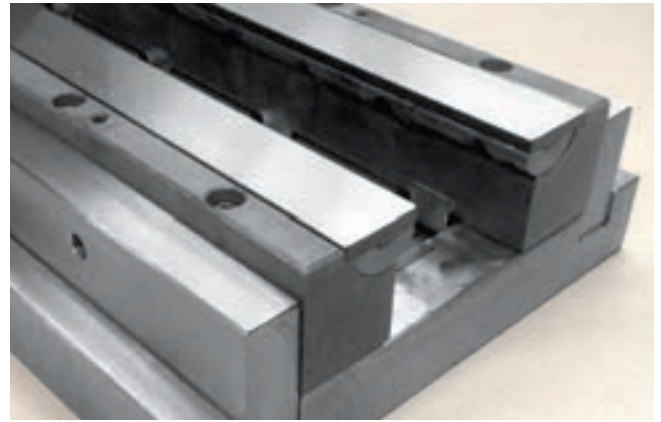
RVT100-3

2500 kN/m max.



500 mm	16.68 in	30.9 kg
455 mm segmented	17.91 in segmented	28.5 kg

42Cr: 1100-1200 N/mm²



Model 4

Our Advantages – Your Convenience

The **model 4 tools** and the **adjustable dies** are suitable for thick sheet metal and large-radius bends. Material specifications vary greatly, therefore no specific data can be given.

- minimum flanges depend on the bending angle
- distortion of holes near the bending line is substantially decreased, although it depends on the type of the sheet metal
- large-radius bends are influenced by sheet metal springback, type of material and flange length

For advice please contact us!

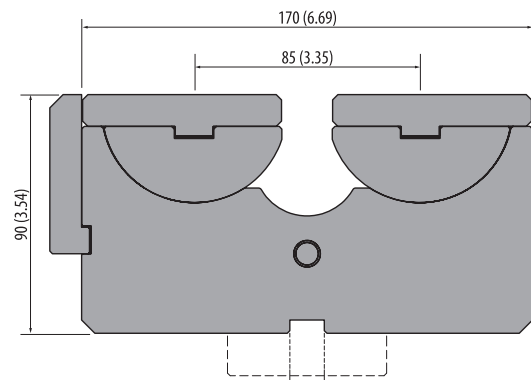
RVM90-4

3000 kN/m max.

		without tang		with tang 0.51 in	
500 mm	16.68 in	56.6 kg	500 mm	16.68 in	58.1 kg
200 mm	7.87 in	22.7 kg	200 mm	7.87 in	23.3 kg

		with base 2.36 in		with offset tang 0.5 in	
500 mm	16.68 in	61.3 kg	500 mm	16.68 in	58.1 kg
200 mm	7.87 in	24.6 kg	200 mm	7.87 in	23.3 kg

42Cr: 1100-1200 N/mm²



Our advantages – Your Convenience

- bending up to 30 mm thick sheet metal
- hardened inserts
- no traditional bending marks
- adjustable openings
 RVPV3 = 39-94 mm (1.54-3.70 in)
 RVHD3 = 39-118 mm (1.54-4.65 in)
 RVHD4 = 70-220 mm (2.76-8.66 in)
- bending of laser-cut sheet metal without damaging the tool
- exact inner radius

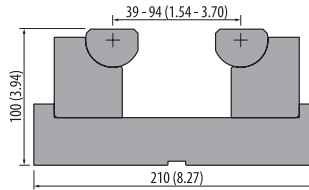
RVPV3

2500 kN/m max.

42Cr: 1100-1200 N/mm²



500 mm	16.68 in	50.0 kg
200 mm	7.87 in	20.0 kg



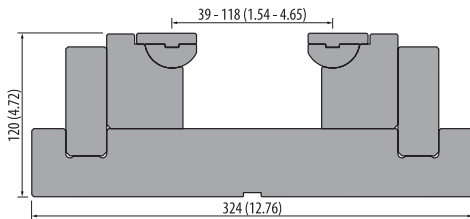
RVHD3

3500 kN/m max.

42Cr: 1100-1200 N/mm²



500 mm	16.68 in	98.0 kg
200 mm	7.87 in	38.1 kg



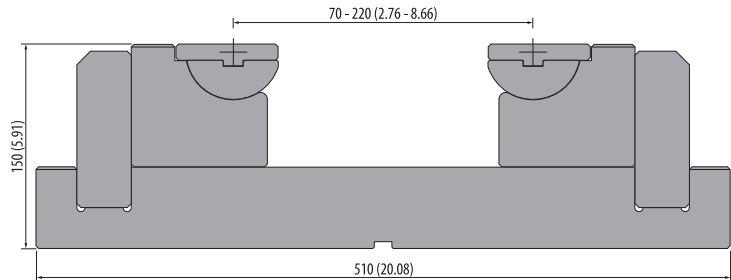
RVHD4

3500 kN/m max.

42Cr: 1100-1200 N/mm²



500 mm	16.68 in	200.0 kg
200 mm	7.87 in	80.0 kg



• V-Bending
• flat inserts

• Radius-Bending
• flat inserts

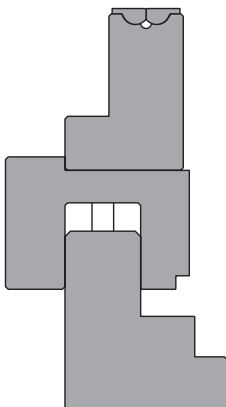
• Conical Bending
• flat inserts

• Radius-Overbending
• concave inserts

• U-Bending
• V-inserts

Hemming and Z-Tools

Hemming Tool



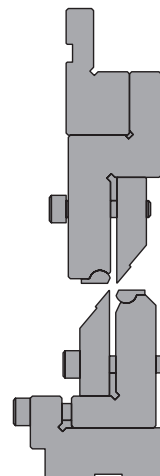
per piece | Price upon request

Production according to your specifications

42Cr: 1100-1200 N/mm²



Joggle Tool



per piece | Price upon request

Production according to your specifications

42Cr: 1100-1200 N/mm²



 **ROLLERI**®



ROLLERI CLAMPING SYSTEMS

Content Explanation	210
ROL200 System for Rolleri R1 type punches	211 - 213
ROL1 System for Rolleri R1 type punches	214 - 215
ROL4 System for Rolleri R1 type punches	215
Intermediates	216
Clamps	217 - 218
W-ROL PN-System for Rolleri R2 type punches	219
ROL3 System for Rolleri R3 and RX type punches	220
ROL crowning table	221
ROL2 System for Rolleri R1 type dies	222 - 223
Movable Clamps for Rolleri R1 type dies	223

ROLLERI CLAMPING SYSTEMS

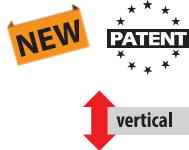
Content Explanation



- all pneumatic clamps work with at least 10 bar pressure

■ ROL200 Clamping

- for **Rolleri R1 type punches**
- **vertical tool change**
- can be used **without modifying** Rolleri R1 type punches
- antifall system
- includes intermediate at your choice
- manual, pneumatic and hydraulic models available
- see pages 214-215



■ ROL1 Clamping

- for **Rolleri R1 type punches**
- **vertical tool change**
- **necessary modification:** Rolleri R1 type punches have to be equipped with spring loaded ball bearings
- antifall system
- includes intermediate at your choice
- manual and pneumatic models available
- dual sided clamping (KDS-System)
- see pages 216-217



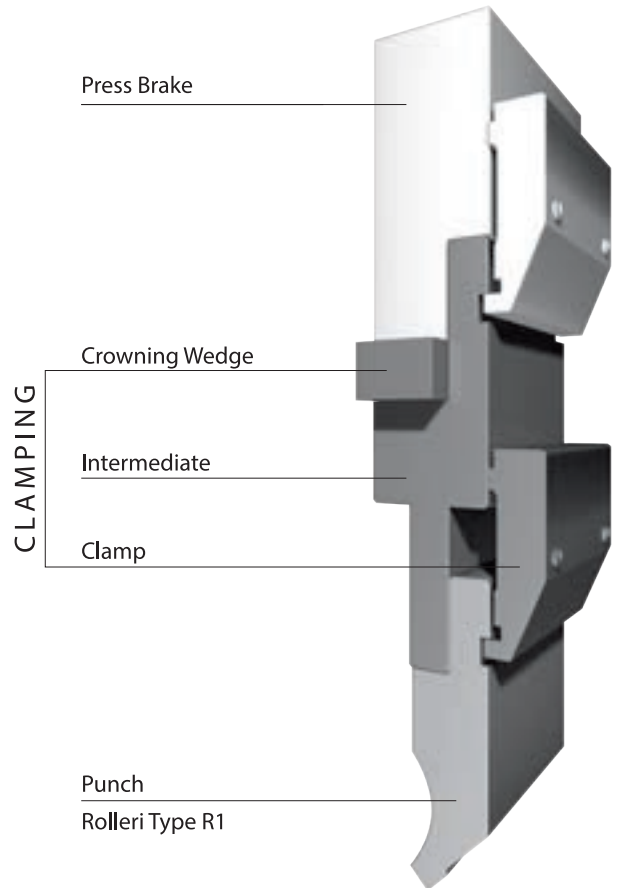
■ ROL4 Clamping

- for **Rolleri R1 type punches**
- **horizontal tool change**
- can be used **without modifying** Rolleri R1 type punches
- antifall system
- includes intermediate at your choice
- manual and hydraulic models available
- dual sided clamping integrated
- see page 217



■ Standard-Clamping

- for **Rolleri R1 type punches**
- composed of clamp and intermediate
- dual sided clamping (KDS-System)
- **horizontal tool change**
- see pages 211-213



■ W-ROL PN Clamping

- for **Rolleri R2 type punches**
- **vertical tool change** with ROL1-System and QuickLock-System
- punches with Safety-Pins are inserted **horizontally**
- antifall system
- pneumatic model available only
- see page 218



■ ROL3 Clamping

- for **Rolleri Type R3/RX punches**
- **vertical or horizontal tool change**
- custom-made
- antifall system
- hydraulic model available only
- see page 219



■ ROL2 Clamping

- for **Rolleri Type R1 dies**
- manual, pneumatic and hydraulic models available
- see pages 220-221



■ Movable Die Clamps

- for **Rolleri Type R1 dies**
- manual model available only
- see page 221

ROLLERI presents his latest innovation:

The new clamping **ROL200** for Punches! Compatible with: Amada, Boschert, Bystronic-Beyeler Euro-B, Durmazlar, Ermaksan, Gasparini, Haco, Promecam, etc. The new **patented** system enables manual, pneumatic or hydraulic vertical clamping of your top tools. The special features are the enormously simple handling and the surprisingly low price, which guarantees huge efficiency. It is available as retrofitting as well as original equipment. This new clamping is a revolution in the market of press brake tooling!

- fast **vertical** tool change for all Rolleri R1 type punches
- can be used without modifying Rolleri R1 type punches
- safe and fast tool change
- substantial improvement in time consumption and related costs
- secure against tool falling down
- available in manual, pneumatic and hydraulic models
- mounting:
Simply from the bottom into the housing, tighten – DONE!
- disassembly:
Untighten, gently lift tool and remove it downwards.
- easy to mount on your press brake.
Modification of the press brake is not necessary.

NEW

PATENT



Rolleri Videos



Tutorial ROL200: www.rolleritools.com/videos/rol200



Rolleri Videos



Application of ROL200 PN:
www.rolleritools.com/videos/rol200



Article on stock

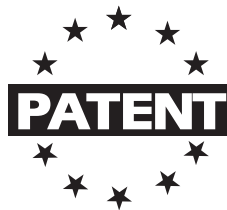


Please ask for delivery time!

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



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



ROL200 – manual



NEW



Model	with Intermediate
ROL200 manual	INT100
	INT120
	INT120-40
	INT150
	INT100 FISSO

L=150 mm (5.91 in)
vertical tool change
Including intermediate at your choice



The ROL200-System is suited for Standard-Punches. There are no modifications necessary!

ROL200 – pneumatic

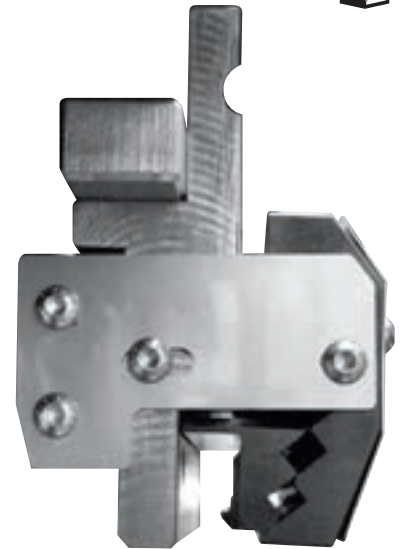


NEW



Model	with Intermediate
ROL200 pneumatic	INT120
	INT150
	INT132-40
	INT150-40

L=150 mm (5.91 in)
vertical tool change
Including intermediate at your choice



ROL200 – hydraulic



NEW



Model	with Intermediate
ROL200 hydraulic	INT120
	INT150

L=150 mm (5.91 in)
vertical tool change
Including intermediate at your choice



If the axis of your press brake is
=20 mm please contact us!



Article on stock



Please ask for delivery time!

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



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

R1

ROLLERI CLAMPING SYSTEMS

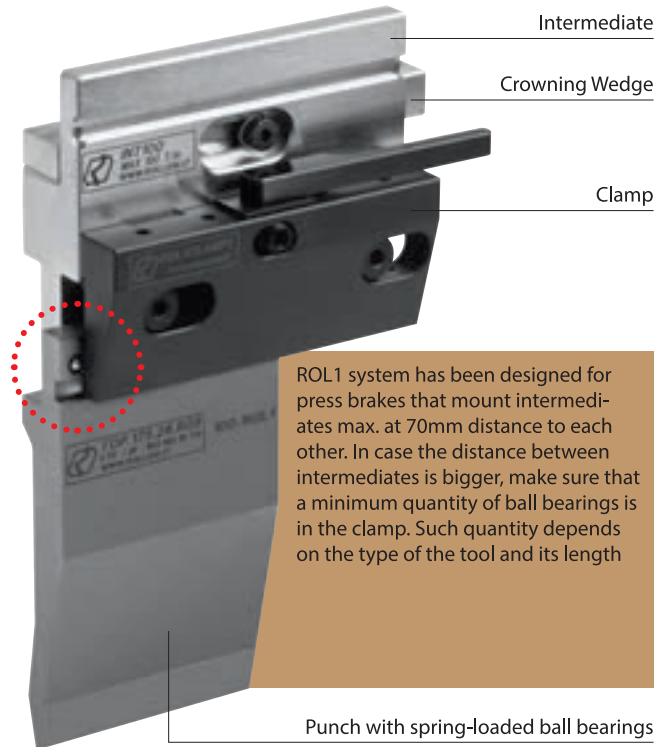
ROL1-System for Punches

In order to use the ROL1 System, punches are modified and equipped with spring-loaded ball bearings.

ROL1 can be used on all press brakes with Rollerri R1 type intermediates with standard tang.

Our Advantages – Your Convenience

- **vertical clamping** of tools is possible thanks to a row of **spring-loaded ball bearings** which are also used as **antifall system** to prevent punches from falling down
- a complete mechanical and efficient fast clamping system for press brakes
- Productivity and versatility of press brakes is substantially 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 change Including intermediate at your choice
ROL1 CLAMP1	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



ROL1 CLAMP1
without Intermediate



ROL1 PN CLAMP1 – pneumatic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool change Including intermediate at your choice
ROL1 PN CLAMP1	INT120	
	INT150	



Mounting example



Rolleri Videos

Application of Clamping Systems
ROL1 CLAMP1: [www.rolleritools.com/
videos/rol1-clamp1](http://www.rolleritools.com/videos/rol1-clamp1)



ROL1 KDS

Model	with Intermediate	L=150 mm (5.91 in) vertical tool change Including intermediate at your choice
ROL1 KDS	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	
	INT120-40	



ROL4-System for Punches

ROL4 – manual

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool change including intermediate at your choice integrated KDS-System
ROL4 manual	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	
	INT120-40	



ROL4 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool change including intermediate at your choice integrated KDS-System
ROL4 hydraulic	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT150-40	
	INT120-40	



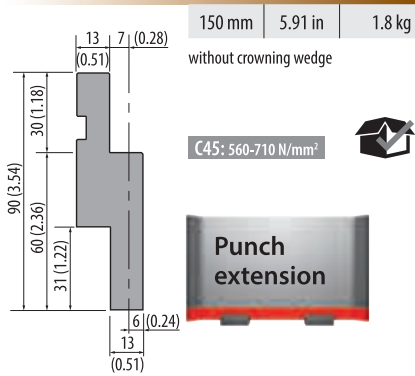
Rolleri Videos

Application of hydraulic clamping ROL4
www.rolleritools.com/videos/rol4-hydraulic-clamping

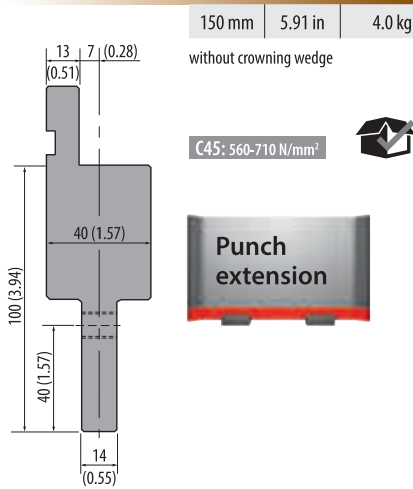


The ROL4-System is suitable for standard Rolleri R1 type punches. No modifications are necessary!

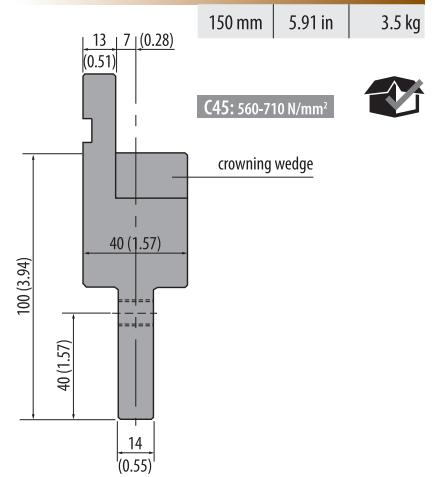
AD4 1000 kN/m max.



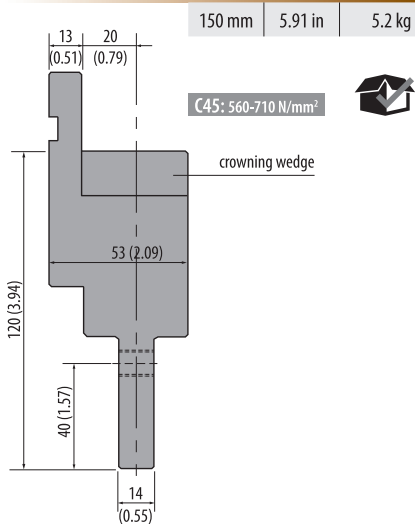
INT100 FISSO 1000 kN/m max.



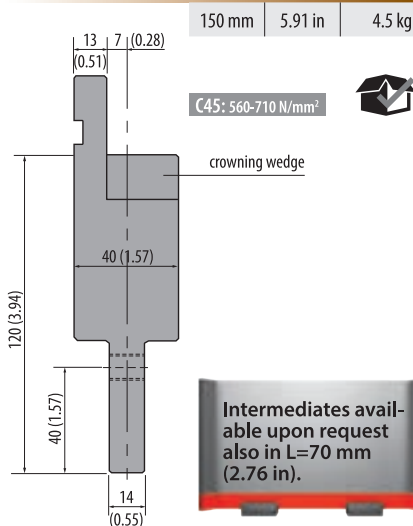
INT100 1000 kN/m max.



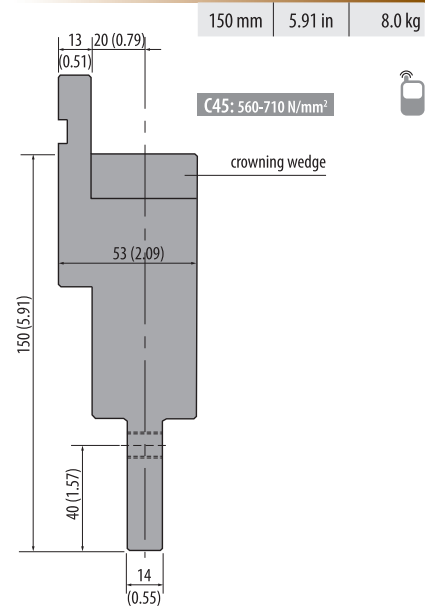
INT120-40 1000 kN/m max.



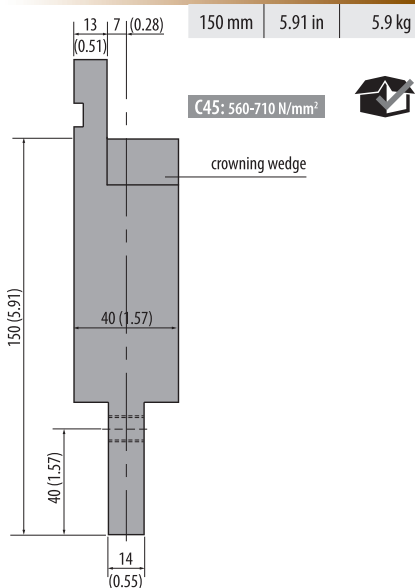
INT120 1000 kN/m max.



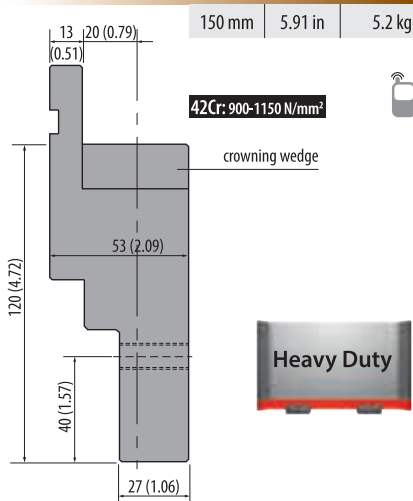
INT150-40 1000 kN/m max.



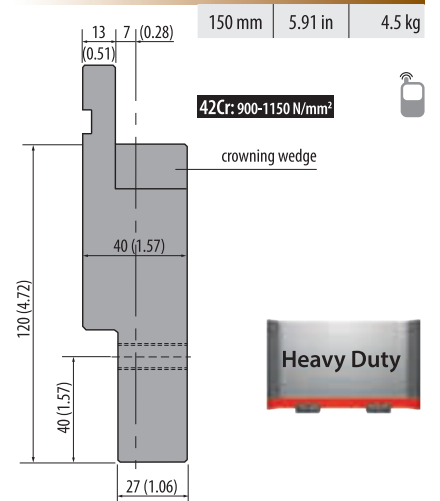
INT150 1000 kN/m max.



INT120-40-HD 1600 kN/m max.



INT120-HD 1600 kN/m max.

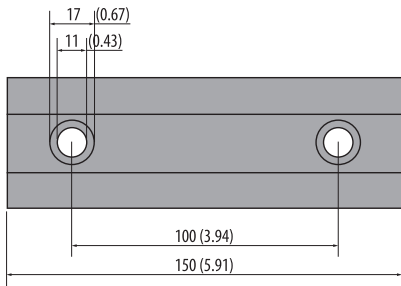


Our Advantages – Your Convenience

- **Rapid Clamping Systems** enable fast horizontal tool change.
- **Plastic Pressure Strip** improves clamping especially with short tool segments.

needed clamps	Length of press brake
4 pieces	835 mm (32.87 in)
6 pieces	1250 mm (49.21 in)
11 pieces	2100 mm (82.68 in)
14 pieces	2600 mm (102.36 in)
16 pieces	3100 mm (122.05 in)
21 pieces	4100 mm (161.42 in)

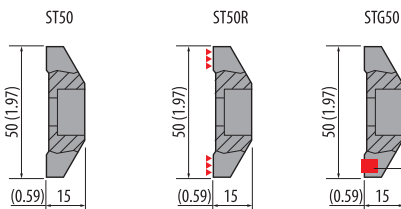
ST50 / ST50R / STG50



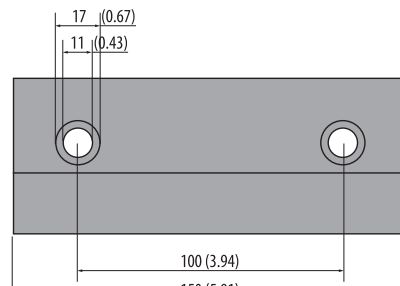
ST50	0.70 kg
ST50R	0.50 kg
STG50	0.70 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²



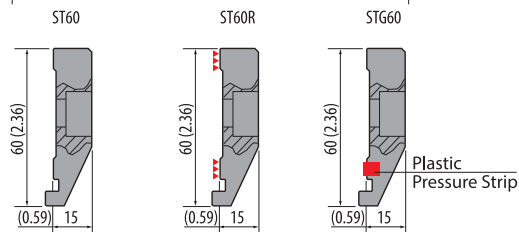
ST60 / ST60R / STG60



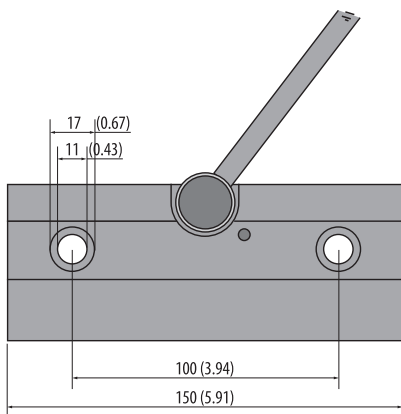
ST60	0.80 kg
ST60R	0.85 kg
STG60	0.80 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²



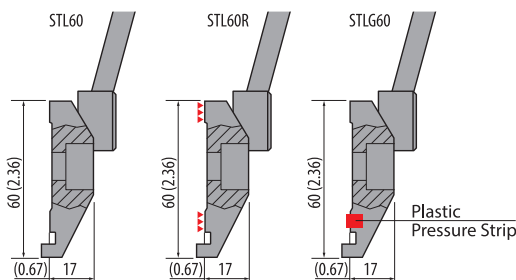
STL60 / STL60R / STLG60



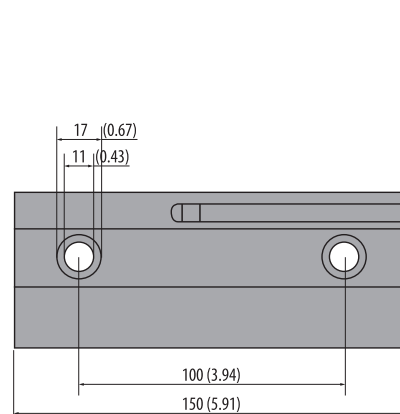
STL60	1.00 kg
STL60R	0.80 kg
STLG60	1.00 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²



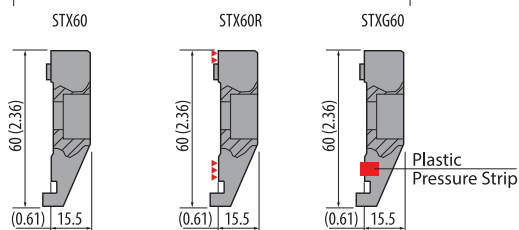
STX60 / STX60R / STXG60



STX60	0.85 kg
STX60R	0.50 kg
STXG60	1.00 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²

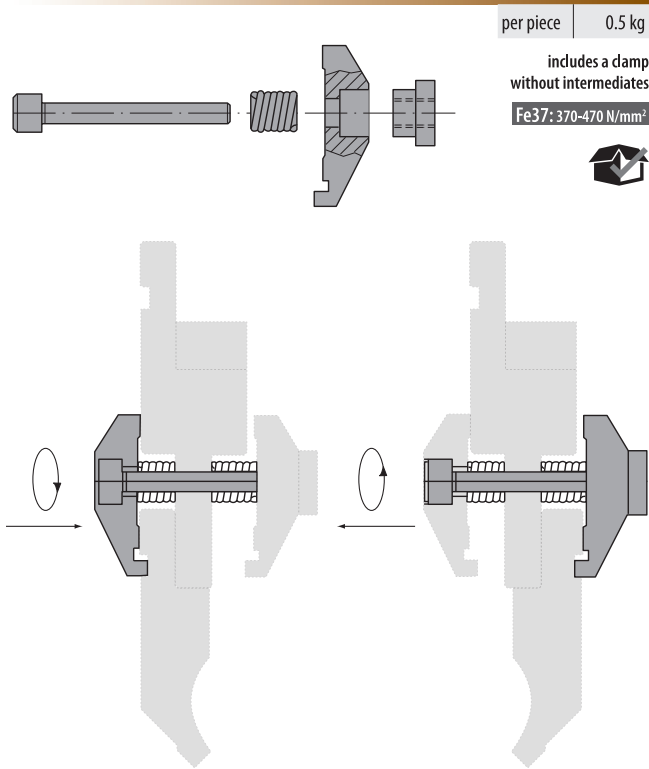


R1

ROLLERI CLAMPING SYSTEMS

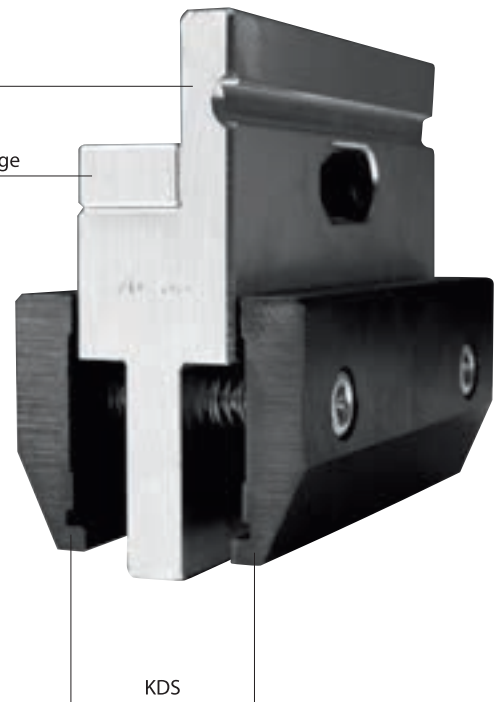
Clamps

KDS

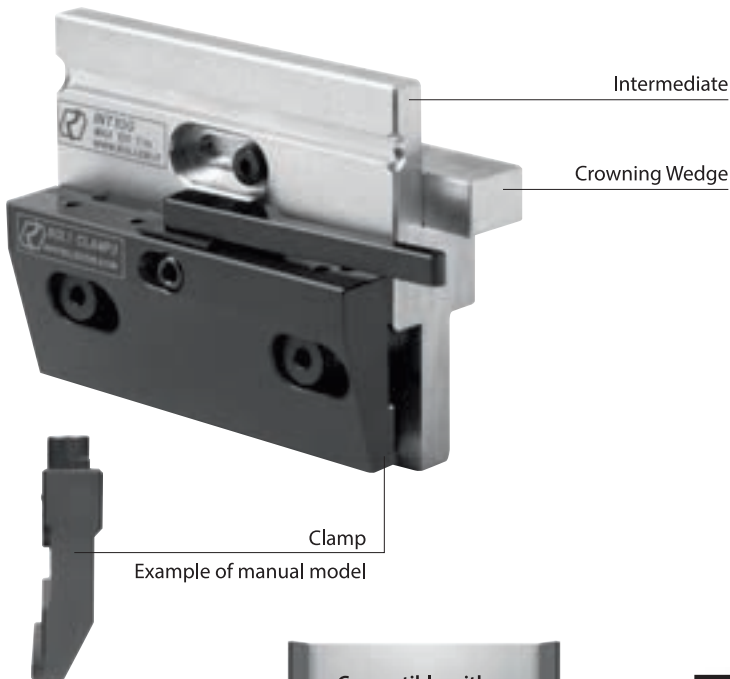


Intermediate

Crowning Wedge



ROL1 CLAMP3 – manual – pneumatic



horizontal

horizontal

Model	with Intermediate
ROL1 CLAMP3 manual	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

ROL1 CLAMP3 manual without Intermediate

Model	with Intermediate
ROL1 CLAMP3 pneumatic	INT120
	INT150

L=150 mm (5.91 in)
horizontal tool change



Including intermediate at your choice

Compatible with standard Rolleri R1 type punches



Rolleri Videos

Application of Clamping System
ROL1 CLAMP3: www.rolleritools.com/videos/rol1-clamp3



Our Advantages – Your Convenience

- vertical tool change of punches with:
 - ROL1-System
 - QuickLock-System
- Horizontal tool change of punches with safety pins
- Improvement in productivity



W-ROL PN – pneumatic

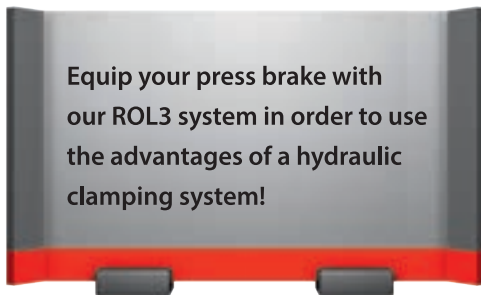


515 mm	20.28 in	26.8 kg/m
1050 mm	41.34 in	53.6 kg/m
2100 mm	82.68 in	107.2 kg/m
2500 mm	98.43 in	134.0 kg/m
3100 mm	122.05 in	160.8 kg/m
4100 mm	161.42 in	214.4 kg/m



ROL3 HYD – hydraulic

500 mm 19.68 in

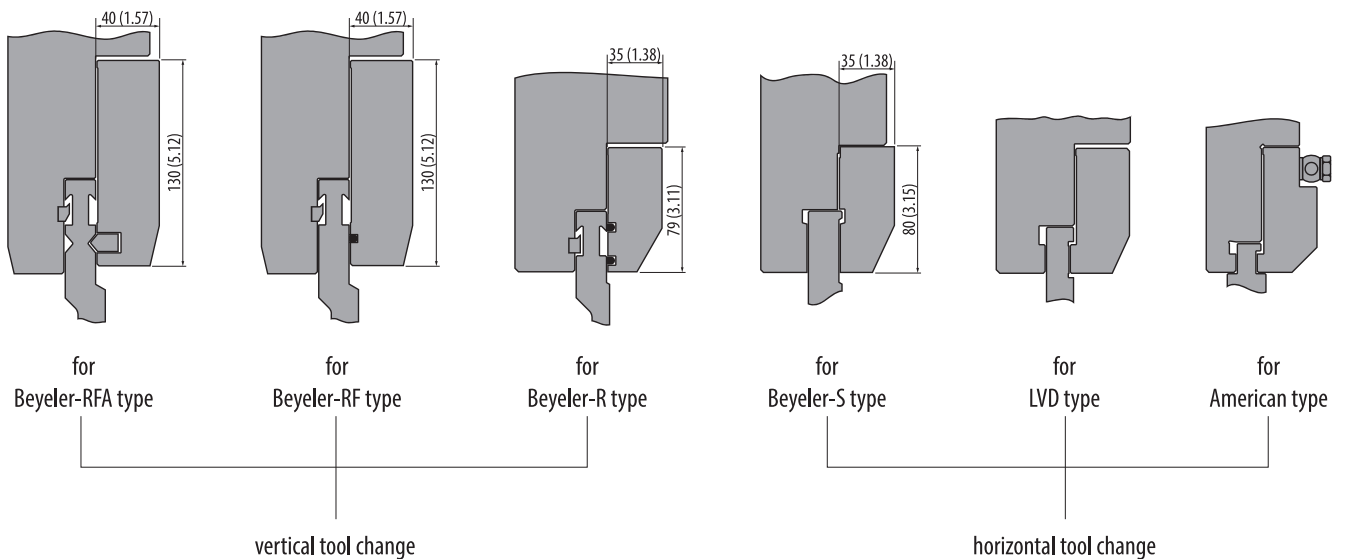


Our Advantages – Your Convenience

- can be used on press brakes with different tang types
- possible customization upon request
- improvement in productivity



Examples of ROL3 with various systems



Explanation

Rolleri crowning tables provide mechanical compensation to the deflections occurring during the bending process. Deflection depends on bending length and on ratio between sheet metal thickness and die opening.

This system is composed by a special rod, which is placed between opposite wedges. Each wedge can be calibrated autonomously to compensate localized deflection. The rod can be manually driven or by a motoreducer controlled by the press brake CNC.

The adjustment of the crowning table is a fast and accurate procedure to carry out before bending.

The crowning table is produced according to the press brake features to optimize its working and its integration to the press brake it is installed in. Rolleri crowning table can be designed to clamp R1 dies with 60mm and 90mm base or R2 dies with 13mm tang and it's supplied with all accessories necessary to mount and align it to the upper beam.

On request, Rolleri crowning table can be equipped with pneumatic clamping systems for lower tools.


Our Advantages – Your Convenience

- You can adjust deflection of the whole length of the press brake or just a short section thanks to independent wedges
- Very precise bending angles
- R1 type dies with 60 mm and 90 mm base can be clamped as well as R2 dies with 13 mm tang
- Automatic crowning through connection to press brake CNC or manual crowning with a handle
- This crowning table can be installed in new press brakes or to retrofit old press brakes
- Precise positioning and alignment of the crowning table onto the press brake table
- Easy and fast usage

NEW

ROL TM R1 – manual


Model	Length		for dies Rolleri Type R1
ROL TM R1	1100 mm	43,31 in	
	2100 mm	82,68 in	
	3100 mm	122,05 in	
	4100 mm	161,42 in	

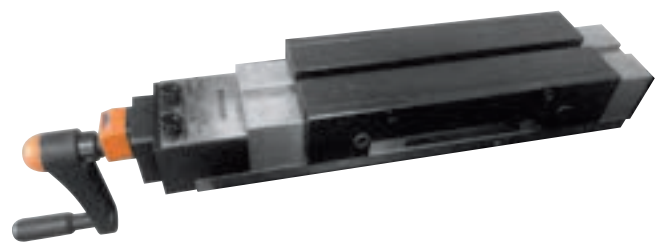
NEW 



ROL TM R2 – manual


Model	Length		for dies Rolleri Type R2
ROL TM R2	1100 mm	43,31 in	
	2100 mm	82,68 in	
	3100 mm	122,05 in	
	4100 mm	161,42 in	

NEW 




ROL TA R1 – automatic

Model	Length		for dies Rolleri Type R1
ROL TA R1	1100 mm	43,31 in	
	2100 mm	82,68 in	
	3100 mm	122,05 in	
	4100 mm	161,42 in	

NEW 

ROL TA R2 – automatic

Model	Length		for dies Rolleri Type R2
ROL TA R2	1100 mm	43,31 in	
	2100 mm	82,68 in	
	3100 mm	122,05 in	
	4100 mm	161,42 in	

NEW 

■ Explanations

The **ROL2 System** is a system which is used to secure the die into place. Such system is available in manual, pneumatic and hydraulic version. The manual version is composed of a special clamp (known as **ROL2 CLAMP1**), which is operated with a central lever.

The **ROL2 System** has a built in spring mechanism which opens and closes the **ROL2 CLAMP1** to clamp and release dies.

A special rubber insert inside the clamp plates guarantees 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.

For example, in a 3 m (118.11 in) press brake all dies are secured with 6 simple hand movements.

Rolleri new **ROL2 pneumatic system** is composed of pneumatic clamps L=150 mm (5.91 in) which are activated by a pneumatic driving unit or by the CNC of the press brake.

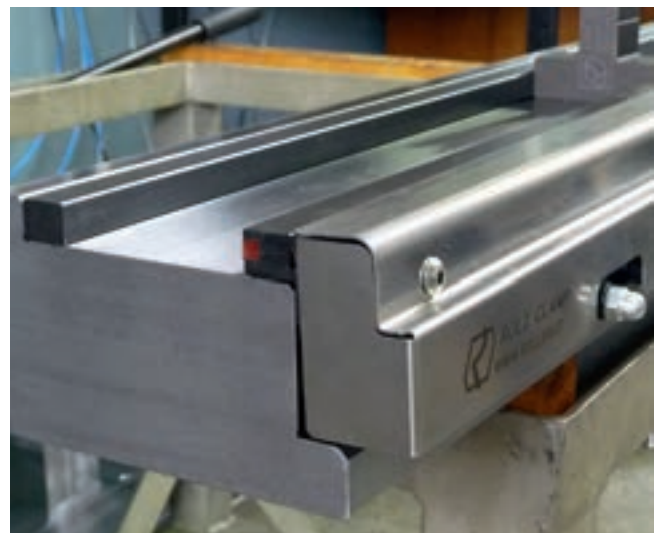
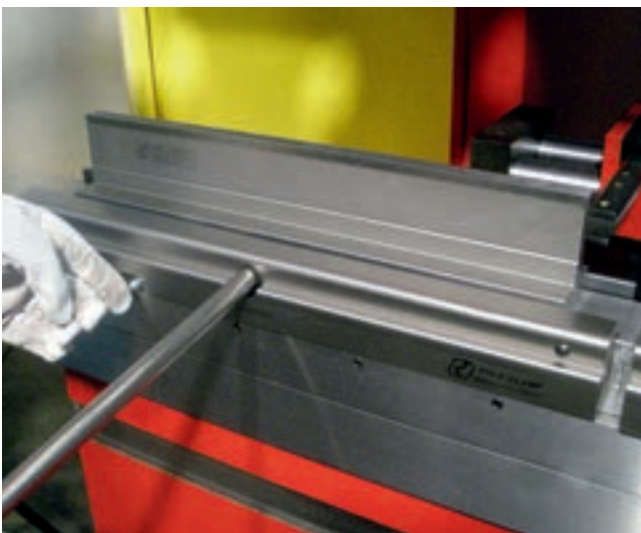
The new design has bigger clamping force and therefore it enables perfect clamping of small segments too.

■ Our Advantages – Your Convenience

- fast tool change
- time-saving system
- reduced production costs
- significantly increased profitability
- improved competitiveness

■ Application

- **Directly on a 60 mm / 2.36 in wide press brake table**
 - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
 - in alternative, modification of the existing threaded holes may be necessary
 - system is compatible with press brakes with automatic crowning tables
- **Directly on a 90 mm / 3.54 in wide press brake table**
 - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
 - in alternative, modification of the existing threaded holes may be necessary
 - to use Rolleri R1 type dies with 60 mm / 2.36 in base, two ground 15 mm / 0.59 in wide shims are supplied to be inserted into the die holder and secured with pins
 - thanks to the rubber inserts, short die segments are perfectly clamped
- **With Die Holder**
 - 60 x 40 mm / 2.36 x 1.57 in die holder, ground and induction hardened.



ROL2 – manual

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	38.0 kg	table: 60 mm	2.36 in	4.0 kg
table: 90 mm	3.54 in	58.0 kg	table: 90 mm	3.54 in	4.5 kg

L=42.32 in



L=19.69 in



ROL2 – hydraulic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

L=42.32 in



L=19.69 in



NEW

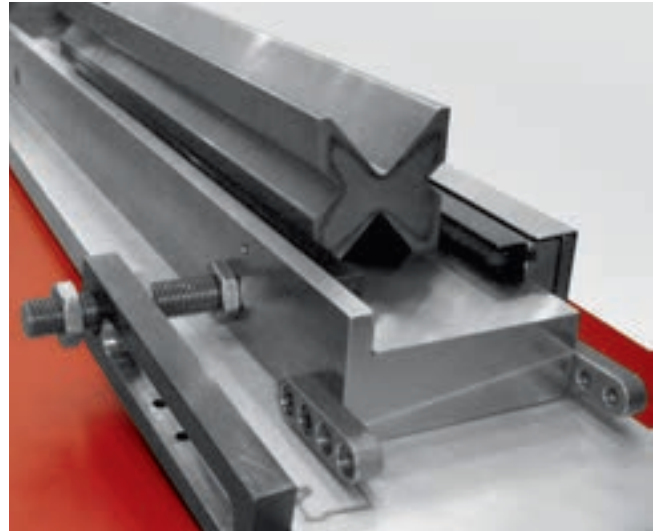
ROL2 – pneumatic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	1.2 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	1.7 kg

L=42.32 in



L=19.69 in



Movable Clamps for Dies

Our Advantages – Your Convenience

- lowerable clamping plate
- significantly easier tool change, thanks to the possibility of removing the tool by sliding it out and not lifting it



Rolleri Videos

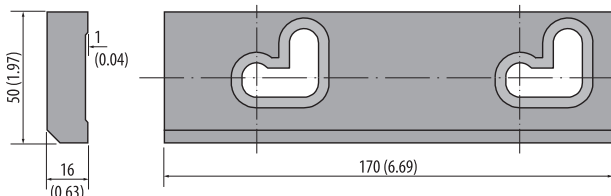
movable die ST50-S:
www.rolleritools.com/videos/movable-die-holders



ST50-S

per piece 0.70 kg

Fe37: 370-470 N/mm²



Article on stock

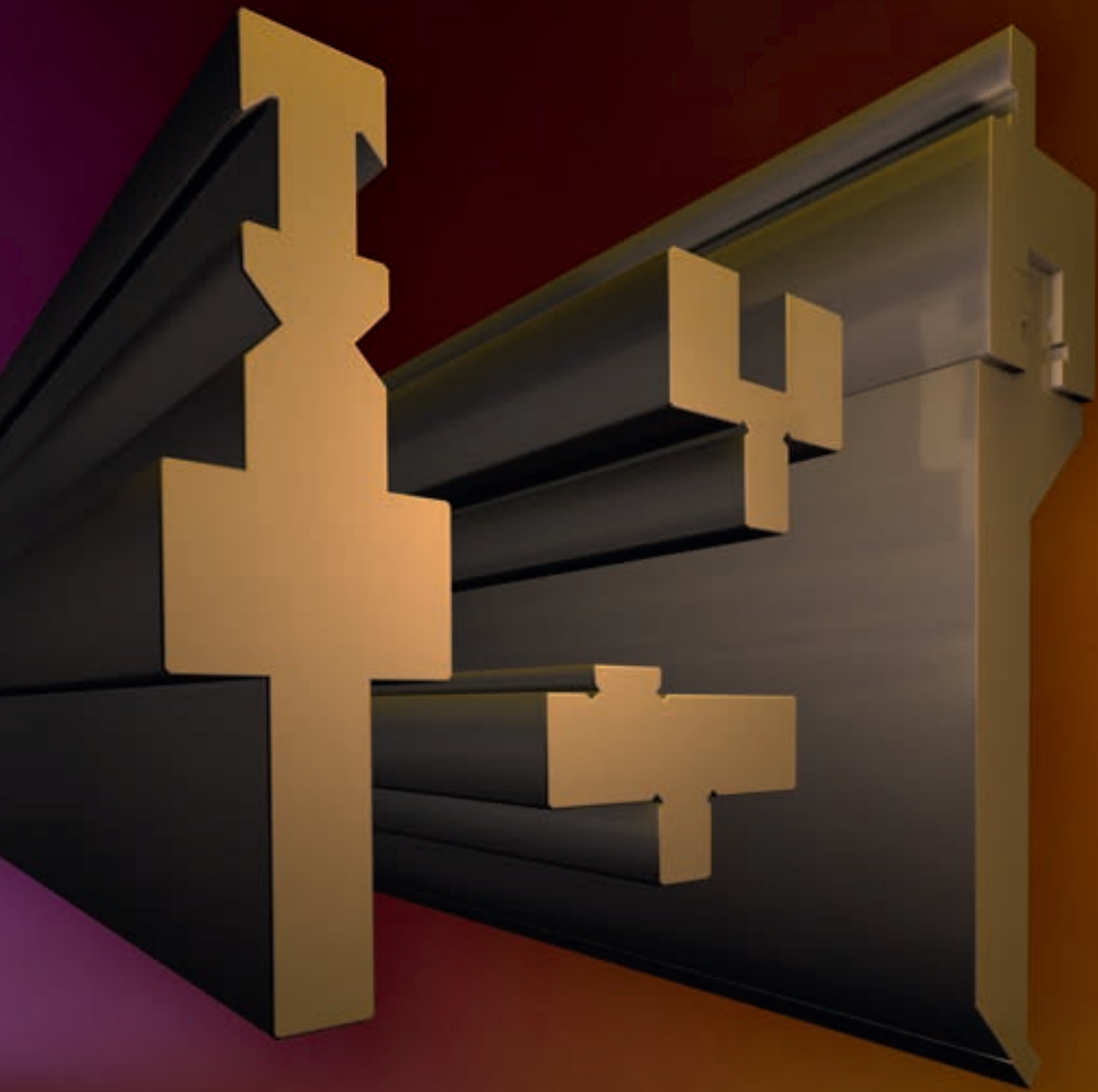


Please ask for delivery time!

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



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



A



ROLLER ADAPTERS

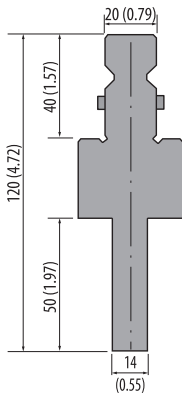
Punch Adapters	226 - 229
Bolted Adapters	230 - 231
Die Holders	232
Die Adapters	233 - 235
Modification: bar	235

A

ROLLERI ADAPTERS Punch Adapters

AD11

1000 kN/m max.



150 mm | 5.91 in | 3.0 kg

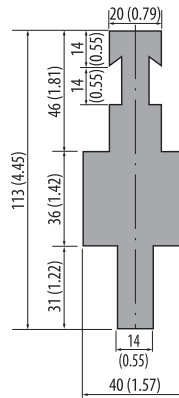
Rolleri Type R2
→ Rolleri Type R1

C45: 560-710 N/mm²



AD22

1000 kN/m max.



150 mm | 5.91 in | 3.4 kg

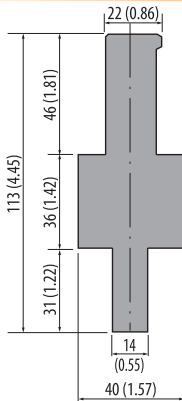
Rolleri Type R3 Beyeler R
→ Rolleri Type R1

C45: 560-710 N/mm²



AD3

1000 kN/m max.



150 mm | 5.91 in | 3.3 kg

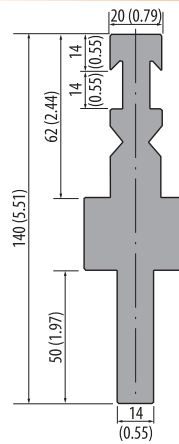
Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



AD10

1000 kN/m max.



150 mm | 5.91 in | 3.4 kg

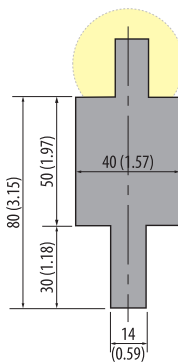
Rolleri Type R3 Beyeler
RFA → Rolleri Type R1

C45: 560-710 N/mm²



AD1

1000 kN/m max.



Tang A: **AD1-A**

150 mm | 5.91 in | 3.1 kg

Tang B: **AD1-B**

150 mm | 5.91 in | 3.1 kg

Tang C: **AD1-C**

150 mm | 5.91 in | 3.1 kg

Tang D: **AD1-D**

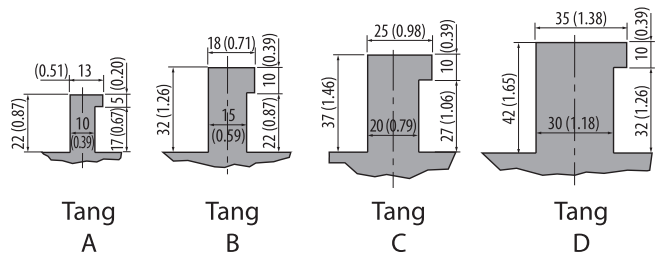
150 mm | 5.91 in | 3.1 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



Tangs LVD



Tang
A

Tang
B

Tang
C

Tang
D

With adapters you can use
the vast range of Rolleri
R1 type punches!

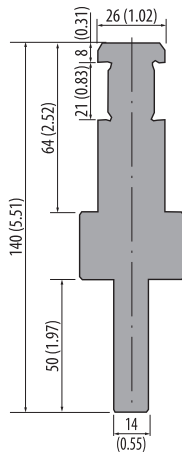
A

ROLLERI ADAPTERS Punch Adapters



AD13

1000 kN/m max.



150 mm | 5.91 in | 3.0 kg

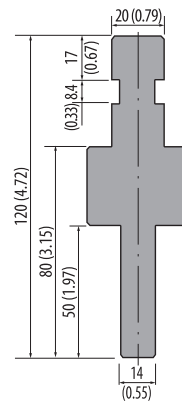
Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²



AD14

1000 kN/m max.



150 mm | 5.91 in | 3.2 kg

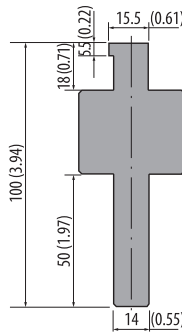
Rolleri Type RX Gas-parini
→ Rolleri Type R1

C45: 560-710 N/mm²



AD15

1000 kN/m max.



150 mm | 5.91 in | 4.0 kg

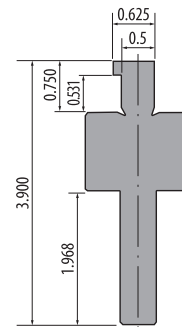
Rolleri Type RX Ajial-Axial
→ Rolleri Type R1

C45: 560-710 N/mm²



AD16

1000 kN/m max.



150 mm | 5.91 in | 4.0 kg

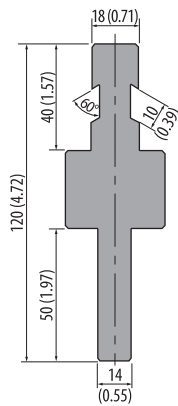
Rolleri Type American
→ Rolleri Type R1

C45: 560-710 N/mm²



AD12

1000 kN/m max.



150 mm | 5.91 in | 1.5 kg

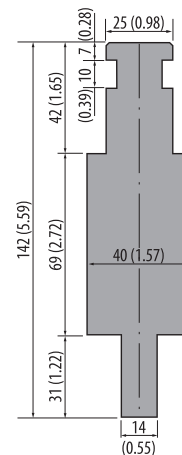
Rolleri Type RX Colgar
→ Rolleri Type R1

C45: 560-710 N/mm²



AD23

1000 kN/m max.



150 mm | 5.91 in | 5.0 kg

Rolleri Type RX Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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



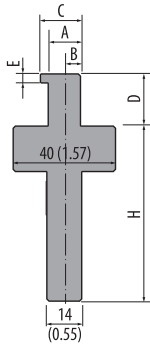
Articles on stock – Please note that delivery time depends on your location.

A

ROLLERI ADAPTERS Punch Adapters

ADX

1000 kN/m max.



150 mm 5.91 in 3.5 kg

Type X
→ Rolleri Type R1

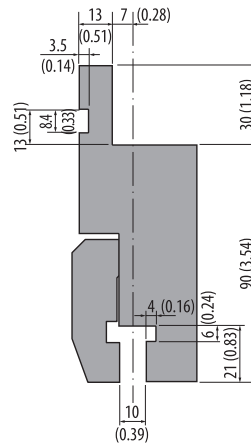
Production according
to your specifications

C45: 560-710 N/mm²



AD19-A

1000 kN/m max.



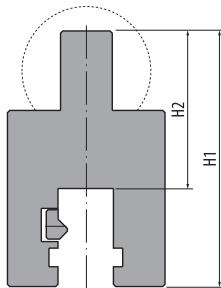
150 mm 5.91 in 6.0 kg

Rolleri Type R1
→ Rolleri Type RX LVD

C45: 560-710 N/mm²



ADX2



150 mm 5.91 in 4.0 kg

Type X
→ Rolleri Type R2

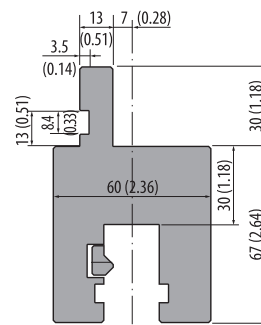
Production according
to your specifications

C45: 560-710 N/mm²



AD20

1000 kN/m max.



150 mm 5.91 in 4.0 kg

Rolleri Type R1
→ Rolleri Type R2

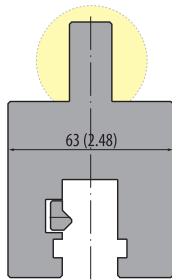
C45: 560-710 N/mm²



Pneumatic
Adapters
see page 219

AD20 LVD

1000 kN/m max.



Tang A: AD20 LVD-A

150 mm 5.91 in 3.6 kg

Tang B: AD20 LVD-B

150 mm 5.91 in 3.8 kg

Tang C: AD20 LVD-C

150 mm 5.91 in 4.0 kg

Tang D: AD20 LVD-D

150 mm 5.91 in 4.0 kg

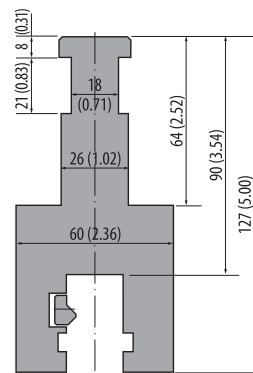
Rolleri Type RX LVD
→ Rolleri Type R2

C45: 560-710 N/mm²



AD28

1000 kN/m max.



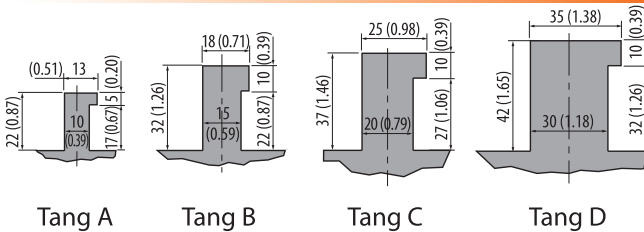
150 mm 5.91 in 5.0 kg

Rolleri Type RX EHT
→ Rolleri Type R2

C45: 560-710 N/mm²



Tangs LVD



Tang A

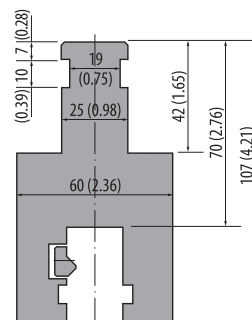
Tang B

Tang C

Tang D

AD29

1000 kN/m max.



150 mm 5.91 in 4.5 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R2

C45: 560-710 N/mm²



Rolleri Videos

Bolted Adapters AW, P. 230-231
www.rolleritools.com/videos/bolted-adapters

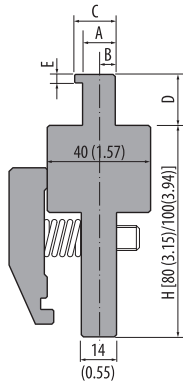


A

ROLLERI ADAPTERS Punch Adapters

INT80-100

1000 kN/m max.



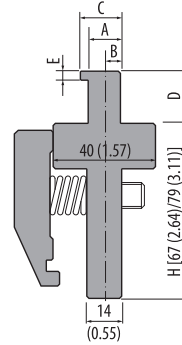
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

C45: 560-710 N/mm²



INT67-79

1000 kN/m max.



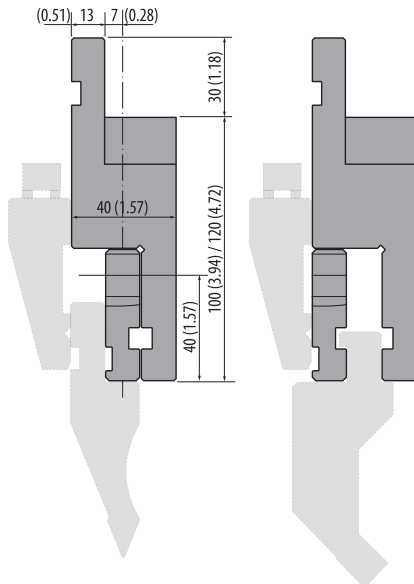
835 mm	32.87 in	20.5 kg
415 mm	16.34 in	10.0 kg

C45: 560-710 N/mm²



INT100-A / INT120-A

1000 kN/m max.



INT100-A		
150 mm	5.91 in	3.5 kg

INT120-A		
150 mm	5.91 in	5.2 kg

C45: 560-710 N/mm²

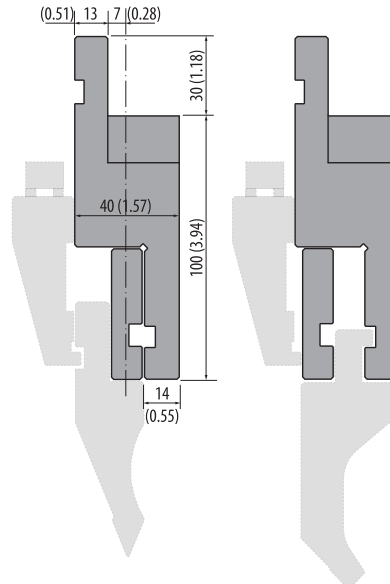
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 217
- Fast Clamping (ROL1 Clamp3), see page 218
- Pneumatic system only on INT120-A (ROL1 Clamp3 PN), see page 218



INT100-N (Newton)

1000 kN/m max.



150 mm	5.91 in	3.5 kg
--------	---------	--------

C45: 560-710 N/mm²



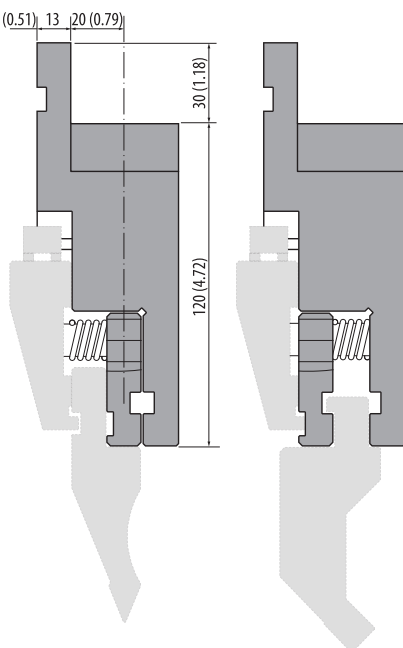
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 217
- Fast Clamping (ROL1 Clamp3), see page 218



INT120-40-A

1000 kN/m max.



150 mm	5.91 in	6.0 kg
--------	---------	--------

C45: 560-710 N/mm²

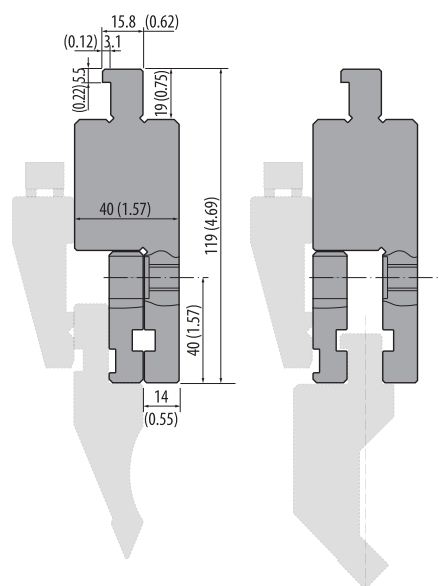
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 217
- Fast Clamping (ROL1 Clamp3), see page 218



INT100-A (American)

1000 kN/m max.



150 mm	5.91 in	3.5 kg
--------	---------	--------

C45: 560-710 N/mm²

suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 217
- Fast Clamping (ROL1 Clamp3), see page 218

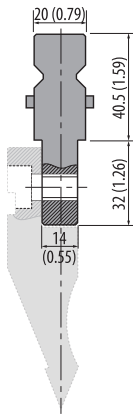


A

ROLLERI ADAPTERS Bolted Adapters

AW11

1000 kN/m max.



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	2.9 kg

Rolleri Type R2
→ Rolleri Type R1

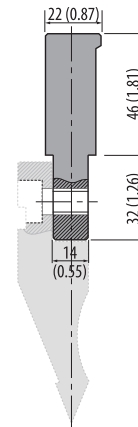
C45: 560-710 N/mm²



Do you prefer our QuickLock or ROL1-System?
Contact us now!

AW3

1000 kN/m max.



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

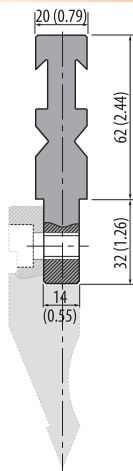
Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



AW10

1000 kN/m max.



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

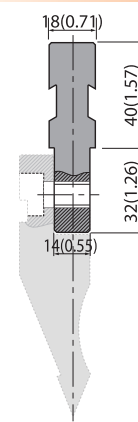
Rolleri Type R3 Beyeler RFA
→ Rolleri Type R1

C45: 560-710 N/mm²



AW12

1000 kN/m max.



835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.5 kg
805 mm segmented	31.69 in segmented	6.7 kg

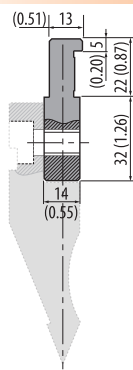
Rolleri Type RX Colgar
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-A

1000 kN/m max.



835 mm	32.87 in	4.5 kg
415 mm	16.34 in	2.2 kg
805 mm segmented	31.69 in segmented	4.3 kg

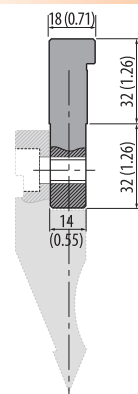
Rolleri Type RX LVD A
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-B

1000 kN/m max.



835 mm	32.87 in	6.3 kg
415 mm	16.34 in	3.1 kg
805 mm segmented	31.69 in segmented	6.0 kg

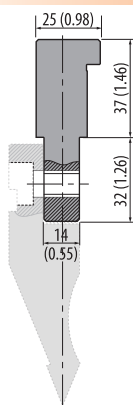
Rolleri Type RX LVD B
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-C

1000 kN/m max.



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

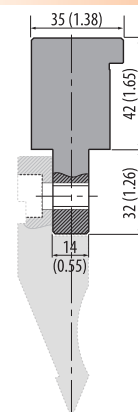
Rolleri Type RX LVD C
→ Rolleri Type R1

C45: 560-710 N/mm²



AW1-D

1000 kN/m max.



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

Rolleri Type RX LVD D
→ Rolleri Type R1

C45: 560-710 N/mm²

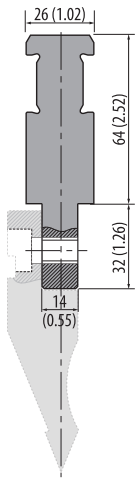


A

ROLLERI ADAPTERS Bolted Adapters

AW13

1000 kN/m max.



835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.3 kg
805 mm segmented	31.69 in segmented	12.1 kg

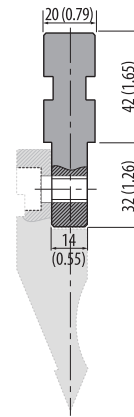
Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²



AW14

1000 kN/m max.



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

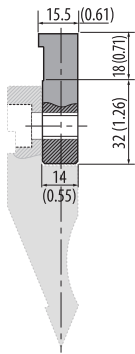
Rolleri Type RX Gasparini
→ Rolleri Type R1

C45: 560-710 N/mm²



AW15

1000 kN/m max.



835 mm	32.87 in	4.6 kg
415 mm	16.34 in	2.3 kg
805 mm segmented	31.69 in segmented	4.4 kg

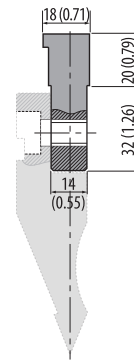
Rolleri Type RX Ajial-Axial
→ Rolleri Type R1

C45: 560-710 N/mm²



AWC16

1000 kN/m max.



835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

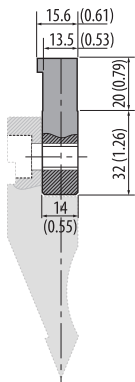
Rolleri Type RX Colly
→ Rolleri Type R1

C45: 560-710 N/mm²



AWC13.5

1000 kN/m max.



835 mm	32.87 in	4.8 kg
415 mm	16.34 in	2.4 kg
805 mm segmented	31.69 in segmented	4.6 kg

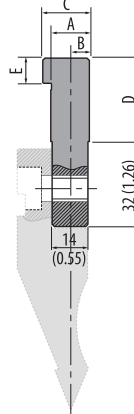
Rolleri Type RX Colly
→ Rolleri Type R1

C45: 560-710 N/mm²



AWX

1000 kN/m max.



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	3.0 kg

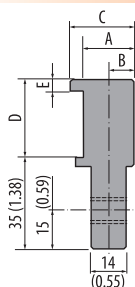
Individual
→ Rolleri Type R1

C45: 560-710 N/mm²



INT35

1000 kN/m max.



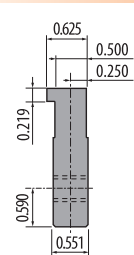
835 mm	32.87 in	4.0 kg
525 mm	20.67 in	2.5 kg
805 mm segmented	31.69 in segmented	3.9 kg

C45: 560-710 N/mm²



INT35-A

1000 kN/m max.



835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

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

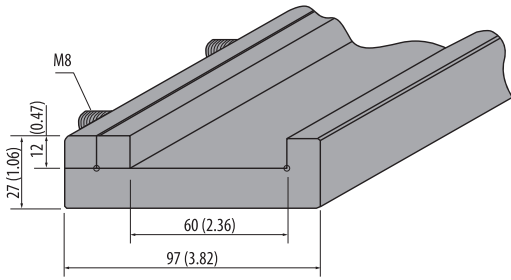


Articles on stock – Please note that delivery time depends on your location.

A

ROLLERI ADAPTERS Die Holders

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

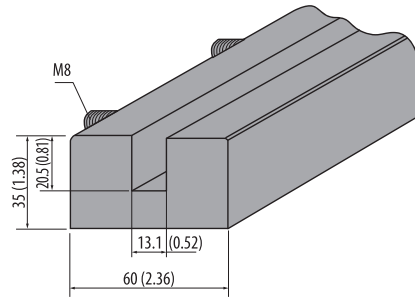


Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm²

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

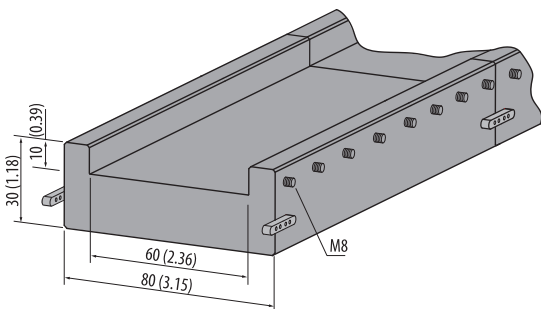


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm²

C 1050/R

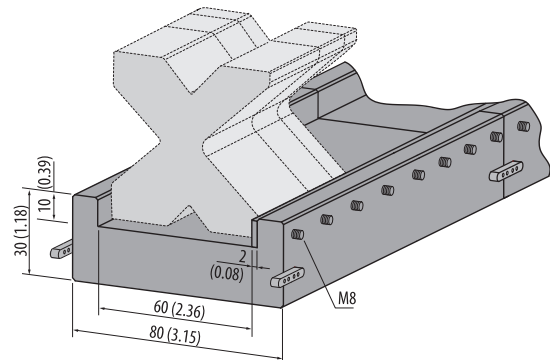


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg



C45: 560-710 N/mm²

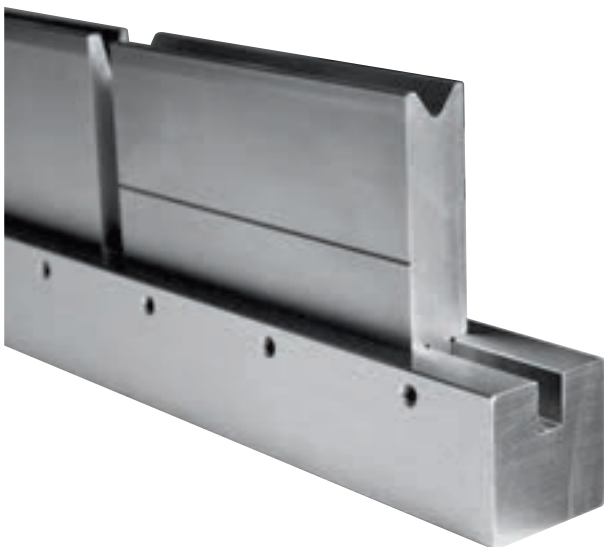
C 1050/RS



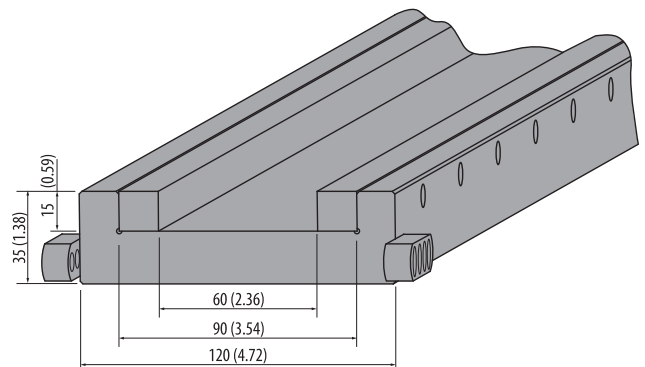
Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



C45: 560-710 N/mm²



C 1050-90



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



C45: 560-710 N/mm²

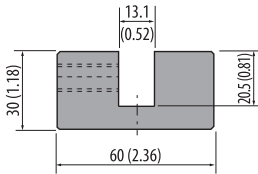
AD6

1000 kN/m max.

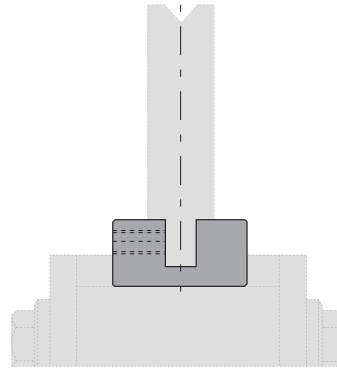
1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD6 Example of Application



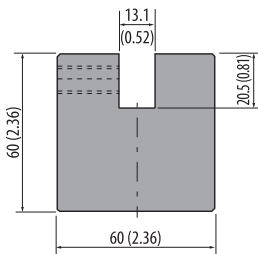
AD5

1000 kN/m max.

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

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD5 Example of Application



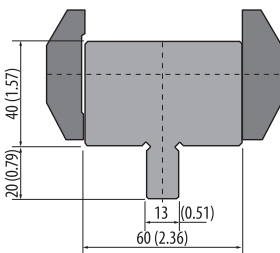
AD7

1000 kN/m max.

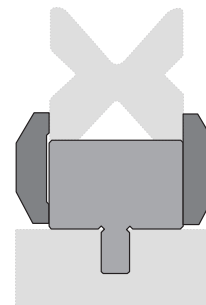
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²



AD7 Example of Application



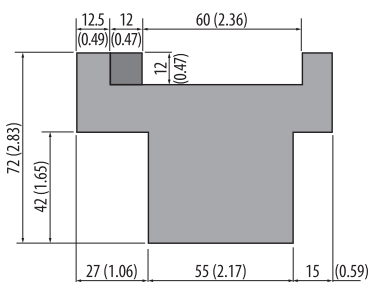
AD24

1000 kN/m max.

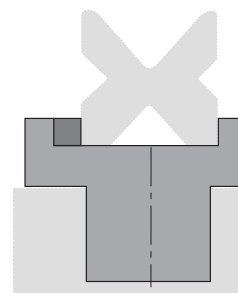
835 mm	32.87 in	28.5 kg
415 mm	16.34 in	14.2 kg

Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²



AD24 Example of Application



Article on stock



Please ask for delivery time!

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



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

A

ROLLERI ADAPTERS Die Adapter

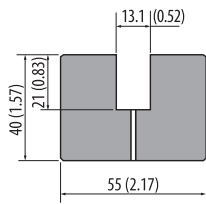
AD25

1000 kN/m max.

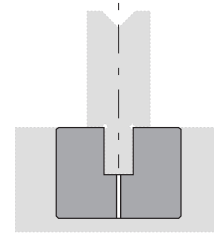
500 mm	19.68 in	7.5 kg
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Rolleri Type RX EHT
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD25 Example of Application



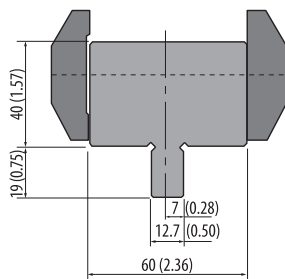
AD9-12.7

1000 kN/m max.

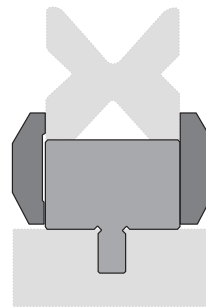
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.5 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



AD9-12.7 Example of Application



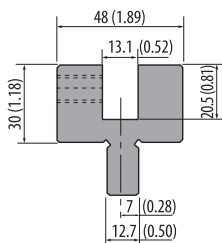
AD8-12.7

1000 kN/m max.

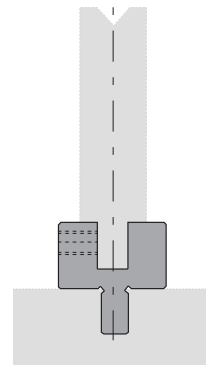
1000 mm	39.37 in	15.0 kg
500 mm	19.68 in	7.5 kg

Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD8-12.7 Example of Application



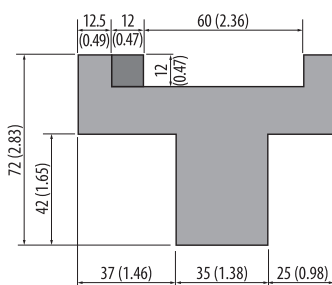
AD26

1000 kN/m max.

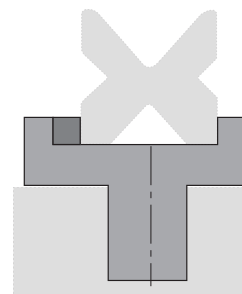
835 mm	32.87 in	23.0 kg
415 mm	16.34 in	11.4 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm²



AD26 Example of Application



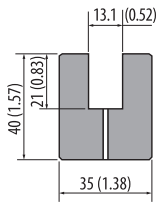
AD27

1000 kN/m max.

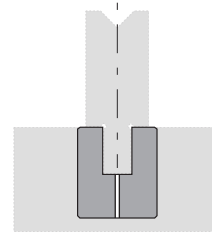
500 mm	19.68 in	4.5 kg
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Rolleri Type RX
Weinbrenner
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD27 Example of Application



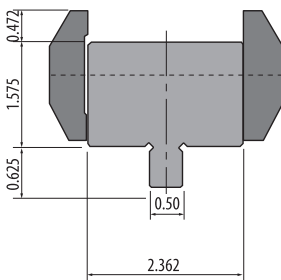
AD17

1000 kN/m max.

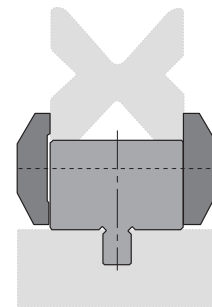
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Type American
→ Rolleri Type R1

C45: 560-710 N/mm²



AD17 Example of Application



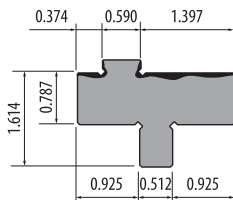
AD18

1000 kN/m max.

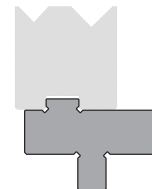
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Type American
→ Rolleri Type R1

C45: 560-710 N/mm²



AD18 Example of Application



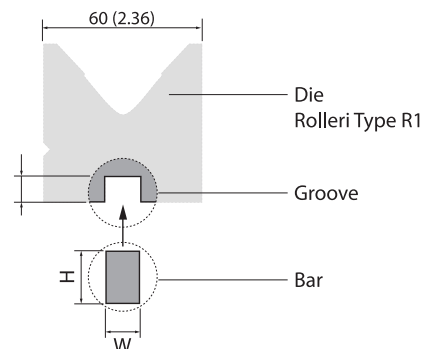
Modification: bar

To use Rolleri Type R1 dies in other press brakes, a 10 mm (0.39 in) groove is milled where a ground bar is mounted.

Wedge Bar (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 prices are found in the Rolleri Modifications Chapter (see page 268)

Mounting example



Article on stock

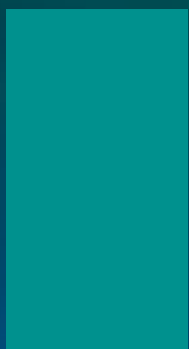


Please ask for delivery time!

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



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





ROLLERI MARK FREE BENDING

Prevention of Bending Marks	238
Bending Foil Holder/Tensioner	238
Bending Foil	239
Polyurethane inserts and holders	240 - 241
Synthetic Dies	242 - 243

ROLLERI MARK FREE / REDUCTION BENDING

Prevention or Reduction of Bending Marks

One of the challenges of bending is preventing the profile from having bending marks, such as scratches and abrasions on the surface areas.

Especially profiles made of:

- Stainless Steel
- Aluminium
- painted metal panels

often show lines in the contact areas between sheet metal and die. This is the consequence of friction occurring when bending sheet metal with dies with small radius on the V opening.

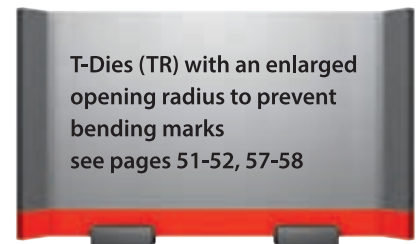
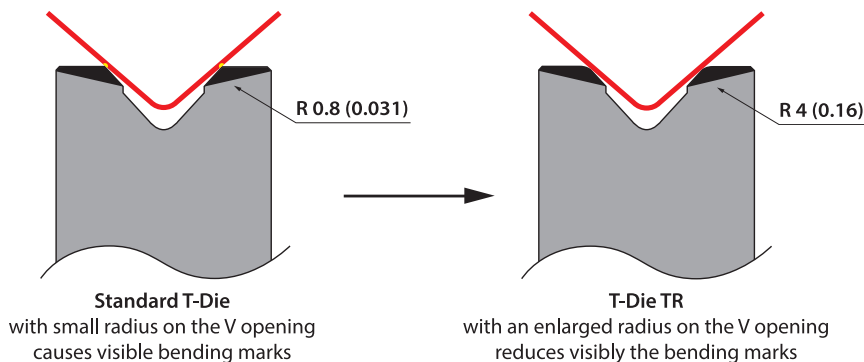
In order to prevent this marking, the following solutions are possible:

- **Bending Foil**
- **Polyurethane inserts**
- **Synthetic Dies**
- **ROLLA-V**
- **enlarged radius on the V opening of a die**



Our Advantages – Your Convenience

- Prevention of scratches and abrasions on bent sheet metals
- No post-processing necessary, with subsequent time and cost efficiency
- increases the product quality
- easy handling



Bending Foil - Holder / Tensioner

CT

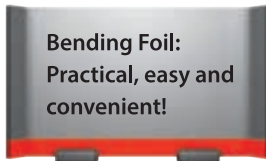


per pair 6.0 kg



Our Advantages – Your Convenience

- easy handling
- flexible positioning
- Prevention of bending marks
- decrease of post-operations of bent parts
- increased product quality



ROLFILM



Model	Thickness (mm)	Thickness (in)	Width (mm)	Width (in)	Length (m)	Length (in)
Rolfilm 3-0.4-100	0.4	0.016	100	3.94	3	118.11
Rolfilm 10-0.4-100	0.4	0.016	100	3.94	10	393.70
Rolfilm 20-0.4-100	0.4	0.016	100	3.94	20	787.40
Rolfilm 30-0.4-100	0.4	0.016	100	3.94	30	1181.10
Rolfilm 3-0.4-150	0.4	0.016	150	5.91	3	118.11
Rolfilm 10-0.4-150	0.4	0.016	150	5.91	10	393.70
Rolfilm 20-0.4-150	0.4	0.016	150	5.91	20	787.40
Rolfilm 30-0.4-150	0.4	0.016	150	5.91	30	1181.10
Rolfilm 3-0.6-150	0.6	0.024	150	5.91	3	118.11
Rolfilm 10-0.6-150	0.6	0.024	150	5.91	10	393.70
Rolfilm 20-0.6-150	0.6	0.024	150	5.91	20	787.40
Rolfilm 30-0.6-150	0.6	0.024	150	5.91	30	1181.10
Rolfilm 3-0.6-200	0.6	0.024	200	7.87	3	118.11
Rolfilm 10-0.6-200	0.6	0.024	200	7.87	10	393.70
Rolfilm 20-0.6-200	0.6	0.024	200	7.87	20	787.40
Rolfilm 30-0.6-200	0.6	0.024	200	7.87	30	1181.10
Rolfilm 3-2-150	2.0	0.079	150	5.91	3	118.11
Rolfilm 10-2-150	2.0	0.079	150	5.91	10	393.70
Rolfilm 20-2-150	2.0	0.079	150	5.91	20	787.40
Rolfilm 30-2-150	2.0	0.079	150	5.91	30	1181.10



Rolleri Videos

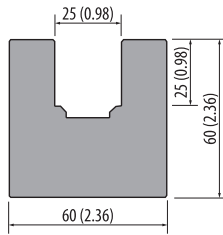
mark free bending:
www.rolleritools.com/videos/mark-free-bending



ROLLERI MARK FREE / REDUCTION BENDING

Polyurethane inserts and holders

MPG25

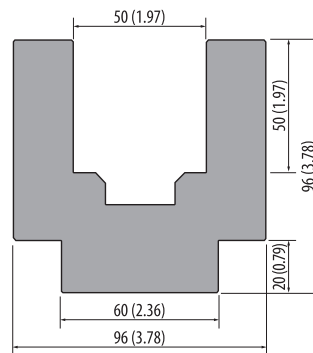


835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg

C45: 560-710 N/mm²



MPG50

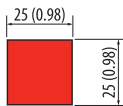


835 mm	32.87 in	44.0 kg
415 mm	16.34 in	22.0 kg

C45: 560-710 N/mm²



GM 25x25

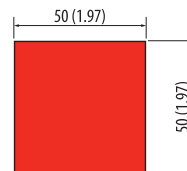


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane



GM 50x50

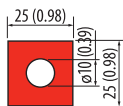


835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

polyurethane



GMF 25x25x10

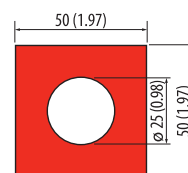


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane



GMF 50x50x25



835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

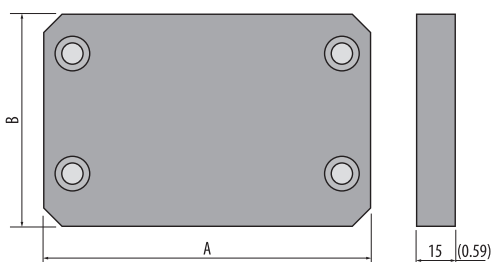
polyurethane



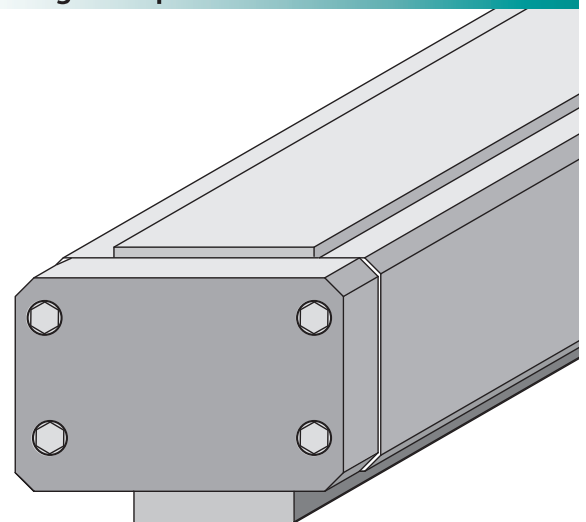
PSTCON

cover plate	Model	A (mm)	A (in)	R (mm)	R (in)	Weight
	PSTCON25	58	2.28	58	2.28	1.2 kg
	PSTCON50	108	4.25	75	2.95	0.6 kg
	PSTCON75	123	4.84	80	3.15	0.8 kg
	PSTCON100	153	6.02	80	3.15	1.0 kg

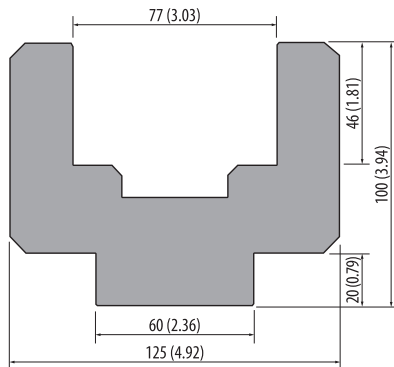
C45: 560-710 N/mm²



Mounting example



MPG75

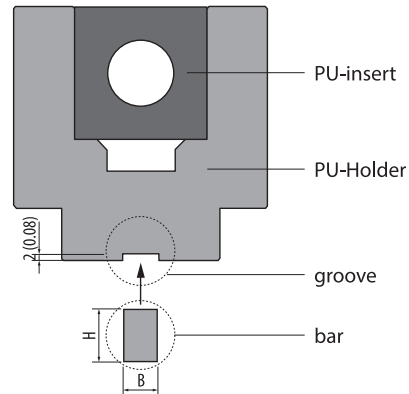


835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg

C45: 560-710 N/mm²

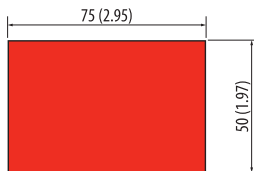


Mounting example



Also mountable on other press brakes!

GM 75x50

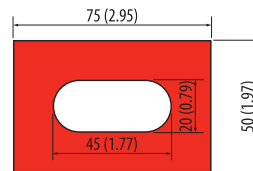


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane



GMF 75x50x20

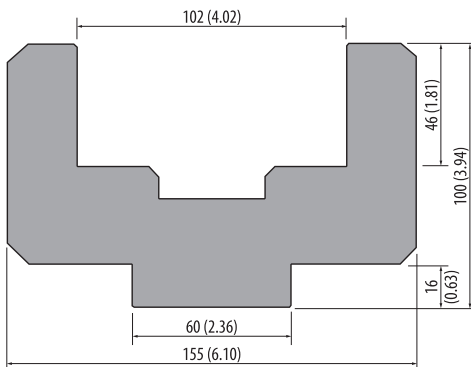


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane



MPG100



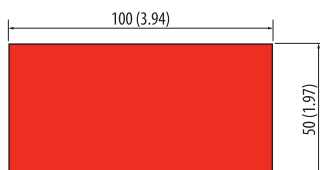
835 mm	32.87 in	55.0 kg
415 mm	16.34 in	27.5 kg

C45: 560-710 N/mm²



Polyurethane inserts are suitable for radius- and U-profile bendings, etc.

GM 100x50

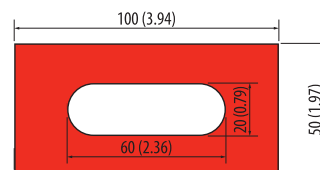


835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg

polyurethane



GMF 100x50x20



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	2.2 kg

polyurethane



Article on stock



Please ask for delivery time!

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



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

ROLLERI MARK FREE / REDUCTION BENDING

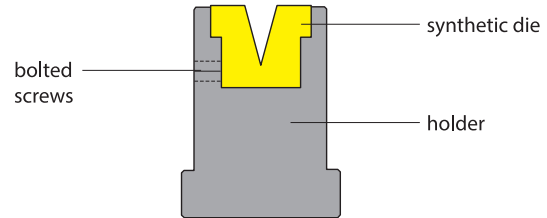
Synthetic Dies

Our Advantages – Your Convenience

- easy handling
- fast and easy change of plastic dies
- prevention of bending marks
- decrease of post-operations of bent pieces
- increased product quality

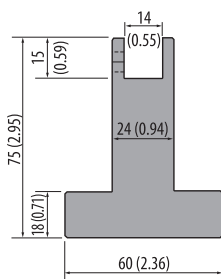
Mounting example

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



TN80.14

1000 kN/m max.



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

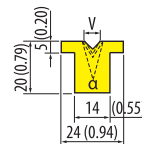
Rolleri Type R1

C45: 560-710 N/mm²



INS14...

200 kN/m max.



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

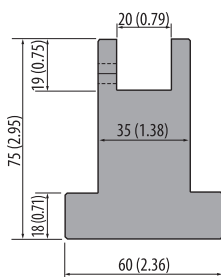


Model	α	V (mm)	V (in)
INS14.06.88	88°	6	0.24
INS14.08.88	88°	8	0.31
INS14.10.88	88°	10	0.39
INS14.06.60	60°	6	0.24
INS14.08.60	60°	8	0.31
INS14.10.60	60°	10	0.39

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

TN80.20

1000 kN/m max.



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

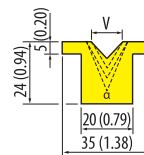
Rolleri Type R1

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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

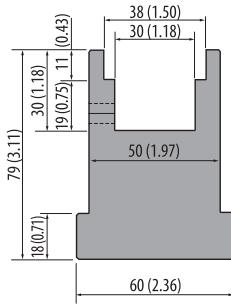


Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

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

TN80.30

1000 kN/m max.



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

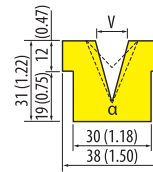
Rolleri Type R1

C45: 560-710 N/mm²



INS30...

200 kN/m max.



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



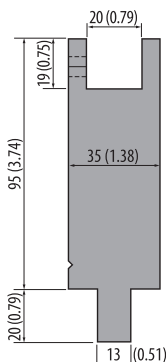
Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.47
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16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

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



TMN95.20

1000 kN/m max.



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

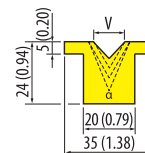
Rolleri Type R2/R3

C45: 560-710 N/mm²



INS20...

200 kN/m max.



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



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

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



Article on stock

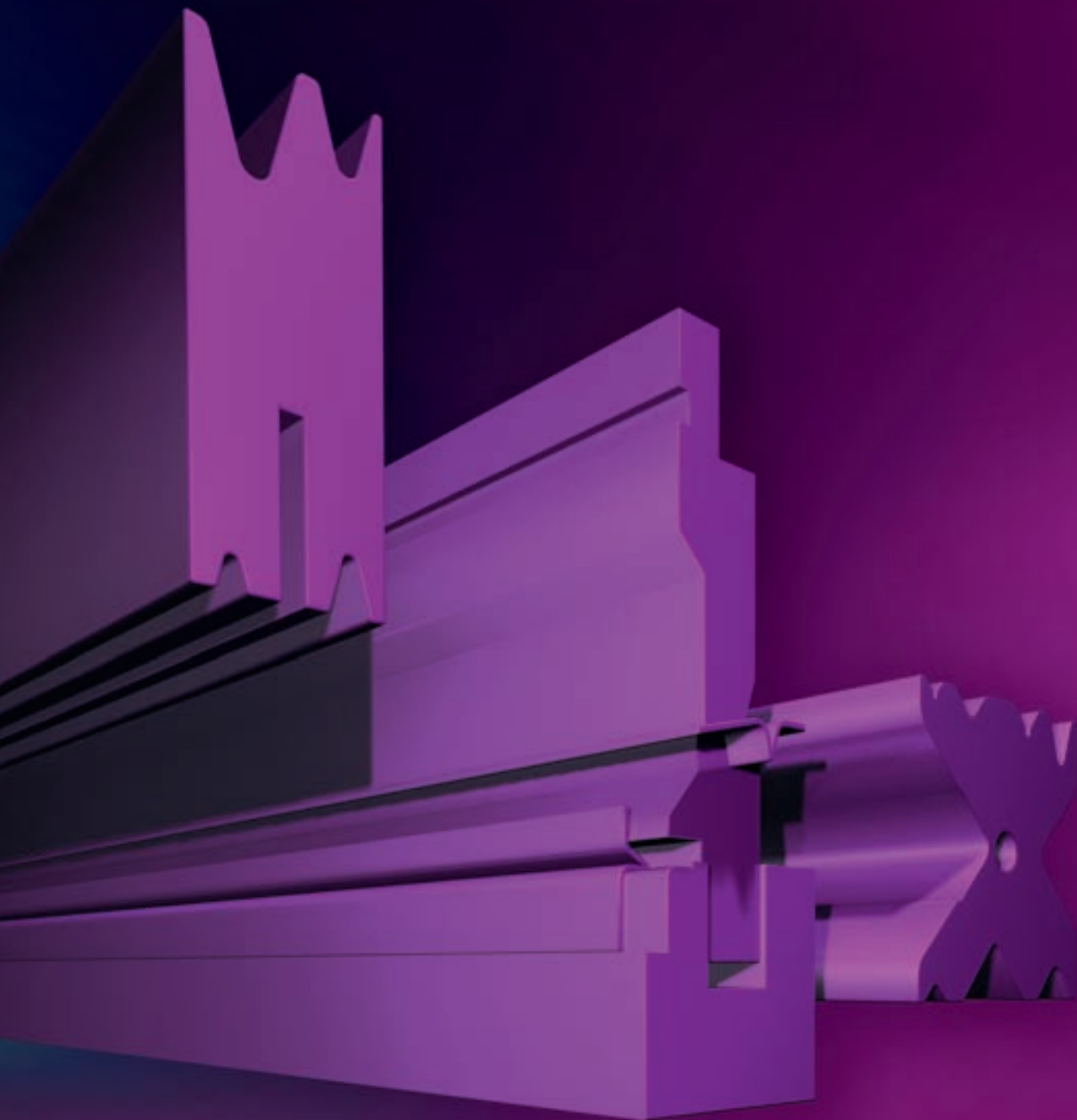


Please ask for delivery time!

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



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





ROLLERI **SPECIAL AND HEAVY DUTY TOOLS**

Explanation of Special Tools	246
Explanation of Heavy Duty Tools	247
Heavy Duty Tools	248 - 249
Examples of Special Tools	250 - 254
Dies with Rollers	255
Adjustable dies	256 - 259
Rolleri VARIO	260
Panel bending tools	260
Rolleri BLACKFIRE	261
Rolleri FreeZinc	261

■ **Our Advantages – Your Convenience**

- in-house construction and production (no reseller or dealer)
- competent consulting
- custom-made solutions
- every single tool is traceable thanks to a unique serial number stamped after the first quality control
- precision grinding (tolerance of +/-0.01mm)
- guaranteed tool reproduction
- exact parallelism
- bending tests upon request

■ **Special Tooling for:**

- Z-Profiles
- Omega-Profiles
- Trapezoidal Profiles
- Coining
- Special hemming
- Hinges
- Large-radius bends
- Special Profiles
- etc.



■ **Material**

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRc	54 - 60 HRc
C45	560-710 N/mm ²	12 - 15.5 HRc	54 - 60 HRc
1.2767	830 N/mm ²	22 - 25 HRc	54 - 60 HRc

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





Our Advantages – Your Convenience

The bending of materials with extreme high resistance, (Hardox, Weldox, etc.), has developed into an important task.

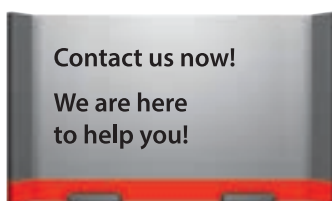
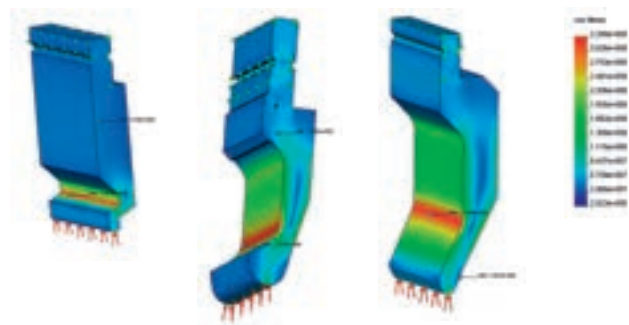
Rolleri heavy duty tools are designed and manufactured for these challenges.

Tools that have up to 4000 kN/m capacity offer you many production possibilities.

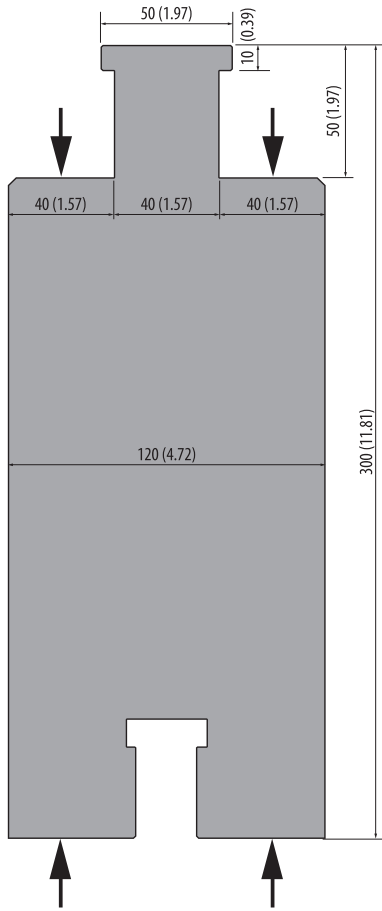
Our long experience in the area of special and heavy duty tooling, along with our own Research and Development Department, guarantees you efficient and convenient bending solutions.

From the clamping system to punches and dies, 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.



RHD.300



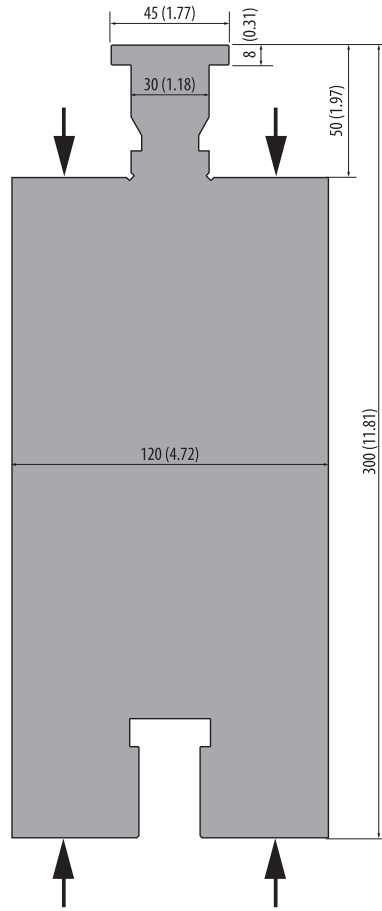
RHD.300-250		
500 mm	19.68 in	122.0 kg

2500 kN/m max.
42Cr: 900-1150 N/mm²

RHD.300-400		
500 mm	19.68 in	122.0 kg

4000 kN/m max.
1.2767: 830 N/mm²

RHD.300 HYD



RHD.300-250 HYD		
500 mm	19.68 in	120.0 kg

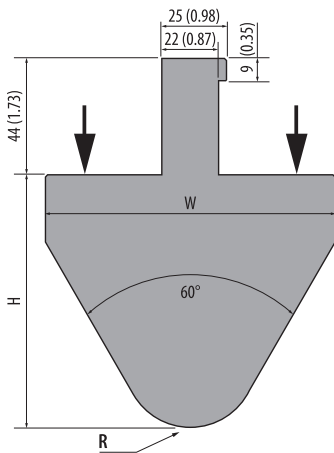
2500 kN/m max.
42Cr: 900-1150 N/mm²

RHD.300-400 HYD		
500 mm	19.68 in	120.0 kg

4000 kN/m max.
1.2767: 830 N/mm²

RHDP.60

500 mm	19.68 in
--------	----------



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

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

42Cr: 900-1150 N/mm²

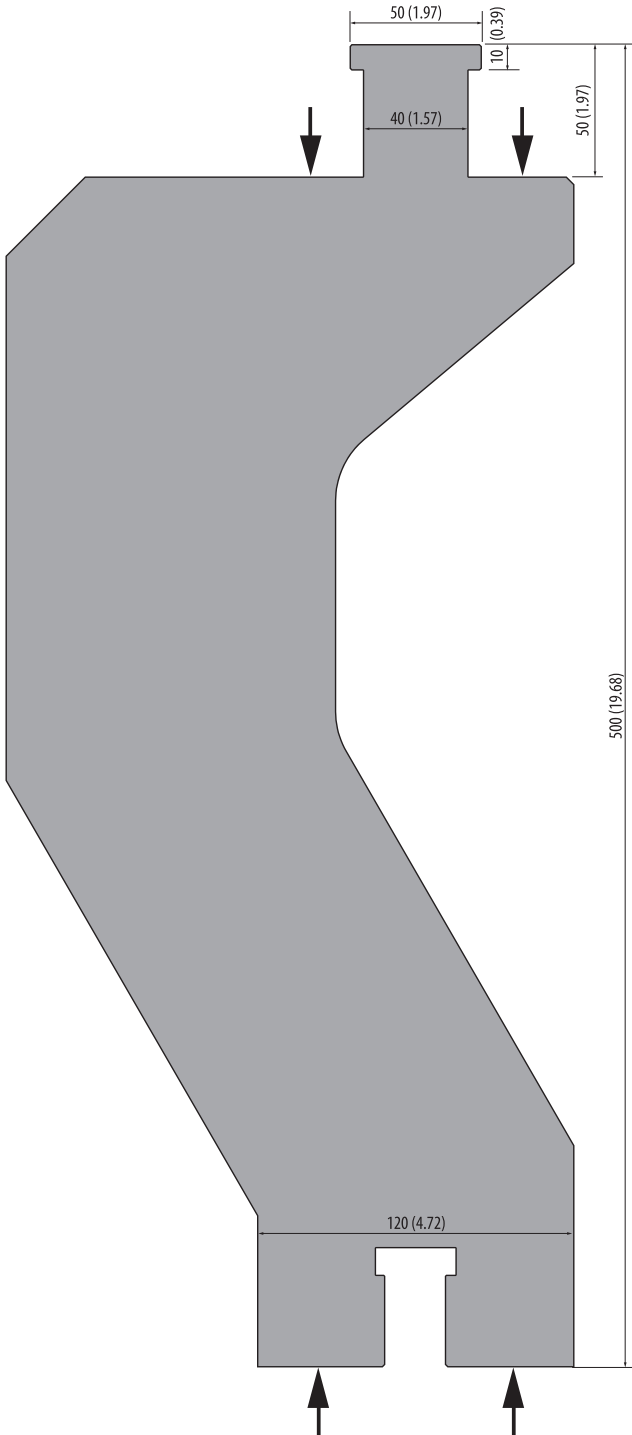
1.2767: 830 N/mm²

RHD.500-200

2000 kN/m.max.

150 mm 19.68 in 253.0 kg

42Cr: 900-1150 N/mm²



More tools for heavy duty operations can be found on pages 191-193



Article on stock



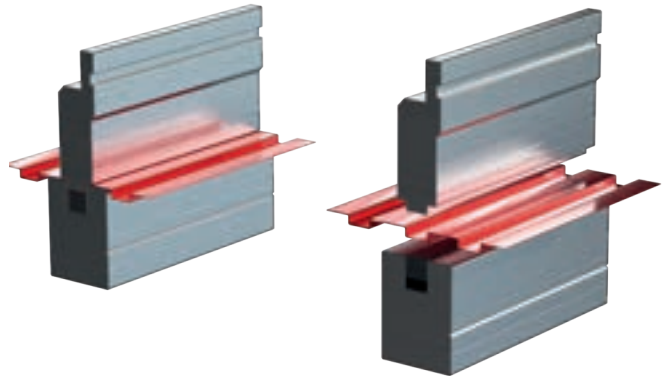
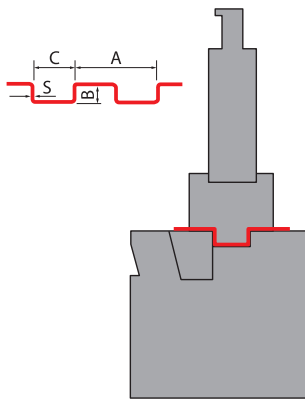
Please ask for delivery time!

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

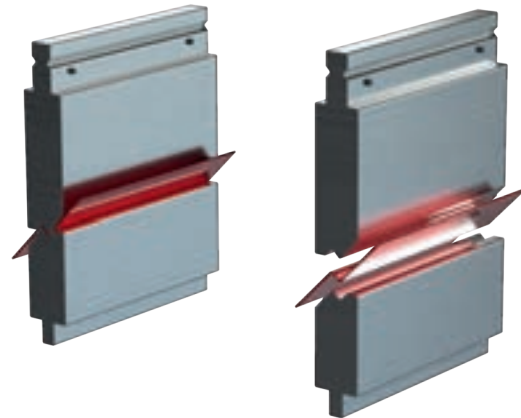
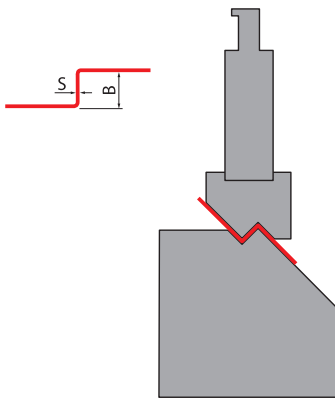


Articles on stock – Please note that delivery time depends on your location.

SPE1



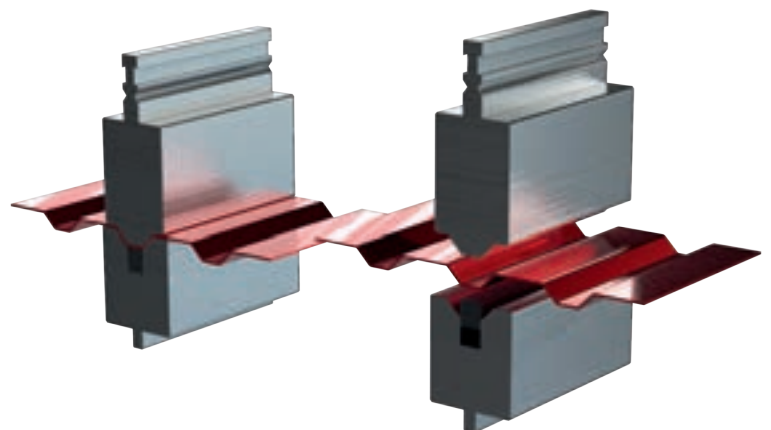
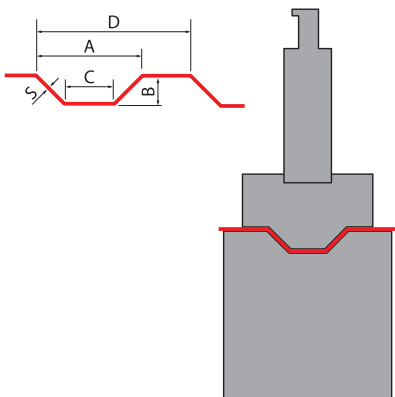
SPE2



Z-Profiles



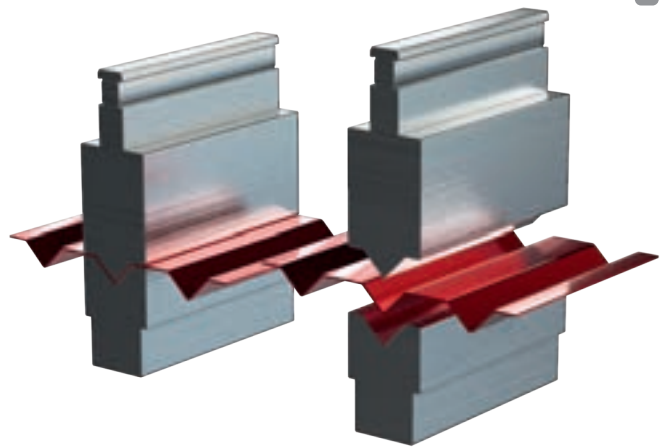
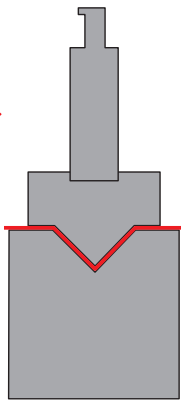
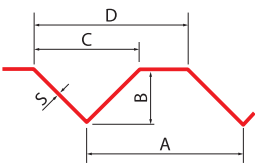
SPE3



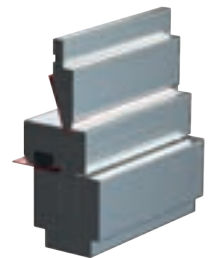
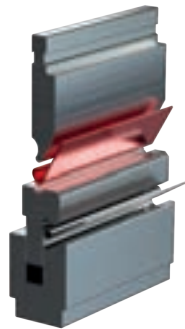
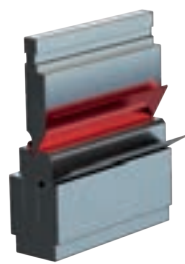
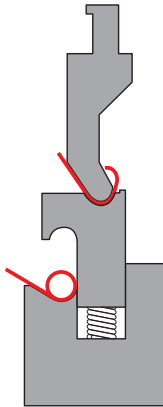
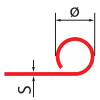
Trapezoidal Profiles



SPE4

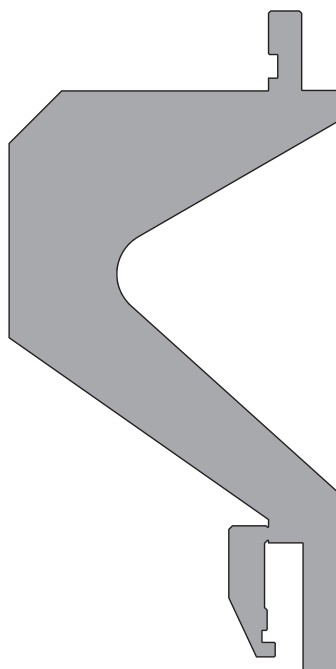


SPE5

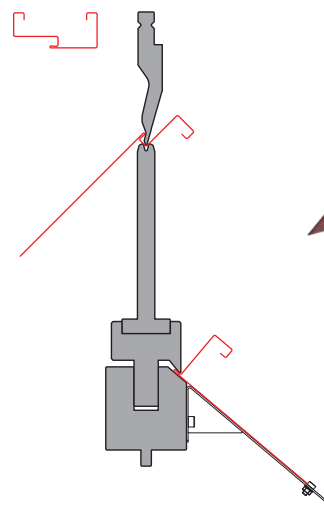


Hinges 

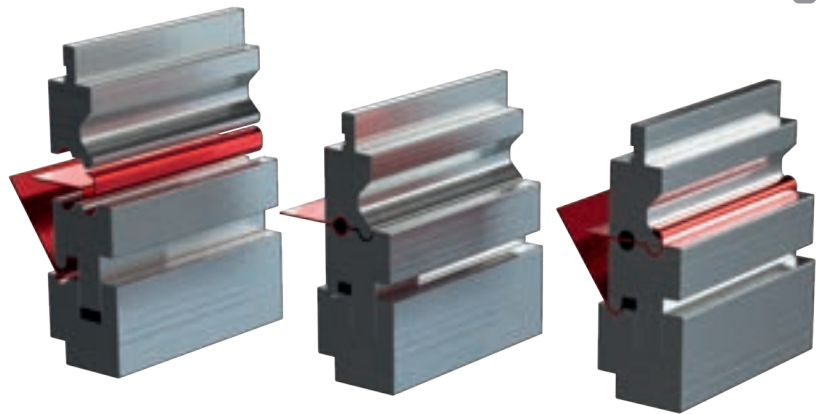
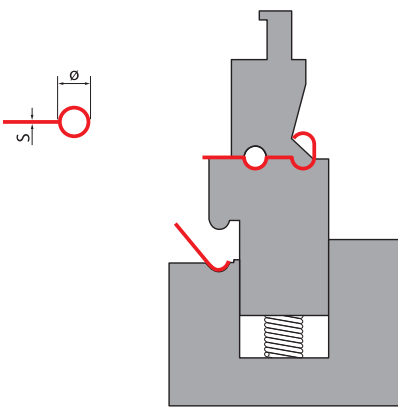
SPE-P4



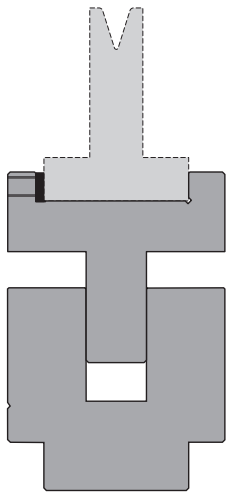
Pre-bending and flattening



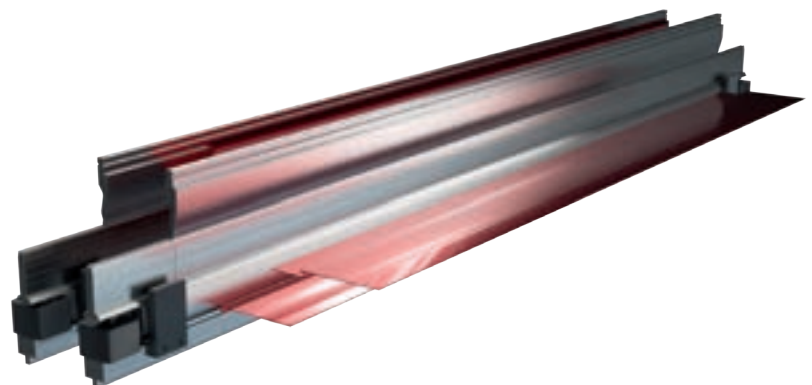
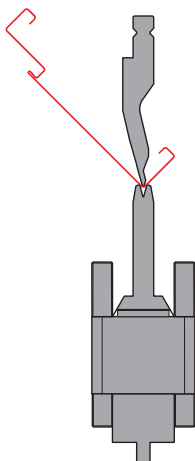
SPE6



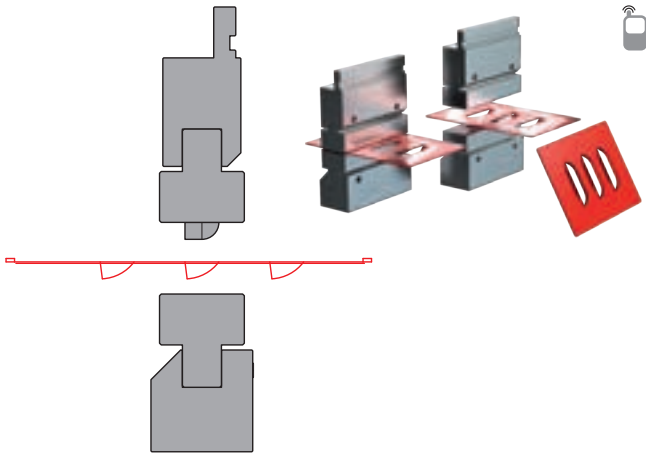
SPE9



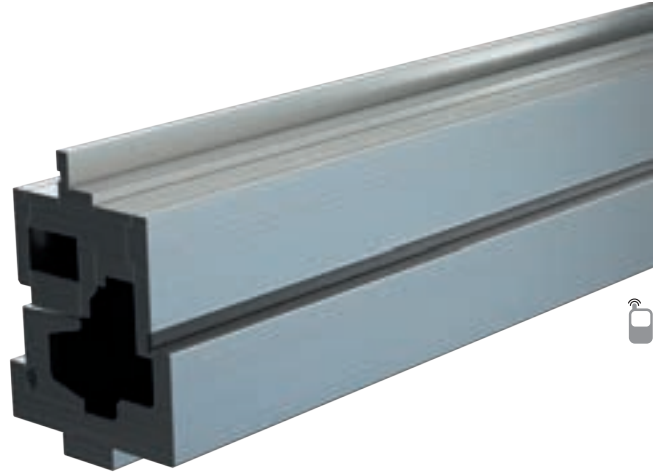
Special-Profile DOORFRAME



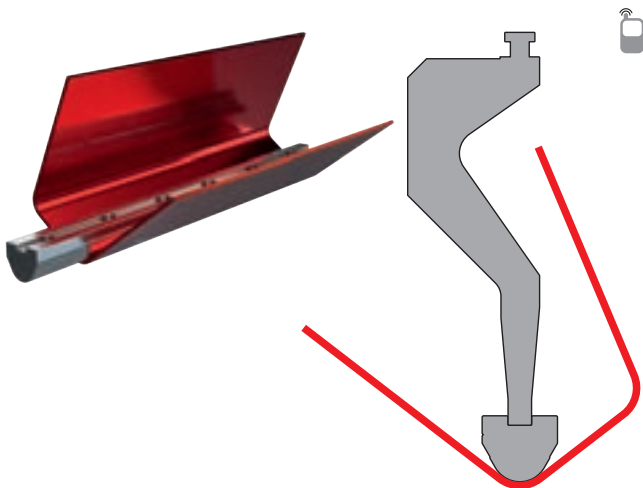
SPE10



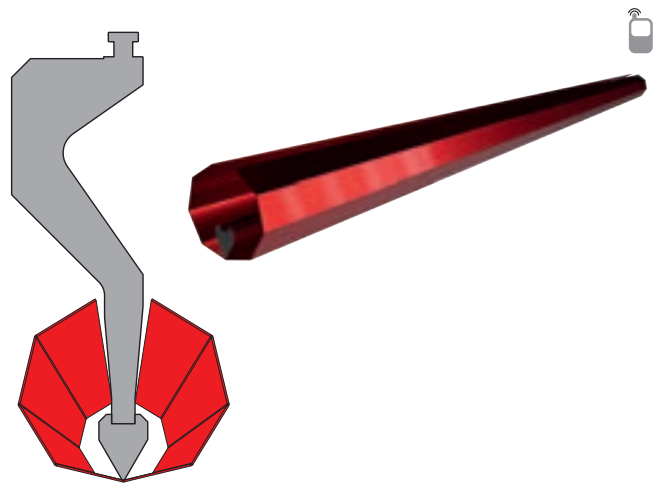
SPE11



Special-Profile



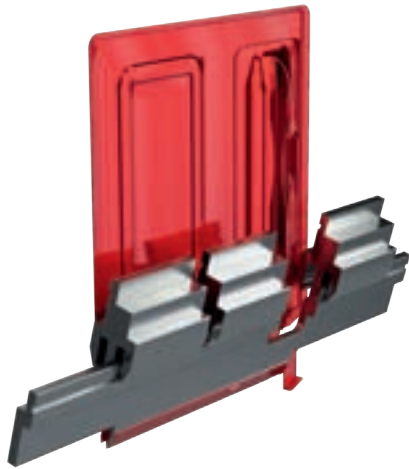
Special-Profile CONICAL POLE



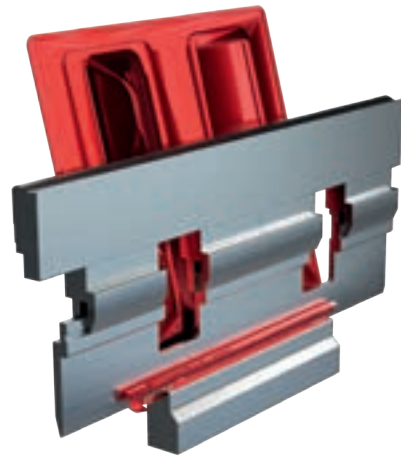
Special-Profile CIRCULAR POLE



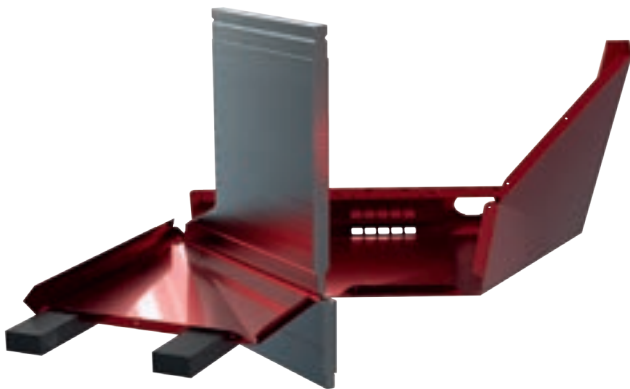
Special-Profile



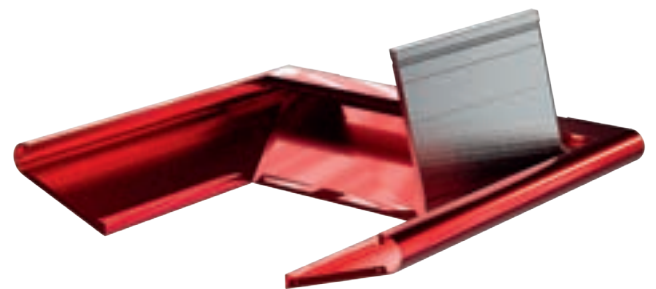
Special-Profile



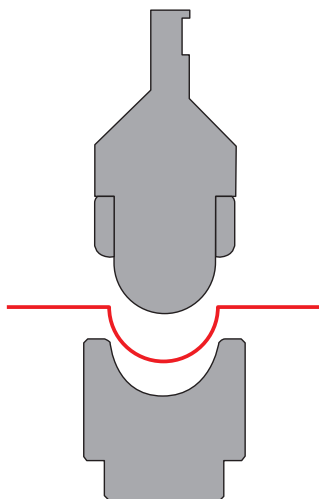
Special-Profile KITCHEN HOODS



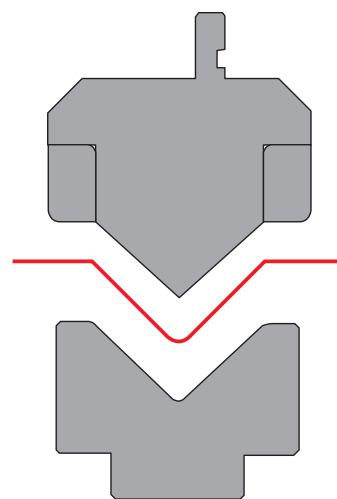
Special-Profile KITCHEN HOODS



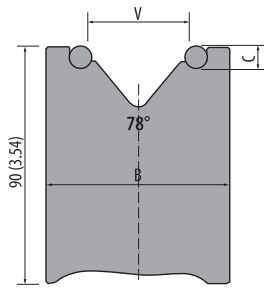
Large radii



Pressing



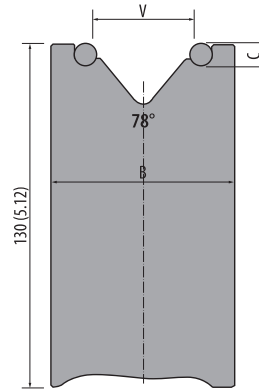
MR90



Rollen: C53.60-62 HRC
42Cr: 900-1150 N/mm²



MR130



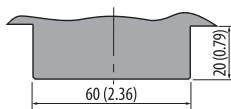
Rollen: C53.60-62 HRC
42Cr: 900-1150 N/mm²



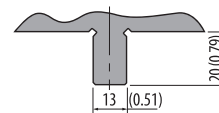
Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
MR90.20.78	20	0.79	45	1.77	6	0.24	835	32.87	15.0
MR90.24.78	24	0.94	49	1.93	6	0.24	835	32.87	17.0
MR90.30.78	30	1.18	60	2.36	8	0.31	835	32.87	21.0
MR90.40.78	40	1.57	70	2.76	8	0.31	835	32.87	24.0
MR90.50.78	50	1.97	84	3.31	10	0.39	835	32.87	28.0
MR90.60.78	60	2.36	94	3.70	10	0.39	835	32.87	31.0
MR90.70.78	70	2.76	104	4.09	10	0.39	835	32.87	35.0

Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
MR130.20.78	20	0.79	45	1.77	6	0.24	835	32.87	22.0
MR130.24.78	24	0.94	49	1.93	6	0.24	835	32.87	25.0
MR130.30.78	30	1.18	60	2.36	8	0.31	835	32.87	28.0
MR130.40.78	40	1.57	70	2.76	8	0.31	835	32.87	34.0
MR130.50.78	50	1.97	84	3.31	10	0.39	835	32.87	40.0
MR130.60.78	60	2.36	94	3.70	10	0.39	835	32.87	45.0
MR130.75.78	75	2.95	118	4.65	16	0.63	835	32.87	50.0
MR130.80.78	80	3.15	123	4.84	16	0.63	835	32.87	55.0
MR130.90.78	90	3.54	133	5.24	16	0.63	835	32.87	60.0
MR130.100.78	100	3.94	143	5.63	16	0.63	835	32.87	65.0
MR130.120.78	120	4.72	163	6.42	16	0.63	835	32.87	70.0

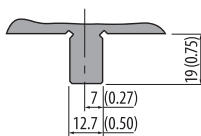
A10



A11



A13



Article on stock



Please ask for delivery time!

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



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

Compatibility

Adjustable dies are:

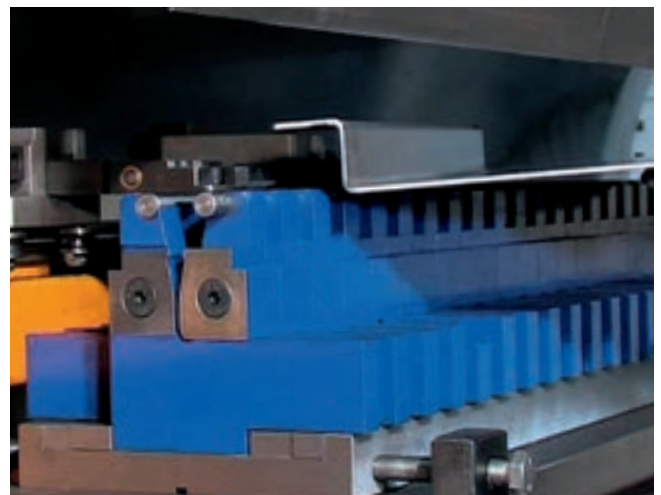
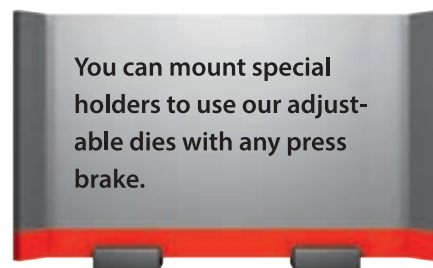
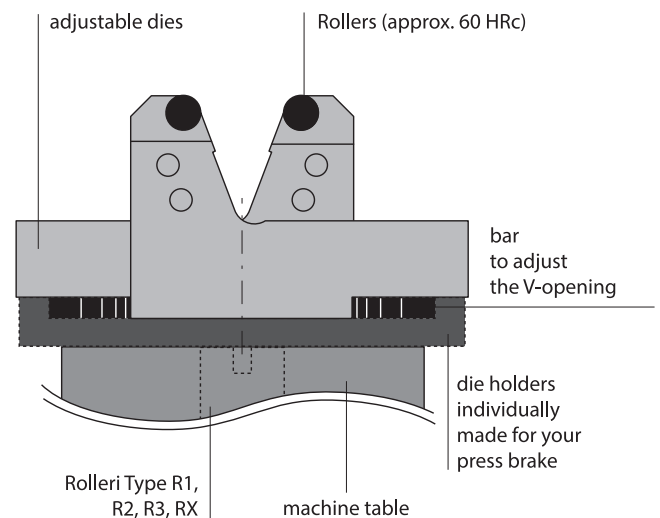
- applicable on all press brakes with die holders

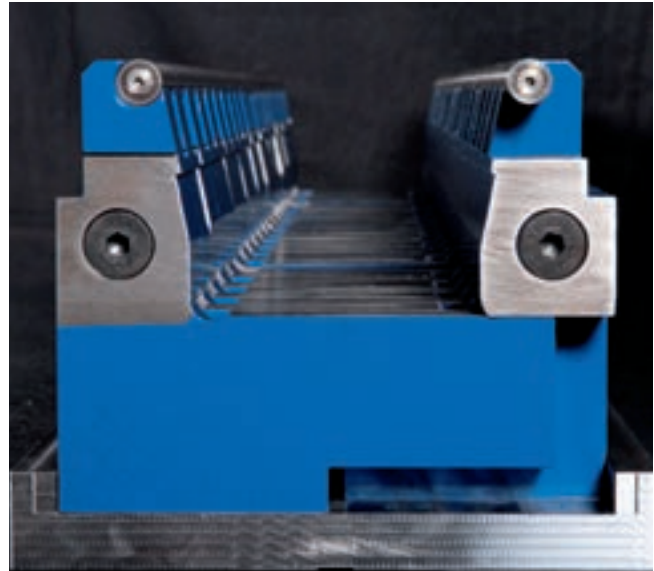
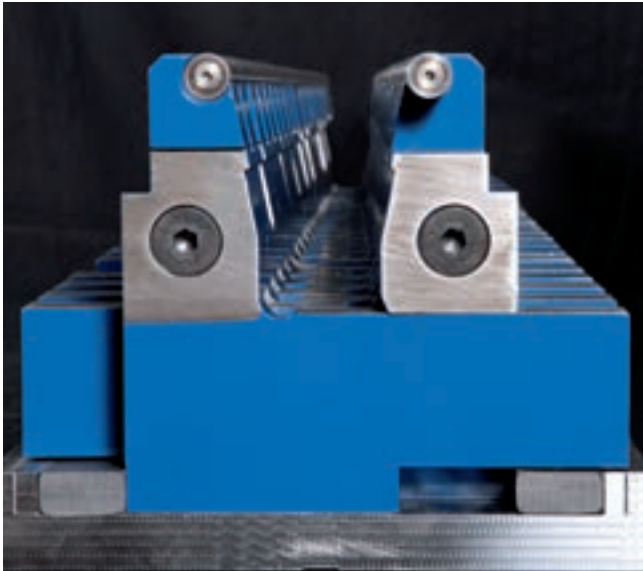
Our Advantages – Your Convenience

- Cover a broad range of V openings, therefore less tool change.
- Bending up to 30°, especially ideal for high-tensile materials with large spring back.
- Reduced marking of the sheet metal thanks to hardened roller bars.
- Minimum wear of the bending radii because of hardened roller bars.
- 10% less press force required.
- Easily modify the internal bending radius by adjusting die opening.
- Reduction of down times by as much as 30% because adjustment spacer bars are quick and easy to change.
- Minimum maintenance costs.
- Simple design to avoid collision with complicated profiles.
- Can be used on both new and existing press brakes.
- Modular design; the user can start buying the die length he needs and add extra die modules later as needed.
- An adjustable die gives you to obtain different V opening in just one tool
- High level of precision and consistency over the long term.
- Modular design with interchangeable components gives you the possibility to replace them quickly and easily
- Very high value for the investment.



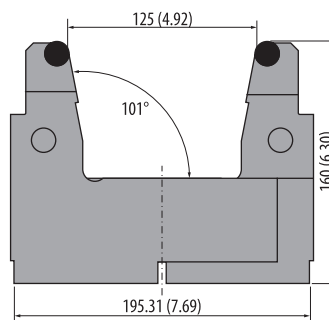
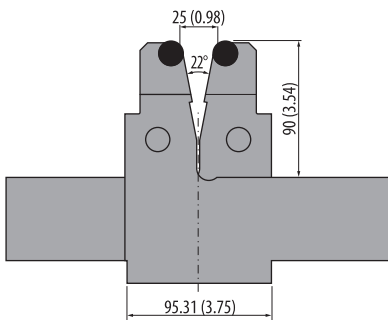
Mounting example





AD25.125

1250 kN/m max. at 90°



250 mm	9.84 in	34.0 kg
500 mm	19.69 in	64.0 kg
550 mm	21.65 in	72.0 kg
1000 mm	39.37 in	125.0 kg
1050 mm	41.34 in	133.0 kg

42Cr: 900-1150 N/mm²

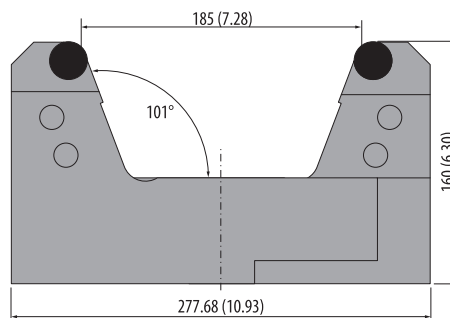
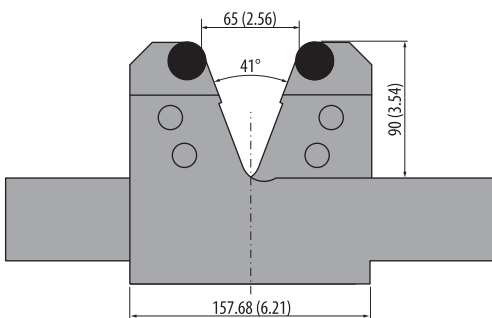


- V=25-125 mm (0.98-4.92 in)
- operating angle 30°-180°
- radius R=8 mm (0.31 in)

Subscribe to our newsletter to get updated information and bending lessons.
You can easily subscribe at www.rolleritools.com/newsletter

AD65.185

2000 kN/m max. at 90°



250 mm	9.84 in	44.0 kg
500 mm	19.69 in	86.0 kg
550 mm	21.65 in	96.0 kg
1000 mm	39.37 in	170.0 kg
1050 mm	41.34 in	180.0 kg

42Cr: 900-1150 N/mm²

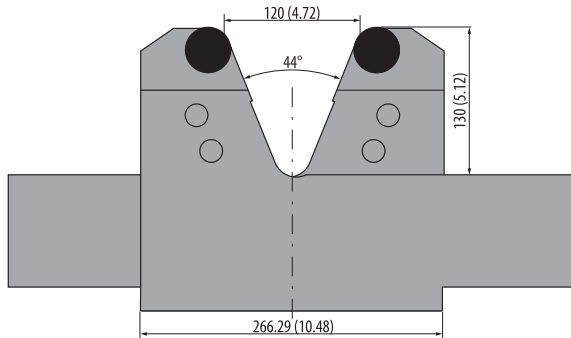


- V=65-185 mm (2.56-7.28 in)
- operating angle 60°-180°
- radius R=12.5 mm (0.49 in)

AD120.300

4000 kN/m max. at 90°

600 mm | 23.62 in | 360.0 kg

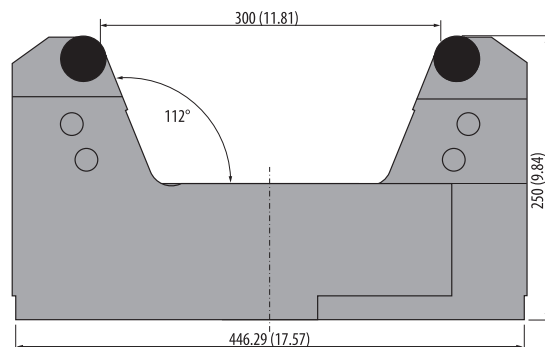


42Cr: 900-1150 N/mm²



- V=120-300 mm (4.72-11.81 in)
- operating angle 60°-180°
- radius R=20 mm (0.79 in)

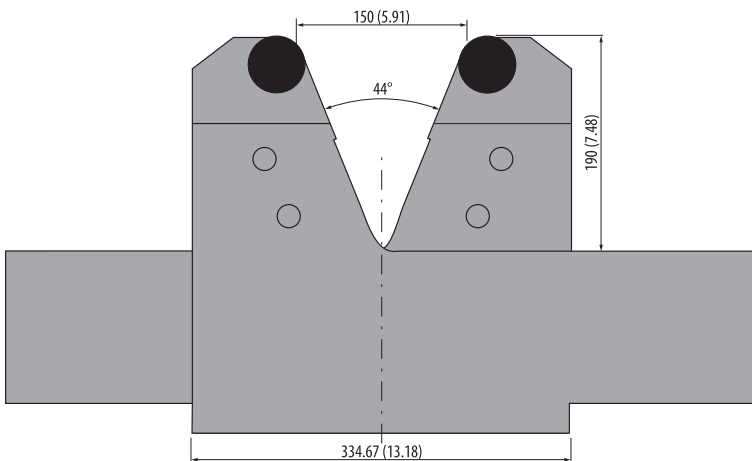
Do you have queries about delivery times, visits from one of our representatives, and other possibilities? Give us a call!



AD150.400

6000 kN/m max. at 90°

600 mm | 23.62 in | 560.0 kg

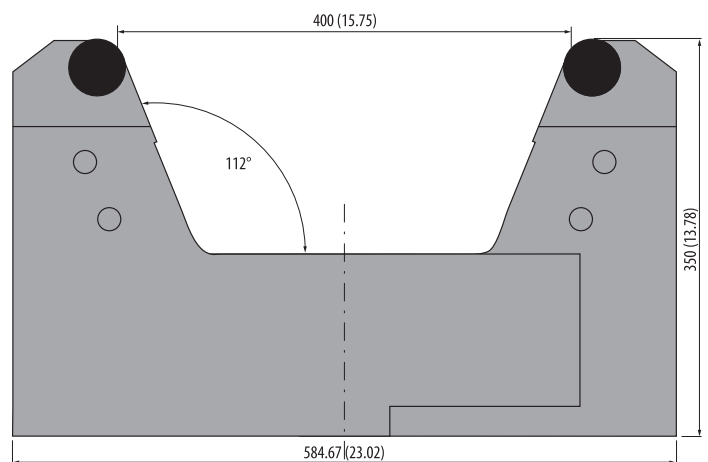


42Cr: 900-1150 N/mm²

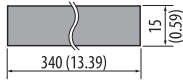


- V=150-400 mm (5.91-15.75 in)
- operating angle 60°-180°
- radius R=25 mm (0.98 in)

Ask for the easy adjustable protective foil to protect your dies from dust and wear. Available for all models!



BAR AD25.185 for AD25.125 + AD65.185



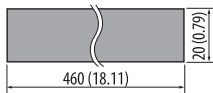
500 mm	19.69 in	21.0 kg
1000 mm	39.37 in	42.0 kg
2000 mm	78.74 in	84.0 kg

Set spacer bars width:
2-5-10-15-20-30-40-50

42Cr: 900-1150 N/mm²



BAR AD120.300 for AD120.300



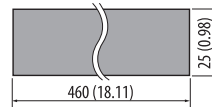
600 mm	23.62 in	45.0 kg
1200 mm	47.24 in	90.0 kg
1800 mm	70.87 in	135.0 kg

Set spacer bars width:
2-5-10-15-20-30-40-50-60

42Cr: 900-1150 N/mm²



BAR AD150.400 for AD150.400



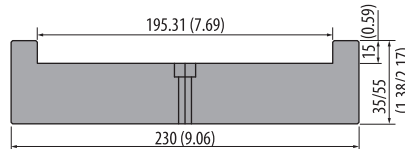
600 mm	23.62 in	55.0 kg
1200 mm	47.24 in	110.0 kg
1800 mm	70.87 in	165.0 kg

Set spacer bars width:
5-10-15-20-30-40-50-60

42Cr: 900-1150 N/mm²



HAD25.125 for AD25.125



Type A = 35 (1.38)	500 mm	19.69 in	20.0 kg
	1000 mm	39.37 in	40.0 kg
	2000 mm	78.74 in	80.0 kg
	3000 mm	118.11 in	120.0 kg

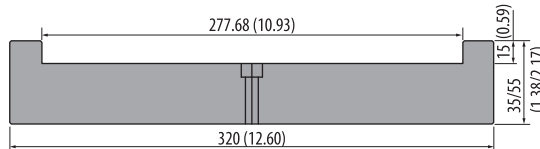
Type B = 55 (2.17)	500 mm	19.69 in	38.0 kg
	1000 mm	39.37 in	76.0 kg
	2000 mm	78.74 in	152.0 kg
	3000 mm	118.11 in	228.0 kg

Holders, available with flat bottom and with tang

42Cr: 900-1150 N/mm²



HAD65.185 for AD65.185



Type A = 35 (1.38)	500 mm	19.69 in	28.0 kg
	1000 mm	39.37 in	56.0 kg
	2000 mm	78.74 in	112.0 kg
	3000 mm	118.11 in	168.0 kg

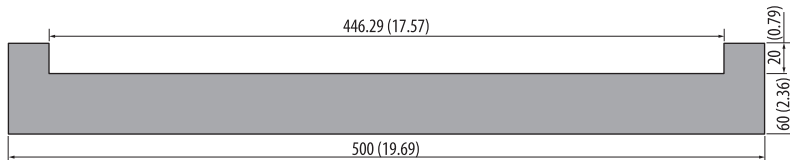
Type B = 55 (2.17)	500 mm	19.69 in	53.0 kg
	1000 mm	39.37 in	106.0 kg
	2000 mm	78.74 in	212.0 kg
	3000 mm	118.11 in	424.0 kg

Holders, available with flat bottom and with tang

42Cr: 900-1150 N/mm²



HAD120.300 for AD120.300



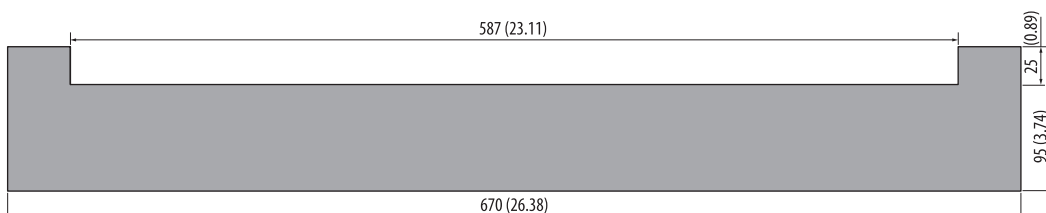
600 mm	23.62 in	99.0 kg
1200 mm	47.24 in	198.0 kg
2400 mm	94.49 in	396.0 kg
3000 mm	118.11 in	495.0 kg

Holder, available with flat bottom

42Cr: 900-1150 N/mm²



HAD150.400 for AD150.400



600 mm	23.62 in	230.0 kg
1200 mm	47.24 in	460.0 kg
2400 mm	94.49 in	920.0 kg
3000 mm	118.11 in	1,150.0 kg

Holder, available with flat bottom

42Cr: 900-1150 N/mm²



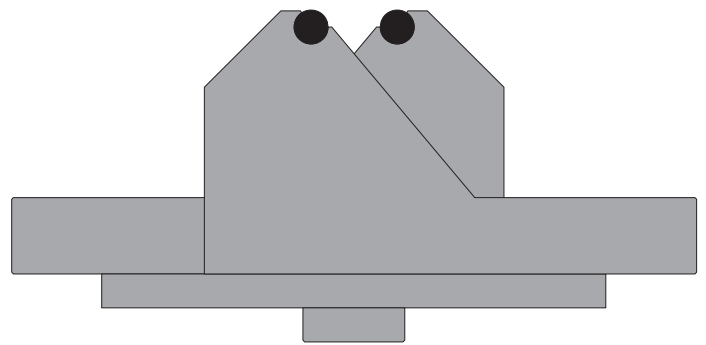
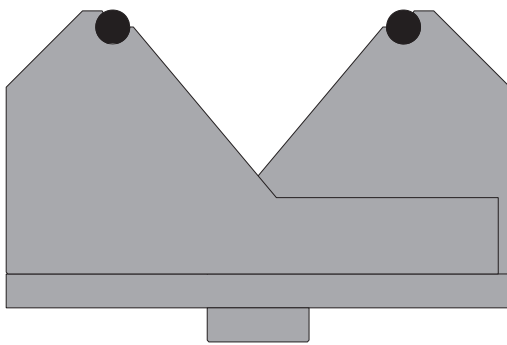
■ Are you looking for a versatile and easy-to use adjustable die?

NEW

Rolleri VARIO is the right solution to your needs!

- different tonnages and V-openings
- manual and motorize models
- modular length

If you need further information or if you want to ask for a quotation, do not hesitate to contact us!



■ Panel bending tools

■ Our Advantages – Your Convenience

- in-house construction (no reseller or dealer)
- production according to your specifications
- every single tool is traceable thanks to a unique serial number stamped after the first quality control
- precision grinding (tolerance of ± 0.01 mm)
- exact parallelism
- use of the best materials, guaranteed high resistance and tensile strength



Rolleri BLACKFIRE

Rolleri BLACKFIRE is a particular tool coating which guarantees corrosion resistance and special design.

This chemical treatment is a long-lasting solution to surface oxidation.

During the phosphatising process, the metal surface of tools changes because of phosphatic crystals formation, which are chemically bound to the tool steel. We can take advantage of these chemical compounds to increase corrosion resistance, so that your tools will have longer operational life.

The glossy black colour of BLACKFIRE represents a new technology which combines usage advantages and better aesthetics.

Tools with BLACKFIRE treatment have different delivery time than standard tools.

Our Advantages – Your Convenience

- no corrosion
- easy and fast tool change
- new design
- longer tool operational life



Rolleri FreeZinc

Our Advantages – Your Convenience

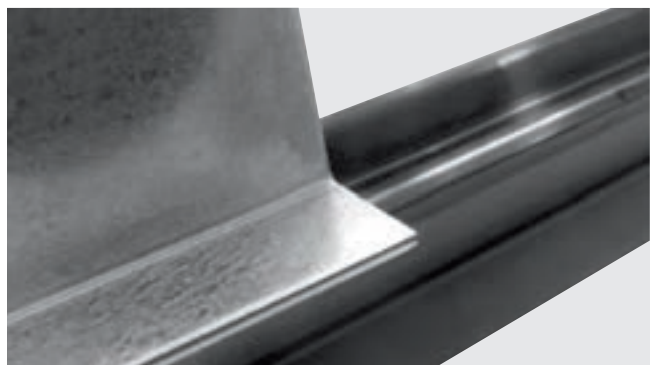
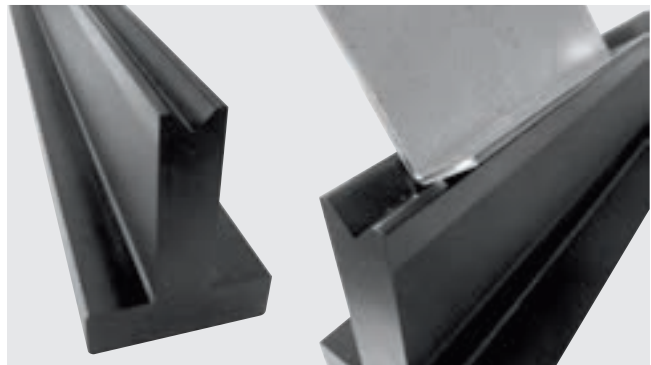
Take advantage of Rolleri new and special surface treatment.

This new improvement gives you the following big advantages:

- No metal residue left on tools during bending of galvanized sheet metal or other sheet metal that tends to leave residue
- No need to clean tools from residue
- Down-time reduction due to tool cleaning and consequently increase in productivity
- Tool protection from oxidation
- Tools aesthetically stand out
- Reduced tool wear and consequently longer operational life
- Lower chances to damage the sheet metal
- Lower risk that the sheet metal gets stuck in the V die opening

If you are interested in this treatment, don't hesitate to contact us!

NEW



Article on stock

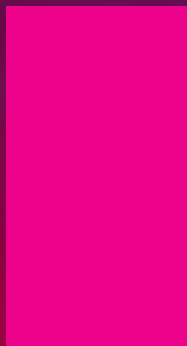
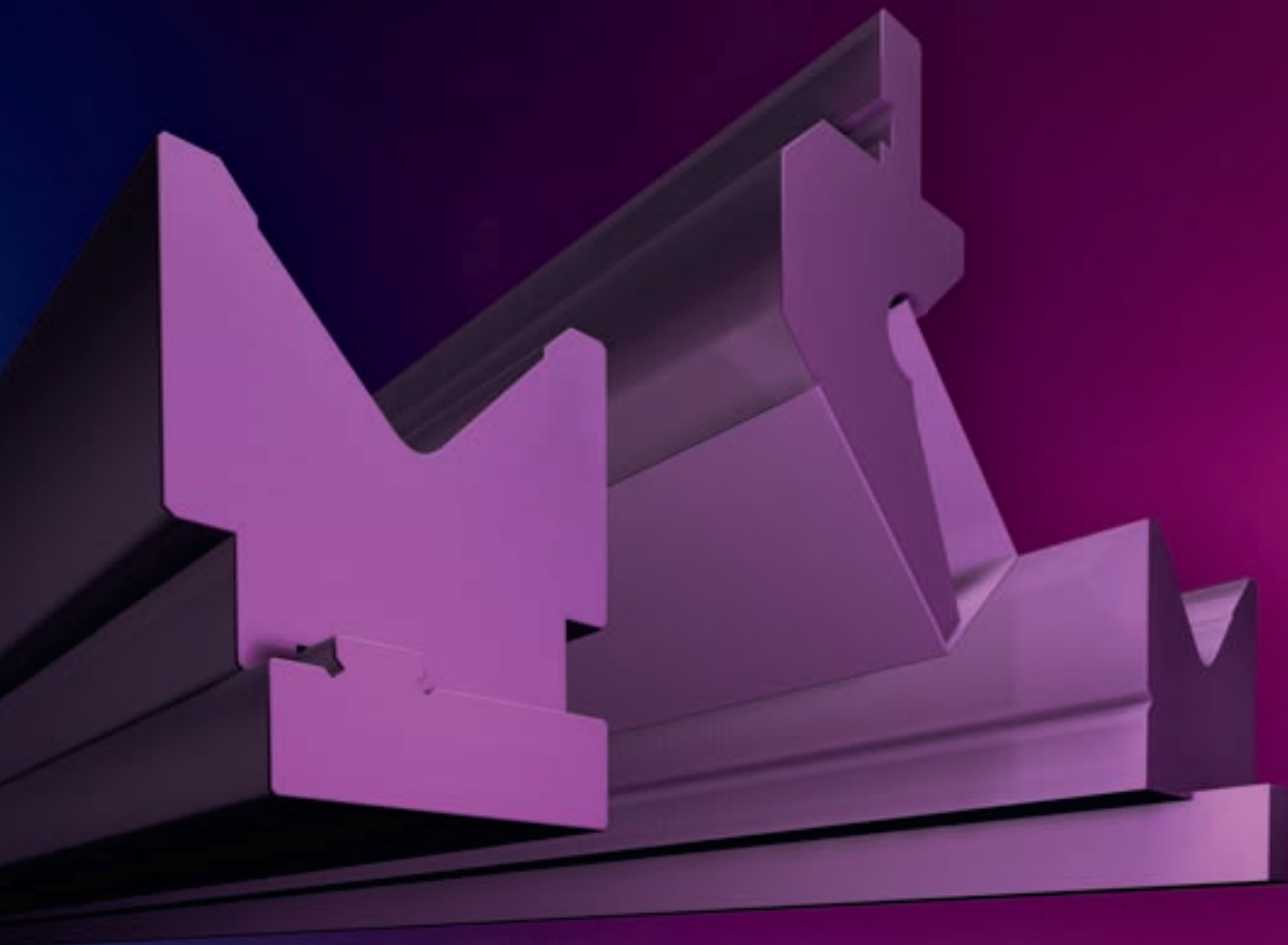
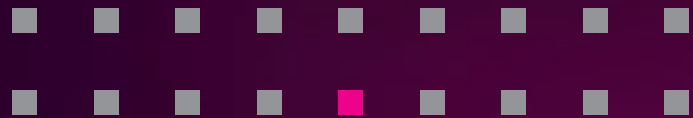


Please ask for delivery time!

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



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





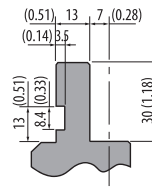
ROLLERI MODIFICATIONS

Modified Tangs	264 - 265
Special Sectioning	266
Horn Pieces	266
Modifying the V-Opening	266
Radius and Angle Modification	267
Grooves for Dies	267
Grooves and bars for dies	268
Gaps and Windows	269

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, convenient, precise

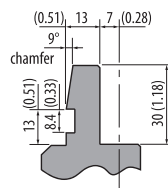
Standard Rolleri Type R1



Fast delivery of these items guaranteed. Please note that delivery terms vary according to your location.

OT

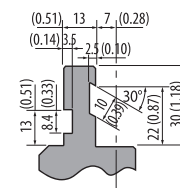
- Modification for:
- for Amada fast clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A1

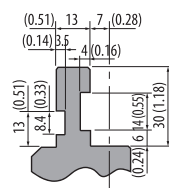
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- pneumatic clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A6

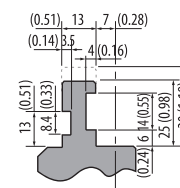
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- Rolleri Type R3
 - Bystronic-Beyeler Euro
 - Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A7

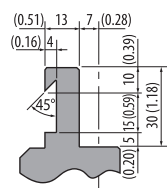
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
- Rolleri Type R3
 - Bystronic-Beyeler Euro
 - Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A8

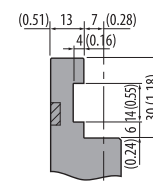
- Groove for:
- hydraulic clamping system Gasparini



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A41

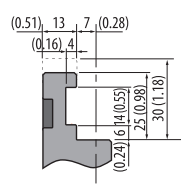
- older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A42

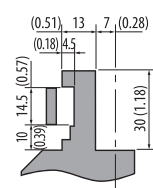
- older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

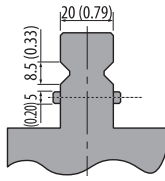
A43

- Groove with steel bar for:
- segmented punches

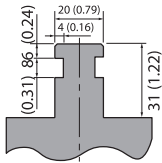


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

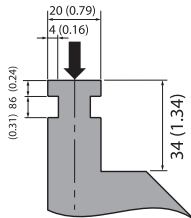
Standard Roller Type R2



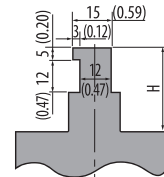
Modification examples Type R2



modification of Roller R2 type punch with shoulder bearing

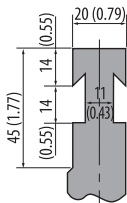


modification of Roller R2 type punch with head bearing

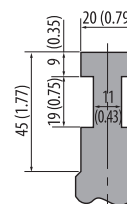
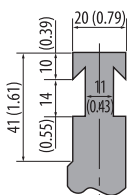


By modifying your existing tools, you can use them in other press brakes!

Standard Roller Type R3



Modification examples Type R3



ROLLERI MODIFICATIONS

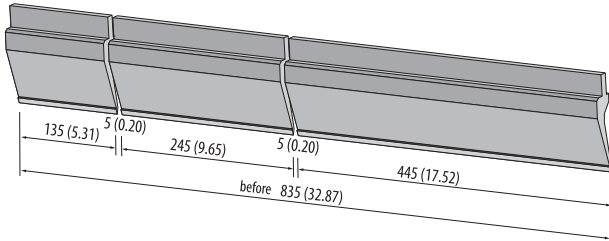
Special Sectioning

- Individual sectioning of your punches and dies
- fast, convenient, precise

Every cut wastes about 5 mm material.

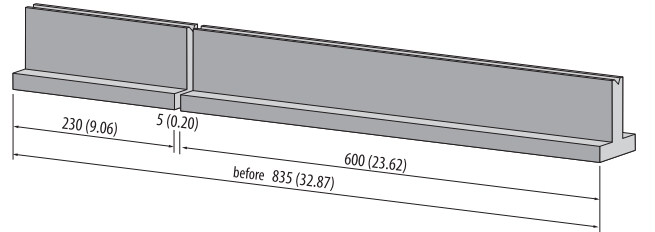
Special Sectioning of Punches

Example of punches production according to your specifications



Special Sectioning of Dies

Example of Dies production according to your specifications

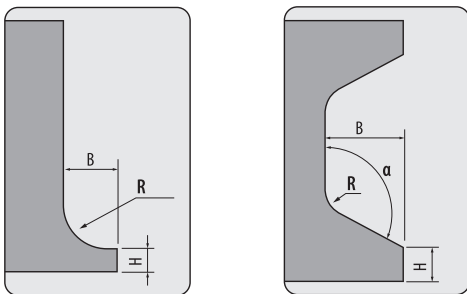


Horn Pieces

- individual horn pieces on punches and dies
- on one or both sides
- fast, convenient, precise

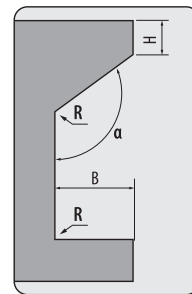
Horn Pieces for Punches

Punch example production according to your specifications



Horn Pieces for Dies

Die example production according to your specifications

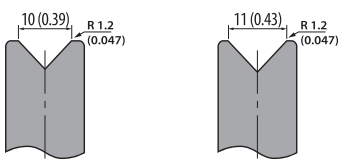


Modifying the V-Opening

- individual modification for dies
- fast, convenient, precise

Modifying the V-Opening

Example production according to your specifications

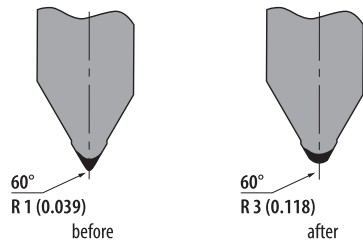


Give us a call for more information!

- Individual modifications of your punches and dies
- fast, convenient, precise

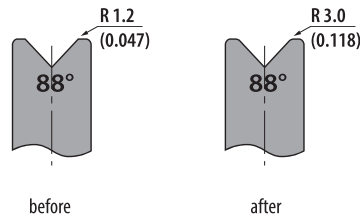
Radius Modifications for Punches

Radius modification Punch example production according to your specifications



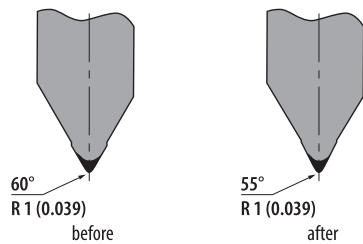
Radius Modifications for Dies

Opening Radius modification die example production according to your specifications



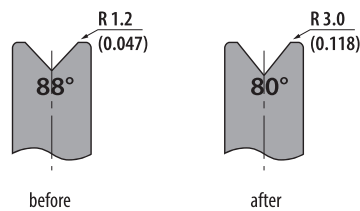
Angle Modification Punches

Angle modification punch example production according to your specifications



Angle Modification Dies

Angle modification die example production according to your specifications

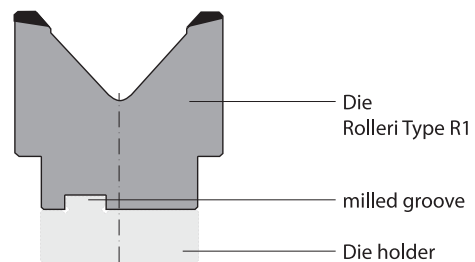


Grooves for Dies

- Milling of grooves to use in other press brakes
- fast, convenient, precise

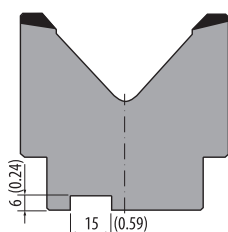


Mounting example



A28

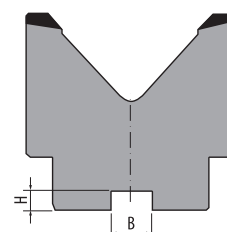
Groove for die holder



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A29

groove production according to your specifications



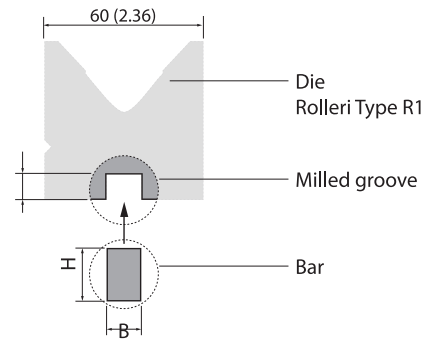
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

ROLLERI MODIFICATIONS

Grooves and bars for dies

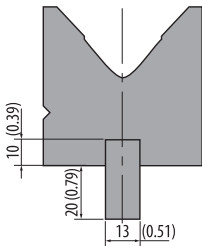
- Rolleri can mill a groove in the die base and insert a bar of the correct dimensions to use the die in a different clamping system
- fast, convenient, precise

Mounting example



A30

- Groove Bars:
13 x 30 mm (0.51 x 1.18 in) for
- Rolleri Type R2
 - Rolleri Type R3

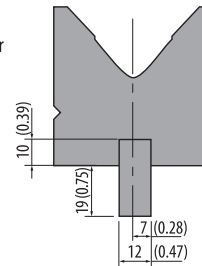


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A31

- Groove Bars:
12 x 29 mm (0.47 x 1.14 in) for
- Rolleri Type RX LVD

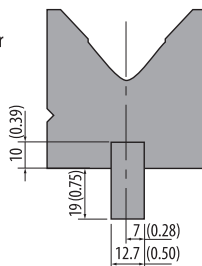


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A32

- Groove Bars:
12.7 x 29 mm (0.50 x 1.14 in) for
- Rolleri Type RX LVD

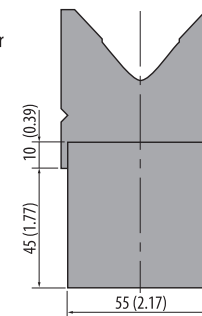


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A44

- Groove Bars:
55 x 55 mm (2.17 x 2.17 in) for
- Rolleri Type RX EHT

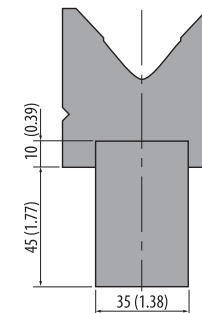


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A45

- Groove Bars:
35 x 55 mm (1.38 x 2.17 in) for
- Rolleri Type RX Weinbrenner

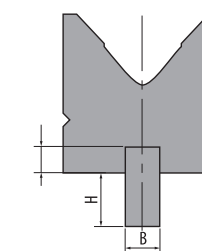


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



AX

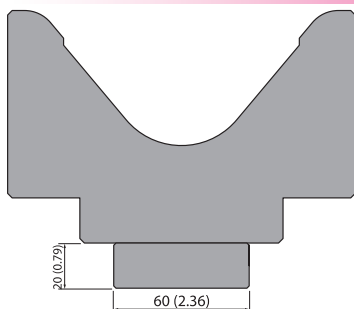
- individual Groove Bars
for other systems



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented



A60

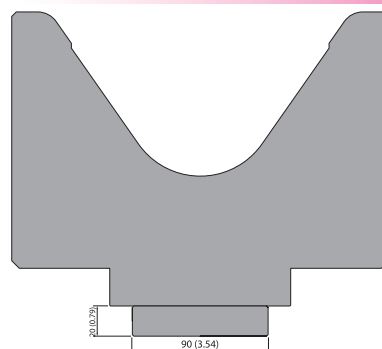


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

- plate for Rolleri R1
Type dies
- M103.80.125,
 - M130.80.160 and
 - M195.70.200



A90



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

- plate for Rolleri R1
Type dies
- M195.70.200
and for Rolleri
Rolla-V die
 - RVM90-4

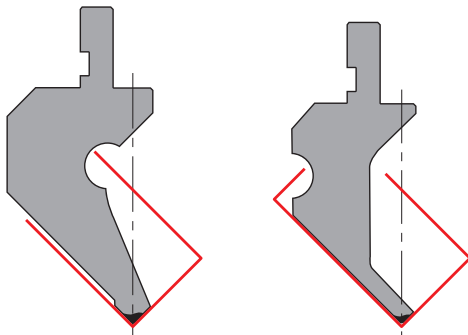


- Tool modifications to bend C profiles, U profiles or other special profiles without collisions
- fast, convenient, precise



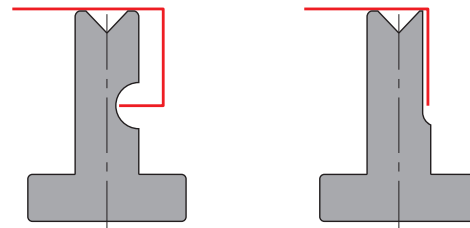
Gaps on Punches

Example Punches
production according to your specifications



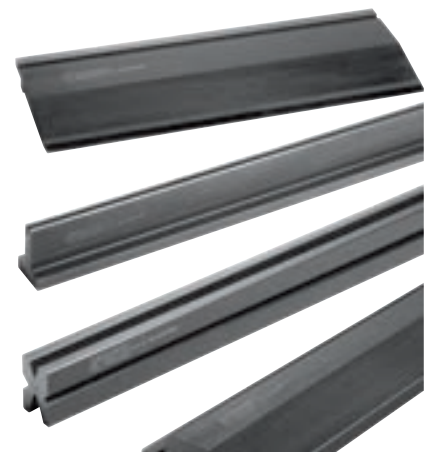
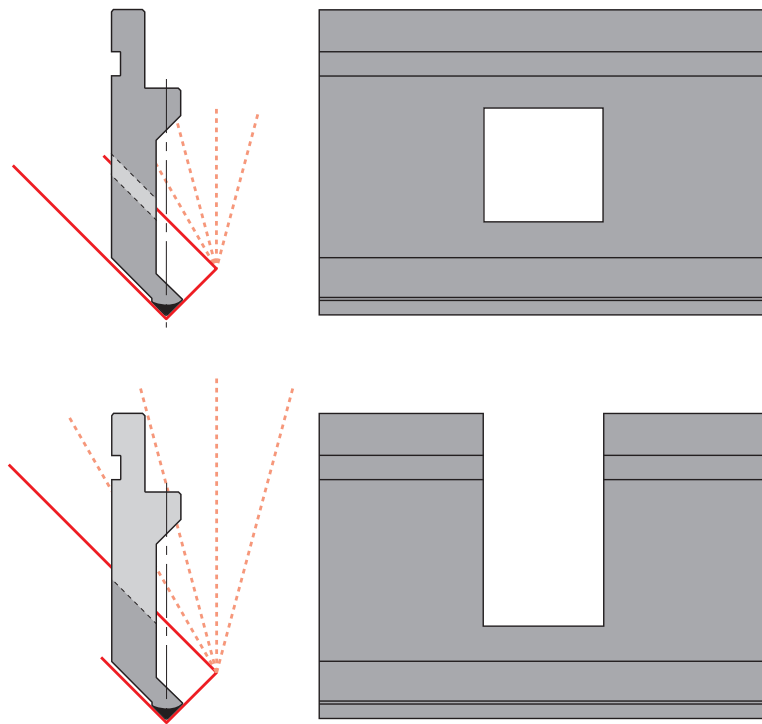
Gaps on Dies

Example Dies
production according to your specifications



Windows for Punches

Example Punches
production according to your specifications



For Rolleri BLACKFIRE
and Rolleri FreeZinc
see page 261



Article
on stock



Please ask for
delivery time!

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



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



ROLLERI ACCESSORIES AND SHEAR BLADES

Tooling Cabinets	272 - 273
Tool Trolley	274
Bending Box	274
Squaring Arms	275
Supporting Arms	276
Back Gauge	276
Shear Blades	276 - 277

Our Advantages – Your Convenience

- Protection against contamination and damage
- Easy access to tools
- Robust construction
- Clear and tidy storage
- Grooves in the construction to position easily the cabinet by means of fork lift trucks
- Painted shelves with variable positioning into drawers



Rolleri Videos

Tool storage demonstration at:
www.rolleritools.com/videos/tooling-cabinets



ARM 835-4 for max. tool length = 835 mm (32.87 in)



850 x 1240 x 1050 (W x H x D)
 33.46 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1
 approx. 20 m (787.40 in)
 Storage capacity



Equipment	
4 Drawers	vertical, on wheels (see CS-1)
16 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
4 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	271.0 kg

ARM 835-5 for max. tool length = 835 mm (32.87 in)



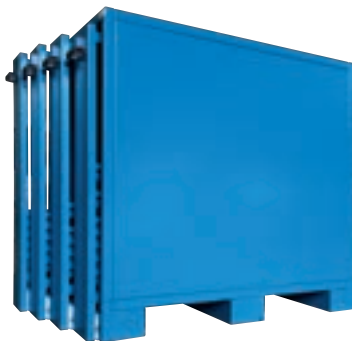
1040 x 1240 x 1050 (W x H x D)
 40.94 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1
 approx. 25 m (984.25 in)
 Storage capacity



Equipment	
5 Drawers	vertical, on wheels (see CS-1)
20 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
5 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	350.0 kg

ARM 1060-4 / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)
 33.46 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3
 approx. 26 m / 39 m (1023.62 in /
 1535.43 in) Storage capacity



Equipment ARM 1060-4	
4 Drawers	vertical, on wheels (see CS-2)
16 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
4 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	340.0 kg

Equipment ARM 1060-4-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	351.0 kg

Equipment ARM 1060-4.13	
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)
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

Equipment ARM 1060-5.13	
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)
Weight	490.0 kg

ARM 1060-4-T / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)
33.46 x 48.82 x 53.54 (W x H x D)

for tools Roller Type R2/R3
approx. 20.8 m / 31.2 m (818.89 in / 1228.34 in) Storage capacity

ARM 1060-5-T / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)
40.94 x 48.82 x 53.54 (W x H x D)

for tools Roller Type R2/R3
approx. 26 m / 41.6 m (1023.62 in / 1637.79 in) Storage capacity

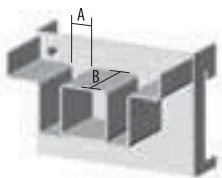
Equipment ARM 1060-4-T	
4 Drawers	vertical, on wheels (see CS-2)
8 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	383.0 kg

Equipment ARM 1060-5-T	
5 Drawers	vertical, on wheels (see CS-2)
10 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
10 Shelves	for type R2/R3 (see shelves UT-4)
Weight	447.0 kg

Equipment ARM 1060-4-T-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
16 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	360.0 kg

Equipment ARM 1060-5-T-CV	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
24 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	500.0 kg

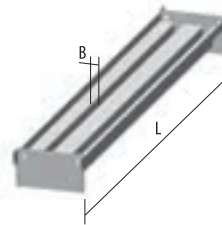
UC-Shelves



Model	L mm (in)	A mm (in)	B mm (in)	Weight
UC-13-1	125 (4.92)	13 (0.51)	76 (2.99)	0.5 kg
UC-13-2	250 (9.84)	13 (0.51)	232 (9.13)	1.0 kg
UC-20-1	125 (4.92)	20 (0.79)	76 (2.99)	0.5 kg
UC-20-2	250 (9.84)	20 (0.79)	232 (9.13)	1.0 kg

2 pieces

UL-Shelves



Model	L mm (in)	B mm (in)	Weight
UL-13-1	270 (10.63)	13 (0.51)	1.2 kg
UL-13-2	580 (22.83)	13 (0.51)	2.5 kg
UL-13-3	1050 (41.34)	13 (0.51)	4.6 kg
UL-13-4	1360 (53.54)	13 (0.51)	6.0 kg
UL-20-1	270 (10.63)	20 (0.79)	1.4 kg
UL-20-2	580 (22.83)	20 (0.79)	3.2 kg
UL-20-3	1050 (41.34)	20 (0.79)	5.8 kg
UL-20-4	1360 (53.54)	20 (0.79)	7.5 kg

UT-Shelves



Model	L (mm)	L (in)	Weight
UT-1	270	10.63	1.4 kg
UT-2	580	22.83	3.2 kg
UT-3	1050	41.34	5.8 kg
UT-4	1360	53.54	7.5 kg

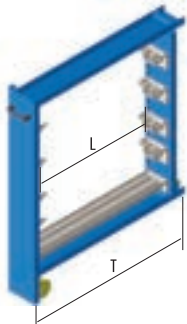
enough room for punches with safety pins

UV-Shelves



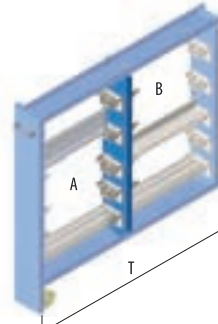
Model	L (mm)	L (in)	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg

CS-Drawers



Model	T mm (in)	L mm (in)	Weight
CS-1	1050 (41.34)	856 (33.70)	22.0 kg
CS-2	1360 (53.54)	1166 (45.91)	25.0 kg

CV-Dividers



Model	T mm (in)	A mm (in)	B mm (in)	Weight
CV-1	1050 (41.34)	580 (22.83)	270 (10.63)	7.0 kg
CV-2	1360 (53.54)	580 (22.83)	580 (22.83)	7.0 kg

ROLLERI ACCESSORIES

Tool Trolley

Our Advantages – Your Convenience

- easy access to tools
- robust construction
- clear and tidy storage
- tools clearly visible

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



Bending Box

Bending Box

per piece 1.6 kg



All necessary measuring instruments for a press brake operator!

It contains PRECISION DIGITAL CALIPER, SET SQUARE, AND ANGLE MEASURING DEVICE.



■ **Our Advantages – Your Convenience**

- easy and fast positioning
- precise and flexible adjustability
- adjustable angle stop
- mountable on all dies
- ideal for long and thin sheet metals



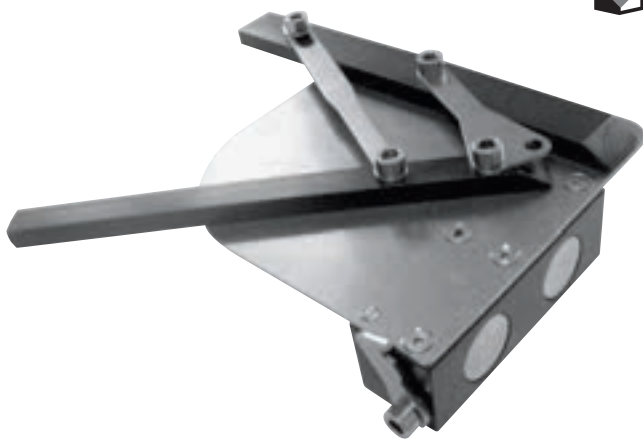
Rolleri Videos

Magnetic Squaring Arms :
[www.rolleritools.com/
videos/squaring-arms](http://www.rolleritools.com/videos/squaring-arms)



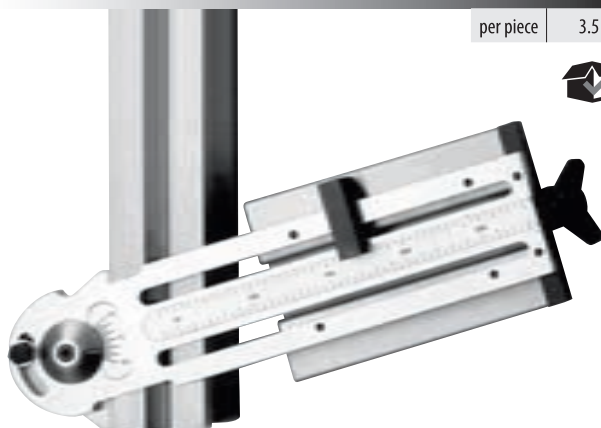
MSA – magnetic

MSA.D (right)	per piece	1.4 kg
MSA.S (left)	per piece	1.4 kg



AS

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



AS FIX

per piece	3.0 kg
-----------	--------



Article on stock



Please ask for delivery time!

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



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

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



- to position big sheet metal correctly
- 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



- it guarantees the correct positioning of the sheet metal and the subsequent correct profile flange
- fast and exact repeatability
- easy handling

Give us a call for more information!

Shear Blades

Rolleri has been producing shear blades for more than 20 years.

To produce shear blades we use high quality steel to guarantee reliability and wear resistance.

New production and retrofitting service: fast, convenient, 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?
- How often do you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

Our Advantages – Your Convenience

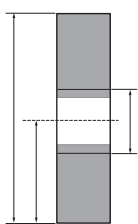
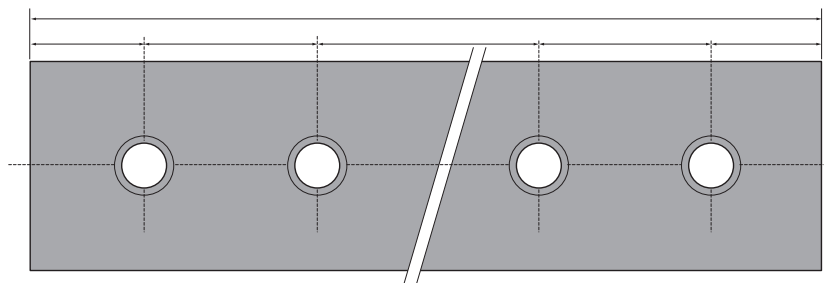
- own production
- custom production
- depending on the cutting material
- high quality Materials
- 4-, 2- or 1-cutting edges
- with threaded holes or dimpled holes



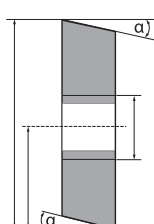
available sizes mm (in)				
50 x 10 (1.97 x 0.39)	55 x 12 (2.17 x 0.47)	60 x 12 (2.36 x 0.47)	65 x 13 (2.56 x 0.51)	70 x 13 (2.76 x 0.51)
50 x 11 (1.97 x 0.43)	55 x 13 (2.17 x 0.51)	60 x 13 (2.36 x 0.51)	65 x 14 (2.56 x 0.55)	70 x 14 (2.76 x 0.55)
50 x 12 (1.97 x 0.47)	55 x 14 (2.17 x 0.55)	60 x 14 (2.36 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)		



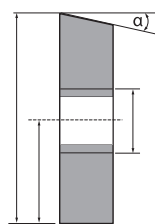
available sizes mm (in)				
75 x 15 (2.95 x 0.59)	80 x 16 (3.15 x 0.63)	85 x 18 (3.35 x 0.71)	90 x 20 (3.54 x 0.79)	100 x 20 (3.94 x 0.79)
75 x 16 (2.95 x 0.63)	80 x 18 (3.15 x 0.71)	85 x 19 (3.35 x 0.75)	90 x 21 (3.54 x 0.83)	100 x 22 (3.94 x 0.87)
75 x 17 (2.95 x 0.67)	80 x 19 (3.15 x 0.75)	85 x 20 (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)				



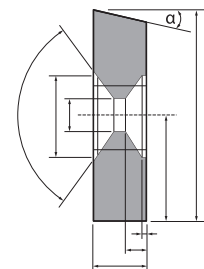
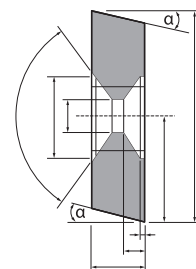
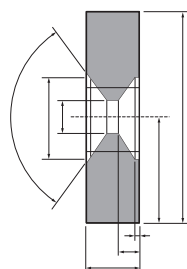
4-sharp



2-sharp



1-sharp



 **ROLLERI®**





ABOUT **US** / VARIOUS INFORMATION

Company	280 - 281
Professional Bending	282 - 283
Production Department	284 - 285
U-Table	286 - 289
Press Force Table	290
Web site	291



Since 1987 we have been producing standard and special tooling. The family owned company (Francesco and Marco Rollerri) can nowadays be considered one of the largest press brake tooling manufacturers in Europe. We offer a fast and reliable service through our partners all over Europe.

The reorganization of our sales force, happened in 2012, has guaranteed a widespread presence of our products in every single market.

In order to give the best delivery times to our customers all over the world, our production has been enlarged considerably with an additional hall and many new machines in the year 2016.



Rolleri Videos

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



ROLLERI IN THE WORLD

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



TEAM

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

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

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

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

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

giving you great support is our daily business!

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



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

WAREHOUSE

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



Look for this symbol in the catalogue!



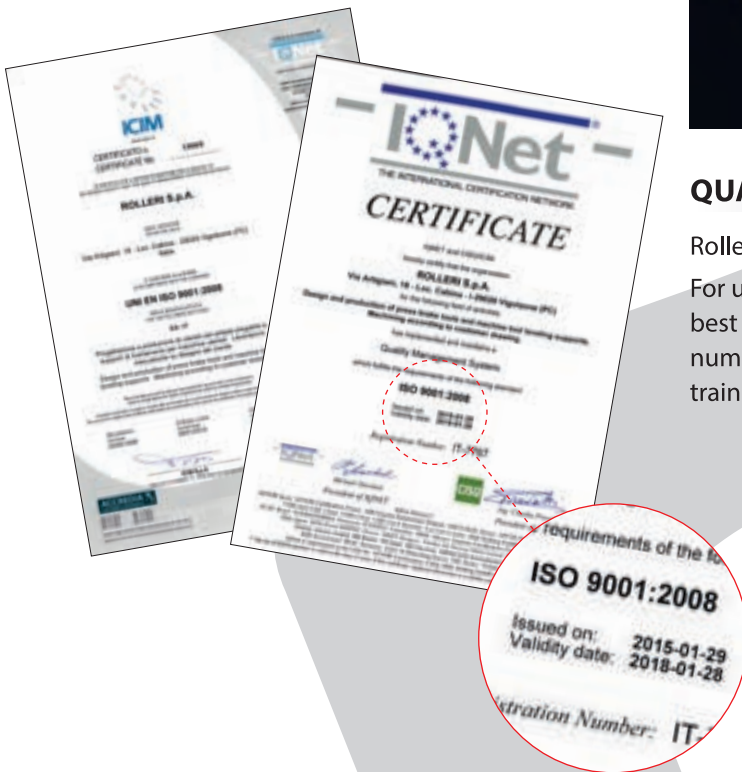
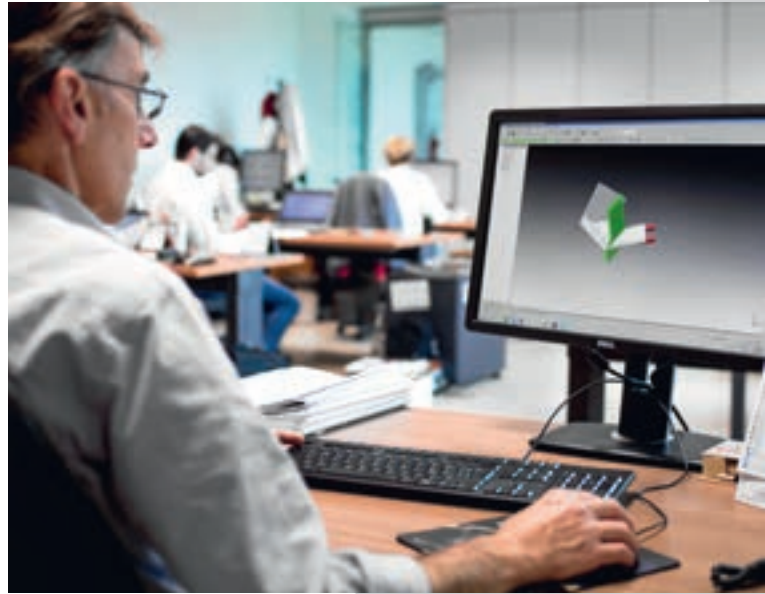
MANUFACTURING

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

Technicians and engineers develop for you convenient and practical solutions.

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

Send us your enquiry today!



QUALITY

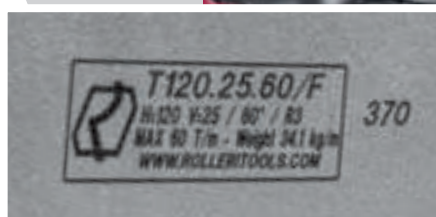
Rolleri is ISO 9001:2008 certified.

For us, being your supplier means helping you to find the best and most convenient tool and to develop a large number of bending solutions. Furthermore, we offer training for your bending department employees.

QUALITY CONTROL

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

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





RAW MATERIAL

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.

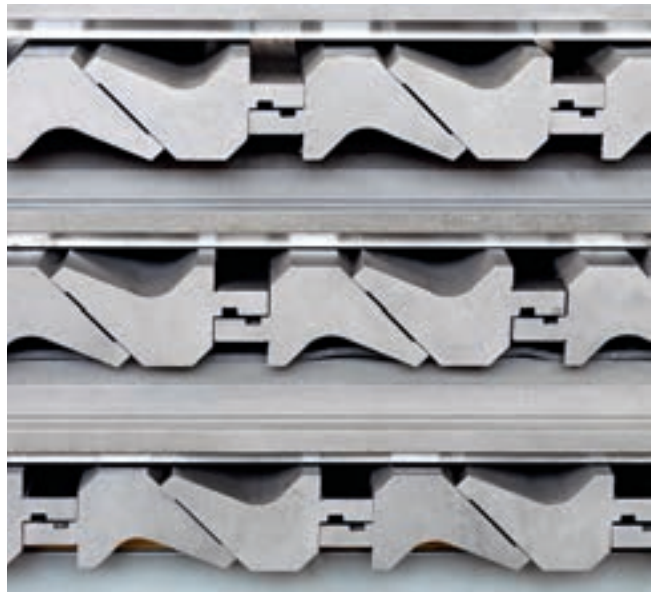
PRESS BRAKE TOOLS

Every tool is manufactured in Rolleri's production facilities.

This enables us to guarantee high quality, repeatability and parallelism thanks to high precision grinding.

We use induction hardening at 54-60 HRC for all tools to get the best results for your punches and dies.

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



INNOVATIONS

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

Our new QuickLock-System, compatible with Rolleri tools Type R2 and our new ROL200 compatible with Rolleri tools type R1, are innovations developed and manufactured in our production facilities.

■ Our machinery

Our comprehensive machinery with state-of-the-art technology guarantees the production of high quality tools.

In addition to the manufactured standard and special tools, we carry out all modifications according to your requirements.

Take advantage of good prices of tool modification to improve the use of your existing tools!



■ CNC-Milling

With our state-of-the-art milling centers we can quickly modify tools with high precision.

Very flexible tilting machine heads can carry out a wide variety of processes.

This is where, grooves, gaps, and other machining types are carried out.

■ CNC-Profile Grinding

Our CNC-Professional grinding machines guarantee high precision (tolerance of ± 0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tools. Radius and angle modifications are precisely carried out upon request.





■ Hardening

The tool working areas are exposed to the highest mechanical stress, because the press brake force is concentrated on small surfaces. For this reason, the press force on tool working areas is very high and it results in high friction between tools and sheet metal to be bent.

In order to have more resistant tools, their surface can be hardened. Rolleri uses induction hardening, which penetrates about 3mm into the tool steel, to guarantee high wear resistance and to offer customers the best solution to competitive prices.

■ Quality Control and Serial numbers

During the production process, every single tool produced by Rolleri is marked with a unique serial number, which guarantees its full traceability. This enables us to certify that all Rolleri tools of the same model in the market have exactly the same dimensions (angle, radius, hardening...).



■ EDM

By using electro-discharge machines, Rolleri can machine hardened and tough materials. This process is based on the definition of the tool shape with a high precision CAD software and the manufacturing of simple and complicated shapes.

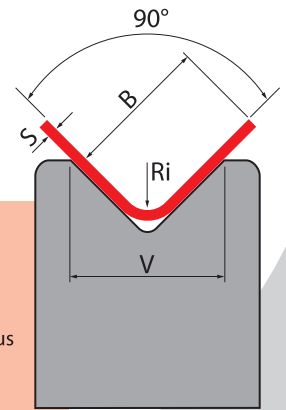
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-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	-------	--------	--------	-------	-------	-------	-------	-------	-------	-------	-------	-------	--------	--------	-------	-------	-------	-------	-------	-------

Press Force Table

The press force table works exactly in the same way as the bending ruler and is very useful to those who deal with sheet metal profiles. It can assist you from the design of profiles, to technical construction, to the buying of tools, and to the finished profile made with a press brake.

In the first column on the left the thickness of the sheet metal is marked as (S). In the three first lines you can find the die V opening (V), the minimum internal edge (B), and the ideal inner profile radius (Ri).

By crossing the thickness with the die opening, you will find the necessary press force per meter. As you can see, for each sheet metal thickness you can choose among 5 different V openings. On the bottom of the page you can find correction factors.



S = Thickness
 V = Die V opening
 B = Min. internal edge
 Ri = Inner Profile Radius

420 N/mm ²																					
S (mm)	4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V	
	3.0	3.5	4.0	5.5	6.5	8.0	10.5	13.0	16.5	21.0	26.0	32.5	41.0	52.0	65.0	81.5	104.0	130.0	163.0	B	
	0.5	0.7	0.8	1.0	1.3	1.5	2.0	2.5	3.2	4.4	5.0	6.5	8.0	10.0	12.0	15.0	20.0	25.0	37.0	Ri	
0.6	60	50	30	20																	
0.8	120	90	70	50	40																
1.0		150	110	80	60	50															
1.2			180	120	90	70	50														
1.5				210	150	120	80	60													
2.0					300	230	160	120	90												
2.5						390	270	200	140	110											
3.0							430	310	230	160	120										
4.0								600	440	320	230	180									
5.0									760	540	390	290	220								
6.0										850	620	450	330	250							
8.0											1210	880	700	460	350						
10.0												1510	1090	790	580	440					
12.0													1730	1240	910	660	500				
15.0		INOX – stainless steel R 700 N/mm ² Ton x 1.7												2130	1550	1130	810	620			
20.0		AL – aluminium R 200 N/mm ² Ton x 0.5														3020	2200	1580	1150	890	
25.0		(R = tensile strength)															3780	2690	1970	1440	

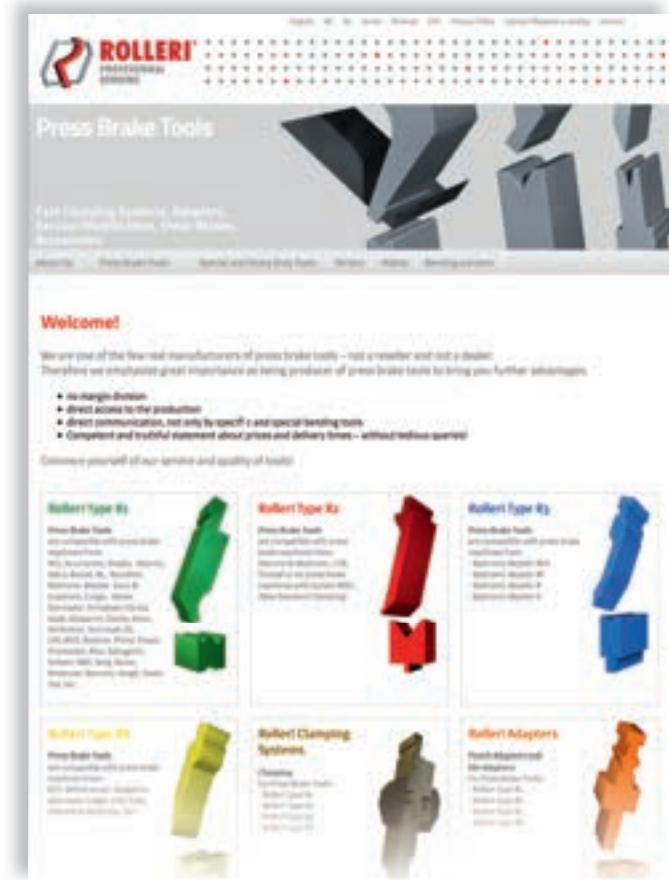
F
kN/m

30°	B x 1.6	R=200 N/mm ²	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm ²	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm ²	r x 1.4	INOX

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and take advantage of:

- drawings 1:1 format available
- extra information and tips
- helpful videos and application examples
- easy website browsing



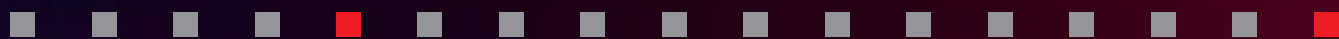
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