ROLLERI®

PROFESSIONAL
BENDING

PRESS BRAKE TOOLS

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

WELCOME …

… to the new Rolleri catalogue!

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

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

Convince yourself of our service and quality of tools!

THE COMPANY

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

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

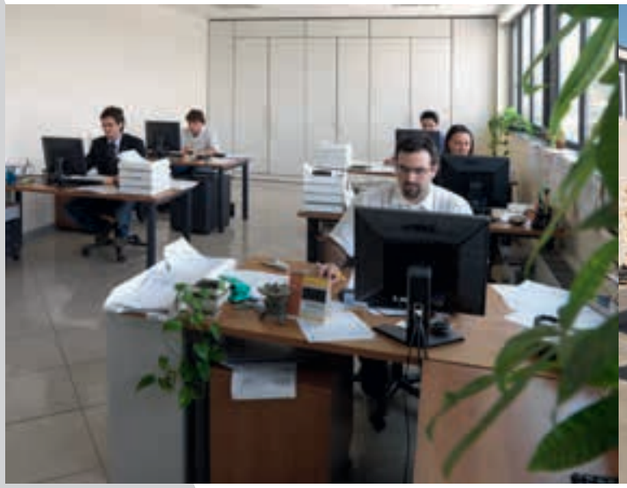
THE TEAM

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

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

Rolleri Videos

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



THE PRODUCTION

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

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

This is what we call accurate repitition.

THE WAREHOUSE

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

on stock — Look for this symbol in the catalogue!

THE SERVICE

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

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

this is our daily business bringing you great support!

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

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

THE CONSTRUCTION

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

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

Inquire with us today!

THE RAW MATERIAL

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

THE QUALITY

Rolleri ISO 9001:2008 certified.

To be your choice supplier means much more to us; together we can find the best and most economic tool and develop a vast number of bending solutions.

We also offer training for your employees in the bending department. These are qualities, where we are glad to assist you along with our extravagant number of bending products.

THE PRESS BRAKE TOOLS

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

THE QUALITY CONTROL

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

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

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

INNOVATIONS

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

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

ROLLERI®

Compatibility

Tools Rolleri Type R1

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

Tools Rolleri Type R2

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

Tools Rolleri Type R3

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

Tools Rolleri Type RX

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

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

PUNCHES ROLLERI TYPE R1

DIES ROLLERI TYPE R1

PUNCHES ROLLERI TYPE R2

DIES ROLLERI TYPE R2

PUNCHES ROLLERI TYPE R3

DIES ROLLERI TYPE R3

TOOLS ROLLERI TYPE RX

ROLLERI DIES ROLLA-V

ROLLERI CLAMPING SYSTEMS

ROLLERI ADAPTERS

ROLLERI MARK FREE BENDING

ROLLERI SPECIAL AND HEAVY DUTY TOOLS

ROLLERI SERVICE / MODIFICATIONS

ROLLERI SHEAR BLADES / ACCESSORIES

ROLLERI®

PUNCHES ROLLERI TYPE R1

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Compatibility

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

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

Compatibility

Punches Rolleri Type R1 are:

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

Our Advantages – Your Convenience

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

Material

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

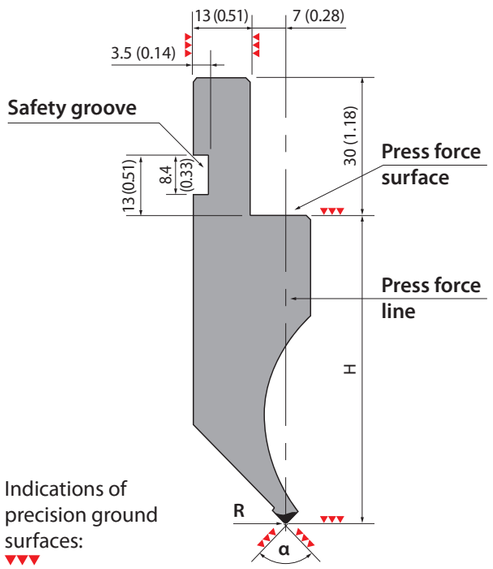
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

All punches Rolleri Type R1:

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

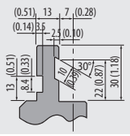


Indications of precision ground surfaces: ▼▼▼

Modifications from Safety Grooves

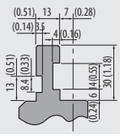
A1

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



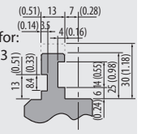
A6

Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan



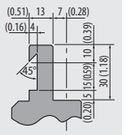
A7

Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan



A8

Groove for:
- hydraulic clamping Gasparini

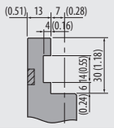


A9

Modified groove for:
- Rolleri Type R3

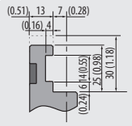
A41

Modified groove for:
- Rolleri Type R3



A42

Modified groove for:
- Rolleri Type R3



More modifications possible upon your request!

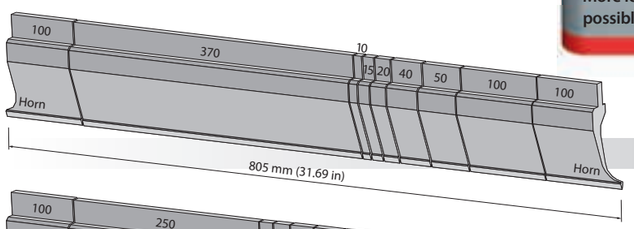
Give us a call or send us an inquiry!

Tool lengths and sectioning

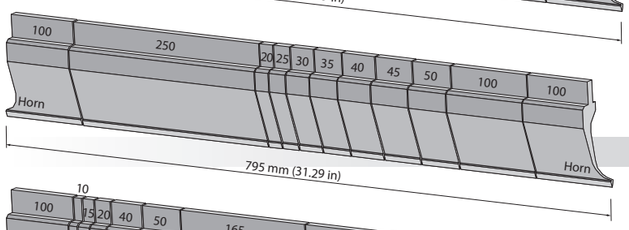
Standard

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

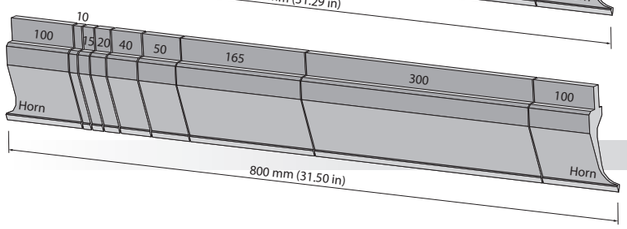
835 mm (32.87 in)
415 mm (16.34 in)
900 mm (35.43 in)



805 mm (31.69 in) segmented (9 segments)



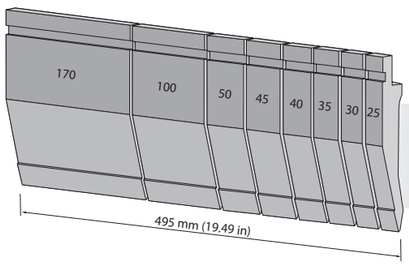
795 mm (31.29 in) segmented (11 segments)



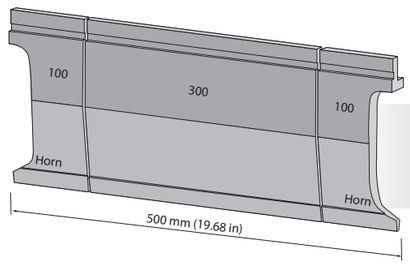
800 mm (31.50 in) segmented (9 segments)

Rolleri TOP-System

525 mm (20.67 in)

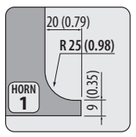


495 mm (19.49 in) segmented (8 segments)

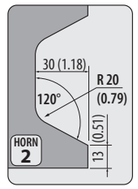


500 mm (19.68 in) segmented (3 segments)

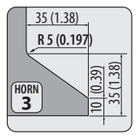
Horn Types



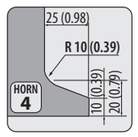
Horn 1
Standard
for all segm.
Punches Rolleri Type R1



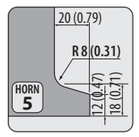
Horn 2
TOP
for all segm.
TOP Punches Rolleri Type R1



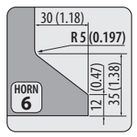
Horn 3
for punches:
00402
00430
11700
04702



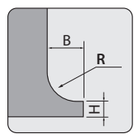
Horn 4
for punches:
20000
20200
10900
10906



Horn 5
for punches:
10300



Horn 6
for punches:
00300

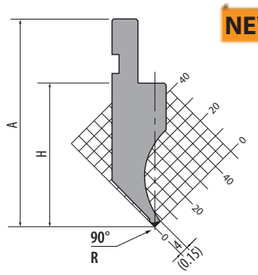


Horn individual
produced according to your specifications

PK.97.90.R06 / P.97.90.R025

350 kN/m max.

NEW

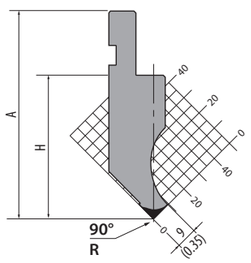


PK.97.90.R06	H=66.80 / A=96.80 / R=0.6 (H=2.63 / A=3.81 / R=0.024)		
	835 mm	32.87 in	10.5 kg
	415 mm	16.34 in	5.2 kg
	795 mm segmented	31.29 in segmented	10.0 kg
	805 mm segmented	31.69 in segmented	10.1 kg
P.97.90.R025	H=66.80 / A=96.80 / R=0.25 (H=2.63 / A=3.81 / R=0.010)		
	835 mm	32.87 in	10.5 kg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

42Cr: 900-1150 N/mm² HORN 1 on stock

PK.97.90.R08 / R025

1000 kN/m max.

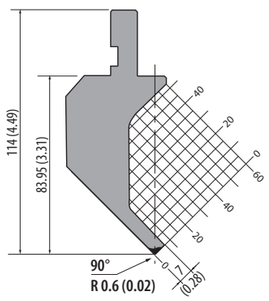


PK.97.90.R08	H=66.35 / A=96.35 / R=0.8 (H=2.61 / A=3.79 / R=0.031)		
	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.5 kg
	805 mm segmented	31.69 in segmented	10.5 kg
PK.97.90.R025	H=66.60 / A=96.60 / R=0.25 (H=2.62 / A=3.80 / R=0.010)		
	835 mm	32.87 in	11.0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

C45: 560-710 N/mm² HORN 1 on stock

PK.114.90.R06

200 kN/m max.

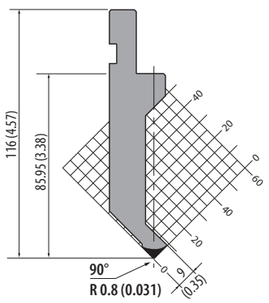


835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm² HORN 1 on stock

PK.116.90.R08

400 kN/m max.

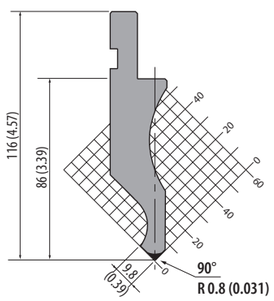


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm² HORN 1 on stock

DK.116.90.R08

500 kN/m max.

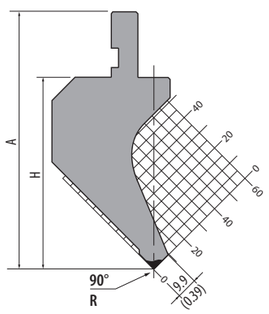


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.4 kg

C45: 560-710 N/mm² HORN 1 on stock

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 on stock

Rolleri Videos

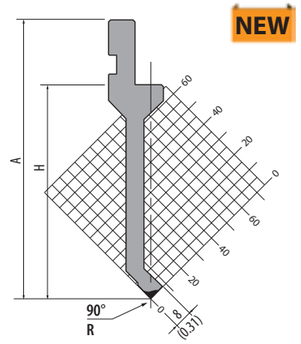
find updated and helpful videos at:
www.rolleritools.com/videos/overview

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

P.130.90.R06 / R025

350 kN/m max.

NEW

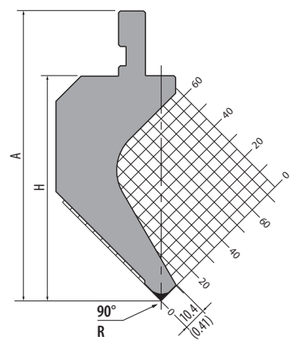


P.130.90.R06	H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024)		
	835 mm	32.87 in	11.5 kg
	415 mm	16.34 in	5.7 kg
	795 mm segmented	31.29 in segmented	10.9 kg
	805 mm segmented	31.69 in segmented	11.0 kg
P.130.90.R025	H=100.00 / A=130.00 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
	835 mm	32.87 in	11.5 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 HORN 1 on stock

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 HORN 1 on stock

90° Segmented Punches with Mobile Horns

Area of Application

- for easy bending of special box profiles

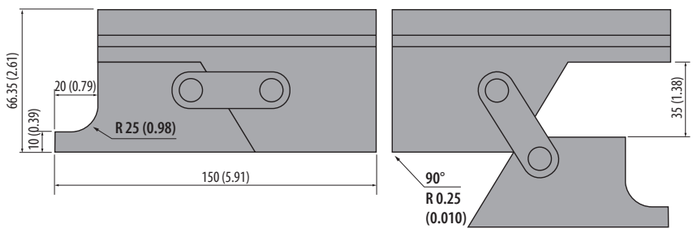
Rolleri Videos

mobile horn demonstration at:
www.rolleritools.com/videos/mobile-horns

SCA.M.90.R08

150 kN/m max.

NEW



per pair	3.5 kg

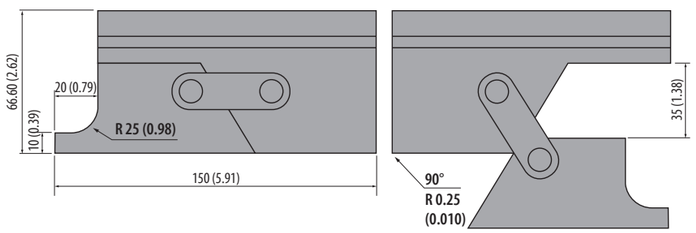
1 Pair left/right compatible with PK.97.90.R08

C45: 560-710 N/mm²

SCA.M.90.R025

150 kN/m max.

NEW



per pair	3.5 kg

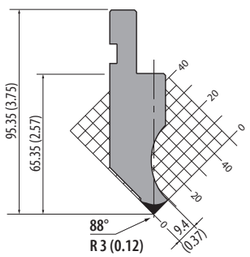
1 Pair left/right compatible with PK.97.90.R025

C45: 560-710 N/mm²

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (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

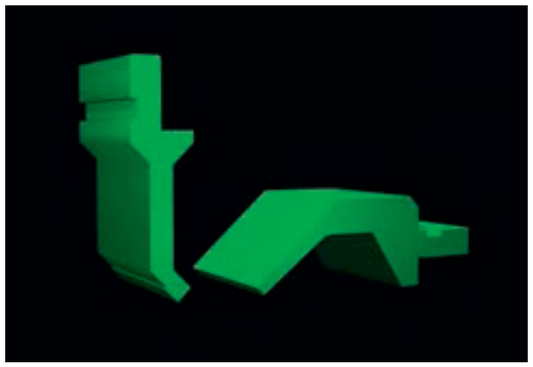
1000 kN/m max.



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

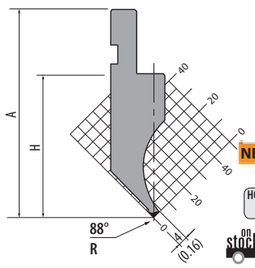
C45: 560-710 N/mm²

HORN 1 — on stock



P.97.88.R06 / R025

350 kN/m max.



NEW

HORN 1 — on stock

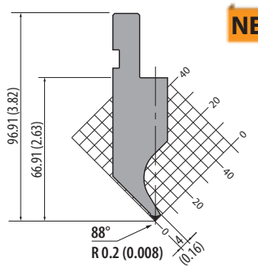
42Cr: 900-1150 N/mm²

P.97.88.R06	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

P.97.88.R025	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

11700

200 kN/m max.



NEW

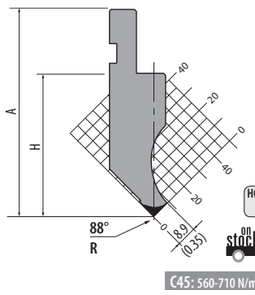
835 mm	32.87 in	10.7 kg
415 mm	16.34 in	5.3 kg
795 mm segmented	31.29 in segmented	10.2 kg
800 mm segmented	31.50 in segmented	10.3 kg

42Cr: 900-1150 N/mm²

HORN 3

P.97.88.R08 / PK.97.88.R025

1000 kN/m max.



HORN 1 — on stock

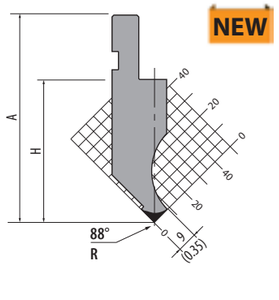
C45: 560-710 N/mm²

P.97.88.R08	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

PK.97.88.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	10.6 kg
	900 mm	35.43 in	11.8 kg

00402 / 00430

1000 kN/m max.



NEW

00402	H=66.90 / A=96.90 / R=0.2 (H=2.63 / A=3.81 / R=0.008)		
	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.5 kg
	800 mm segmented	31.50 in segmented	10.5 kg

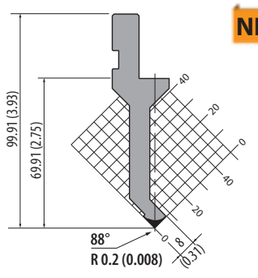
00430	H=65.68 / A=95.68 / R=3 (H=2.59 / A=3.77 / R=0.118)		
	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.5 kg
	800 mm segmented	31.50 in segmented	10.5 kg

C45: 560-710 N/mm²

HORN 3

20000

300 kN/m max.



NEW

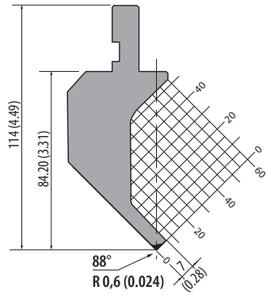
835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
800 mm segmented	31.50 in segmented	7.6 kg

42Cr: 900-1150 N/mm²

HORN 4

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

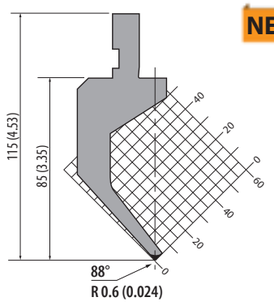
42Cr: 900-1150 N/mm²

HORN 1 — on stock

ROLLERI® PROFESSIONAL BENDING

P.115.88.R06

130 kN/m max.



NEW

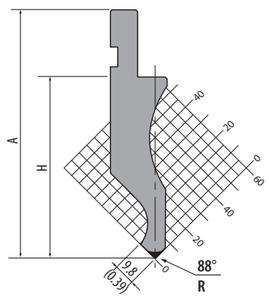
835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.7 kg
805 mm segmented	31.69 in segmented	5.8 kg

42Cr: 900-1150 N/mm²

HORN 1

D.116.88.R08 / R3

500 kN/m max.



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

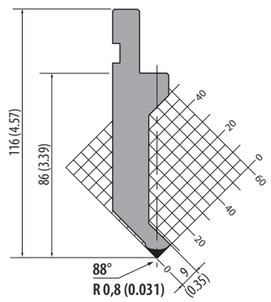
D.116.88.R3	H=85.00 / A=115.00 / R=3.0 (H=3.35 / A=4.53 / R=0.118)		
	835 mm	32.87 in	11.9 kg
	415 mm	16.34 in	5.9 kg
	795 mm segmented	31.29 in segmented	11.3 kg
	805 mm segmented	31.69 in segmented	11.5 kg

C45: 560-710 N/mm²

HORN 1 — on stock

P.116.88.R08

400 kN/m max.



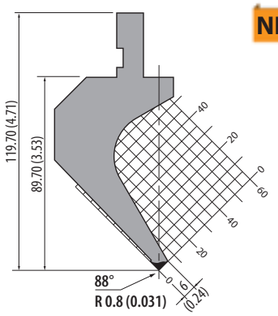
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.4 kg
805 mm segmented	31.69 in segmented	11.5 kg

C45: 560-710 N/mm²

HORN 1 — on stock

PS.120.88.R08

450 kN/m max.



NEW

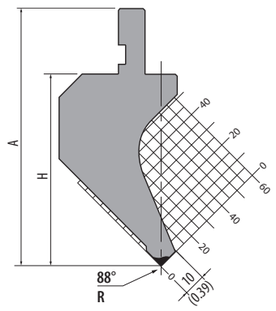
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg

C45: 560-710 N/mm²

HORN 1

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

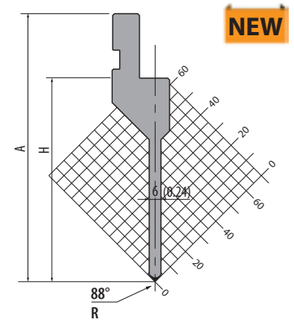
PK.120.88.R025	H=89.60 / A=120.00 / R=0.25 (H=3.53 / A=4.72 / R=0.010)		
	835 mm	32.87 in	21.0 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.0 kg
	805 mm segmented	31.69 in segmented	20.2 kg

C45: 560-710 N/mm²

HORN 1 — on stock

10900 / 10906

500 kN/m max.



NEW

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

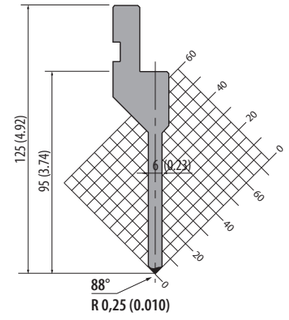
10906	H=94.74 / A=124.74 / R=0.6 (H=3.73 / A=4.91 / R=0.024)		
	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	800 mm segmented	31.50 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

HORN 4

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

HORN 1 — on stock

on stock Article on stock

Please ask for delivery time!

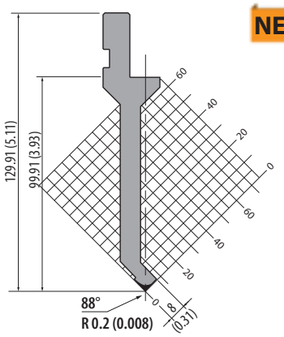
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

20200

300 kN/m max.

NEW



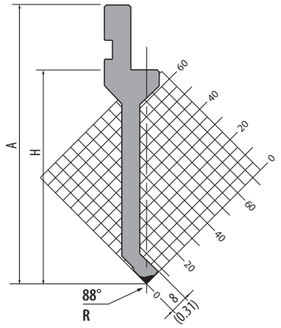
835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
800 mm segmented	31.50 in segmented	9.6 kg

42Cr: 900-1150 N/mm²

HORN 4

P.130.88.R06 / PK.130.88.R025

350 kN/m max.



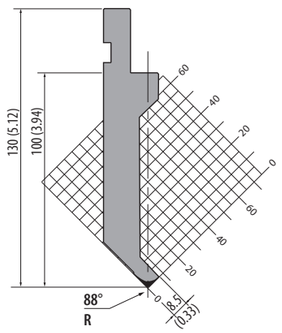
P.130.88.R06	H=100.00 / A=130.00 / R=0.6 (H= 3.94 / A=5.12 / R=0.024)		
	835 mm	32.87 in	9.8 kg
	415 mm	16.34 in	4.9 kg
	795 mm segmented	31.29 in segmented	9.3 kg
	805 mm segmented	31.69 in segmented	9.4 kg
	900 mm	35.43 in	10.5 kg
PK.130.88.R025	H=99.95 / A=129.95 / R=0.25 (H=3.94 / A=5.12 / R=0.010)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

42Cr: 900-1150 N/mm²

HORN 1 on stock

P.130.88.R08 / R025

400 kN/m max.



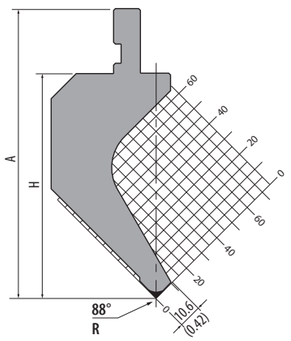
P.130.88.R08	H=100.00 / A=130.00 / R=0.8 (H=3.94 / A=5.12 / R=0.031)		
	835 mm	32.87 in	14.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.3 kg
	805 mm segmented	31.69 in segmented	13.4 kg
P.130.88.R025	H=100.00 / A=130.00 / R=0.25 (H=3.94 / A=5.12 / R=0.010)		
	835 mm	32.87 in	13.7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

C45: 560-710 N/mm²

HORN 1 on stock

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

500 kN/m max.



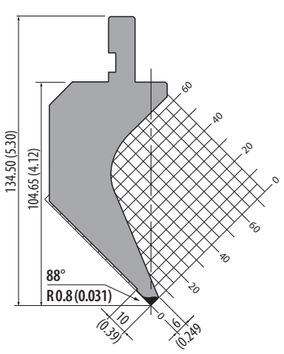
P.135.88.R08	H=104.65 / A=134.50 / R=0.8 (H=4.12 / A=5.30 / R=0.031)		
	835 mm	32.87 in	22.5 kg
	415 mm	16.34 in	11.2 kg
	795 mm segmented	31.29 in segmented	21.4 kg
	805 mm segmented	31.69 in segmented	21.7 kg
P.135.88.R3	H=103.40 / A=133.40 / R=3.0 (H=4.07 / A=5.25 / R=0.118)		
	835 mm	32.87 in	22.5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

C45: 560-710 N/mm²

HORN 1 on stock

PS.135.88.R08

450 kN/m max.



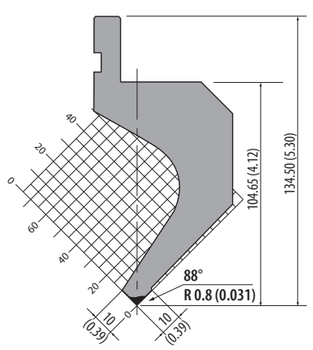
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	12.5 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²

HORN 1 on stock

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

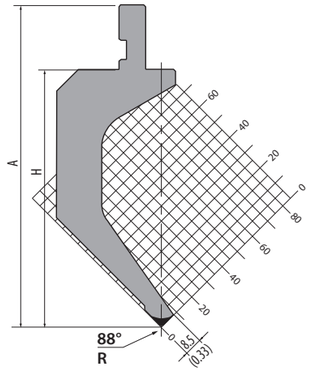
C45: 560-710 N/mm²

HORN 1 on stock

ROLLERI® PROFESSIONAL BENDING

P.150.88.R08 / R3

500 kN/m max.



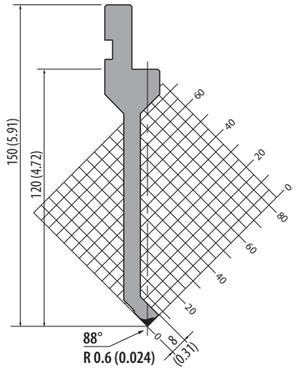
P.150.88.R08	H=120.00 / A=150.00 / R=0.8 (H=4.72 / A=5.91 / R=0.031)		
	835 mm	32.87 in	21.5 kg
	415 mm	16.34 in	10.5 kg
	795 mm segmented	31.29 in segmented	20.4 kg
	805 mm segmented	31.69 in segmented	20.7 kg
	900 mm	35.43 in	23.1 kg
P.150.88.R3	H=119.00 / A=149.00 / R=3.0 (H=4.69 / A=5.87 / R=0.118)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

HORN 1 on stock

P.150.88.R06

350 kN/m max.



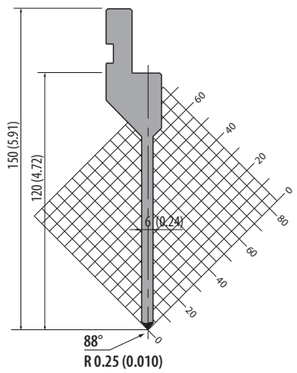
900 mm	35.43 in	12.9 kg
415 mm	16.34 in	5.9 kg
795 mm segmented	31.29 in segmented	12.2 kg
805 mm segmented	31.69 in segmented	12.4 kg

42Cr: 900-1150 N/mm²

HORN 1 on stock

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

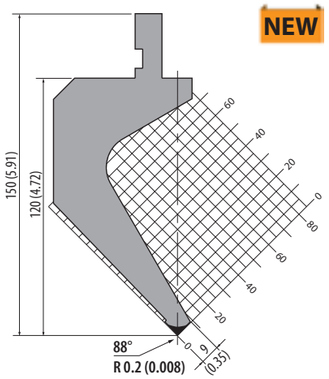
42Cr: 900-1150 N/mm²

HORN 1 on stock

04702

500 kN/m max.

NEW



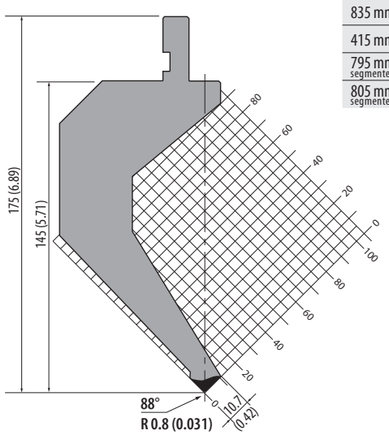
835 mm	32.87 in	26.0 kg
415 mm	16.34 in	12.9 kg
795 mm segmented	31.29 in segmented	24.8 kg
800 mm segmented	31.50 in segmented	24.9 kg

42Cr: 900-1150 N/mm²

HORN 3

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

HORN 1 on stock

on stock Article on stock

Please ask for delivery time!

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

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

P.195.88.R08

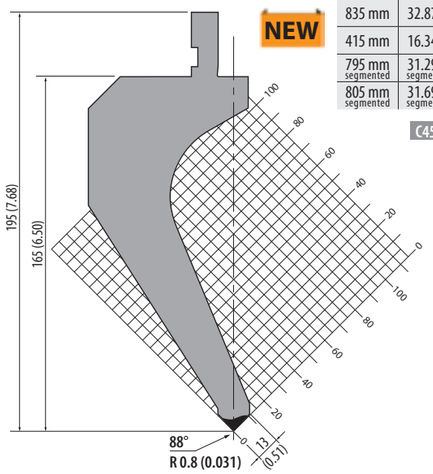
600 kN/m max.

NEW

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

HORN 1



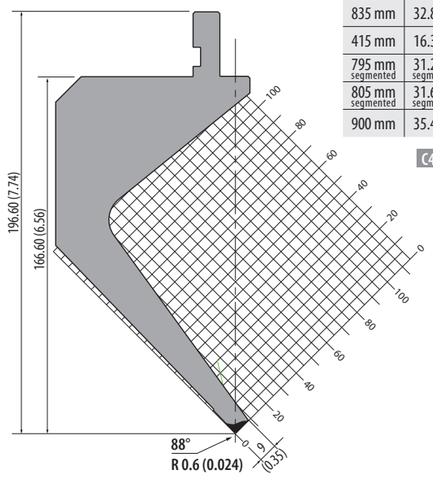
P.196.88.R06

300 kN/m max.

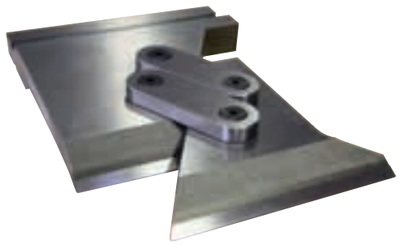
835 mm	32.87 in	41.8 kg
415 mm	16.34 in	20.8 kg
795 mm segmented	31.29 in segmented	39.7 kg
805 mm segmented	31.69 in segmented	40.2 kg
900 mm	35.43 in	45.0 kg

C45: 560-710 N/mm²

HORN 1 on stock



88° Segmented Punches with Mobile Horns



Area of Application

- for easy bending of special box profiles

Rolleri Videos

mobile horn demonstration at:
www.rolleritools.com/videos/mobile-horns

SCA.M.88.R08

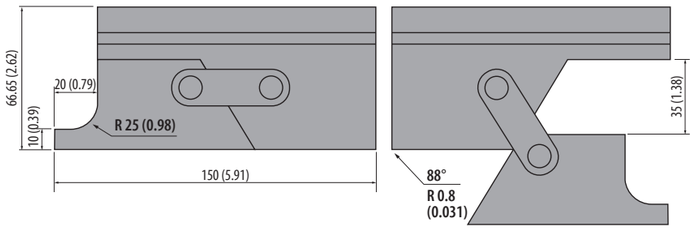
150 kN/m max.

NEW

per pair	3.5 kg

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

C45: 560-710 N/mm²



SCA.M.88.R025

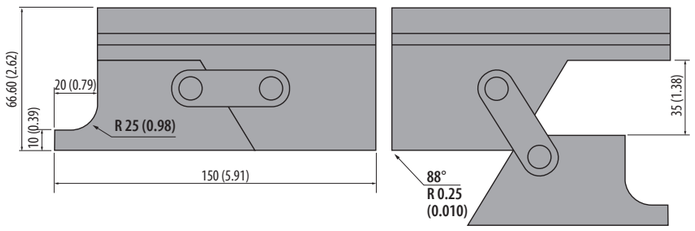
150 kN/m max.

NEW

per pair	3.5 kg

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

C45: 560-710 N/mm²

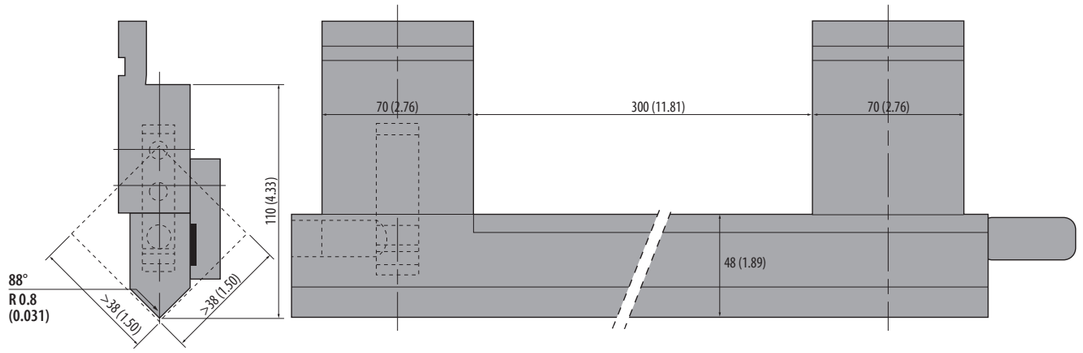


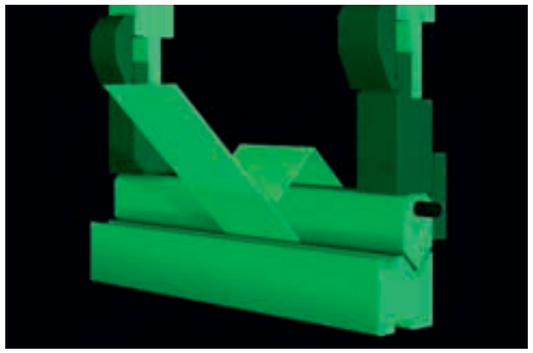
SPE.11

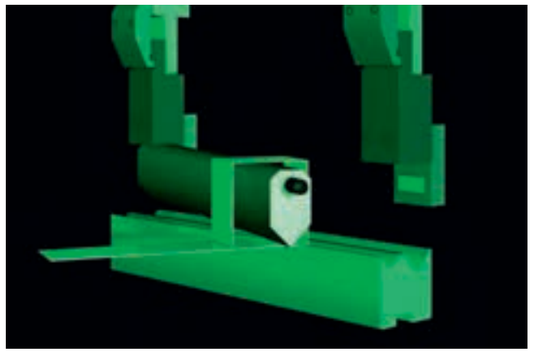
150 kN/m max.

per piece	7.0 kg

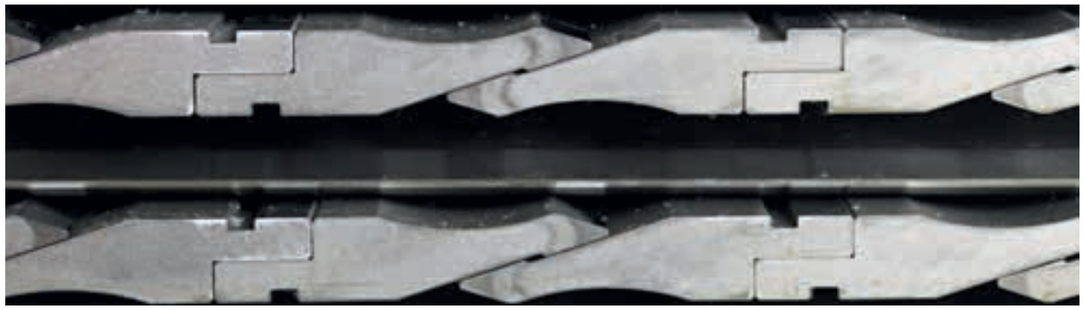
42Cr: 900-1150 N/mm²





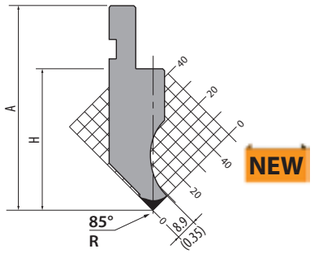


Articles on stock – Please note that delivery time varies according to your location



P.97.85.R08 / PK.95.85.R3

1000 kN/m max.



NEW

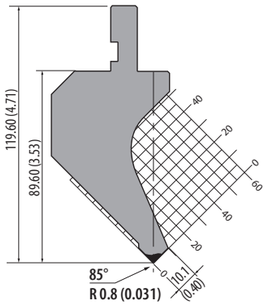
P.97.85.R08	H=66.60 / A=96.50 / R=0.8 (H=2.62 / A=3.80 / R=0.031)		
	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.5 kg
	795 mm segmented	31.29 in segmented	10.4 kg
	805 mm segmented	31.69 in segmented	10.6 kg
PK.95.85.R3	H=65.45 / A=95.45 / R=3.0 (H=2.58 / A=3.76 / R=0.118)		
	835 mm	32.87 in	11.0 kg
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

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

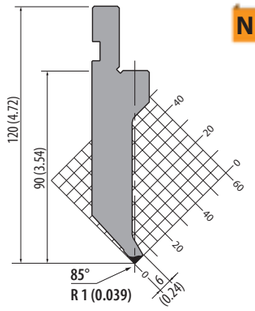
C45: 560-710 N/mm²

HORN 1 on stock

P.120.85.R1

800 kN/m max.

NEW



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

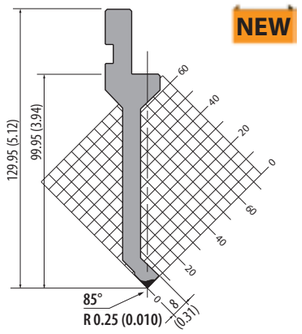
42Cr: 900-1150 N/mm²

HORN 1

P.130.85.R025

350 kN/m max.

NEW



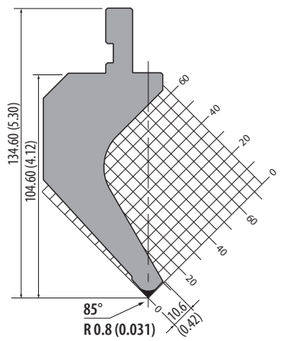
835 mm	32.87 in	11.5 kg
415 mm	16.34 in	5.7 kg
795 mm segmented	31.29 in segmented	10.9 kg
805 mm segmented	31.69 in segmented	11.1 kg

42Cr: 900-1150 N/mm²

HORN 1 on stock

PK.135.85.R08

500 kN/m max.



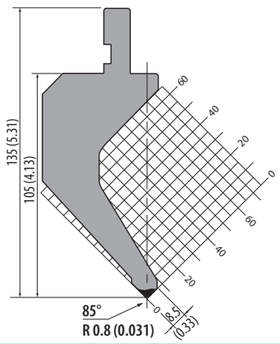
835 mm	32.87 in	22.2 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	21.1 kg
805 mm segmented	31.69 in segmented	21.4 kg

C45: 560-710 N/mm²

HORN 1 on stock

P.135.85.R08

800 kN/m max.



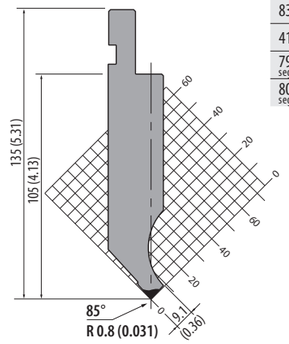
835 mm	32.87 in	20.9 kg
415 mm	16.34 in	10.4 kg
795 mm segmented	31.29 in segmented	19.9 kg
805 mm segmented	31.69 in segmented	20.1 kg

42Cr: 900-1150 N/mm²

HORN 1 on stock

PS.135.85.R08

1000 kN/m max.



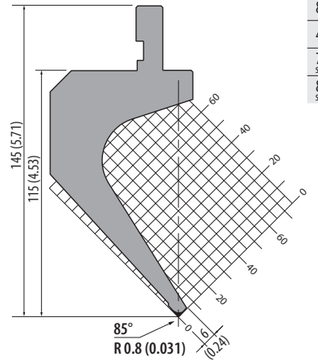
835 mm	32.87 in	17.7 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	16.8 kg
805 mm segmented	31.69 in segmented	17.0 kg

C45: 560-710 N/mm²

HORN 1 on stock

P.145.85.R08

600 kN/m max.



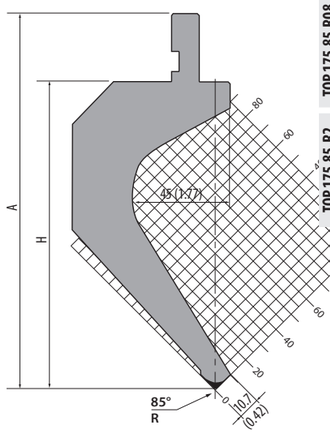
835 mm	32.87 in	22.6 kg
415 mm	16.34 in	11.2 kg
795 mm segmented	31.29 in segmented	21.5 kg
805 mm segmented	31.69 in segmented	21.7 kg

42Cr: 900-1150 N/mm²

HORN 1 on stock

TOP.175.85.R08 / R2

900 kN/m max.



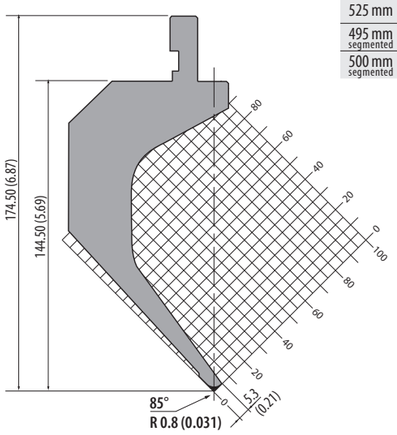
TOP.175.85.R08	H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
	525 mm	20.67 in	20.9 kg
	495 mm segmented	19.49 in segmented	19.7 kg
	500 mm segmented	19.68 in segmented	19.9 kg
TOP.175.85.R2	H=144.30 / A=174.30 / R=2.0 (H=5.68 / A=6.86 / R=0.079)		
	525 mm	20.67 in	20.9 kg
	495 mm segmented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

42Cr: 900-1150 N/mm²

HORN 2 on stock

TOP.175.85.R08.S

200 kN/m max.



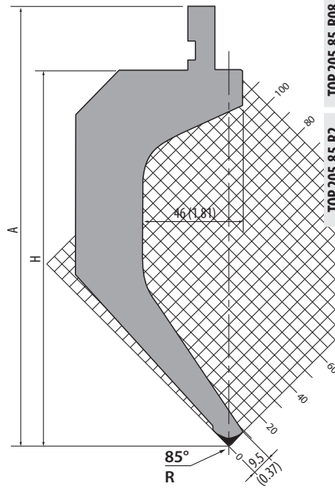
525 mm	20.67 in	18.5 kg
495 mm segmented	19.49 in segmented	17.4 kg
500 mm segmented	19.68 in segmented	17.6 kg

42Cr: 900-1150 N/mm²

HORN 2 on stock

TOP.205.85.R08 / R2

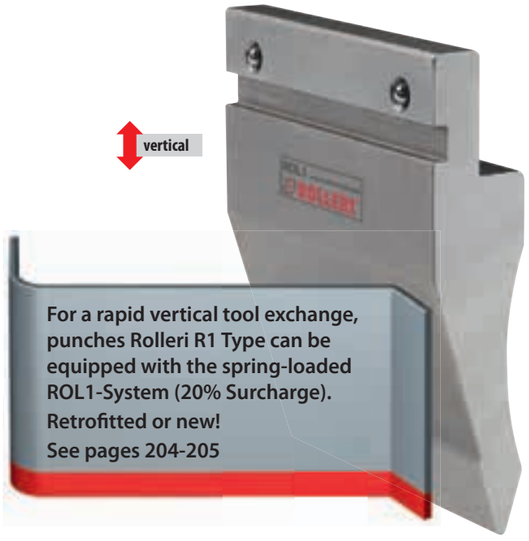
700 kN/m max.



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

42Cr: 900-1150 N/mm²

HORN 2 on stock



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

on stock Article on stock

Please ask for delivery time!

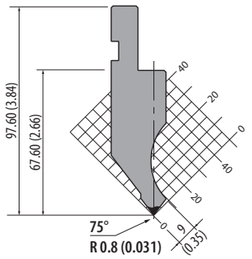
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

75° Punches

P.97.75.R08

1000 kN/m max.



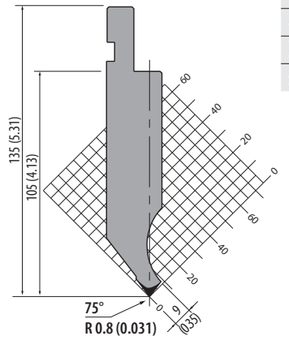
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock

P.135.75.R08

1000 kN/m max.



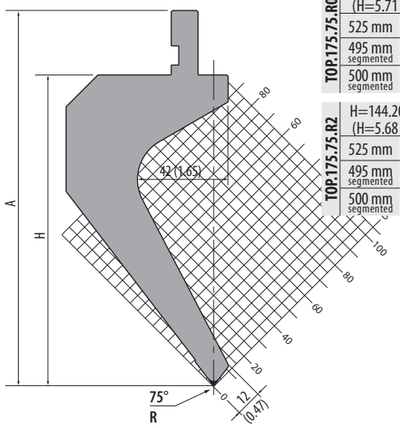
835 mm	32.87 in	17.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	16.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock

TOP.175.75.R08 / R2

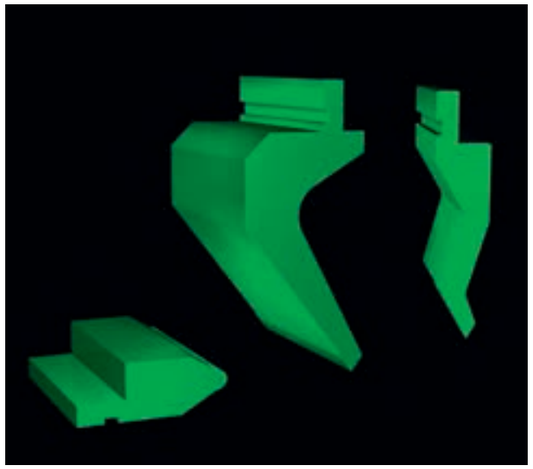
750 kN/m max.



TOP.175.75.R08	H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
	525 mm	20.67 in	21.5 kg
	495 mm segmented	19.49 in segmented	20.3 kg
	500 mm segmented	19.68 in segmented	20.5 kg
TOP.175.75.R2	H=144.20 / A=174.20 / R=2.0 (H=5.68 / A=6.86 / R=0.079)		
	525 mm	20.67 in	21.5 kg
	495 mm segmented	19.49 in segmented	20.3 kg
	500 mm segmented	19.68 in segmented	20.5 kg

42Cr: 900-1150 N/mm²

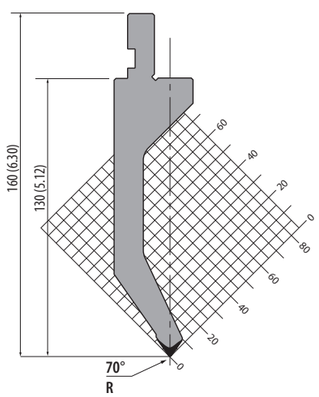
HORN 2 — on stock



70° Punches

P.160.70.R08 / R3

450 kN/m max.



P.160.70.R08	R=0.8 (0.031)		
	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	8.9 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.3 kg
P.160.70.R3	R=3.0 (0.118)		
	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	8.9 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.3 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock

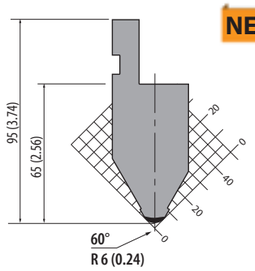
ROLLERI® PROFESSIONAL BENDING

60° Punches

00300

NEW

1000 kN/m max.



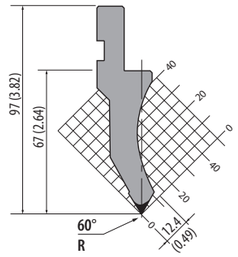
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.2 kg
800 mm segmented	31.50 in segmented	14.4 kg

C45: 560-710 N/mm²

HORN 6

P.97.60.R08 / R2

600 kN/m max.



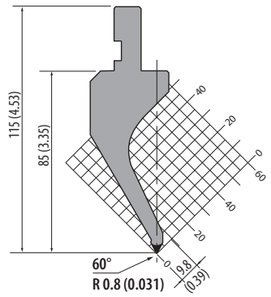
P.97.60.R08	R=0.8 (0.031)		
	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	4.5 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	805 mm segmented	31.69 in segmented	8.7 kg
P.97.60.R2	R=2.0 (0.079)		
	835 mm	32.87 in	9.0 kg
	415 mm	16.34 in	5.0 kg
	795 mm segmented	31.29 in segmented	8.5 kg
	805 mm segmented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

C45: 560-710 N/mm²

HORN 1 — on stock

P.115.60.R08

400 kN/m max.



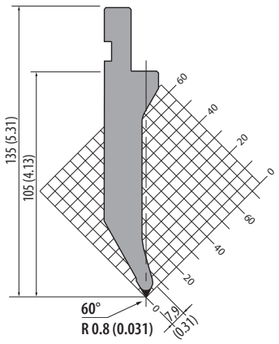
835 mm	32.87 in	11.9 kg
415 mm	16.34 in	6.0 kg
795 mm segmented	31.29 in segmented	11.3 kg
805 mm segmented	31.69 in segmented	11.4 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock

P.135.60.R08

800 kN/m max.



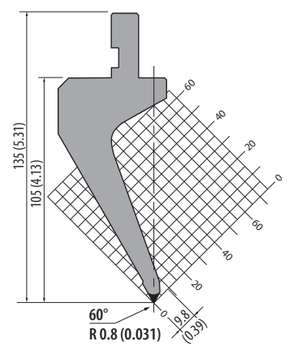
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock

PG.135.60.R08

700 kN/m max.



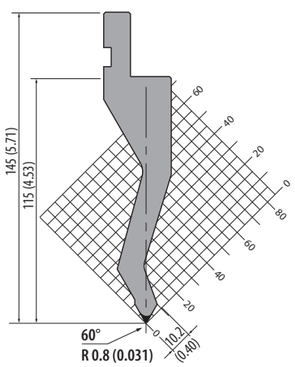
835 mm	32.87 in	16.5 kg
415 mm	16.34 in	8.5 kg
795 mm segmented	31.29 in segmented	15.7 kg
805 mm segmented	31.69 in segmented	15.9 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock

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

HORN 1 — on stock

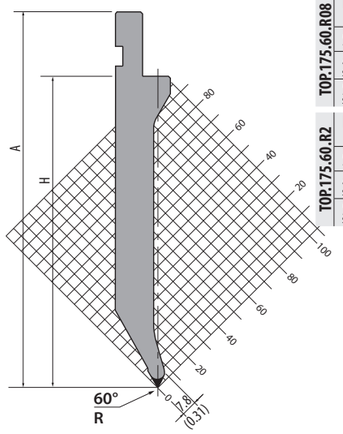
Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

R1 ROLLERI TYPE R1

60° Punches

TOP.175.60.R08 / R2

800 kN/m max.



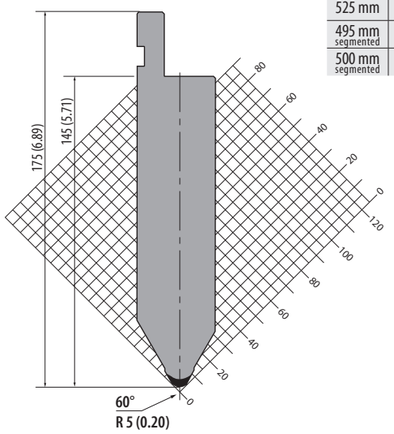
TOP.175.60.R08	H=145.00 / A=175.00 / R=0.8 (H=5.71 / A=6.89 / R=0.031)		
	525 mm	20.67 in	12.0 kg
	495 mm segmented	19.49 in segmented	11.3 kg
	500 mm segmented	19.68 in segmented	11.4 kg
TOP.175.60.R2	H=143.80 / A=173.80 / R=2.0 (H=5.66 / A=6.84 / R=0.079)		
	525 mm	20.67 in	12.0 kg
	495 mm segmented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

42Cr: 900-1150 N/mm²

HORN 2 on stock

TOP.175.60.R5

1600 kN/m max.



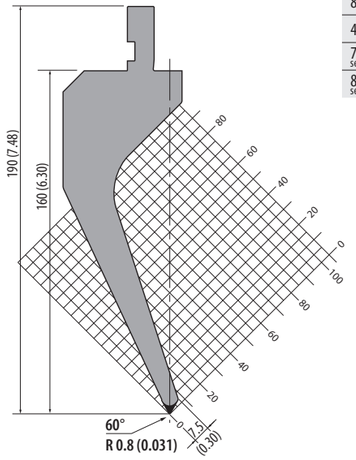
525 mm	20.67 in	22.0 kg
495 mm segmented	19.49 in segmented	20.7 kg
500 mm segmented	19.68 in segmented	20.9 kg

42Cr: 900-1150 N/mm²

HORN 2 on stock

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

HORN 1 on stock

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

R1 ROLLERI TYPE R1

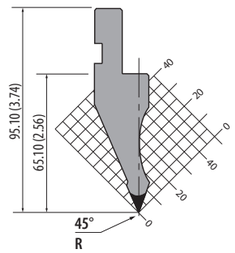
45° Punches

ROLLERI® PROFESSIONAL BENDING

1 R1

P.95.45.R08 / R15

800 kN/m max.



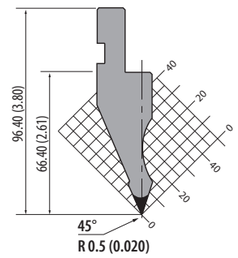
P.95.45.R08	R=0.8 (0.031)		
	835 mm	32.87 in	9.5 kg
	415 mm	16.34 in	4.2 kg
	795 mm segmented	31.29 in segmented	9.0 kg
	805 mm segmented	31.69 in segmented	9.0 kg
P.95.45.R15	R=1.5 (0.059)		
	835 mm	32.87 in	9.5 kg
	415 mm	16.34 in	4.2 kg
	795 mm segmented	31.29 in segmented	9.5 kg
	805 mm segmented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

C45: 560-710 N/mm²

HORN 1 on stock

P.97.45.R05

800 kN/m max.



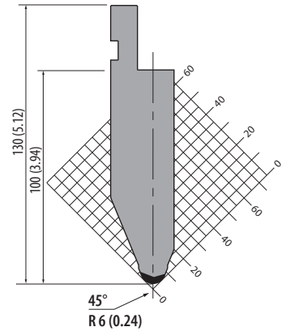
835 mm	32.87 in	10.2 kg
415 mm	16.34 in	5.1 kg
795 mm segmented	31.29 in segmented	9.7 kg
805 mm segmented	31.69 in segmented	9.8 kg
900 mm	35.43 in	10.9 kg

C45: 560-710 N/mm²

HORN 1 on stock

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

HORN 1 on stock

Faster vertical tool exchange with ROL100 vertical
See pages 202-203

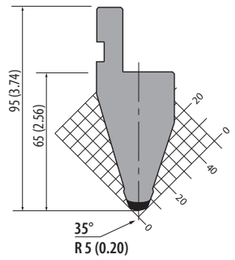
on stock Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

R1 ROLLERI TYPE R1

35° Punches

P.95.35.R5

1000 kN/m max.



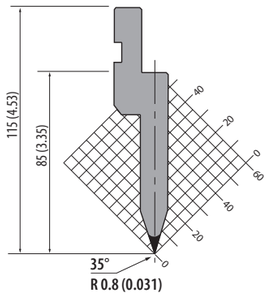
835 mm	32.87 in	13.5 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	12.8 kg
805 mm segmented	31.69 in segmented	13.0 kg

C45: 560-710 N/mm²

HORN 1 — on stock

PU.85.35.R08

1000 kN/m max.



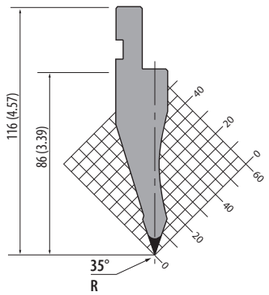
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.6 kg

C45: 560-710 N/mm²

HORN 1 — on stock

P.116.35.R08 / R15

700 kN/m max.



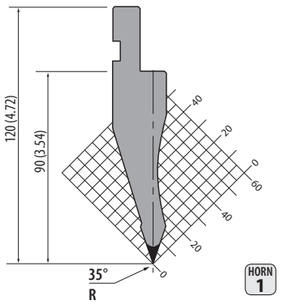
P.116.35.R08	R=0.8 (0.031)		
	835 mm	32.87 in	10.5 kg
	415 mm	16.34 in	5.7 kg
	795 mm segmented	31.29 in segmented	10.0 kg
	805 mm segmented	31.69 in segmented	10.1 kg
P.116.35.R15	R=1.5 (0.059)		
	835 mm	32.87 in	11.0 kg
	415 mm	16.34 in	5.7 kg
	795 mm segmented	31.29 in segmented	10.4 kg
	805 mm segmented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

C45: 560-710 N/mm²

HORN 1 — on stock

P.120.35.R08 / R15 / R3

700 kN/m max.



P.120.35.R08	R=0.8 (0.031)		
	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
P.120.35.R15	R=1.5 (0.059)		
	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
P.120.35.R3	R=3.0 (0.118)		
	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

HORN 1 — on stock

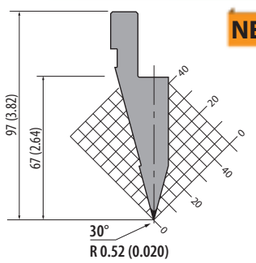
C45: 560-710 N/mm²

30° Punches

10300

1000 kN/m max.

NEW



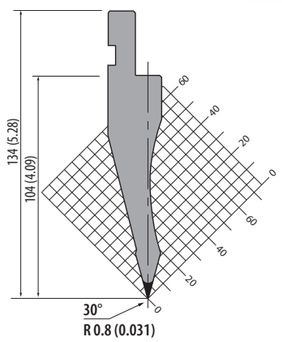
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg
795 mm segmented	31.29 in segmented	10.4 kg
800 mm segmented	31.50 in segmented	10.6 kg

42Cr: 900-1150 N/mm²

HORN 5

PS.134.30.R08

700 kN/m max.



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

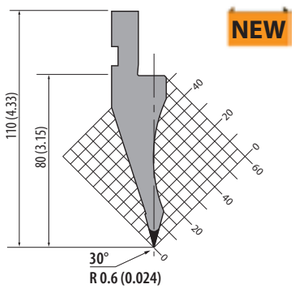
C45: 560-710 N/mm²

HORN 1 — on stock

P.110.30.R06

500 kN/m max.

NEW



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

C45: 560-710 N/mm²

HORN 1

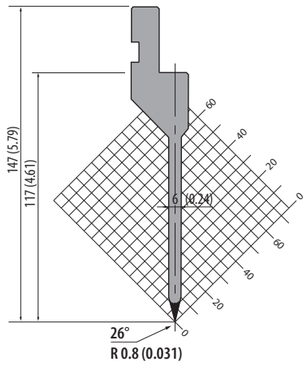
R1 ROLLERI TYPE R1

26° Punches

ROLLERI® PROFESSIONAL BENDING

P.147.26.R08

500 kN/m max.



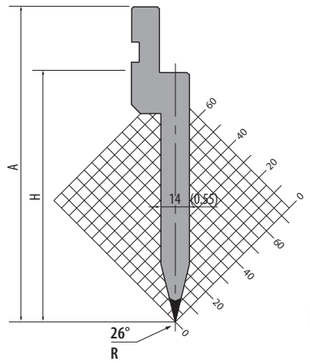
835 mm	32.87 in	9.8 kg
415 mm	16.34 in	4.9 kg
795 mm segmented	31.29 in segmented	9.3 kg
805 mm segmented	31.69 in segmented	9.4 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock

PU.117.26.R08 / R3

1000 kN/m max.



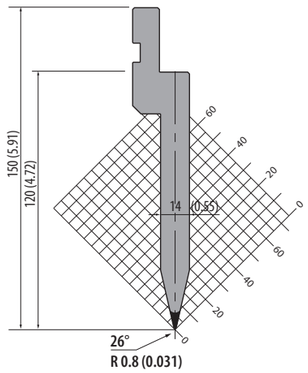
PU.117.26.R08	H=117.00 / A=147.00 / R=0.8 (H=4.61 / A=5.79 / R=0.031)		
	835 mm	32.87 in	13.5 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.8 kg
	805 mm segmented	31.69 in segmented	13.0 kg
PU.117.26.R3	H=109.00 / A=139.00 / R=3.0 (H=4.29 / A=5.47 / R=0.118)		
	835 mm	32.87 in	13.5 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

HORN 1 — on stock

PU.150.26.R08.L

1000 kN/m max.



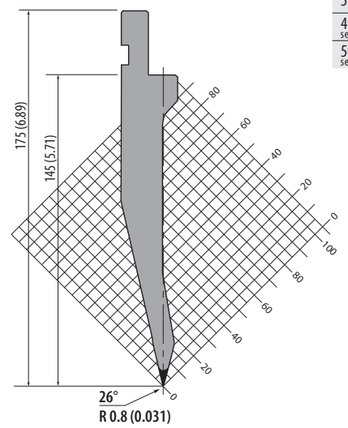
900 mm	35.43 in	15.0 kg
415 mm	16.34 in	6.2 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

HORN 1 — on stock

TOP.175.26.R08

950 kN/m max.



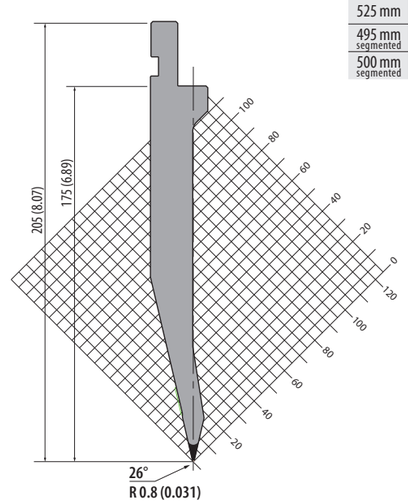
525 mm	20.67 in	11.0 kg
495 mm segmented	19.49 in segmented	10.4 kg
500 mm segmented	19.68 in segmented	10.5 kg

42Cr: 900-1150 N/mm²

HORN 2 — on stock

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

HORN 2 — on stock

on stock — Article on stock

Please ask for delivery time!

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

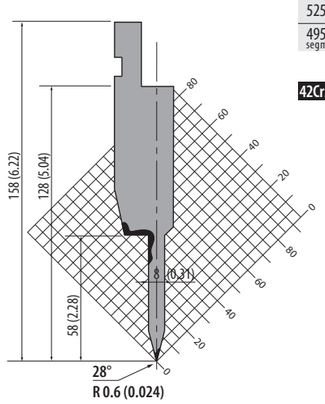
Articles on stock – Please note that delivery time depends on your location.

28°/24° Hemming tools

TOP.SP.134.28.8

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

42Cr: 900-1150 N/mm²

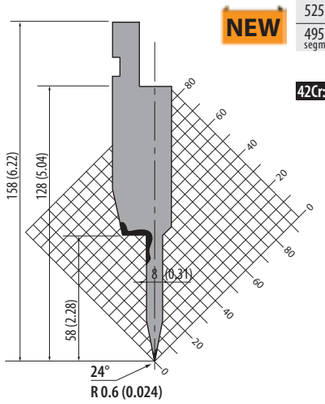


TOP.SP.134.24.8

NEW

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

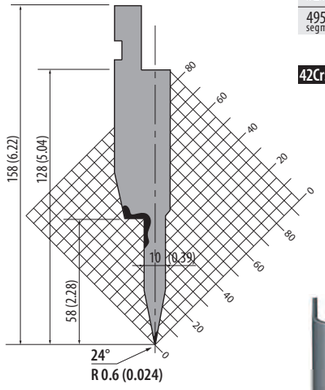
42Cr: 900-1150 N/mm²



TOP.SP.134.24.10

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

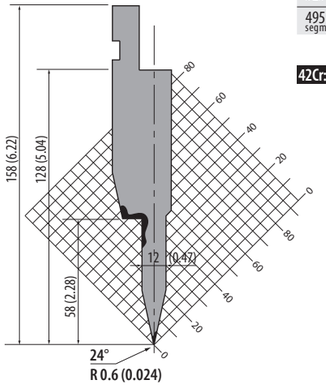
42Cr: 900-1150 N/mm²



TOP.SP.134.24.12

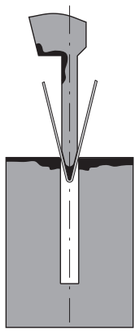
525 mm	20.67 in	11.6 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

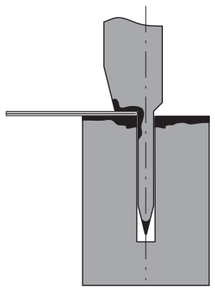


Only for thin material!
Hemming Dies
See page 75

Example of application



800 kN/m max.



1000 kN/m max.

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80

Z-Profile Tools

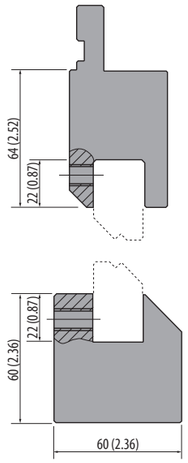
ROLLERI® PROFESSIONAL BENDING

CPZ

1000 kN/m max.

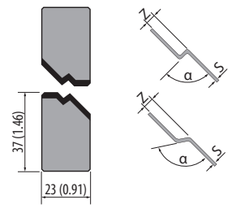
835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.7 kg

C45: 560-710 N/mm²



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

1000 kN/m max.



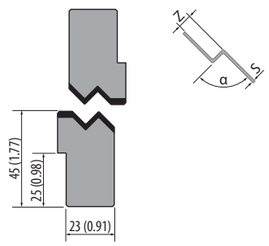
C45: 560-710 N/mm²

Model	Z mm	Z in	α	S* mm	S* inch		Weight		Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	835 mm / 32.87 in	11.0 kg	415 mm / 16.34 in	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

Z-Tool Inserts 90°

1000 kN/m max.



C45: 560-710 N/mm²

Model	Z mm	Z in	α	S* mm	S* inch		Weight		Weight
CEZ 9.0	9	0.35	90°	1.8	0.07	835 mm / 32.87 in	13.5 kg	415 mm / 16.34 in	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

Article on stock

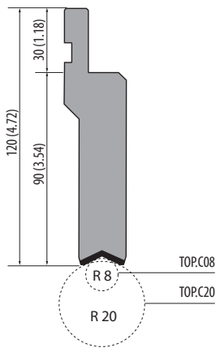
Please ask for delivery time!

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

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

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

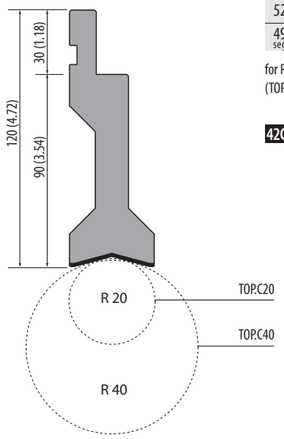
42Cr: 900-1150 N/mm²

on stock

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

TOP.PC.120-20

1000 kN/m max.



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

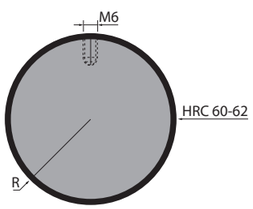
for Radius tools with R20-R40
(TOP.C20-TOP.C40) see below

42Cr: 900-1150 N/mm²

on stock

TOP-Radius Tools: R8-40

1000 kN/m max.



Material: C53 induction hardened 60-62 HRc

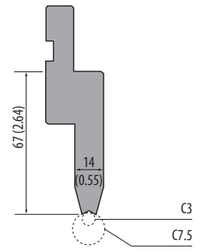
on stock

C53: 610-760 N/mm²

Model	R mm	R in		Weight		Weight
TOP.C08	8	0.31	525 mm / 20.67 in	0.8 kg	495 mm / 16.34 in segmented	1.9 kg
TOP.C10	10	0.39		1.3 kg		2.7 kg
TOP.C12.5	12.5	0.49		2.0 kg		2.8 kg
TOP.C15	15	0.59		3.0 kg		3.8 kg
TOP.C17.5	17.5	0.69		4.0 kg		4.7 kg
TOP.C20	20	0.79		5.2 kg		6.6 kg
TOP.C25	25	0.98		8.1 kg		7.5 kg
TOP.C30	30	1.18		11.7 kg		11.3 kg
TOP.C35	35	1.38		16.0 kg		15.1 kg
TOP.C40	40	1.57		20.7 kg		19.5 kg

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

on stock

Mark-free bending with PU-Upholstery

See pages 226-227

C3 - C7.5

400 kN/m max.

on stock

C45: 560-710 N/mm²

Model	R mm	R in		Weight		Weight
C3	3.0	0.12	835 mm / 32.87 in	0.20 kg	415 mm / 16.34 in	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

on stock Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

PU.67.14

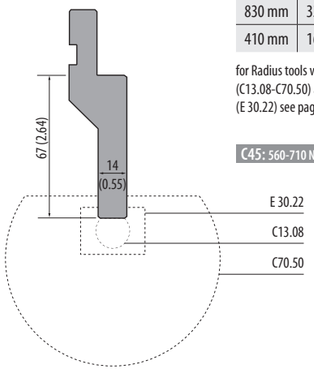
800 kN/m max.

830 mm	32.68 in	9.0 kg
410 mm	16.14 in	5.0 kg

for Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see page 33

C45: 560-710 N/mm²

on stock



PU.87.14

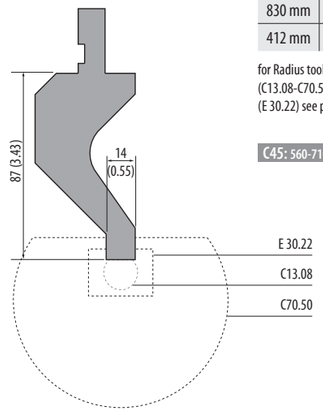
500 kN/m max.

830 mm	32.68 in	9.0 kg
412 mm	16.22 in	4.5 kg

for Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see page 33

C45: 560-710 N/mm²

on stock



PU.105.14

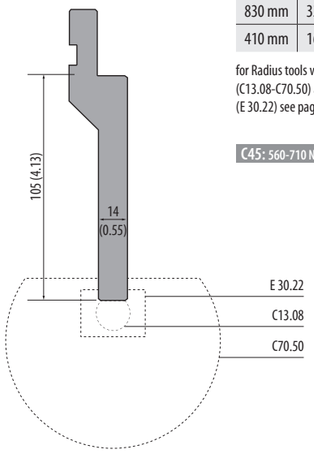
800 kN/m max.

830 mm	32.68 in	12.0 kg
410 mm	16.14 in	6.0 kg

for Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see page 33

C45: 560-710 N/mm²

on stock



PU.115.14

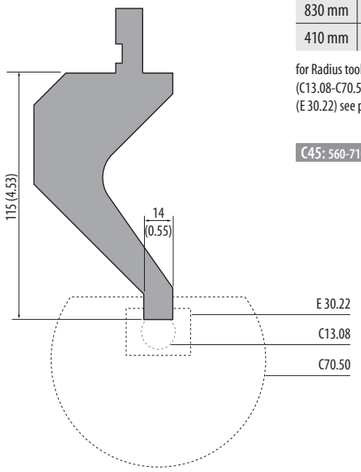
500 kN/m max.

830 mm	32.68 in	26.0 kg
410 mm	16.14 in	13.0 kg

for Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see page 33

C45: 560-710 N/mm²

on stock



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.

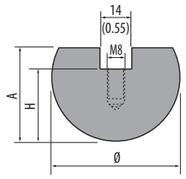
on stock

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)

800 kN/m max.

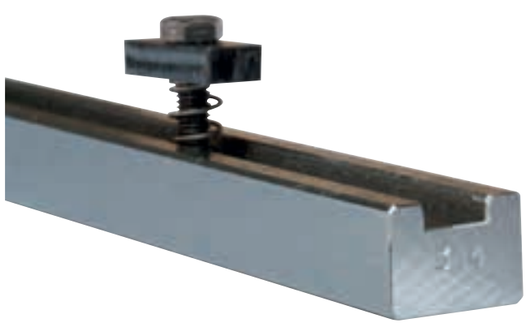


on stock

C45: 560-710 N/mm²

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

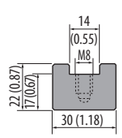
Hemming Tool



E30.22

800 kN/m max.

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



C45: 560-710 N/mm²

on stock

on stock Article on stock

Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (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
- **Increase in leg length**
- for **special increase in leg length** see SPE-p4 in the area of special tools on page 237

AD4

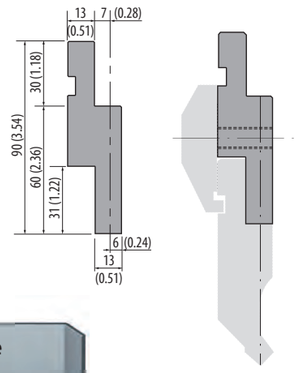
1000 kN/m max.

per piece	1.8 kg

L=150 mm

Punch extension without wedge crowning

C45: 560-710 N/mm²



Compatible tensioner see page 200

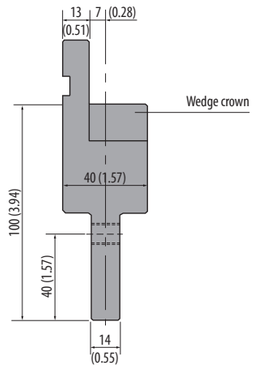
INT100

1000 kN/m max.

per piece	3.5 kg

L=150 mm

C45: 560-710 N/mm²



INT100 FISSO

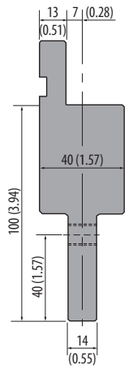
1000 kN/m max.

per piece	4.0 kg

L=150 mm

Punch extension without wedge crowning

C45: 560-710 N/mm²



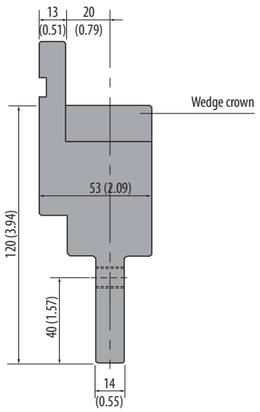
INT120-40

1000 kN/m max.

per piece	5.2 kg

L=150 mm

C45: 560-710 N/mm²



Intermediates also available in L=70 mm upon request.

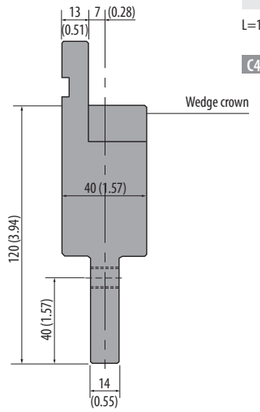
INT120

1000 kN/m max.

per piece	4.5 kg

L=150 mm

C45: 560-710 N/mm²



ROLLERI® PROFESSIONAL BENDING

1 R1

INT150-40

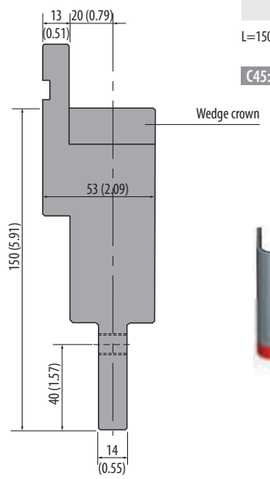
NEW

1000 kN/m max.

per piece	8.0 kg

L=150 mm

C45: 560-710 N/mm²



Rolleri Clamping Systems
See pages 198-205

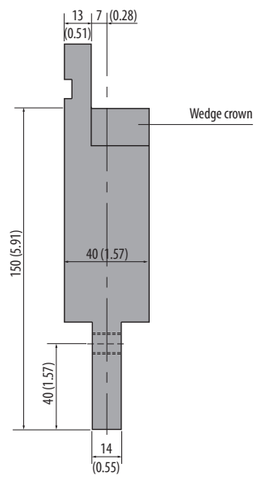
INT150

1000 kN/m max.

per piece	5.9 kg

L=150 mm

C45: 560-710 N/mm²



INT120-40-HD (Heavy Duty)

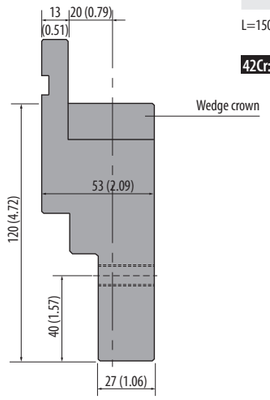
NEW

1600 kN/m max.

per piece	5.2 kg

L=150 mm

42Cr: 900-1150 N/mm²



INT120-HD (Heavy Duty)

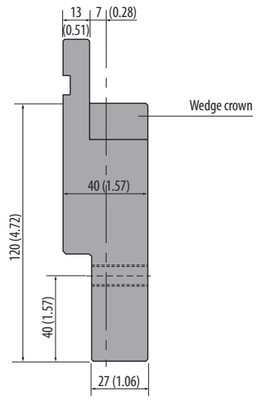
NEW

1600 kN/m max.

per piece	4.5 kg

L=150 mm

42Cr: 900-1150 N/mm²



Punch Adapters

AD20

1000 kN/m max.

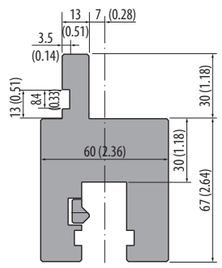
per piece	4.0 kg

L=150 mm

head-bearing

Rolleri Type R1 → Rolleri Type R2

C45: 560-710 N/mm²



Punches Rolleri Type R2 see pages 85-90

AD19-A

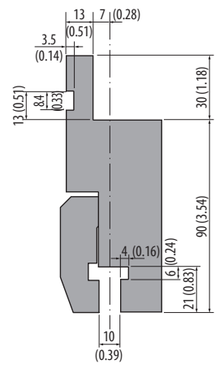
1000 kN/m max.

per piece	6.0 kg

L=150 mm

Rolleri Type R1 → Rolleri Type RX LVD

C45: 560-710 N/mm²



Punches Rolleri Type RX LVD see page 162

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

DIES ROLLERI TYPE R1

Content Explanation	38 - 39
2-V Dies 90°	40
2-V Dies 88°	40 - 41
2-V Dies 60°	42
2-V Dies 35°	42
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Compatibility

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

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

Compatibility

Dies Rolleri Type R1 are:

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

Our Advantages – Your Convenience

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

Material

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

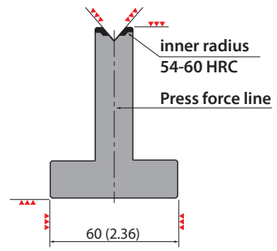
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC

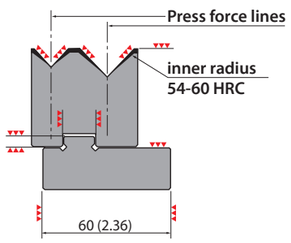
- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

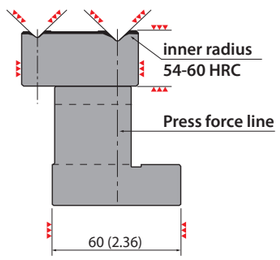
Tang

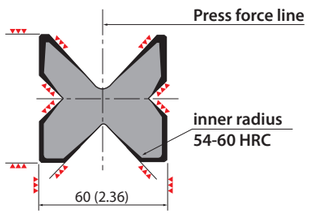
All dies Rolleri Type R1 are standardized with a **60 mm (2.36 in) tang**. (Differing data see each tool.)

Indications of precision ground surfaces:
▼▼▼









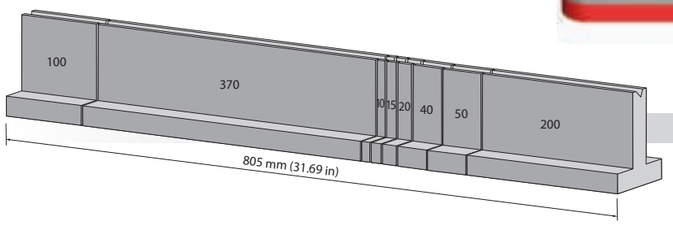
Tool lengths and sectioning

Standard

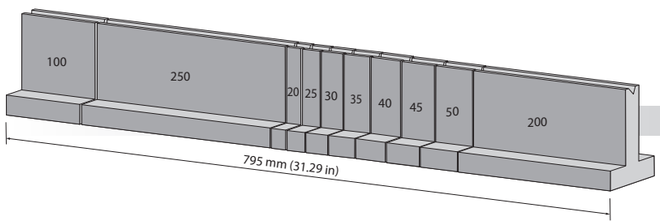
Segmented tools are delivered in complete sets. Single pieces are also available!

More lengths and sectionings are possible upon request.

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



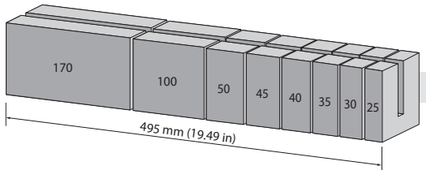
805 mm (31.69 in) segmented (8 segments)



795 mm (31.29 in) segmented (10 segments)

Rolleri TOP-System

525 mm (20.67 in)



495 mm (19.49 in) segmented (8 segments)

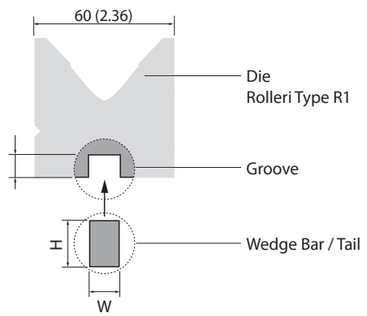
Modification: Wedge Bar / Tail

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

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

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

Mounting example



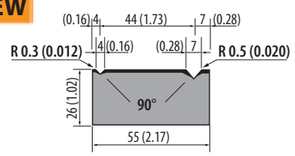
R1 ROLLERI TYPE R1

2-V Dies 90°

M26.90.03

1000 kN/m max.

NEW

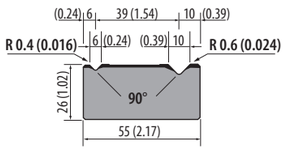


835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²

M26.90.01

1000 kN/m max.

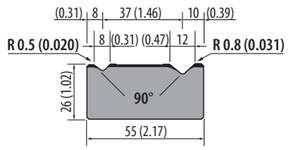


835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
900 mm	35.43 in	10.0 kg

C45: 560-710 N/mm²

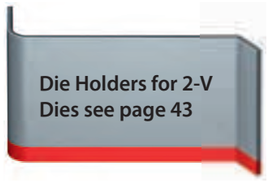
M26.90.02

1000 kN/m max.



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

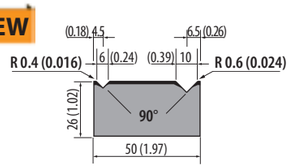
C45: 560-710 N/mm²



12300

700 kN/m max.

NEW



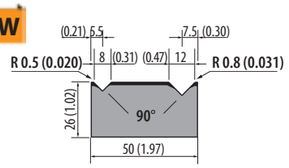
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

C45: 560-710 N/mm²

12400

800 kN/m max.

NEW



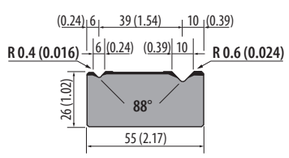
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

C45: 560-710 N/mm²

2-V Dies 88°

M26.88.01

1000 kN/m max.

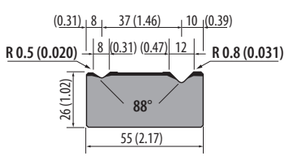


835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²

M26.88.02

1000 kN/m max.

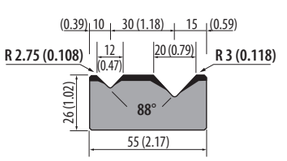


835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²

M26.88.03

1000 kN/m max.

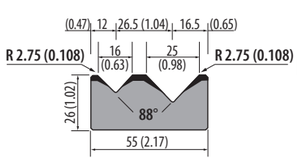


835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²

M26.88.04

1000 kN/m max.



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

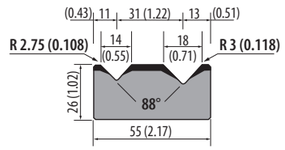
C45: 560-710 N/mm²

2-V Dies 88°

ROLLERI® PROFESSIONAL BENDING

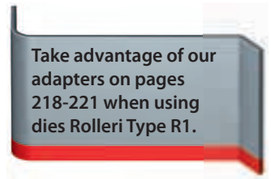
M26.88.05

1000 kN/m max.



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

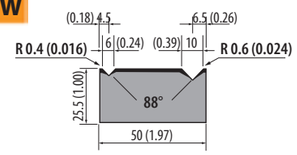
C45: 560-710 N/mm²



12306

700 kN/m max.

NEW



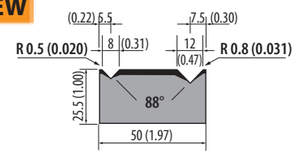
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

C45: 560-710 N/mm²

12406

800 kN/m max.

NEW



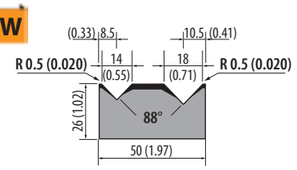
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	3.9 kg

C45: 560-710 N/mm²

12500

1000 kN/m max.

NEW



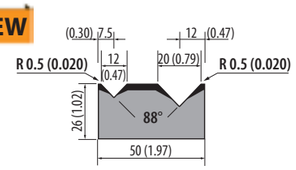
835 mm	32.87 in	7.7 kg
415 mm	16.34 in	3.8 kg

C45: 560-710 N/mm²

12600

1000 kN/m max.

NEW



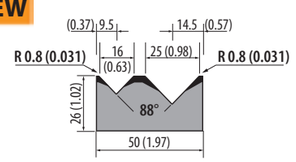
835 mm	32.87 in	7.5 kg
415 mm	16.34 in	3.7 kg

C45: 560-710 N/mm²

12700

700 kN/m max.

NEW



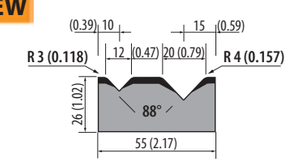
835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.4 kg

C45: 560-710 N/mm²

31400

1000 kN/m max.

NEW



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

C45: 560-710 N/mm²

Article on stock

Please ask for delivery time!

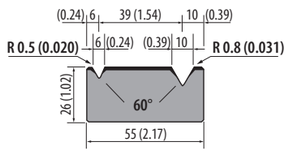
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

2-V Dies 60°

M26.60.01

600 kN/m max.



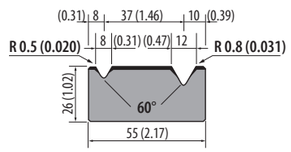
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
900 mm	35.43 in	10.0 kg

C45: 560-710 N/mm²

on stock

M26.60.02

800 kN/m max.



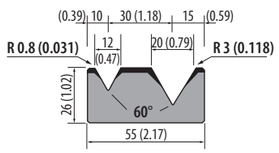
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg

C45: 560-710 N/mm²

on stock

M26.60.03

800 kN/m max.



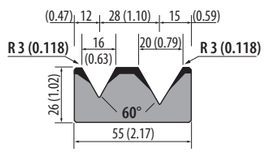
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg

C45: 560-710 N/mm²

on stock

M26.60.05

800 kN/m max.



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

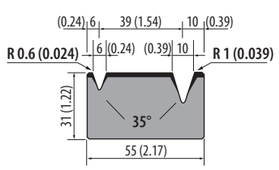
C45: 560-710 N/mm²

on stock

2-V Dies 35°

M31.35.01

300 kN/m max.



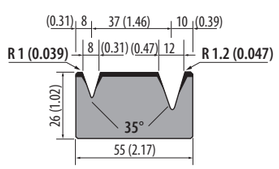
835 mm	32.87 in	11.0 kg
415 mm	16.34 in	5.5 kg

C45: 560-710 N/mm²

on stock

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

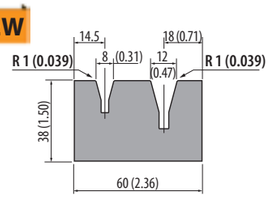
on stock

2-V Dies 30°

33700

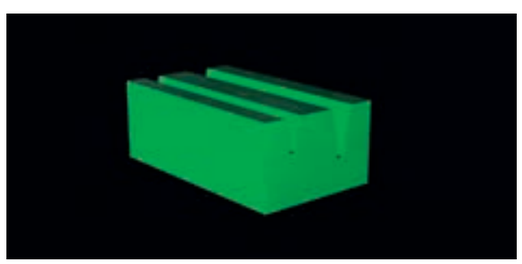
300 kN/m max.

NEW



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

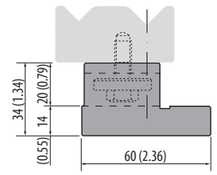
42Cr: 900-1150 N/mm²



Die Holders for 2-V Dies

ROLLERI® PROFESSIONAL BENDING

SU034



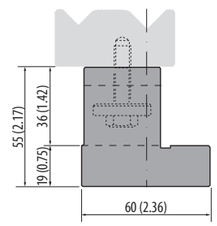
830 mm	32.68 in	9.0 kg
410 mm	16.14 in	4.5 kg

for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²

on stock

SU055



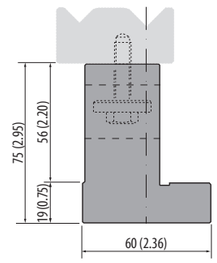
830 mm	32.68 in	14.5 kg
410 mm	16.14 in	7.2 kg

for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²

on stock

SU075

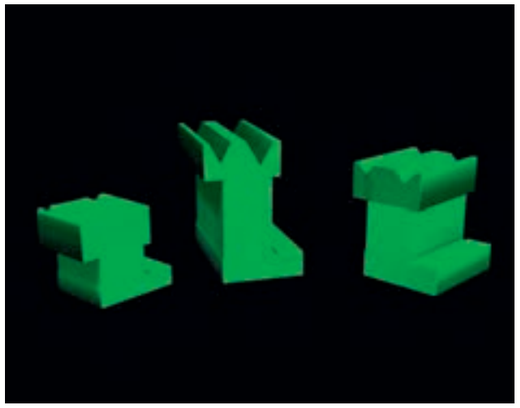


830 mm	32.68 in	20.5 kg
410 mm	16.14 in	10.0 kg

for all 2-V Dies
pages 40-42

C45: 560-710 N/mm²

on stock



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

on stock Article on stock

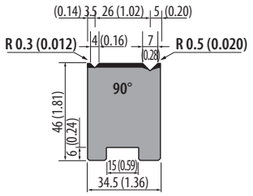
Please ask for delivery time!

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

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

Self Centering 2-V Dies 90°

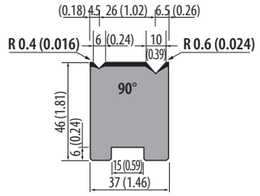
46-10
800 kN/m max.



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

C45: 800-850 N/mm²

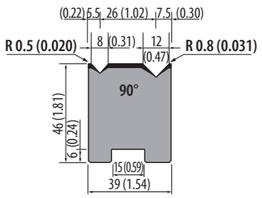
46-11
800 kN/m max.



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

C45: 800-850 N/mm²

46-12
800 kN/m max.

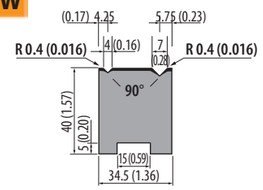


835 mm	32.87 in	10.0 kg
415 mm	16.34 in	5.0 kg
795 mm segmented	31.29 in segmented	9.5 kg
805 mm segmented	31.69 in segmented	9.6 kg

C45: 800-850 N/mm²

50190
600 kN/m max.

NEW

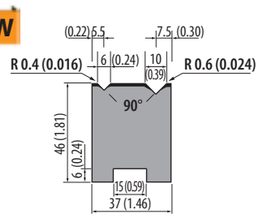


835 mm	32.87 in	9.7 kg
415 mm	16.34 in	4.8 kg
795 mm segmented	31.29 in segmented	9.2 kg
805 mm segmented	31.69 in segmented	9.4 kg

C45: 800-850 N/mm²

50290
700 kN/m max.

NEW

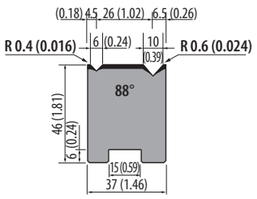


835 mm	32.87 in	10.5 kg
415 mm	16.34 in	5.2 kg
795 mm segmented	31.29 in segmented	10.0 kg
805 mm segmented	31.69 in segmented	10.1 kg

C45: 800-850 N/mm²

Self Centering 2-V Dies 88°

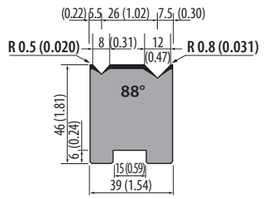
46.11.88
800 kN/m max.



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

C45: 800-850 N/mm²

46.13
800 kN/m max.



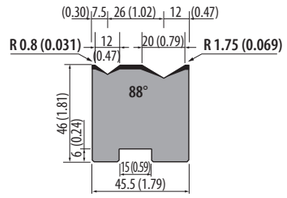
835 mm	32.87 in	10.9 kg
415 mm	16.34 in	5.4 kg
795 mm segmented	31.29 in segmented	10.4 kg
805 mm segmented	31.69 in segmented	10.5 kg

C45: 800-850 N/mm²

Self Centering 2-V Dies 88°

ROLLERI® PROFESSIONAL BENDING

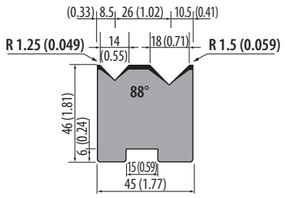
46.14
800 kN/m max.



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

C45: 800-850 N/mm²

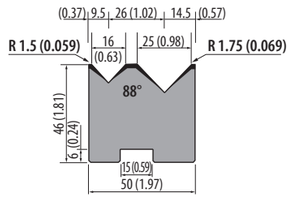
46.15
800 kN/m max.



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

C45: 800-850 N/mm²

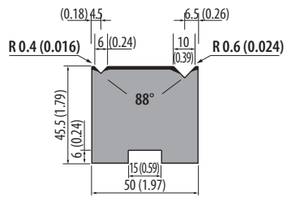
46.16
800 kN/m max.



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

C45: 800-850 N/mm²

30247
700 kN/m max.

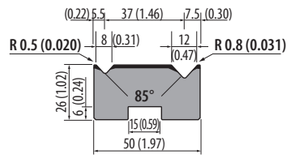


835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.4 kg
795 mm segmented	31.29 in segmented	16.2 kg
805 mm segmented	31.69 in segmented	16.4 kg

C45: 800-850 N/mm²

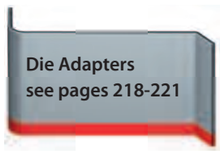
Self Centering 2-V Dies 85°

M26.85.02
1000 kN/m max.



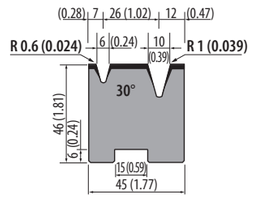
835 mm	32.87 in	9.0 kg
415 mm	16.34 in	4.5 kg
795 mm segmented	31.29 in segmented	8.6 kg
805 mm segmented	31.69 in segmented	8.7 kg

42Cr: 900-1150 N/mm²



Self Centering 2-V Dies 30°

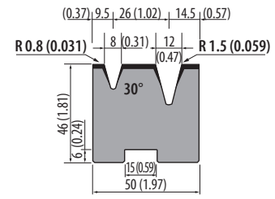
46.17
400 kN/m max.



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

C45: 800-850 N/mm²

46.18
400 kN/m max.



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

C45: 800-850 N/mm²

Article on stock

Please ask for delivery time!

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

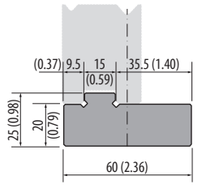
Articles on stock – Please note that delivery time depends on your location.

Die Holders for Self Centering 2-V Dies

PM60

1000 kN/m max.

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



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

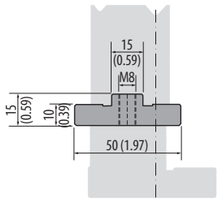
C45: 560-710 N/mm²

on stock

PM50

1000 kN/m max.

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



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

C45: 560-710 N/mm²

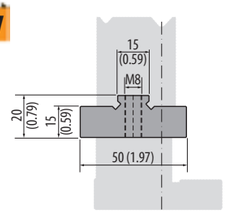
on stock

PM50.20

NEW

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 44-45

C45: 800-850 N/mm²

on stock

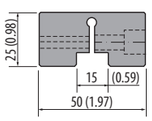
Clamping Piece for Self Centering 2-V Dies

PB60

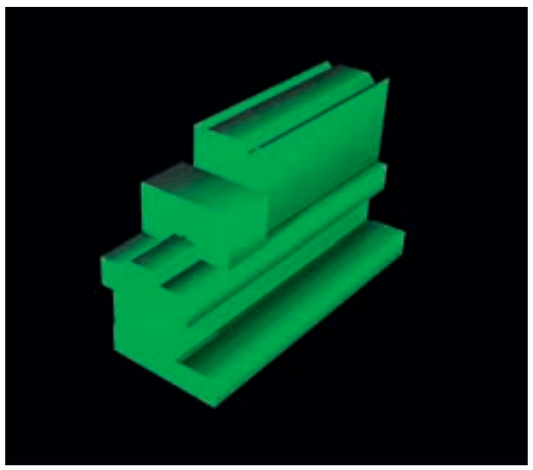
pair	0.2 kg

Fe37

on stock



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



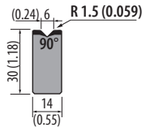
Self Centering 1-V Dies 90°

32000

NEW

950 kN/m max.

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



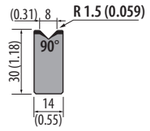
C45: 560-710 N/mm²

32100

NEW

950 kN/m max.

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



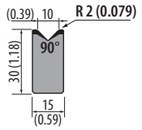
C45: 560-710 N/mm²

32300

NEW

950 kN/m max.

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



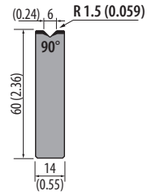
C45: 560-710 N/mm²

07000

NEW

950 kN/m max.

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



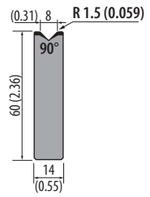
C45: 560-710 N/mm²

07100

NEW

950 kN/m max.

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



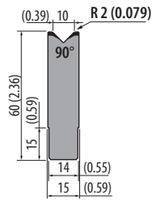
C45: 560-710 N/mm²

07300

NEW

950 kN/m max.

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



C45: 560-710 N/mm²

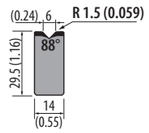
Self Centering 1-V Dies 88°

32006

NEW

950 kN/m max.

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



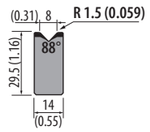
C45: 560-710 N/mm²

32106

NEW

950 kN/m max.

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



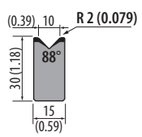
C45: 560-710 N/mm²

32200

NEW

950 kN/m max.

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



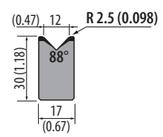
C45: 560-710 N/mm²

32400

NEW

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

on stock Article on stock

Please ask for delivery time!

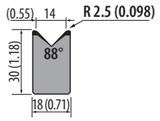
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

32500

1000 kN/m max.

NEW



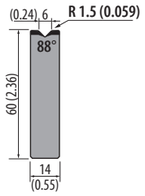
835 mm	32.87 in	3.3 kg
415 mm	16.34 in	1.6 kg

C45: 560-710 N/mm²

07006

950 kN/m max.

NEW



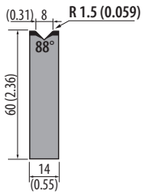
835 mm	32.87 in	5.5 kg
415 mm	16.34 in	2.7 kg

C45: 560-710 N/mm²

07106

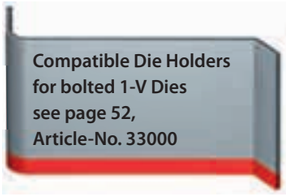
950 kN/m max.

NEW



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

C45: 560-710 N/mm²

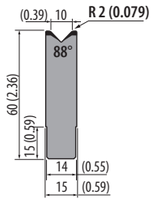


Compatible Die Holders
for bolted 1-V Dies
see page 52,
Article-No. 33000

07200

950 kN/m max.

NEW



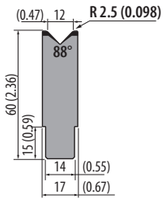
835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg

C45: 560-710 N/mm²

07400

950 kN/m max.

NEW

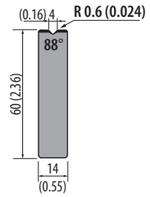


835 mm	32.87 in	6.0 kg
415 mm	16.34 in	3.0 kg

C45: 560-710 N/mm²

AMR60.04.88

1000 kN/m max.

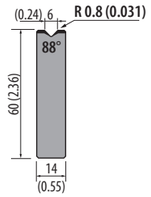


835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²

AMR60.06.88

1000 kN/m max.

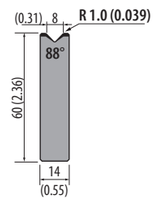


835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²

AMR60.08.88

1000 kN/m max.

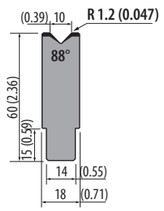


835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²

AMR60.10.88

1000 kN/m max.

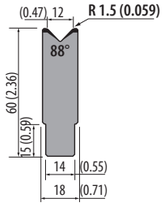


835 mm	32.87 in	5.6 kg
415 mm	16.34 in	2.8 kg
795 mm segmented	31.29 in segmented	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

C45: 560-710 N/mm²

AMR60.12.88

1000 kN/m max.

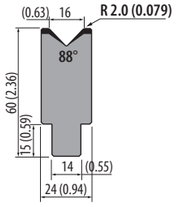


835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

C45: 560-710 N/mm²

AMR60.16.88

1000 kN/m max.

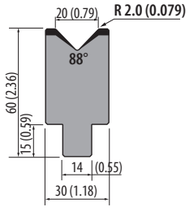


835 mm	32.87 in	7.1 kg
415 mm	16.34 in	3.5 kg
795 mm segmented	31.29 in segmented	6.8 kg
805 mm segmented	31.69 in segmented	6.9 kg

C45: 560-710 N/mm²

AMR60.20.88

1000 kN/m max.



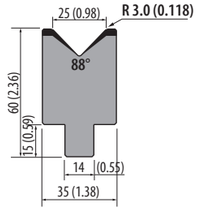
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
795 mm segmented	31.29 in segmented	7.6 kg
805 mm segmented	31.69 in segmented	7.7 kg

C45: 560-710 N/mm²

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

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

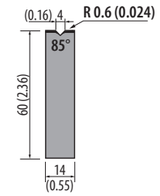
Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

Self Centering 1-V Dies 85°

AMR60.04.85

1000 kN/m max.

NEW



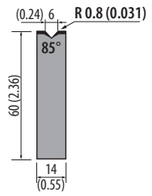
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²

AMR60.06.85

1000 kN/m max.

NEW



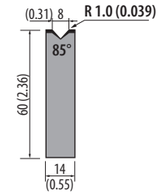
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²

AMR60.08.85

1000 kN/m max.

NEW



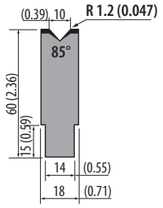
835 mm	32.87 in	5.4 kg
415 mm	16.34 in	2.7 kg
795 mm segmented	31.29 in segmented	5.1 kg
805 mm segmented	31.69 in segmented	5.2 kg

C45: 560-710 N/mm²

AMR60.10.85

1000 kN/m max.

NEW



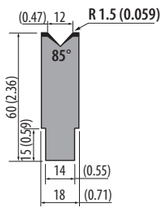
835 mm	32.87 in	5.6 kg
415 mm	16.34 in	2.8 kg
795 mm segmented	31.29 in segmented	5.3 kg
805 mm segmented	31.69 in segmented	5.4 kg

C45: 560-710 N/mm²

AMR60.12.85

1000 kN/m max.

NEW



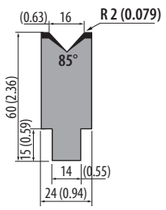
835 mm	32.87 in	6.1 kg
415 mm	16.34 in	3.0 kg
795 mm segmented	31.29 in segmented	5.8 kg
805 mm segmented	31.69 in segmented	5.9 kg

C45: 560-710 N/mm²

AMR60.16.85

1000 kN/m max.

NEW



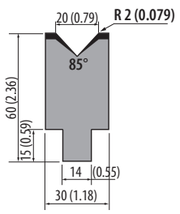
835 mm	32.87 in	7.1 kg
415 mm	16.34 in	3.5 kg
795 mm segmented	31.29 in segmented	6.8 kg
805 mm segmented	31.69 in segmented	6.9 kg

C45: 560-710 N/mm²

AMR60.20.85

1000 kN/m max.

NEW



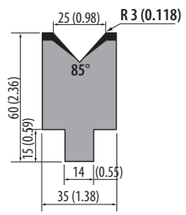
835 mm	32.87 in	8.0 kg
415 mm	16.34 in	4.0 kg
795 mm segmented	31.29 in segmented	7.6 kg
805 mm segmented	31.69 in segmented	7.7 kg

C45: 560-710 N/mm²

AMR60.25.85

1000 kN/m max.

NEW

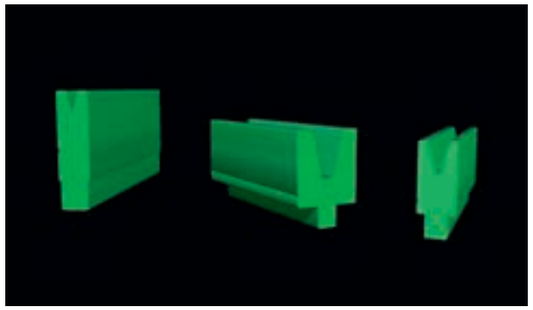


835 mm	32.87 in	9.2 kg
415 mm	16.34 in	4.6 kg
795 mm segmented	31.29 in segmented	8.8 kg
805 mm segmented	31.69 in segmented	8.9 kg

C45: 560-710 N/mm²

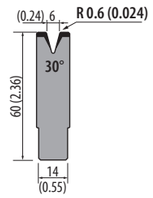
Self Centering 1-V Dies 30°

ROLLERI® PROFESSIONAL BENDING



AMR60.06.30

350 kN/m max.

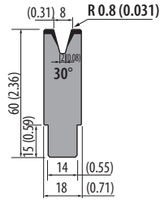


835 mm	32.87 in	5.9 kg
415 mm	16.34 in	2.9 kg
795 mm segmented	31.29 in segmented	5.6 kg
805 mm segmented	31.69 in segmented	5.7 kg

C45: 560-710 N/mm²

AMR60.08.30

350 kN/m max.

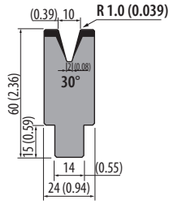


835 mm	32.87 in	6.6 kg
415 mm	16.34 in	3.3 kg
795 mm segmented	31.29 in segmented	6.3 kg
805 mm segmented	31.69 in segmented	6.4 kg

C45: 560-710 N/mm²

AMR60.10.30

500 kN/m max.

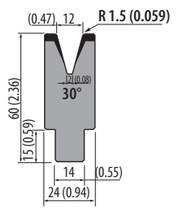


835 mm	32.87 in	7.8 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.4 kg
805 mm segmented	31.69 in segmented	7.5 kg

C45: 560-710 N/mm²

AMR60.12.30

400 kN/m max.

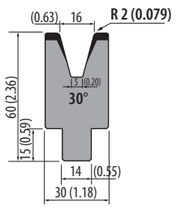


835 mm	32.87 in	7.9 kg
415 mm	16.34 in	3.9 kg
795 mm segmented	31.29 in segmented	7.5 kg
805 mm segmented	31.69 in segmented	7.6 kg

C45: 560-710 N/mm²

AMR60.16.30

450 kN/m max.

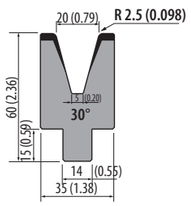


835 mm	32.87 in	8.8 kg
415 mm	16.34 in	4.7 kg
795 mm segmented	31.29 in segmented	8.4 kg
805 mm segmented	31.69 in segmented	8.5 kg

C45: 560-710 N/mm²

AMR60.20.30

500 kN/m max.

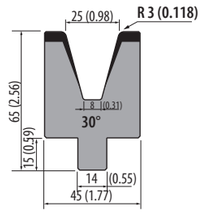


835 mm	32.87 in	15.9 kg
415 mm	16.34 in	7.9 kg
795 mm segmented	31.29 in segmented	15.1 kg
805 mm segmented	31.69 in segmented	15.3 kg

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

Article on stock

Please ask for delivery time!

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

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

Die Holders for Self Centering 1-V Dies

33000

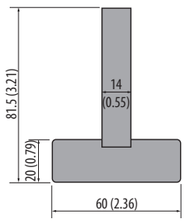
1000 kN/m max.

NEW

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

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

C45: 560-710 N/mm²



SU61F

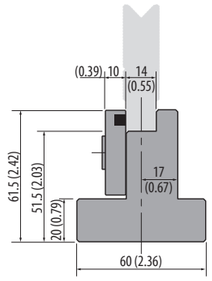
1000 kN/m max.

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

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

C45: 560-710 N/mm²

on stock



08000

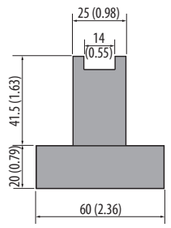
950 kN/m max.

NEW

1050 mm	41.34 in	17.8 kg

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

C45: 560-710 N/mm²



08100

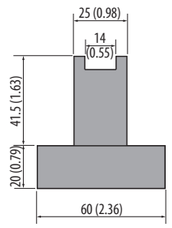
950 kN/m max.

NEW

1260 mm	49.61 in	21.4 kg

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

C45: 560-710 N/mm²



Prevention of Bending Marks

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

- Protective Sheets
- PU-Upholstery
- Synthetic Dies

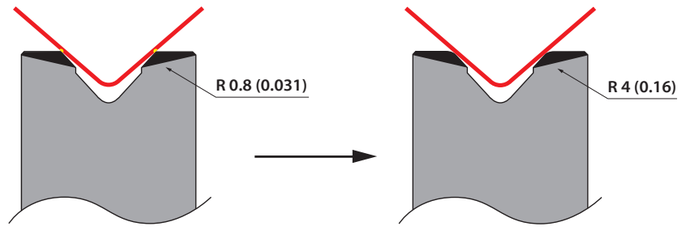
The alternative to these options mentioned above, is a modification of the dies:

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

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

Our Advantages – Your Convenience

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



Standard T-Die
with small inner radius
causes visible bending marks

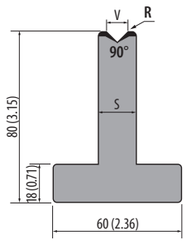
T-Die TR
with a larger inner radius
clearly reduces bending marks

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

T-Dies 90°, H=80 (3.15), H=120 (4.72)

T-Dies 90°, H=80 mm (3.15 in)

1000 kN/m max.



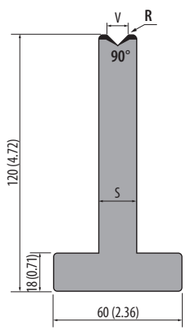
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	835 mm / 32.87 in Weight	415 mm / 16.34 in Weight	795 mm / 31.30 in segmented Weight	805 mm / 31.69 in segmented Weight	900 mm / 35.43 in Weight
T80.06.90	6	0.24	0.4	0.02	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg	14.0 kg
T80.08.90	8	0.31	0.5	0.02	14	0.55	13.0 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	7.5kg	14.3 kg	14.5 kg	

C45: 560-710 N/mm²

on stock

T-Dies 90°, H=120 mm (4.72 in)

1000 kN/m max.



Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	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

on stock

on stock Article on stock

Please ask for delivery time!

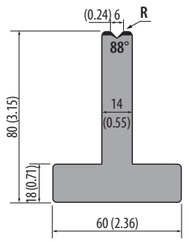
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

T-Dies 88°, H=80 (3.15)

T80.06.88 / TR80.06.88

1000 kN/m max.



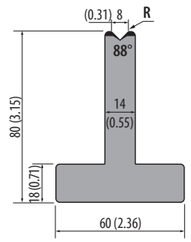
	R=0.4 (0.016)		
T80.06.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
	R=2.75 (0.108)		
TR80.06.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T80.08.88 / TR80.08.88

1000 kN/m max.



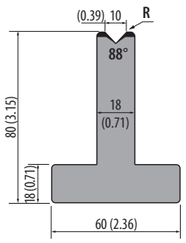
	R=0.5 (0.020)		
T80.08.88	835 mm	32.87 in	12.6 kg
	415 mm	16.34 in	6.3 kg
	795 mm segmented	31.29 in segmented	12.0 kg
	805 mm segmented	31.69 in segmented	12.1 kg
	R=2.75 (0.108)		
TR80.08.88	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T80.10.88 / TR80.10.88

1000 kN/m max.



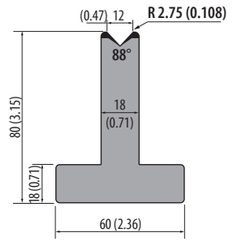
	R=0.8 (0.031)		
T80.10.88	835 mm	32.87 in	14.2 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	13.5 kg
	805 mm segmented	31.69 in segmented	13.7 kg
	R=2.75 (0.108)		
TR80.10.88	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T80.12.88

1000 kN/m max.



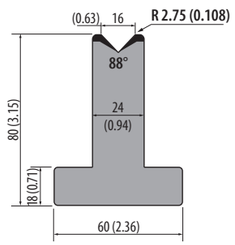
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

C45: 560-710 N/mm²

on stock

T80.16.88

1000 kN/m max.



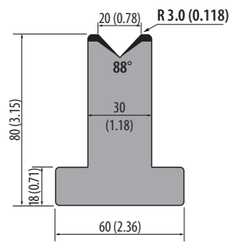
835 mm	32.87 in	16.6 kg
415 mm	16.34 in	8.3 kg
795 mm segmented	31.29 in segmented	15.8 kg
805 mm segmented	31.69 in segmented	16.0 kg

C45: 560-710 N/mm²

on stock

T80.20.88

1000 kN/m max.



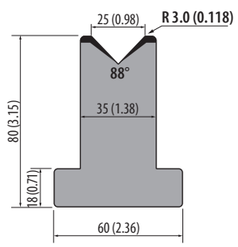
835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg
795 mm segmented	31.29 in segmented	17.6 kg
805 mm segmented	31.69 in segmented	17.8 kg

C45: 560-710 N/mm²

on stock

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

on stock

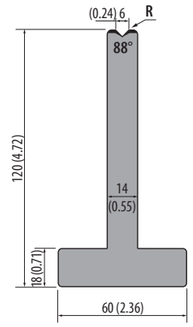
Articles on stock – Please note that delivery time varies according to your location.

T-Dies 88°, H=120 (4.72)

ROLLERI® PROFESSIONAL BENDING

T120.06.88 / TR120.06.88

1000 kN/m max.



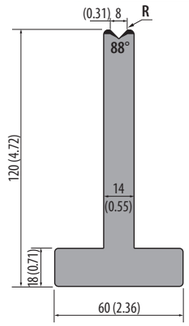
	R=0.4 (0.016)		
T120.06.88	835 mm	32.87 in	16.5 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.7 kg
	805 mm segmented	31.69 in segmented	16.0 kg
	R=2.75 (0.108)		
TR120.06.88	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T120.08.88 / TR120.08.88

1000 kN/m max.



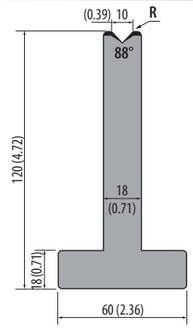
	R=0.5 (0.020)		
T120.08.88	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
	R=2.75 (0.108)		
TR120.08.88	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T120.10.88 / TR120.10.88

1000 kN/m max.



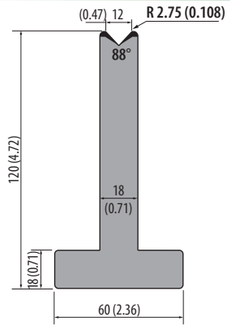
	R=0.8 (0.031)		
T120.10.88	835 mm	32.87 in	19.0 kg
	415 mm	16.34 in	9.5 kg
	795 mm segmented	31.29 in segmented	18.0 kg
	805 mm segmented	31.69 in segmented	18.3 kg
	R=2.75 (0.108)		
TR120.10.88	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T120.12.88

1000 kN/m max.



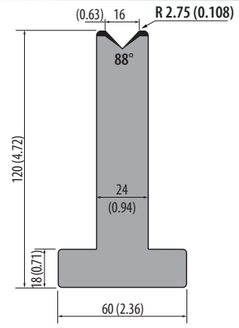
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	18.0 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²

on stock

T120.16.88

1000 kN/m max.



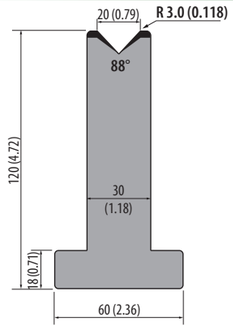
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²

on stock

T120.20.88

1000 kN/m max.



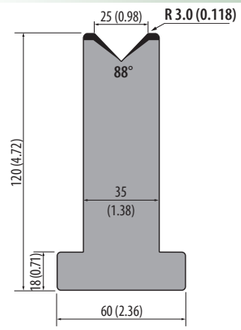
835 mm	32.87 in	27.0 kg
415 mm	16.34 in	13.5 kg
795 mm segmented	31.29 in segmented	25.7 kg
805 mm segmented	31.69 in segmented	26.0 kg

C45: 560-710 N/mm²

on stock

T120.25.88

1000 kN/m max.



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

C45: 560-710 N/mm²

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on stock Article on stock

Please ask for delivery time!

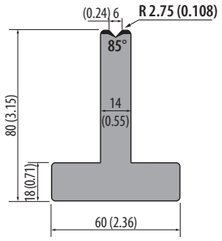
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

T-Dies 85°, H=80 (3.15)

T80.06.85

1000 kN/m max.

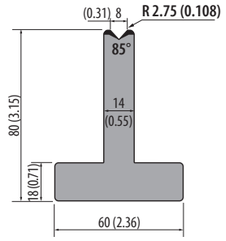


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

T80.08.85

1000 kN/m max.

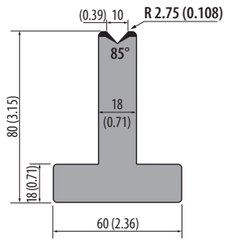


835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.2 kg
795 mm segmented	31.29 in segmented	12.0 kg
805 mm segmented	31.69 in segmented	12.1 kg

C45: 560-710 N/mm²

T80.10.85

1000 kN/m max.

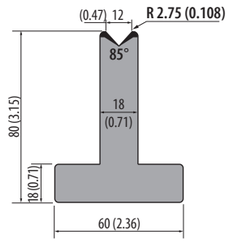


835 mm	32.87 in	14.2 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.5 kg
805 mm segmented	31.69 in segmented	13.7 kg

C45: 560-710 N/mm²

T80.12.85

1000 kN/m max.

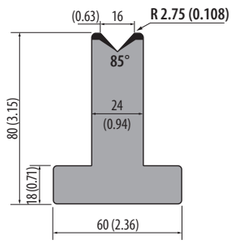


835 mm	32.87 in	14.1 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.4 kg
805 mm segmented	31.69 in segmented	13.6 kg

C45: 560-710 N/mm²

T80.16.85

1000 kN/m max.

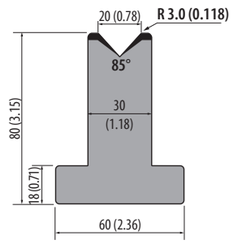


835 mm	32.87 in	16.4 kg
415 mm	16.34 in	8.2 kg
795 mm segmented	31.29 in segmented	15.6 kg
805 mm segmented	31.69 in segmented	15.8 kg

C45: 560-710 N/mm²

T80.20.85

1000 kN/m max.

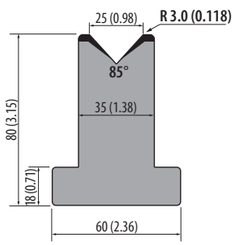


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²

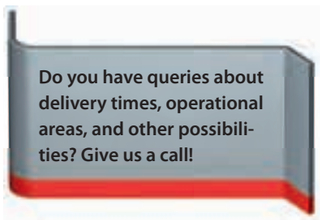
T80.25.85

1000 kN/m max.



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

C45: 560-710 N/mm²



T-Dies 85°, H=120 (4.72)

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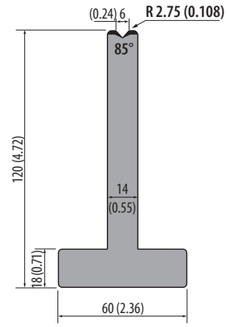
T120.06.85

1000 kN/m max.

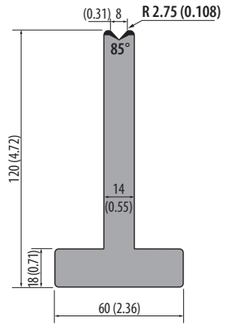


835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

C45: 560-710 N/mm²

T120.08.85

1000 kN/m max.

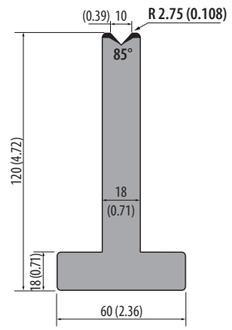


835 mm	32.87 in	16.3 kg
415 mm	16.34 in	8.1 kg
795 mm segmented	31.29 in segmented	15.5 kg
805 mm segmented	31.69 in segmented	15.7 kg

C45: 560-710 N/mm²

T120.10.85

1000 kN/m max.

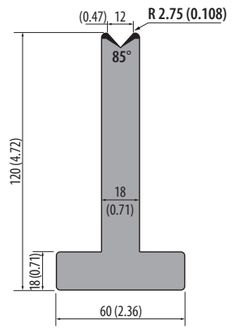


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²

T120.12.85

1000 kN/m max.

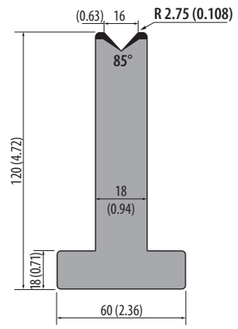


835 mm	32.87 in	18.9 kg
415 mm	16.34 in	9.4 kg
795 mm segmented	31.29 in segmented	18.0 kg
805 mm segmented	31.69 in segmented	18.2 kg

C45: 560-710 N/mm²

T120.16.85

1000 kN/m max.

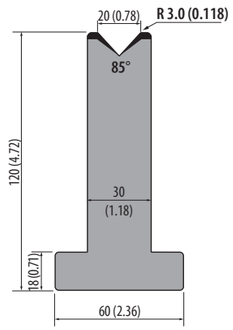


835 mm	32.87 in	22.7 kg
415 mm	16.34 in	11.3 kg
795 mm segmented	31.29 in segmented	21.7 kg
805 mm segmented	31.69 in segmented	21.9 kg

C45: 560-710 N/mm²

T120.20.85

1000 kN/m max.

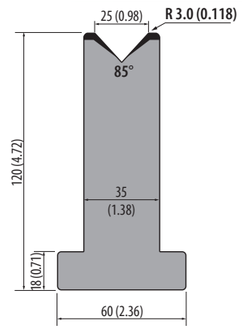


835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg
795 mm segmented	31.29 in segmented	28.6 kg
805 mm segmented	31.69 in segmented	28.9 kg

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

Article on stock

Please ask for delivery time!

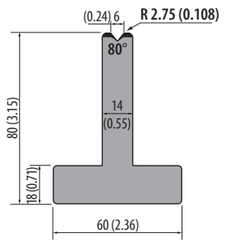
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

T-Dies 80°, H=80 (3.15)

T80.06.80

950 kN/m max.



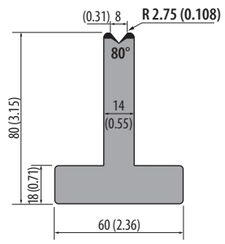
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

on stock

T80.08.80

950 kN/m max.



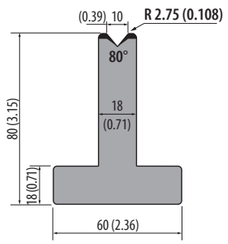
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

on stock

T80.10.80

950 kN/m max.



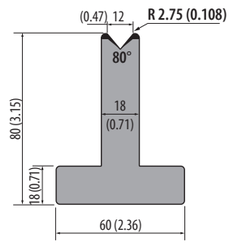
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

on stock

T80.12.80

950 kN/m max.



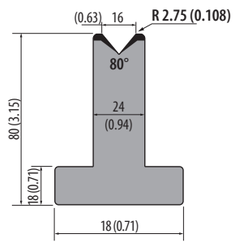
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

on stock

T80.16.80

950 kN/m max.



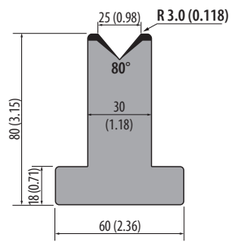
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

on stock

T80.20.80

950 kN/m max.



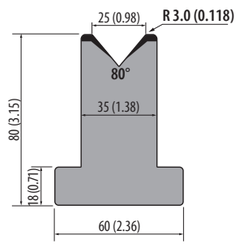
835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.5 kg

C45: 560-710 N/mm²

on stock

T80.25.80

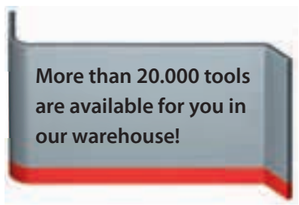
950 kN/m max.



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

on stock

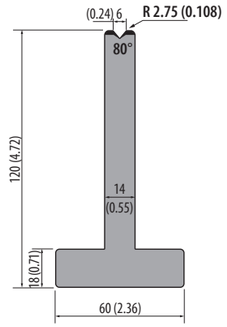


T-Dies 80°, H=120 (4.72)

ROLLERI® PROFESSIONAL BENDING

T120.06.80

950 kN/m max.



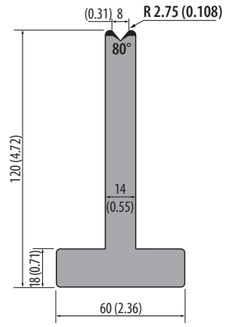
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²

on stock

T120.08.80

950 kN/m max.



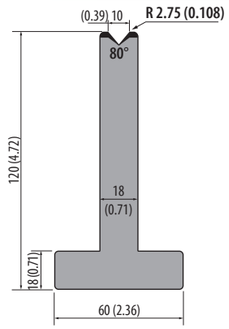
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²

on stock

T120.10.80

950 kN/m max.



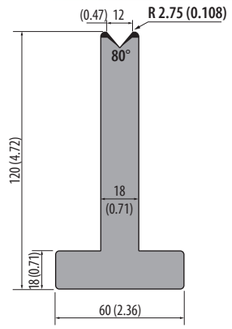
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²

on stock

T120.12.80

950 kN/m max.



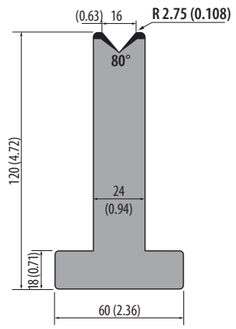
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²

on stock

T120.16.80

950 kN/m max.



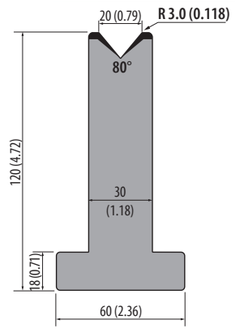
835 mm	32.87 in	18.8 kg
415 mm	16.34 in	9.3 kg
795 mm segmented	31.29 in segmented	17.9 kg
805 mm segmented	31.69 in segmented	18.1 kg

C45: 560-710 N/mm²

on stock

T120.20.80

950 kN/m max.



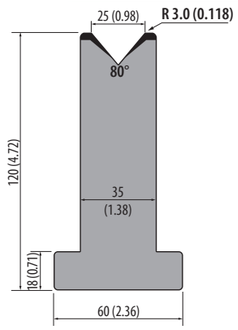
835 mm	32.87 in	26.3 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	25.0 kg
805 mm segmented	31.69 in segmented	25.4 kg

C45: 560-710 N/mm²

on stock

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

on stock

on stock Article on stock

Please ask for delivery time!

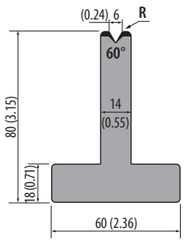
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

T-Dies 60°, H=80 (3.15)

T80.06.60 / TR80.06.60

600 kN/m max.



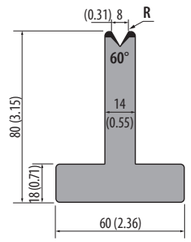
T80.06.60	R=0.5 (0.020)		
	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
TR80.06.60	R=1.5 (0.059)		
	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T80.08.60 / TR80.08.60

600 kN/m max.



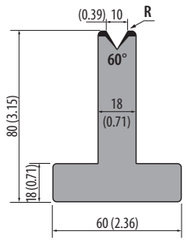
T80.08.60	R=0.8 (0.031)		
	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented	31.69 in segmented	12.5 kg
TR80.08.60	R=1.5 (0.059)		
	835 mm	32.87 in	13.0 kg
	415 mm	16.34 in	6.5 kg
	795 mm segmented	31.29 in segmented	12.4 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T80.10.60 / TR80.10.60

600 kN/m max.



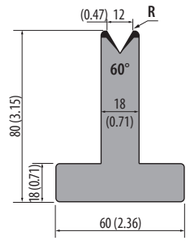
T80.10.60	R=0.8 (0.031)		
	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
TR80.10.60	R=2.75 (0.108)		
	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T80.12.60 / TR80.12.60

600 kN/m max.



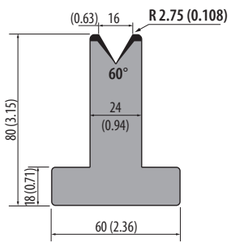
T80.12.60	R=0.8 (0.031)		
	835 mm	32.87 in	17.0 kg
	415 mm	16.34 in	7.0 kg
	795 mm segmented	31.29 in segmented	16.2 kg
	805 mm segmented	31.69 in segmented	16.4 kg
TR80.12.60	R=2.75 (0.108)		
	835 mm	32.87 in	15.0 kg
	415 mm	16.34 in	7.5 kg
	795 mm segmented	31.29 in segmented	14.3 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T80.16.60

600 kN/m max.



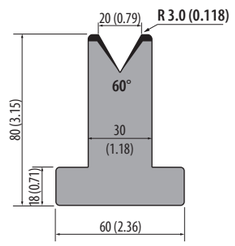
835 mm	32.87 in	15.6 kg
415 mm	16.34 in	8.7 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	15.0 kg

C45: 560-710 N/mm²

on stock

T80.20.60

600 kN/m max.



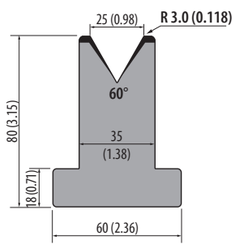
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.4 kg

C45: 560-710 N/mm²

on stock

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

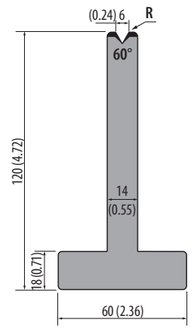
on stock

T-Dies 60°, H=120 (4.72)

ROLLERI® PROFESSIONAL BENDING

T120.06.60 / TR120.06.60

600 kN/m max.



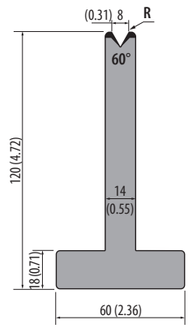
T120.06.60	R=0.5 (0.020)		
	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
TR120.06.60	R=1.5 (0.059)		
	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T120.08.60 / TR120.08.60

600 kN/m max.



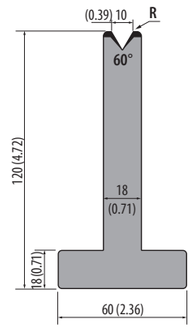
T120.08.60	R=0.8 (0.031)		
	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented	31.69 in segmented	15.4 kg
TR120.08.60	R=1.5 (0.059)		
	835 mm	32.87 in	16.0 kg
	415 mm	16.34 in	8.0 kg
	795 mm segmented	31.29 in segmented	15.2 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T120.10.60 / TR120.10.60

600 kN/m max.



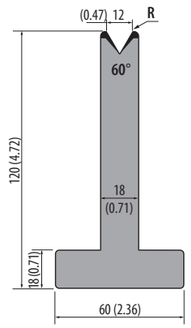
T120.10.60	R=0.8 (0.031)		
	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
TR120.10.60	R=2.75 (0.108)		
	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T120.12.60 / TR120.12.60

600 kN/m max.



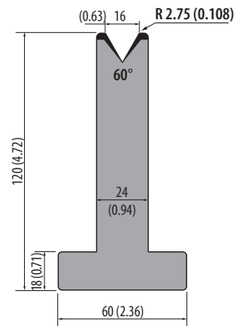
T120.12.60	R=0.8 (0.031)		
	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented	31.69 in segmented	17.4 kg
TR120.12.60	R=2.75 (0.108)		
	835 mm	32.87 in	18.0 kg
	415 mm	16.34 in	9.0 kg
	795 mm segmented	31.29 in segmented	17.1 kg
	805 mm segmented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

C45: 560-710 N/mm²

on stock

T120.16.60

600 kN/m max.



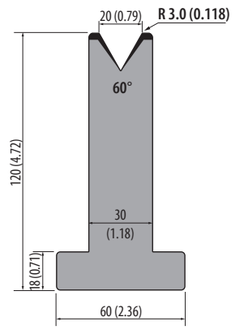
835 mm	32.87 in	22.4 kg
415 mm	16.34 in	11.1 kg
795 mm segmented	31.29 in segmented	21.3 kg
805 mm segmented	31.69 in segmented	21.6 kg

C45: 560-710 N/mm²

on stock

T120.20.60

600 kN/m max.



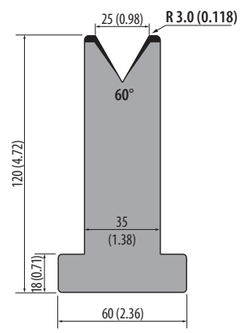
835 mm	32.87 in	26.0 kg
415 mm	16.34 in	13.0 kg
795 mm segmented	31.29 in segmented	24.8 kg
805 mm segmented	31.69 in segmented	25.0 kg

C45: 560-710 N/mm²

on stock

T120.25.60

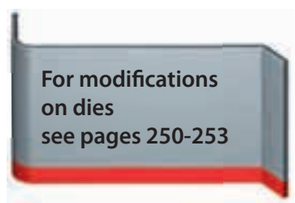
600 kN/m max.



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

on stock



on stock Article on stock

Please ask for delivery time!

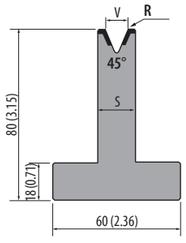
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

T-Dies 45°, H=80 (3.15), H=120 (4.72)

T-Dies 45°, H=80 mm (3.15 in)

500 kN/m max.



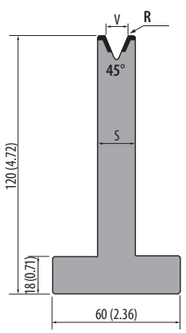
Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	835 mm / 32.87 in Weight	415 mm / 16.34 in Weight	795 mm / 31.30 in segmented Weight	805 mm / 31.69 in segmented Weight
T80.06.45	6	0.24	0.8	0.03	14	0.55	13.0 kg	6.5 kg	12.4 kg	12.5 kg
T80.08.45	8	0.31	1.0	0.04	18	0.71	15.0 kg	7.5 kg	14.3 kg	14.5 kg
T80.10.45	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

on stock

T-Dies 45°, H=120 mm (4.72 in)

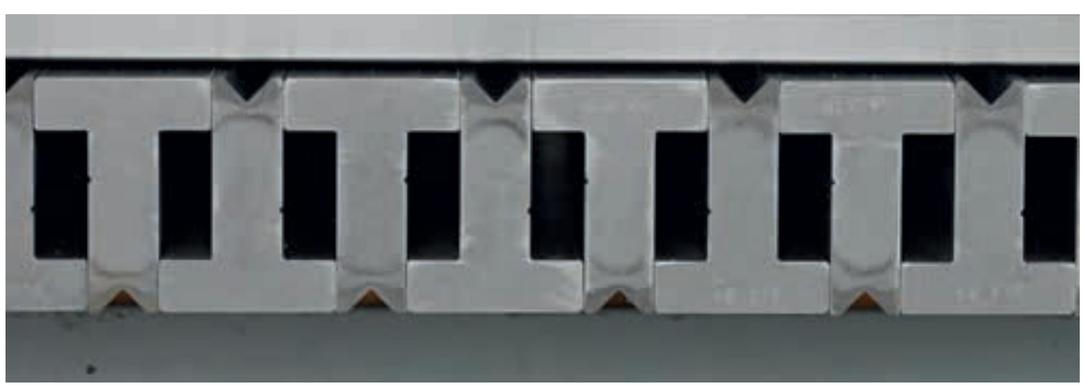
500 kN/m max.



Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	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
T120.06.45	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

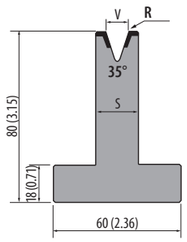
on stock



T-Dies 35°, H=80 (3.15), H=120 (4.72)

ROLLERI® PROFESSIONAL BENDING

T-Dies 35°, H=80 mm (3.15 in)

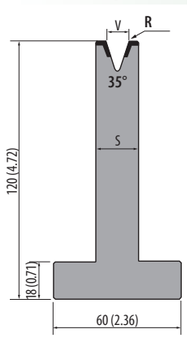


Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	835 mm / 32.87 in Weight	415 mm / 16.34 in Weight	795 mm / 31.30 in segmented Weight	805 mm / 31.69 in segmented Weight
T80.06.35	6	0.24	0.8	0.03	14	0.55	350	12.5 kg	6.5 kg	11.9 kg	12.0 kg
T80.08.35	8	0.31	1.0	0.04	16	0.63	350	13.0 kg	7.0 kg	12.4 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

on stock

T-Dies 35°, H=120 mm (4.72 in)



Model	V (mm)	V (in)	R (mm)	R (in)	S (mm)	S (in)	kN/m max.	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
T120.06.35	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

on stock

on stock Article on stock

Please ask for delivery time!

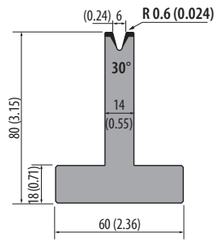
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

T-Dies 30°, H=80 (3.15)

T80.06.30

350 kN/m max.

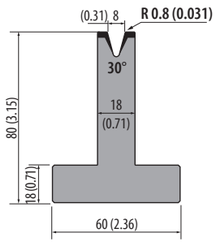


835 mm	32.87 in	12.4 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	11.8 kg
805 mm segmented	31.69 in segmented	12.0 kg

C45: 560-710 N/mm²

T80.08.30

350 kN/m max.

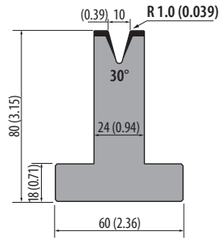


835 mm	32.87 in	13.0 kg
415 mm	16.34 in	6.5 kg
795 mm segmented	31.29 in segmented	12.4 kg
805 mm segmented	31.69 in segmented	12.6 kg

C45: 560-710 N/mm²

T80.10.30

500 kN/m max.

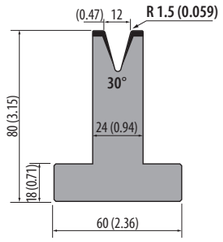


835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²

T80.12.30

400 kN/m max.

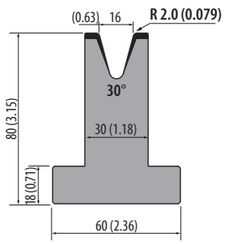


835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²

T80.16.30

450 kN/m max.

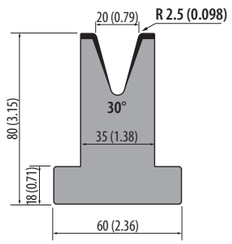


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²

T80.20.30

500 kN/m max.

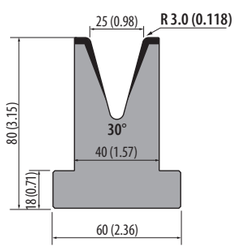


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	8.9 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²

T80.25.30

500 kN/m max.



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

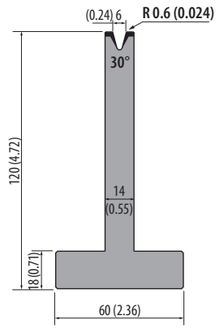
C45: 560-710 N/mm²

T-Dies 30°, H=120 (4.72)

ROLLERI® PROFESSIONAL BENDING

T120.06.30

350 kN/m max.

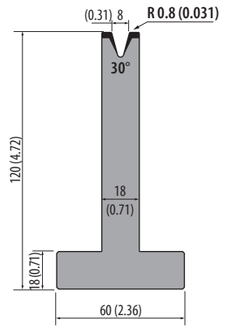


835 mm	32.87 in	16.0 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	15.2 kg
805 mm segmented	31.69 in segmented	15.4 kg

C45: 560-710 N/mm²

T120.08.30

350 kN/m max.

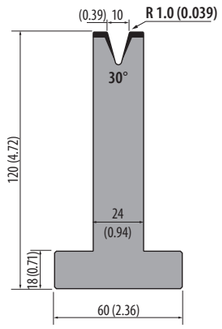


835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²

T120.10.30

500 kN/m max.

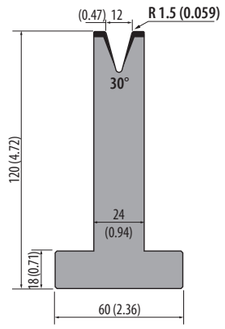


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.9 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²

T120.12.30

400 kN/m max.

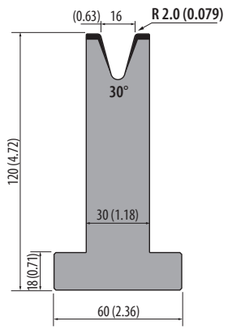


835 mm	32.87 in	22.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²

T120.16.30

450 kN/m max.

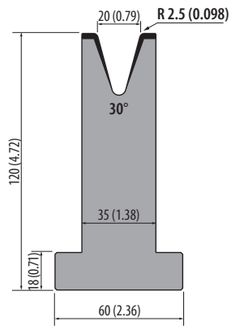


835 mm	32.87 in	25.8 kg
415 mm	16.34 in	12.8 kg
795 mm segmented	31.29 in segmented	24.6 kg
805 mm segmented	31.69 in segmented	24.9 kg

C45: 560-710 N/mm²

T120.20.30

500 kN/m max.

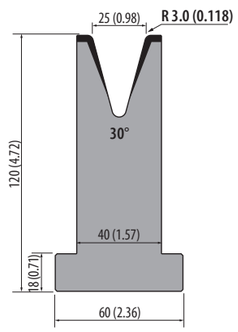


835 mm	32.87 in	28.0 kg
415 mm	16.34 in	14.0 kg
795 mm segmented	31.29 in segmented	26.7 kg
805 mm segmented	31.69 in segmented	27.0 kg

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

Article on stock

Please ask for delivery time!

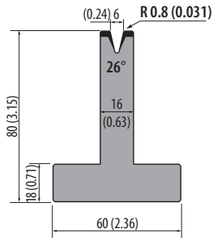
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

T-Dies 26°, H=80 (3.15)

T80.06.26

200 kN/m max.



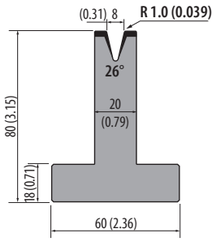
835 mm	32.87 in	14.0 kg
415 mm	16.34 in	7.0 kg
795 mm segmented	31.29 in segmented	13.3 kg
805 mm segmented	31.69 in segmented	13.5 kg

C45: 560-710 N/mm²

on stock

T80.08.26

200 kN/m max.



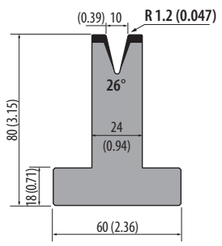
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg
795 mm segmented	31.29 in segmented	14.3 kg
805 mm segmented	31.69 in segmented	14.5 kg

C45: 560-710 N/mm²

on stock

T80.10.26

200 kN/m max.



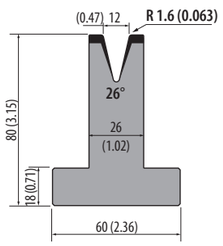
835 mm	32.87 in	15.5 kg
415 mm	16.34 in	8.0 kg
795 mm segmented	31.29 in segmented	14.8 kg
805 mm segmented	31.69 in segmented	14.9 kg

C45: 560-710 N/mm²

on stock

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

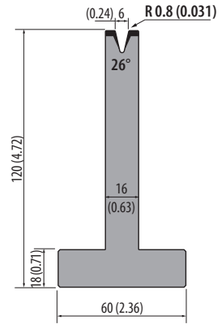
on stock

T-Dies 26°, H=120 (4.72)

ROLLERI® PROFESSIONAL BENDING

T120.06.26

200 kN/m max.



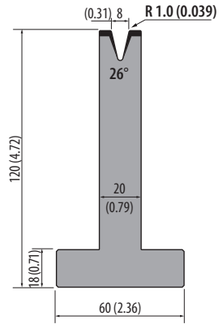
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²

on stock

T120.08.26

200 kN/m max.



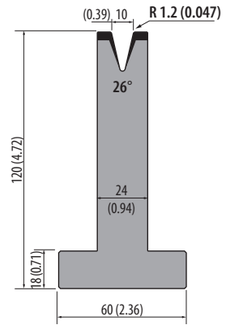
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²

on stock

T120.10.26

200 kN/m max.



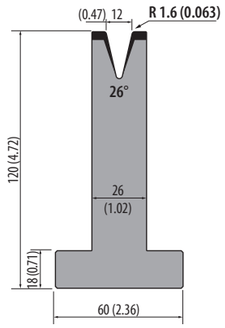
835 mm	32.87 in	22.0 kg
415 mm	16.34 in	11.0 kg
795 mm segmented	31.29 in segmented	20.9 kg
805 mm segmented	31.69 in segmented	21.2 kg

C45: 560-710 N/mm²

on stock

T120.12.26

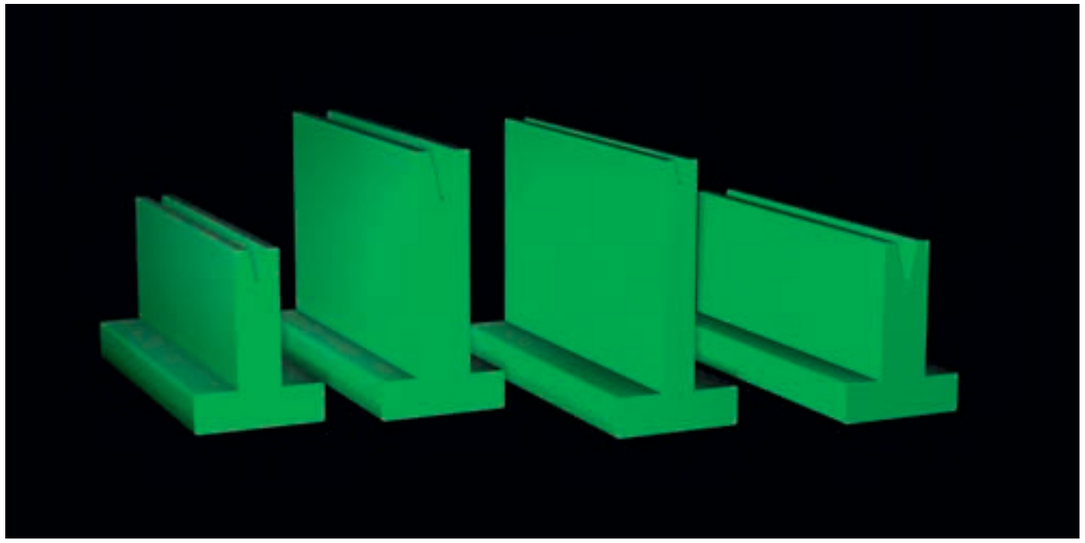
200 kN/m max.



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

on stock



on stock Article on stock

Please ask for delivery time!

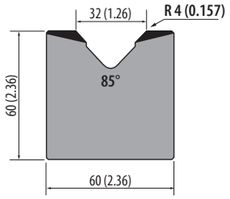
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

1-V Dies, 85°

M60.85.32

1000 kN/m max.



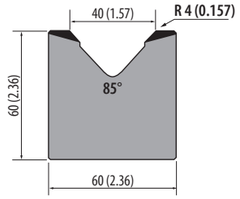
835 mm	32.87 in	21.6 kg
415 mm	16.34 in	10.7 kg
795 mm segmented	31.29 in segmented	20.6 kg
805 mm segmented	31.69 in segmented	20.8 kg

C45: 560-710 N/mm²

on stock

M60.85.40

1000 kN/m max.



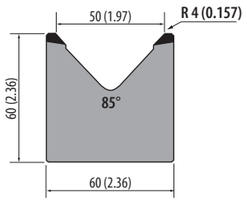
835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.5 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²

on stock

M60.85.50

1000 kN/m max.



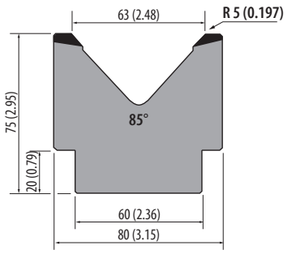
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg
795 mm segmented	31.29 in segmented	18.1 kg
805 mm segmented	31.69 in segmented	18.3 kg

C45: 560-710 N/mm²

on stock

M75.85.63

1000 kN/m max.



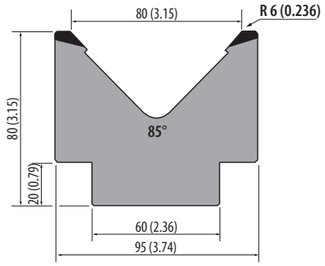
835 mm	32.87 in	29.2 kg
415 mm	16.34 in	14.5 kg
795 mm segmented	31.29 in segmented	27.8 kg
805 mm segmented	31.69 in segmented	28.0 kg

C45: 560-710 N/mm²

on stock

M80.85.80

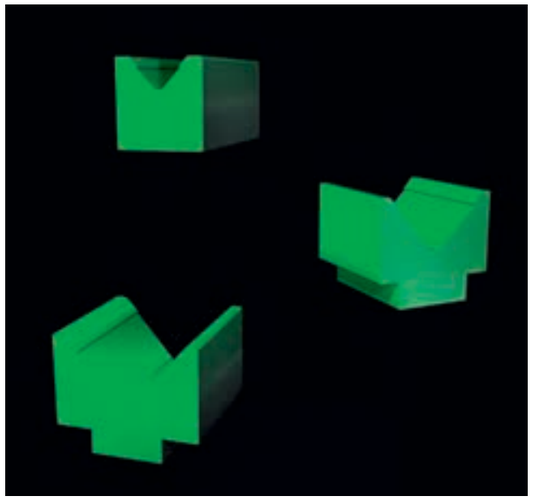
1000 kN/m max.



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

on stock

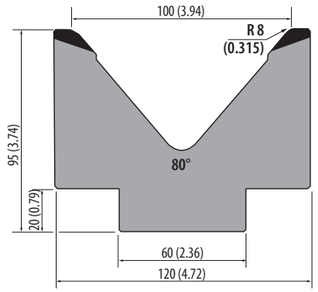


1-V Dies, 80°

ROLLERI® PROFESSIONAL BENDING

M95.80.100

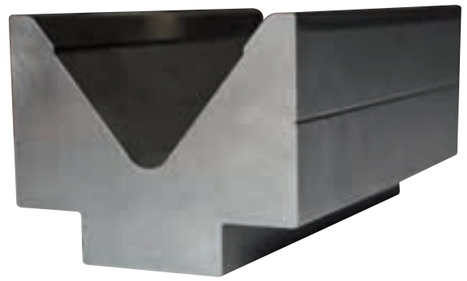
1000 kN/m max.



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

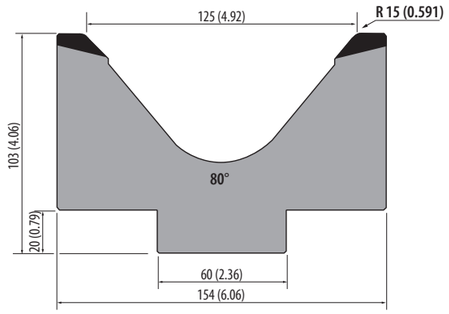
C45: 560-710 N/mm²

on stock



MK103.80.125

700 kN/m max.



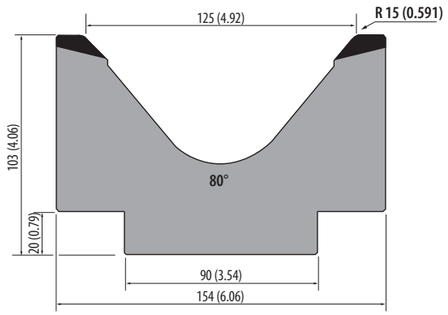
835 mm	32.87 in	62.0 kg
415 mm	16.34 in	31.0 kg
795 mm segmented	31.29 in segmented	59.0 kg
805 mm segmented	31.69 in segmented	59.8 kg

on stock

C45: 560-710 N/mm²

M103.80.125

1000 kN/m max.



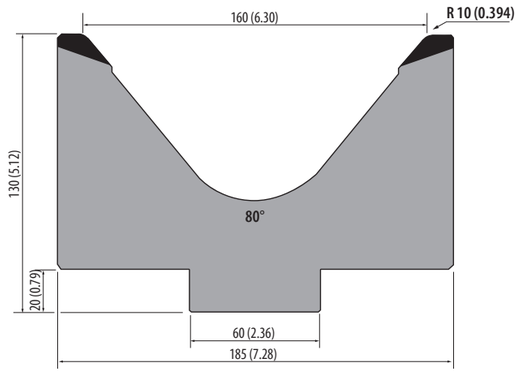
835 mm	32.87 in	64.9 kg
415 mm	16.34 in	32.2 kg
795 mm segmented	31.29 in segmented	61.4 kg
805 mm segmented	31.69 in segmented	62.5 kg

on stock

C45: 560-710 N/mm²

MK130.80.160

700 kN/m max.



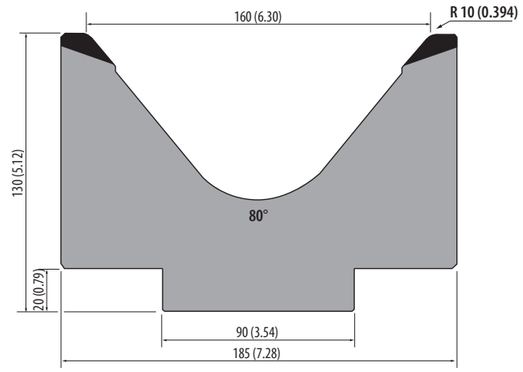
835 mm	32.87 in	93.0 kg
415 mm	16.34 in	46.5 kg
795 mm segmented	31.29 in segmented	88.5 kg
805 mm segmented	31.69 in segmented	89.7 kg

on stock

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

on stock

C45: 560-710 N/mm²

on stock Article on stock

Please ask for delivery time!

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

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

1-V Dies, 70°

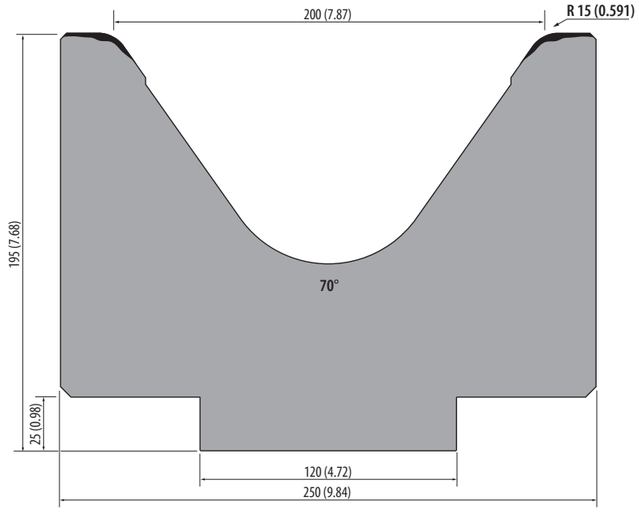
M195.70.200

1800 kN/m max.

415 mm	16.34 in	104.0 kg

42Cr: 900-1150 N/mm²

on stock



1-V Dies, 60°

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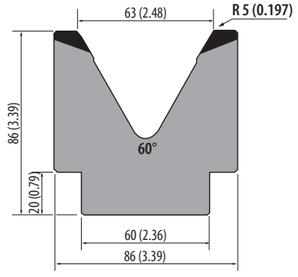
M86.60.63

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

on stock



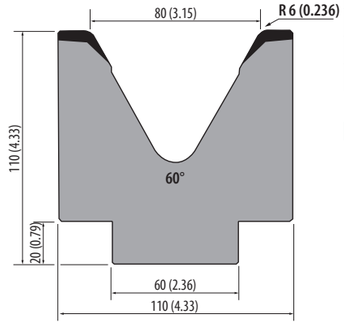
M110.60.80

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

on stock



1-V Dies, 45°

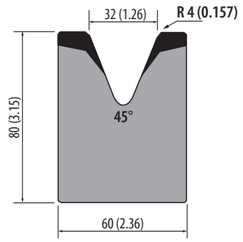
M80.45.32

1000 kN/m max.

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

C45: 560-710 N/mm²

on stock



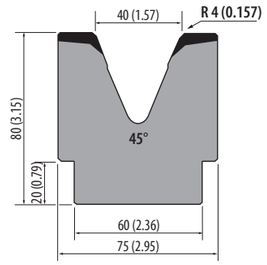
M80.45.40

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

on stock



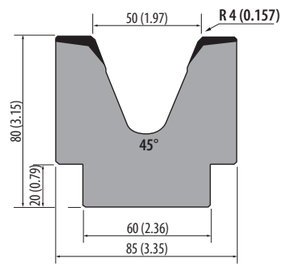
M80.45.50

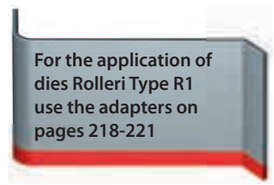
950 kN/m max.

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

on stock





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

on stock Article on stock

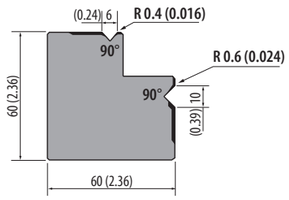
Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (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.

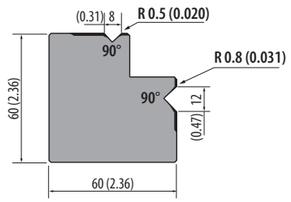


835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²

M60.90.02

800 kN/m max.

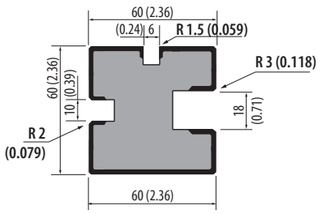


835 mm	32.87 in	21.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	20.0 kg
805 mm segmented	31.69 in segmented	20.2 kg

C45: 560-710 N/mm²

M.360.R

1000 kN/m max.

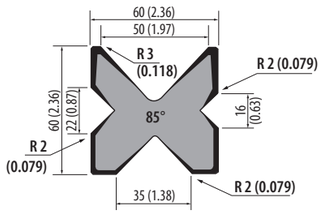


835 mm	32.87 in	20.0 kg
415 mm	16.34 in	10.0 kg
795 mm segmented	31.29 in segmented	19.0 kg
805 mm segmented	31.69 in segmented	19.3 kg

C45: 560-710 N/mm²

M.460.R

800 kN/m max.

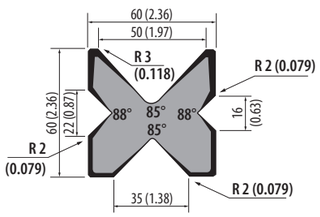


835 mm	32.87 in	15.7 kg
415 mm	16.34 in	7.7 kg
795 mm segmented	31.29 in segmented	14.9 kg
805 mm segmented	31.69 in segmented	15.1 kg

C45: 560-710 N/mm²

M.460

800 kN/m max.

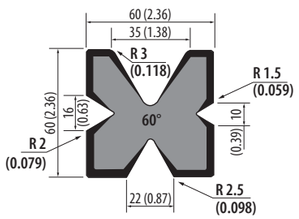


835 mm	32.87 in	15.8 kg
415 mm	16.34 in	7.8 kg
795 mm segmented	31.29 in segmented	15.0 kg
805 mm segmented	31.69 in segmented	15.2 kg

C45: 560-710 N/mm²

M.460.60

600 kN/m max.

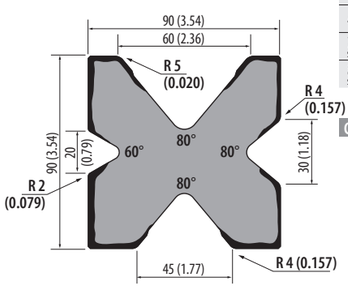


835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg
795 mm segmented	31.29 in segmented	17.1 kg
805 mm segmented	31.69 in segmented	17.3 kg

C45: 560-710 N/mm²

M.490

1000 kN/m max.

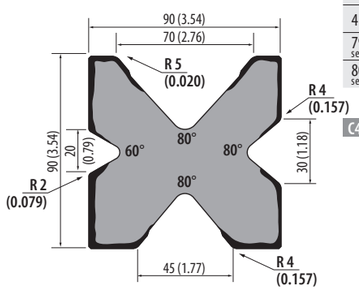


835 mm	32.87 in	38.9 kg
415 mm	16.34 in	20.0 kg
795 mm segmented	31.29 in segmented	37.0 kg
805 mm segmented	31.69 in segmented	37.5 kg

C45: 560-710 N/mm²

M.490.70

600 kN/m max.

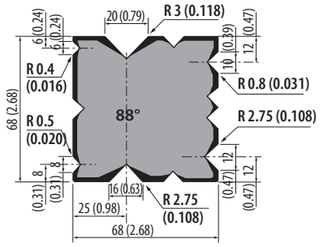


835 mm	32.87 in	35.9 kg
415 mm	16.34 in	18.0 kg
795 mm segmented	31.29 in segmented	34.2 kg
805 mm segmented	31.69 in segmented	34.6 kg

C45: 560-710 N/mm²

T70-88

1000 kN/m max.



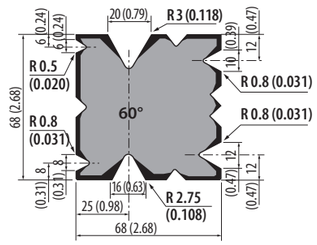
525 mm	20.67 in	17.5 kg
495 mm segmented	19.49 in segmented	16.5 kg

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

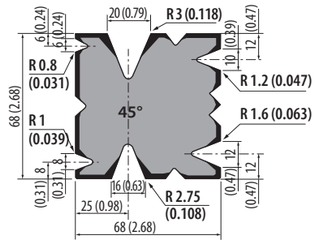


V (mm)	6	8	10	12	16	20
V (in)	0,24	0,31	0,39	0,47	0,63	0,79
kN/m max.	600	600	600	600	800	800

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

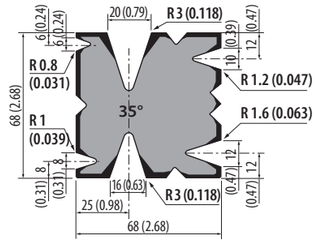


V (mm)	6	8	10	12	16	20
V (in)	0,24	0,31	0,39	0,47	0,63	0,79
kN/m max.	400	400	500	500	700	700

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

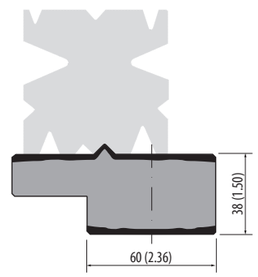


V (mm)	6	8	10	12	16	20
V (in)	0,24	0,31	0,39	0,47	0,63	0,79
kN/m max.	300	350	450	450	500	500

SU-T70

525 mm | 20.67 in | 12.4 kg

C45: 560-710 N/mm²

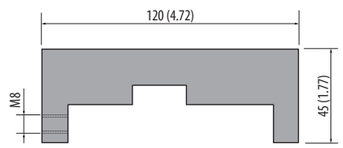


PB-T70

20 mm | 0.79 in | 0.2 kg

per pair

Fe37



Special Punches and Dies see pages 236-241

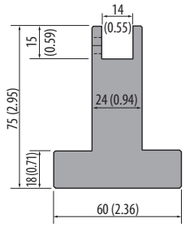
Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

TN80.14

1000 kN/m max.

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

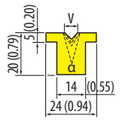
C45: 560-710 N/mm²



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

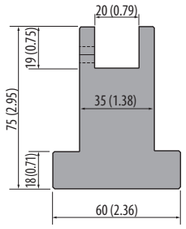
Model	α	V (mm)	V (in)
INS14.06.45	45°	6	0.24
INS14.08.45	45°	8	0.31
INS14.10.45	45°	10	0.39
INS14.06.30	30°	6	0.24
INS14.08.30	30°	8	0.31

TN80.20

1000 kN/m max.

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

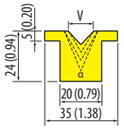
C45: 560-710 N/mm²



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

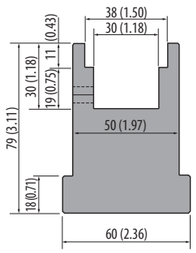
Model	α	V (mm)	V (in)
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39

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

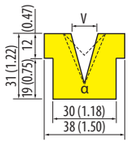


For advantages and mounting examples see Mark-Free bending Chapter on pages 228-229

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

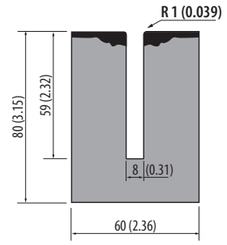
Model	α	V (mm)	V (in)
INS30.06.45	45°	6	0.24
INS30.08.45	45°	8	0.31
INS30.10.45	45°	10	0.39
INS30.12.45	45°	12	0.47
INS30.16.45	45°	16	0.63
INS30.20.45	45°	20	0.79
INS30.06.30	30°	6	0.24
INS30.08.30	30°	8	0.31
INS30.10.30	30°	10	0.39
INS30.12.30	30°	12	0.47
INS30.16.30	30°	16	0.63

ROLLERI® PROFESSIONAL BENDING

TOP.SM-134.28.8 / TOP.SM-134.24.8

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

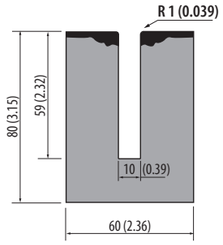
42Cr: 900-1150 N/mm²



TOP.SM-134.24.10

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

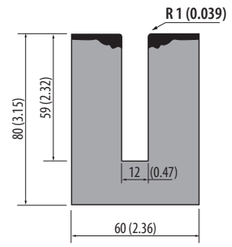
42Cr: 900-1150 N/mm²



TOP.SM-134.24.12

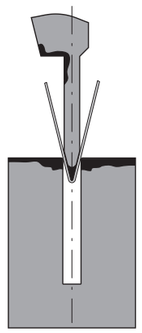
525 mm	20.67 in	16.8 kg
495 mm segmented	19.49 in segmented	15.9 kg

42Cr: 900-1150 N/mm²

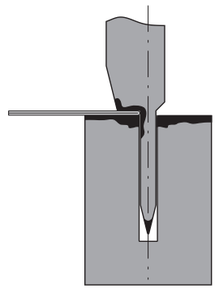


Compatible Hemming Punches see page 28

Example of application



500 kN/m max.



1000 kN/m max.

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26

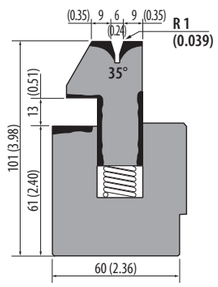
S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

Spring-loaded Hemming Dies

S101.35.06

600 kN/m max.



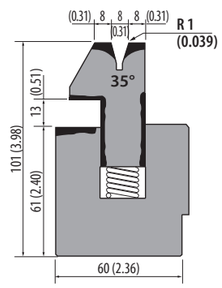
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.4 kg

C45: 800-850 N/mm²

on stock

S101.35.08

600 kN/m max.



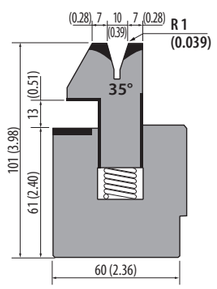
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²

on stock

S101.35.10

600 kN/m max.



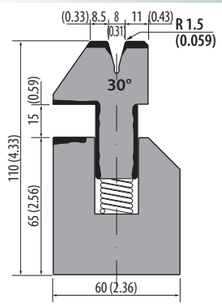
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 800-850 N/mm²

on stock

S110.30.08

800 kN/m max.



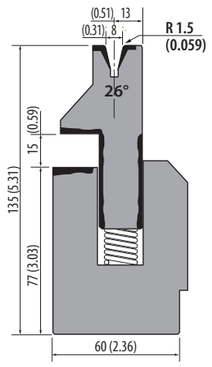
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.0 kg

C45: 800-850 N/mm²

on stock

S135.26.08

400 kN/m max.



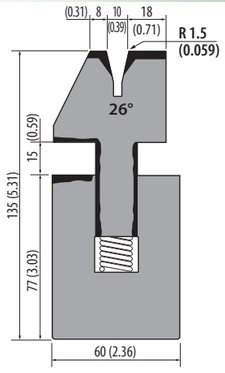
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

C45: 800-850 N/mm²

on stock

S135.26.10

1000 kN/m max.



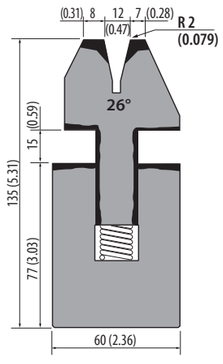
835 mm	32.87 in	41.5 kg
415 mm	16.34 in	20.7 kg

C45: 800-850 N/mm²

on stock

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

on stock

Our Advantage – Your Convenience

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

Rolleri Videos

demonstration of hemming dies at:
www.rolleritools.com/videos/hemming-dies

Pneumatic Hemming Dies

ROLLERI® PROFESSIONAL BENDING

KPN

per piece	1.0 kg

Accessories for pneumatic hemming dies

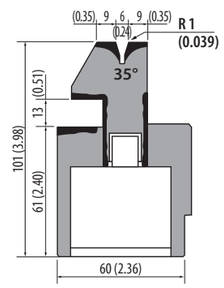
on stock

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26
1.5	0.06	4.6	0.18	22	38
2.0	0.08	5.5	0.22	30	50
2.5	0.10	6.5	0.26	55	-
3.0	0.12	8.0	0.31	70	-

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80
1.5	0.06	3.0	0.12	63	95
2.0	0.08	4.0	0.16	80	130
2.5	0.10	5.0	0.20	90	-
3.0	0.12	6.0	0.24	100	-

S101PN.35.06

600 kN/m max.



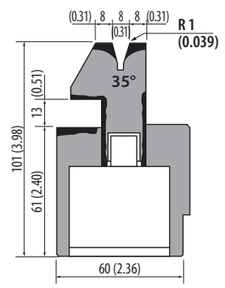
835 mm	32.87 in	30.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²

on stock

S101PN.35.08

600 kN/m max.



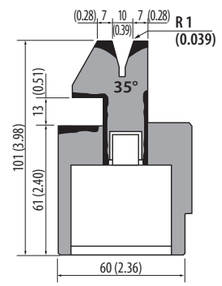
835 mm	32.87 in	31.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²

on stock

S101PN.35.10

600 kN/m max.



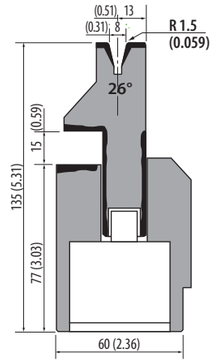
835 mm	32.87 in	29.0 kg
415 mm	16.34 in	15.5 kg

C45: 560-710 N/mm²

on stock

S135PN.26.08

400 kN/m max.



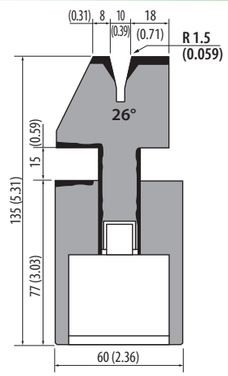
835 mm	32.87 in	39.8 kg
415 mm	16.34 in	21.0 kg

42Cr: 900-1150 N/mm²

on stock

S135PN.26.10

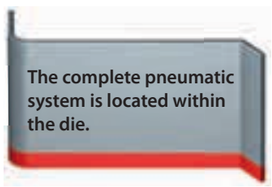
1000 kN/m max.



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

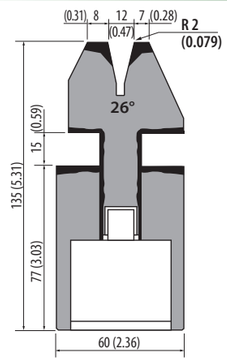
C45: 560-710 N/mm²

on stock



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

on stock

on stock Article on stock

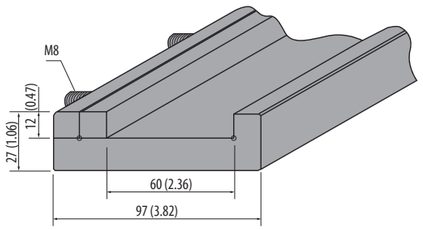
Please ask for delivery time!

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

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

Adpater Rails for Dies

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



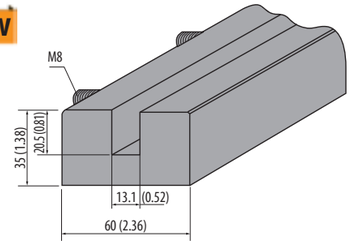
Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg

on stock

C45: 560-710 N/mm²

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

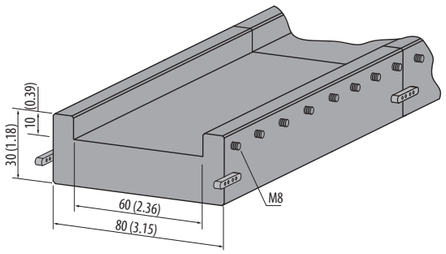
NEW



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

C45: 560-710 N/mm²

C 1050/R

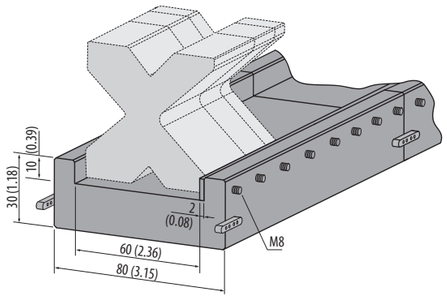


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg

on stock

C45: 560-710 N/mm²

C 1050/RS

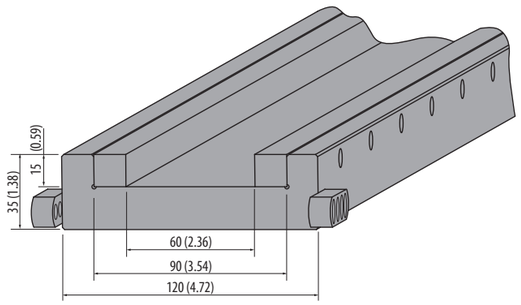


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg

on stock

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

on stock

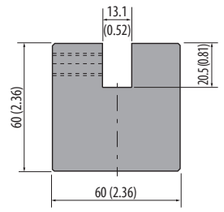
C45: 560-710 N/mm²

Die Adapters

ROLLERI® PROFESSIONAL BENDING

AD5

1000 kN/m max.



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

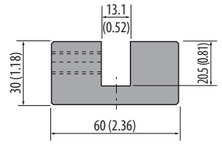
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

on stock

AD6

1000 kN/m max.



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

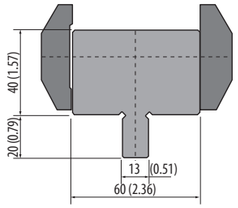
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

on stock

AD7

1000 kN/m max.



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

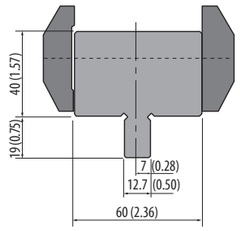
Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²

on stock

AD9-12.7

1000 kN/m max.

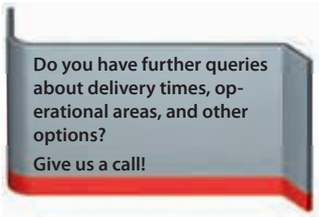


835 mm	32.87 in	19.6 kg
415 mm	16.34 in	9.7 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²

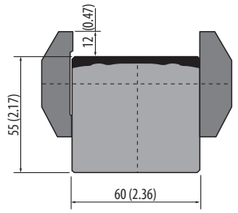
on stock



Die Extensions

CTS60

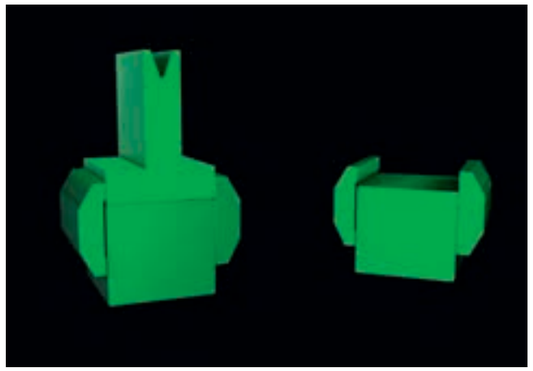
1000 kN/m max.



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

C45: 560-710 N/mm²

on stock



on stock Article on stock

Please ask for delivery time!

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

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

PUNCHES ROLLERI TYPE R2

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90° Punches	85
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80° Punches	87
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28° Punches	89 - 90
28°/24° Hemming Tools	91
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Radius Tools	93 - 94
Punch Extensions	95
Punch Adapters	95

Compatibility

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

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

Compatibility

Punches Rolleri Type R2 are:

- **compatible** with press brake machines from: Bystronic-Hämmerle, LVD, Trumpf or on press brake machines with System NSCL (New Standard Clamping)
- also applicable on all other press brake machines **with adapter-systems** (see page 214).

Our Advantages – Your Convenience

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

Material

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

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	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**
2. **Safety Pins**
3. **ROL-System**

ATTENTION:

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

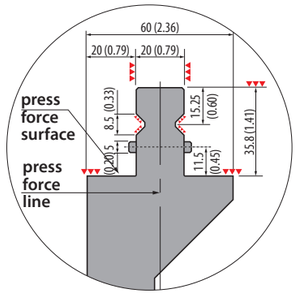
Safety Pins
All tools that weigh more than 12 kg, are delivered by default with safety pins. This applies to all standard tool lengths and some segmented tools.

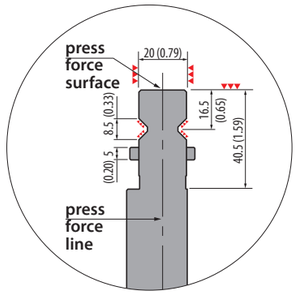
ROL1-System
Alternatively, you have the option of using tools with spring-loaded balls. Also here the max. weight is 12.5 kg per tool.

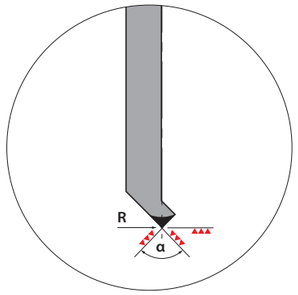
If you have any questions, please call to be assisted by one of our representatives!

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

Indications of precision ground surfaces:
▼▼▼







Clamping Systems

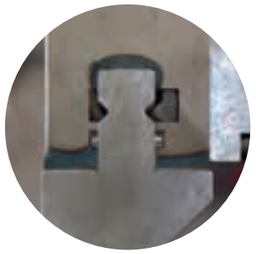
QuickLock (Standard)

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

Rolleri Videos
QuickLock System:
www.rolleritools.com/videos/quicklock

Safety Pins (Standard)

- **horizontal** tool exchange



ROL1-System

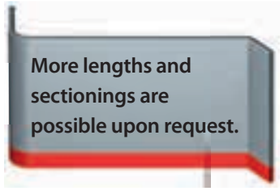
- **vertical** tool exchange through spring-loaded balls, which are built into the tool
- increased longevity
- easy handling
- requires hardened tang
- applicable on tools < 12.5 kg

3 R2

Content Explanation Punches

Tool Lengths and Sectioning

Standard



500 mm (19.68 in)

515 mm (20.28 in)

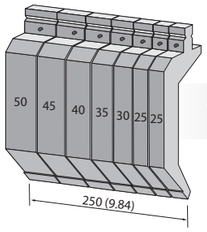
525 mm (20.67 in)

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

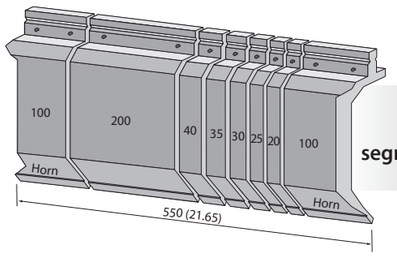
Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94) Horn l.	100 (3.94) Horn r.	100 (3.94)
1250 (49.21)	2	1	1	1	1	1	1	1	8
2050 (80.71)	2	1	1	1	1	1	1	1	16
2550 (100.39)	2	1	1	1	1	1	1	1	21
3050 (120.08)	2	1	1	1	1	1	1	1	26
4050 (159.45)	2	1	1	1	1	1	1	1	36

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

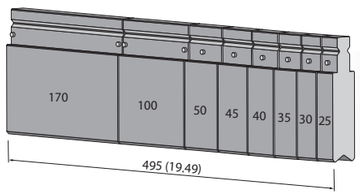
Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94) Horn l.	100 (3.94) Horn r.	100 (3.94)	200 (7.87)	300 (11.81)
1250 (49.21)	2	1	1	1	1	1	1	1	1	2	1
2050 (80.71)	2	1	1	1	1	1	1	1	1	3	3
2550 (100.39)	2	1	1	1	1	1	1	1	1	4	4
3050 (120.08)	2	1	1	1	1	1	1	1	1	5	5
4050 (159.45)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



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

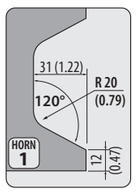


550 mm
(21.65 in)
segmented / FW
(8 segments)

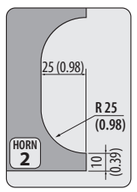


495 mm
(19.49 in)
segmented / F
(8 segments)

Horn Types



Horn 1
Standard for all segmented
Punches Rolleri Type R2



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

90° Punches

TPR237.90.R06

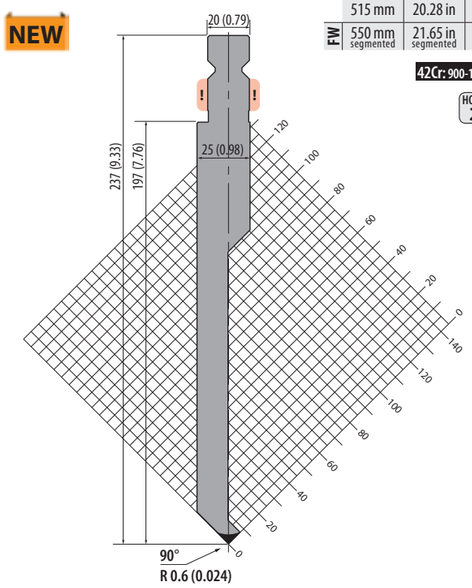
600 kN/m max.

NEW

	515 mm	20.28 in	17.5 kg
FW	550 mm segmented	21.65 in segmented	18.7 kg

42Cr: 900-1150 N/mm²

HORN 2



TPR237.90.R12

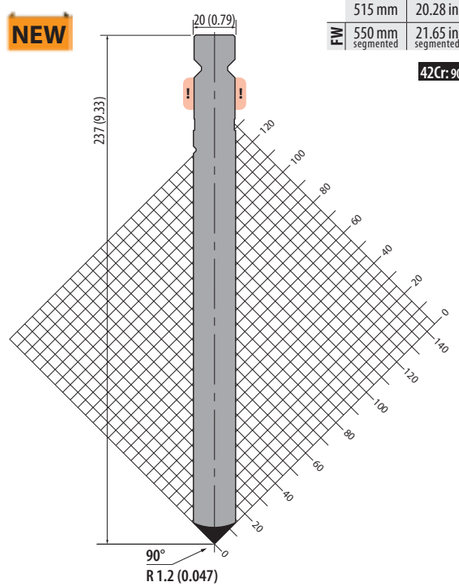
1000 kN/m max.

NEW

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

42Cr: 900-1150 N/mm²

HORN 2



86° Punches

TPR135.86.R1

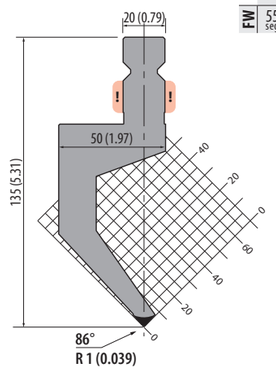
650 kN/m max.

NEW

	515 mm	20.28 in	12.3 kg
FW	550 mm segmented	21.65 in segmented	13.1 kg

42Cr: 900-1150 N/mm²

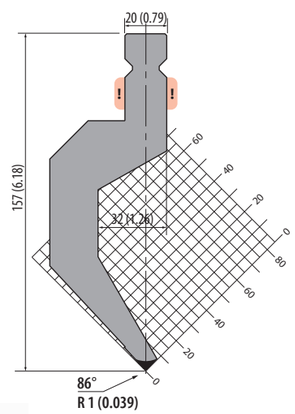
HORN 2



TPR157.86.R1

800 kN/m max.

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

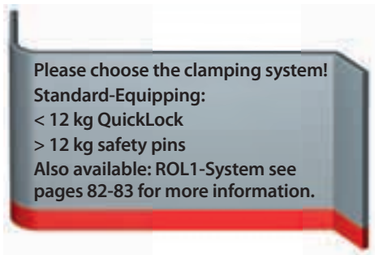


Segments of Sectioning FB (300, 200, 100, 100 Horn l., 100 Horn r., 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

HORN 1 on stock

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



3 R2

on stock Article on stock

Please ask for delivery time!

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

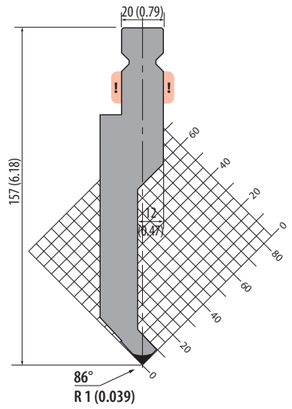
Articles on stock – Please note that delivery time depends on your location.

R2 ROLLERI TYPE R2

86° Punches

TPR157.86.R1-A

800 kN/m max.



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

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

42Cr: 900-1150 N/mm²

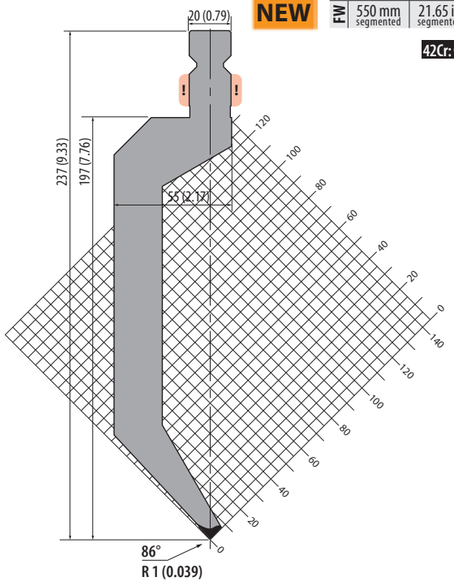
HORN 1 — on stock

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

TPR237.86.R1

500 kN/m max.

NEW



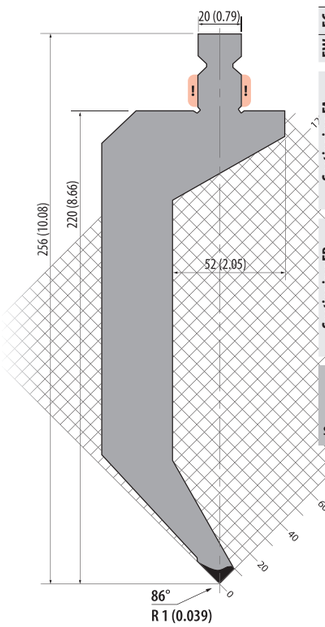
FW	515 mm	20.28 in	23.0 kg
FW	550 mm segmented	21.65 in segmented	24.6 kg

42Cr: 900-1150 N/mm²

HORN 2

TPR256.86.R1

800 kN/m max.



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

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

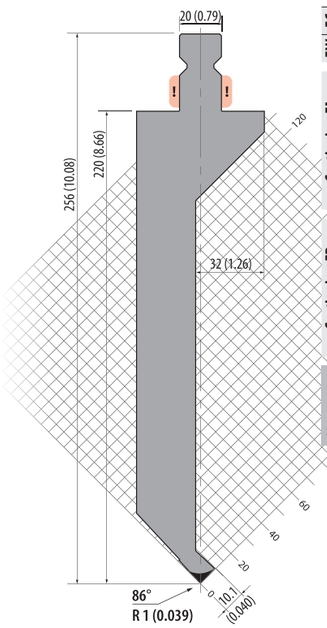
42Cr: 900-1150 N/mm²

HORN 1 — on stock

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

TPR256.86.R1-A

800 kN/m max.



FC	500 mm	19.68 in	28.5 kg
FW	250 mm segmented	9.84 in segmented	12.5 kg
FW	550 mm segmented	21.65 in segmented	31.4 kg
Sectioning FA	1250 mm	49.21 in	62.5 kg
Sectioning FA	2050 mm	80.71 in	102.5 kg
Sectioning FA	2550 mm	100.39 in	127.5 kg
Sectioning FA	3050 mm	120.08 in	152.5 kg
Sectioning FA	4050 mm	159.45 in	202.5 kg
Sectioning FB	1250 mm	49.21 in	62.5 kg
Sectioning FB	2050 mm	80.71 in	102.5 kg
Sectioning FB	2550 mm	100.39 in	127.5 kg
Sectioning FB	3050 mm	120.08 in	152.5 kg
Sectioning FB	4050 mm	159.45 in	202.5 kg

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock

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

R2 ROLLERI TYPE R2

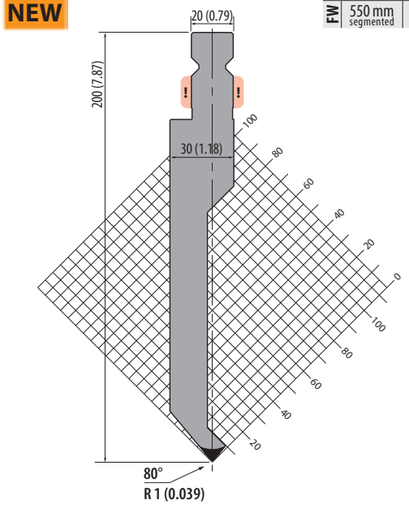
80° Punches

ROLLERI® PROFESSIONAL BENDING

TPR200.80.R1

800 kN/m max.

NEW



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

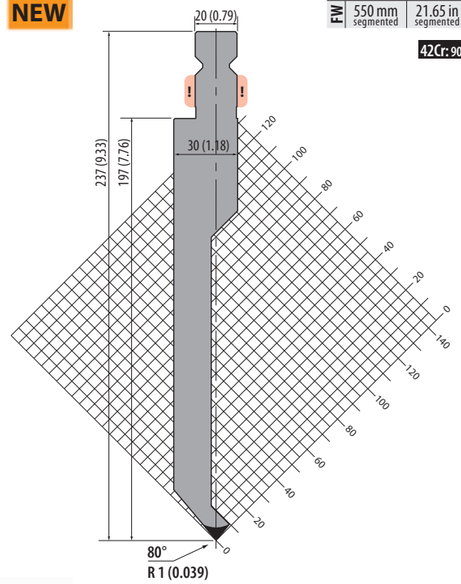
42Cr: 900-1150 N/mm²

HORN 2

TPR237.80.R1

800 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

HORN 2

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

3 R2

on stock — Article on stock

Please ask for delivery time!

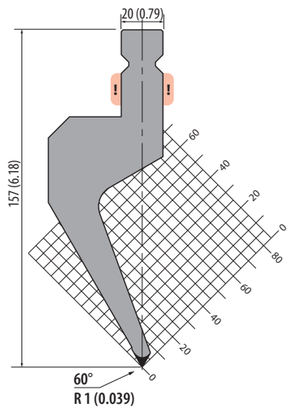
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

60° Punches

TPR157.60.R1

700 kN/m max.



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

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

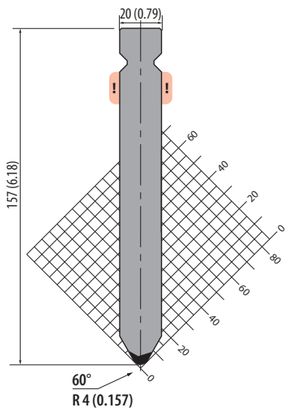
42Cr: 900-1150 N/mm²

HORN 1 — on stock

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

TPR157.60.R4

1300 kN/m max.



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

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

42Cr: 900-1150 N/mm²

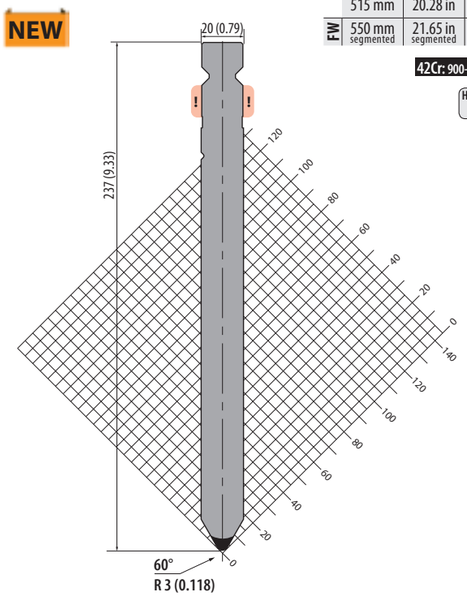
HORN 1 — on stock

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

TPR237.60.R3

1300 kN/m max.

NEW



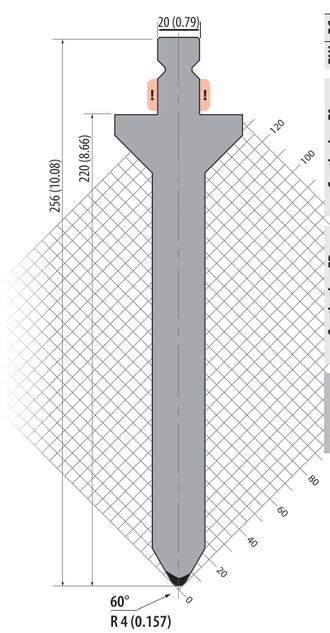
FW	515 mm	20.28 in	18.8 kg
	550 mm segmented	21.65 in segmented	20.1 kg

42Cr: 900-1150 N/mm²

HORN 2

TPR256.60.R4

1300 kN/m max.



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

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock

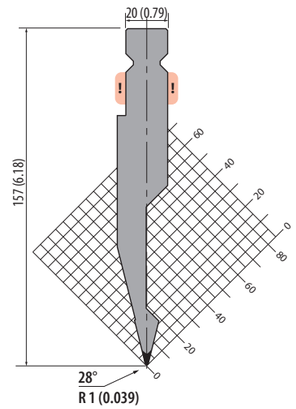
HORN 2 only for 550 mm (21.65 in) segm.

28° Punches

ROLLERI® PROFESSIONAL BENDING

TPR157.28.R1

600 kN/m max.



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

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

42Cr: 900-1150 N/mm²

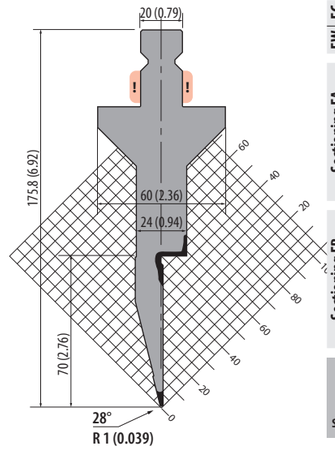
HORN 1 — on stock

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

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

TPR176.28.R1

400 kN/m max.



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

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

42Cr: 900-1150 N/mm²

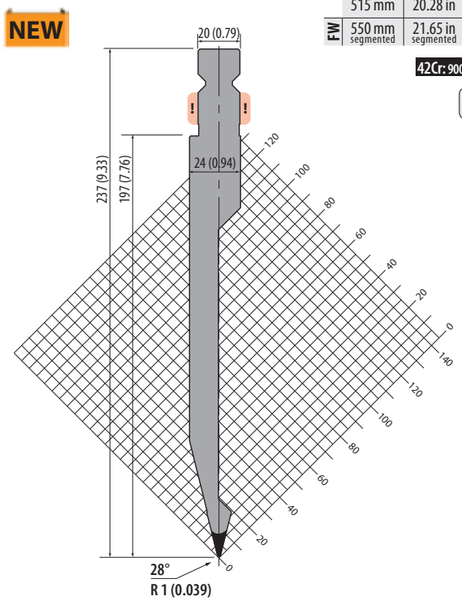
HORN 1 — on stock

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

TPR237.28.R1

600 kN/m max.

NEW



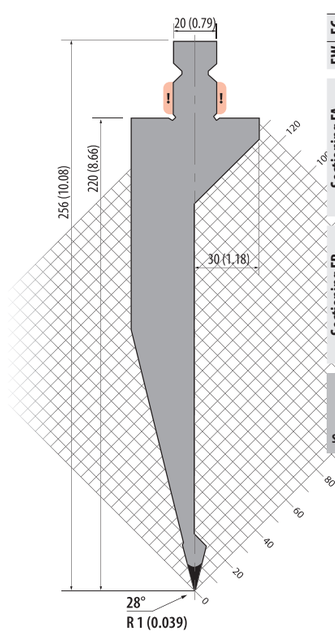
FW	515 mm	20.28 in	15.0 kg
	550 mm segmented	21.65 in segmented	16.0 kg

42Cr: 900-1150 N/mm²

HORN 2

TPR256.28.R1

600 kN/m max.



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

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock

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

on stock Article on stock

Please ask for delivery time!

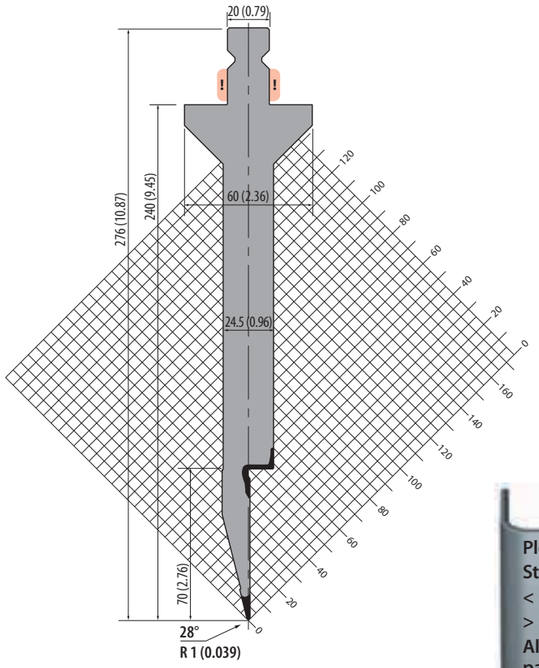
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

28° Punches

TPR276.28.R1

400 kN/m max.



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

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock

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

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

Rolleri Videos

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

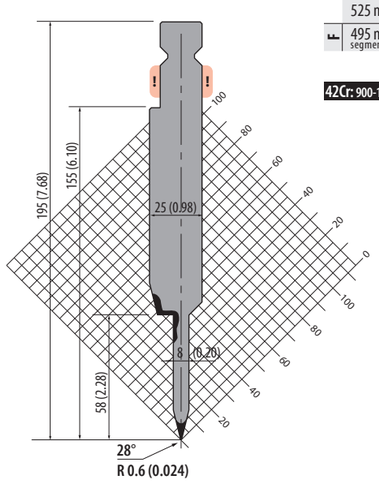
28°/24° Hemming Punches

ROLLERI® PROFESSIONAL BENDING

TPR.SP.195.28.8

	525 mm	20.67 in	9.4 kg
F	495 mm segmented	19.49 in segmented	8.9 kg

42Cr: 900-1150 N/mm² — on stock

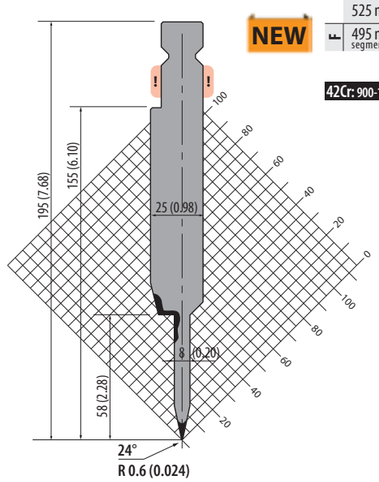


TPR.SP.195.24.8

NEW

	525 mm	20.67 in	9.4 kg
F	495 mm segmented	19.49 in segmented	8.9 kg

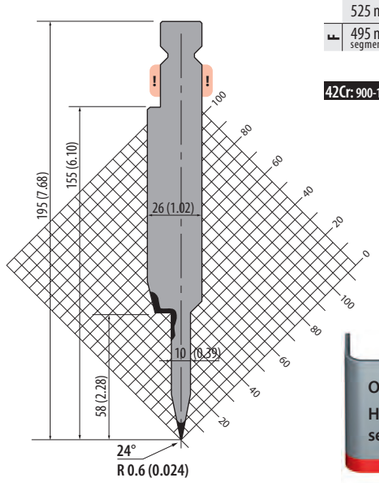
42Cr: 900-1150 N/mm² — on stock



TPR.SP.195.24.10

	525 mm	20.67 in	15.5 kg
F	495 mm segmented	19.49 in segmented	9.3 kg

42Cr: 900-1150 N/mm² — on stock

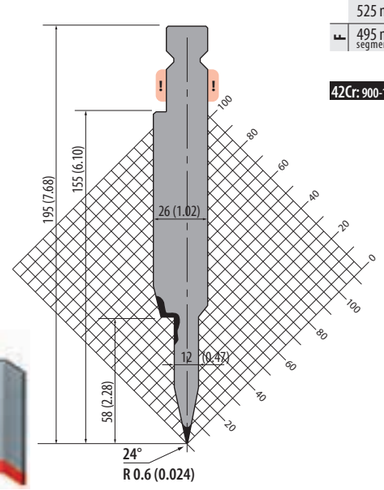


Only for thin material!
Hemming Dies
see page 118

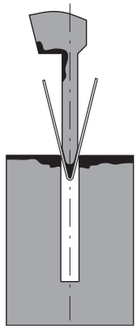
TPR.SP.195.24.12

	525 mm	20.67 in	15.5 kg
F	495 mm segmented	19.49 in segmented	9.5 kg

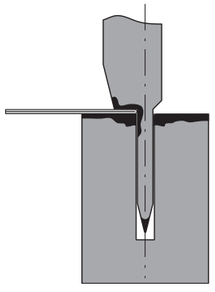
42Cr: 900-1150 N/mm² — on stock



Example of application



800 kN/m max.



1000 kN/m max.

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80

on stock — Article on stock

Please ask for delivery time!

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

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

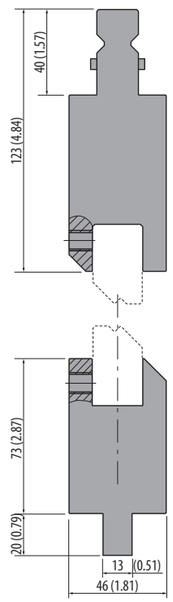
TPZ

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

on stock

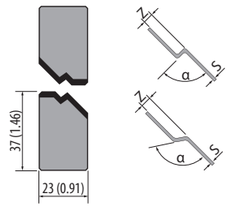


Please choose the clamping system!
Standard-Equipping:
< 12 kg QuickLock
> 12 kg safety pins
Also available: ROL1-System see pages 82-83 for more information.

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

1000 kN/m max.

C45: 560-710 N/mm²



Model	Z mm	Z in	α	S* mm	S* inch	835 mm / 32.87 in Weight	415 mm / 16.34 in 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

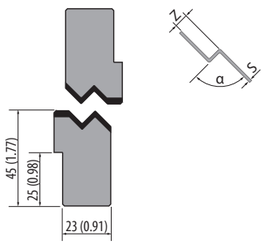
* Fe Rmax = 42 Kg/mm²

Z- Profile Tool Inserts 90°

1000 kN/m max.

C45: 560-710 N/mm²

on stock



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

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

* Fe Rmax = 42 Kg/mm²

TPR143.10

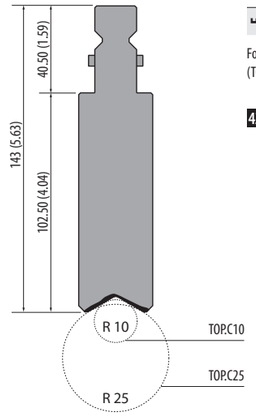
1000 kN/m max.

	525 mm	20.67 in	18.0 kg
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

on stock



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

TPR136.15

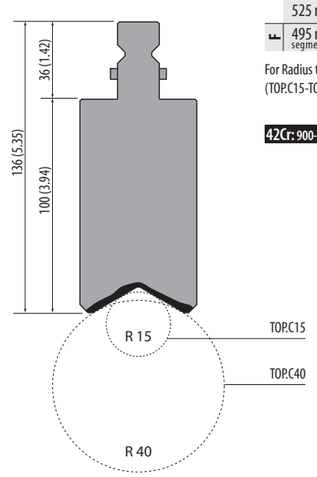
1000 kN/m max.

	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

on stock



Radius punches: R10-40

1000 kN/m max.

Material C53 induction hardened 60-62HRc

on stock

C53: 610-760 N/mm²

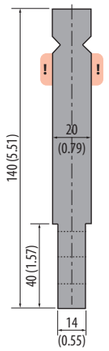
Model	R mm	R in	525 mm / 20.67 in Weight	495 mm / 16.34 in segmented Weight
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg

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

Radius Tools

TPR140-14

800 kN/m max.



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

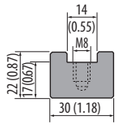
For Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see below

C45: 560-710 N/mm²

on stock

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

on stock

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

800 kN/m max.

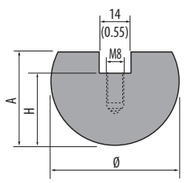
on stock

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)

800 kN/m max.



on stock

C45: 560-710 N/mm²

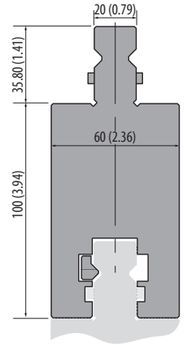
Model	Ø mm	Ø in	H mm	H in	A mm	A in	835 mm / 32.87 in Weight	415 mm / 16.34 in Weight
C17.12	25	0.98	17	0.67	22	0.87	2.5 kg	1.2 kg
C20.15	30	1.18	20	0.79	27	1.06	3.7 kg	1.8 kg
C22.17	35	1.38	22	0.87	32	1.26	5.0 kg	2.4 kg
C24.20	40	1.57	24	0.94	34	1.34	7.0 kg	3.5 kg
C29.25	50	1.97	29	1.14	39	1.54	10.0kg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

ROLLERI® PROFESSIONAL BENDING

Punch Extensions

AD21

1500 kN/m max.



150 mm	5.91 in	7.0 kg

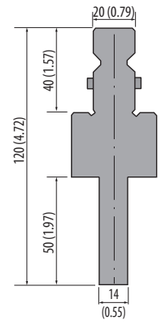
42Cr: 900-1150 N/mm²

on stock

Punch Adapters

AD11

1000 kN/m max.

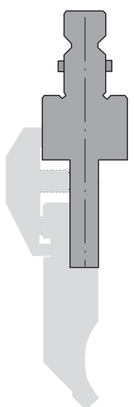


150 mm	5.91 in	3.0 kg

C45: 560-710 N/mm²

on stock

Example of application



For more Adpaters see pages 212-217

on stock Article on stock

Please ask for delivery time!

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

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

DIES ROLLERI TYPE R2

Content Explanation	98 - 99
Dies H=55 (2.17) - 85 (3.35)	100
Dies 90°, H=100 (3.94)	101
Dies 86°, H=100 (3.94)	101 - 103
Dies 84°, H=100 (3.94)	103 - 104
Dies 80°, H=100 (3.94)	105
Dies 60°, H=120 (4.72)	106
Dies 30°, H=100 (3.94)	106 - 108
Dies 86°, H=150 (5.91)	109 - 110
Dies 84°, H=150 (5.91)	110 - 111
Dies 80°, H=150 (5.91)	112
Dies 30°, H=150 (5.91)	113 - 114
Die Adapters	115
Synthetic Dies, H=100 (3.94)	116
Hemming Dies	118 - 119

Compatibility

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

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

Compatibility

Dies Rolleri Type R2 are:

- **compatible** with press brake machines with a table groove for pins 13 x 20 mm (0.51 x 0.79 in): Bystronic-Hämmerle, Trumpf
- also applicable on all other press brake machines **with Adapter-Systems and Adapter Rails** (see pages 218-221).

Our Advantages – Your Convenience

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

Material

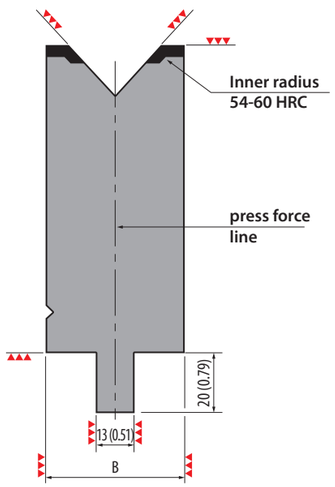
The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

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



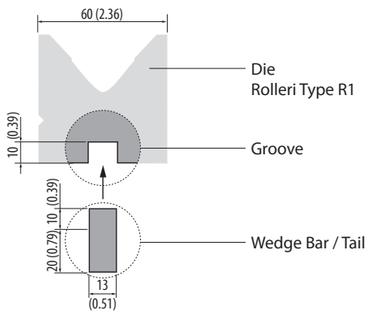
Indications of precision ground surfaces:
▼▼▼

Modification: Wedge Bar / Tail

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

For more specific information and prices go to page 252 in the Service Chapter.

A30 (Mounting example)



R2 ROLLERI TYPE R2
Content Explanation Dies

ROLLERI® PROFESSIONAL BENDING

Tool lengths and sectioning

Standard

More lengths and sectionings are possible upon request.

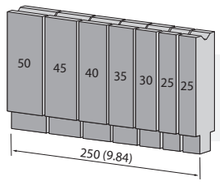
500 mm (19.68 in)
515 mm (20.28 in)
525 mm (20.67 in)
1000 mm (39.37 in)

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

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

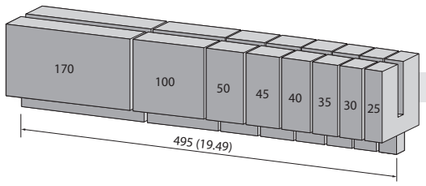
Sectioning FB
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

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

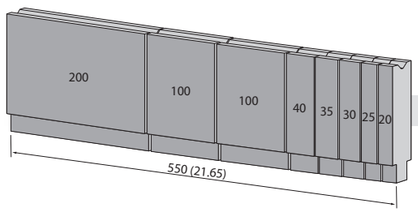


250 mm (9.84 in) segmented / FC (7 segments)

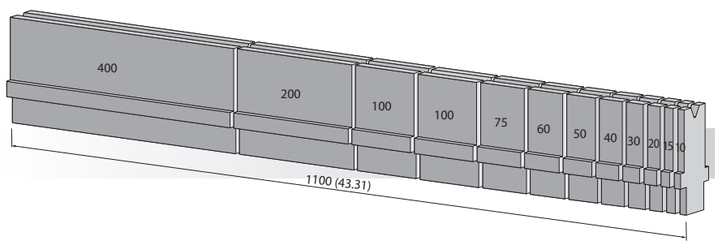
Segmented tools are delivered in complete sets. Single pieces are also available!



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



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



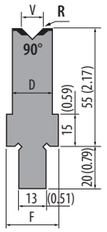
1100 mm (43.31) segmented (12 segments)

4
R2

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

Dies, H=55 (2.17) / H=60 (2.36) / H=65 (2.56) / H=70 (2.76) / H=85 (3.35)

90° Dies, H=55 (2.17)



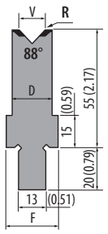
Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in Weight	500 mm / 19.68 in Weight	1100 mm / 43.31 in segmented Weight
BMR55.06.90	6	0.24	0.4	0.02	15	0.59	25	0.98	1150	8.5 kg	4.2 kg	8.5 kg
BMR55.08.90	8	0.31	0.5	0.02	15	0.59	25	0.98	1100	9.0 kg	4.5 kg	8.5 kg
BMR55.10.90	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

on stock

Individual drawings see pages 138-142

88° Dies, H=55 (2.17)

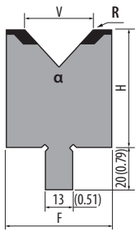


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in Weight	500 mm / 19.68 in Weight	1100 mm / 43.31 in segmented Weight
BMR55.10.88	10	0.39	1.0	0.04	20	0.79	25	0.98	1100	11.0 kg	5.0 kg	12.0 kg
BMR55.12.88	12	0.47	1.5	0.06	20	0.79	25	0.98	1200	10.5 kg	5.2 kg	10.0 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

on stock

85° / 80° / 60° Dies, H=55 (2.17) / H=65 (2.56) / H=85 (3.35)

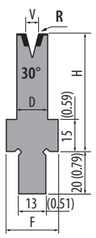


Model	α	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	F (mm)	F (in)	kN/m max.	1000 mm / 39.37 in Weight	500 mm / 19.68 in Weight	1100 mm / 43.31 in segmented Weight
BMR55.32.85	85	32	1.26	4.0	0.16	55	2.17	50	1.97	1200	21.0 kg	10.5 kg	20.5 kg
BMR55.40.85	85	40	1.57	4.0	0.16	55	2.17	55	2.17	1200	21.5 kg	10.7 kg	25.0 kg
BMR65.80.80	80	80	3.15	10.0	0.39	65	2.56	100	3.94	1700	39.0 kg	20.0 kg	43.0 kg
BMR85.100.80	80	100	3.94	12.0	0.47	85	3.35	125	4.92	2300	62.0 kg	31.0 kg	69.0 kg
BMR55.40.60	60	40	1.57	5.0	0.20	55	2.17	55	2.17	1300	20.3 kg	10.5 kg	22.3 kg
BMR55.50.60	60	50	1.97	5.0	0.20	55	2.17	70	2.76	1200	25.0 kg	12.0 kg	21.0 kg
BMR65.60.60	60	60	2.36	7.0	0.28	65	2.56	80	3.15	1100	31.0 kg	15.5 kg	34.1 kg

42Cr: 900-1150 N/mm²

on stock

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.	1000 mm / 39.37 in Weight	500 mm / 19.68 in Weight	1100 mm / 43.31 in segmented 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

on stock

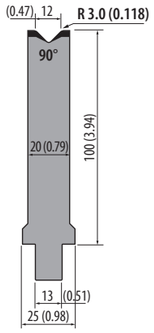
ROLLERI® PROFESSIONAL BENDING

Dies 90°, H=100 (3.94)

WMR100.12.90

1200 kN/m max.

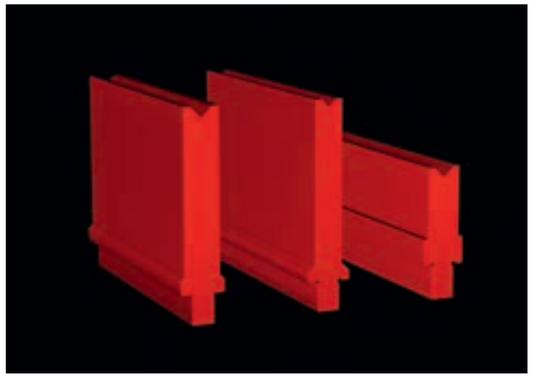
NEW



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

42Cr: 900-1150 N/mm²

on stock

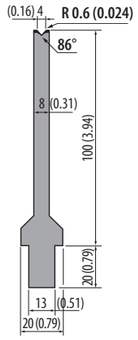


Dies 86°, H=100 (3.94)

TMR100.04.86

250 kN/m max.

NEW



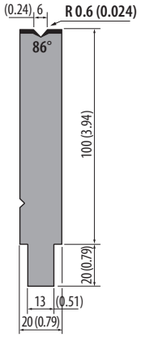
	500 mm	19.68 in	4.5 kg
FC	250 mm segmented	9.84 in segmented	2.3 kg
FW	550 mm segmented	21.65 in segmented	4.9 kg
Sectioning FA	1250 mm	49.21 in	11.3 kg
	2050 mm	80.71 in	18.5 kg
	2550 mm	100.39 in	23.0 kg
	3050 mm	120.08 in	27.5 kg
	4050 mm	159.45 in	36.5 kg
Sectioning FB	1250 mm	49.21 in	11.3 kg
	2050 mm	80.71 in	18.5 kg
	2550 mm	100.39 in	23.0 kg
	3050 mm	120.08 in	27.5 kg
	4050 mm	159.45 in	36.5 kg

42Cr: 900-1150 N/mm²

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

TMR100.06.86

1200 kN/m max.



	500 mm	19.68 in	8.9 kg
FC	250 mm segmented	9.84 in segmented	4.5 kg
FW	550 mm segmented	21.65 in segmented	9.8 kg
Sectioning FA	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg

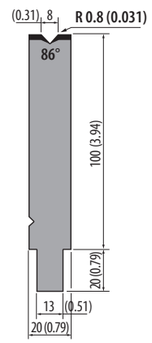
42Cr: 900-1150 N/mm²

on stock

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

TMR100.08.86

1150 kN/m max.



	500 mm	19.68 in	7.9 kg
FC	250 mm segmented	9.84 in segmented	3.0 kg
FW	550 mm segmented	21.65 in segmented	8.7 kg
Sectioning FA	1250 mm	49.21 in	15.0 kg
	2050 mm	80.71 in	24.6 kg
	2550 mm	100.39 in	30.6 kg
	3050 mm	120.08 in	36.6 kg
	4050 mm	159.45 in	48.6 kg
Sectioning FB	1250 mm	49.21 in	15.0 kg
	2050 mm	80.71 in	24.6 kg
	2550 mm	100.39 in	30.6 kg
	3050 mm	120.08 in	36.6 kg
	4050 mm	159.45 in	48.6 kg

42Cr: 900-1150 N/mm²

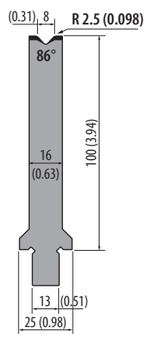
on stock

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

WMR100.08.86

400 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

4 R2

on stock Article on stock

Please ask for delivery time!

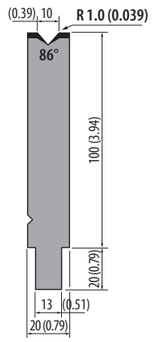
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

Dies 86°, H=100 (3.94)

TMR100.10.86

1100 kN/m max.



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

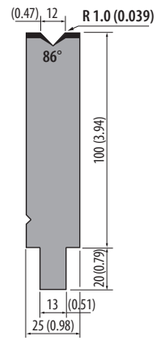
on stock

42Cr: 900-1150 N/mm²

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

TMR100.12.86

1200 kN/m max.



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

on stock

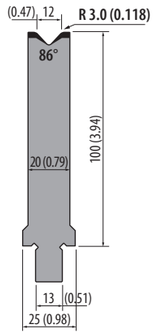
42Cr: 900-1150 N/mm²

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

WMR100.12.86

1200 kN/m max.

NEW

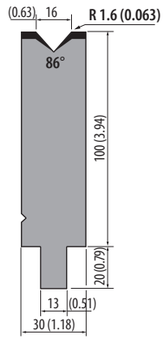


FW	515 mm	20.28 in	9.0 kg
	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²

TMR100.16.86

1200 kN/m max.



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

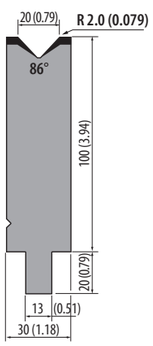
on stock

42Cr: 900-1150 N/mm²

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

TMR100.20.86

1150 kN/m max.



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

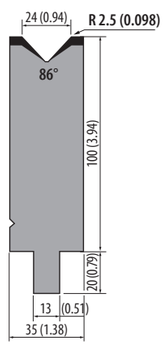
on stock

42Cr: 900-1150 N/mm²

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

TMR100.24.86

1200 kN/m max.



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

on stock

42Cr: 900-1150 N/mm²

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

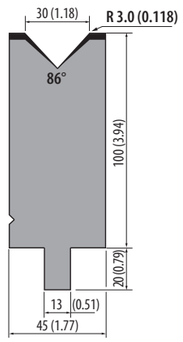
R2 ROLLERI TYPE R2

ROLLERI® PROFESSIONAL BENDING

Dies 86°, H=100 (3.94)

TMR100.30.86

1200 kN/m max.



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

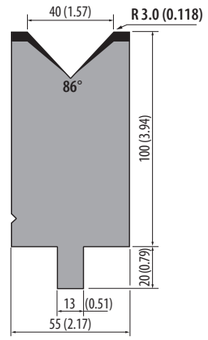
on stock

42Cr: 900-1150 N/mm²

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

TMR100.40.86

1200 kN/m max.



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

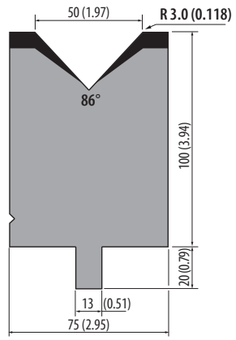
on stock

42Cr: 900-1150 N/mm²

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

TMR100.50.86

1500 kN/m max.



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

on stock

42Cr: 900-1150 N/mm²

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

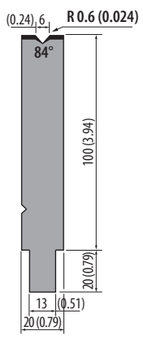
Die Adapters see pages 218-221

Dies 84°, H=100 (3.94)

TMR100.06.84

1200 kN/m max.

NEW



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

on stock

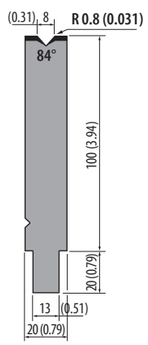
42Cr: 900-1150 N/mm²

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

TMR100.08.84

1150 kN/m max.

NEW



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

on stock

42Cr: 900-1150 N/mm²

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

on stock Article on stock

Please ask for delivery time!

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

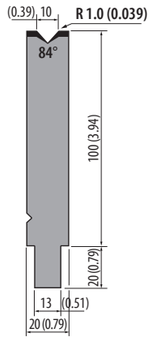
Articles on stock – Please note that delivery time depends on your location.

Dies 84°, H=100 (3.94)

TMR100.10.84

1100 kN/m max.

NEW



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

on stock

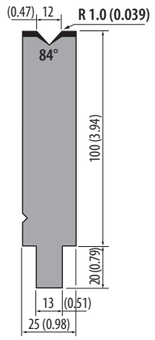
42Cr: 900-1150 N/mm²

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

TMR100.12.84

1200 kN/m max.

NEW



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

on stock

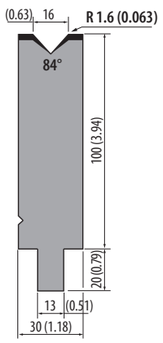
42Cr: 900-1150 N/mm²

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

TMR100.16.84

1200 kN/m max.

NEW



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

on stock

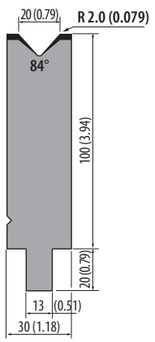
42Cr: 900-1150 N/mm²

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

TMR100.20.84

1150 kN/m max.

NEW



FC	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
Sectioning FA	1250 mm	49.21 in	30.5 kg
Sectioning FA	2050 mm	80.71 in	50.0 kg
Sectioning FA	2550 mm	100.39 in	62.2 kg
Sectioning FA	3050 mm	120.08 in	74.4 kg
Sectioning FA	4050 mm	159.45 in	98.8 kg
Sectioning FB	1250 mm	49.21 in	30.5 kg
Sectioning FB	2050 mm	80.71 in	50.0 kg
Sectioning FB	2550 mm	100.39 in	62.2 kg
Sectioning FB	3050 mm	120.08 in	74.4 kg
Sectioning FB	4050 mm	159.45 in	98.8 kg

on stock

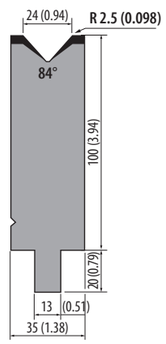
42Cr: 900-1150 N/mm²

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

TMR100.24.84

1200 kN/m max.

NEW



FC	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
Sectioning FA	1250 mm	49.21 in	35.0 kg
Sectioning FA	2050 mm	80.71 in	57.4 kg
Sectioning FA	2550 mm	100.39 in	71.4 kg
Sectioning FA	3050 mm	120.08 in	85.4 kg
Sectioning FA	4050 mm	159.45 in	113.4 kg
Sectioning FB	1250 mm	49.21 in	35.0 kg
Sectioning FB	2050 mm	80.71 in	57.4 kg
Sectioning FB	2550 mm	100.39 in	71.4 kg
Sectioning FB	3050 mm	120.08 in	85.4 kg
Sectioning FB	4050 mm	159.45 in	113.4 kg

on stock

42Cr: 900-1150 N/mm²

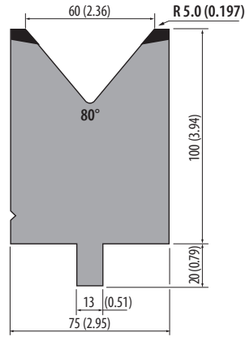
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

Dies 80°, H=100 (3.94)

ROLLERI® PROFESSIONAL BENDING

TMR100.60.80

1500 kN/m max.



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

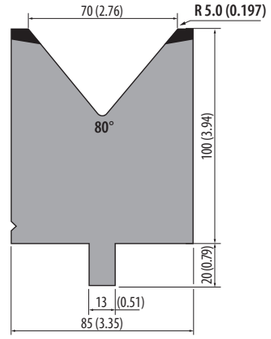
on stock

42Cr: 900-1150 N/mm²

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

TMR100.70.80

1500 kN/m max.



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

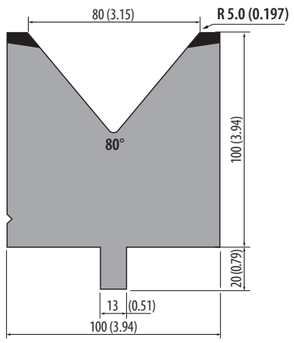
on stock

42Cr: 900-1150 N/mm²

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

TMR100.80.80

1500 kN/m max.



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

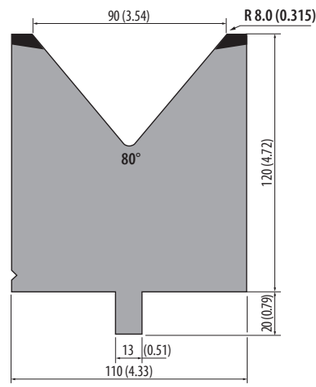
on stock

42Cr: 900-1150 N/mm²

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

TMR120.90.80

1500 kN/m max.



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

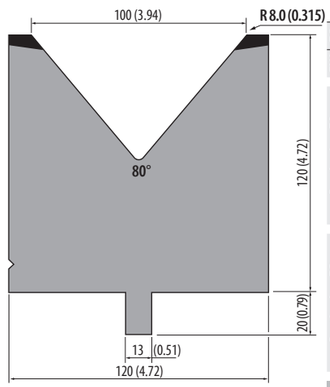
on stock

42Cr: 900-1150 N/mm²

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

TMR120.100.80

1500 kN/m max.



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

on stock

42Cr: 900-1150 N/mm²

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

on stock Article on stock

Please ask for delivery time!

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

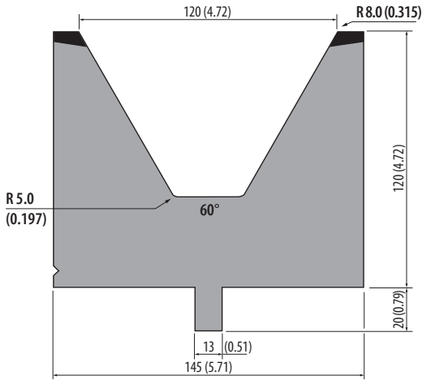
Articles on stock – Please note that delivery time depends on your location.

Dies 60°, H=120 (4.72)

TMR120.120.60

1600 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

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

Rolleri Videos

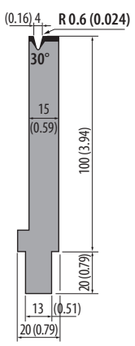
find updated and helpful videos at:
www.rolleritools.com/videos/overview

Dies 30°, H=100 (3.94)

TMR100.04.30

150 kN/m max.

NEW



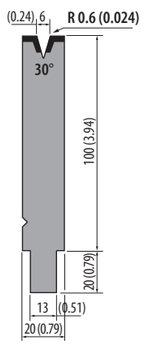
FC	500 mm	19.68 in	7.0 kg
FC	250 mm segmented	9.84 in segmented	3.5 kg
FW	550 mm segmented	21.65 in segmented	7.7 kg
Sectioning FA	1250 mm	49.21 in	17.5 kg
Sectioning FA	2050 mm	80.71 in	28.7 kg
Sectioning FA	2550 mm	100.39 in	35.7 kg
Sectioning FA	3050 mm	120.08 in	42.7 kg
Sectioning FA	4050 mm	159.45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

42Cr: 900-1150 N/mm²

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

TMR100.06.30

400 kN/m max.



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

42Cr: 900-1150 N/mm²

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

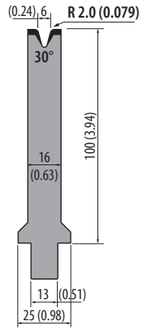
ROLLERI® PROFESSIONAL BENDING

Dies 30°, H=100 (3.94)

WMR100.06.30

400 kN/m max.

NEW

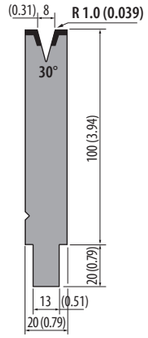


FW	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²

TMR100.08.30

400 kN/m max.



FC	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	9.4 kg
Sectioning FA	1250 mm	49.21 in	21.3 kg
Sectioning FA	2050 mm	80.71 in	34.9 kg
Sectioning FA	2550 mm	100.39 in	43.4 kg
Sectioning FA	3050 mm	120.08 in	51.9 kg
Sectioning FA	4050 mm	159.45 in	68.9 kg
Sectioning FB	1250 mm	49.21 in	21.3 kg
Sectioning FB	2050 mm	80.71 in	34.9 kg
Sectioning FB	2550 mm	100.39 in	43.4 kg
Sectioning FB	3050 mm	120.08 in	51.9 kg
Sectioning FB	4050 mm	159.45 in	68.9 kg

on stock

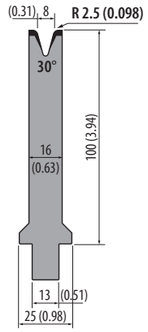
42Cr: 900-1150 N/mm²

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

WMR100.08.30

400 kN/m max.

NEW

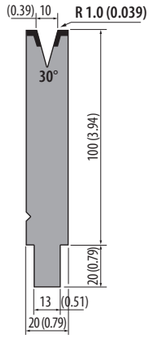


FW	515 mm	20.28 in	7.7 kg
FW	550 mm segmented	21.65 in segmented	8.2 kg

42Cr: 900-1150 N/mm²

TMR100.10.30

400 kN/m max.



FC	500 mm	19.68 in	8.5 kg
FC	250 mm segmented	9.84 in segmented	3.5 kg
FW	550 mm segmented	21.65 in segmented	9.4 kg
Sectioning FA	1250 mm	49.21 in	17.5 kg
Sectioning FA	2050 mm	80.71 in	28.7 kg
Sectioning FA	2550 mm	100.39 in	35.7 kg
Sectioning FA	3050 mm	120.08 in	42.7 kg
Sectioning FA	4050 mm	159.45 in	56.7 kg
Sectioning FB	1250 mm	49.21 in	17.5 kg
Sectioning FB	2050 mm	80.71 in	28.7 kg
Sectioning FB	2550 mm	100.39 in	35.7 kg
Sectioning FB	3050 mm	120.08 in	42.7 kg
Sectioning FB	4050 mm	159.45 in	56.7 kg

on stock

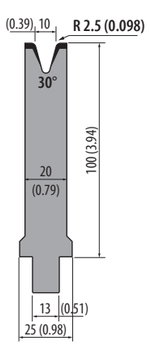
42Cr: 900-1150 N/mm²

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

WMR100.10.30

400 kN/m max.

NEW

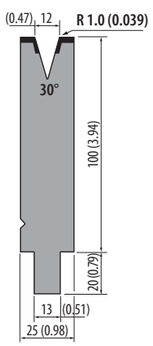


FW	515 mm	20.28 in	9.0 kg
FW	550 mm segmented	21.65 in segmented	9.6 kg

42Cr: 900-1150 N/mm²

TMR100.12.30

400 kN/m max.



FC	500 mm	19.68 in	10.3 kg
FC	250 mm segmented	9.84 in segmented	5.3 kg
FW	550 mm segmented	21.65 in segmented	11.3 kg
Sectioning FA	1250 mm	49.21 in	26.3 kg
Sectioning FA	2050 mm	80.71 in	43.1 kg
Sectioning FA	2550 mm	100.39 in	53.6 kg
Sectioning FA	3050 mm	120.08 in	64.1 kg
Sectioning FA	4050 mm	159.45 in	85.1 kg
Sectioning FB	1250 mm	49.21 in	26.3 kg
Sectioning FB	2050 mm	80.71 in	43.1 kg
Sectioning FB	2550 mm	100.39 in	53.6 kg
Sectioning FB	3050 mm	120.08 in	64.1 kg
Sectioning FB	4050 mm	159.45 in	85.1 kg

on stock

42Cr: 900-1150 N/mm²

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

on stock Article on stock

Please ask for delivery time!

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

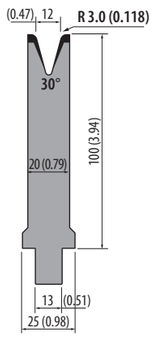
Articles on stock – Please note that delivery time depends on your location.

Dies 30°, H=100 (3.94)

WMR100.12.30

400 kN/m max.

NEW

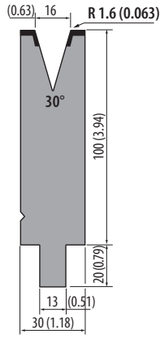


FW	515 mm	20.28 in	8.9 kg
	550 mm segmented	21.65 in segmented	9.5 kg

42Cr: 900-1150 N/mm²

TMR100.16.30

500 kN/m max.



FC	500 mm	19.68 in	11.8 kg
	250 mm segmented	9.84 in segmented	6.0 kg
FW	550 mm segmented	21.65 in segmented	12.9 kg
Sectioning FA	1250 mm	49.21 in	29.5 kg
	2050 mm	80.71 in	48.4 kg
	2550 mm	100.39 in	60.2 kg
	3050 mm	120.08 in	72.0 kg
	4050 mm	159.45 in	95.6 kg
Sectioning FB	1250 mm	49.21 in	29.5 kg
	2050 mm	80.71 in	48.4 kg
	2550 mm	100.39 in	60.2 kg
	3050 mm	120.08 in	72.0 kg
	4050 mm	159.45 in	95.6 kg

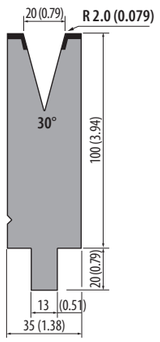
on stock

42Cr: 900-1150 N/mm²

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

TMR100.20.30

600 kN/m max.



FC	500 mm	19.68 in	13.0 kg
	250 mm segmented	9.84 in segmented	6.5 kg
FW	550 mm segmented	21.65 in segmented	14.3 kg
Sectioning FA	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.0 kg
Sectioning FB	1250 mm	49.21 in	32.5 kg
	2050 mm	80.71 in	53.3 kg
	2550 mm	100.39 in	66.3 kg
	3050 mm	120.08 in	79.3 kg
	4050 mm	159.45 in	105.0 kg

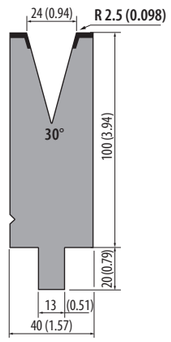
on stock

42Cr: 900-1150 N/mm²

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

TMR100.24.30

650 kN/m max.



FC	500 mm	19.68 in	15.0 kg
	250 mm segmented	9.84 in segmented	7.5 kg
FW	550 mm segmented	21.65 in segmented	16.5 kg
Sectioning FA	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg
	4050 mm	159.45 in	122.0 kg
Sectioning FB	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	76.5 kg
	3050 mm	120.08 in	91.5 kg
	4050 mm	159.45 in	122.0 kg

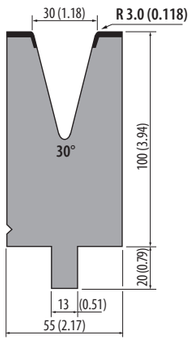
on stock

42Cr: 900-1150 N/mm²

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

TMR100.30.30

900 kN/m max.



FC	500 mm	19.68 in	19.0 kg
	250 mm segmented	9.84 in segmented	9.5 kg
FW	550 mm segmented	21.65 in segmented	20.9 kg
Sectioning FA	1250 mm	49.21 in	47.5 kg
	2050 mm	80.71 in	80.0 kg
	2550 mm	100.39 in	96.9 kg
	3050 mm	120.08 in	116.0 kg
	4050 mm	159.45 in	154.0 kg
Sectioning FB	1250 mm	49.21 in	47.5 kg
	2050 mm	80.71 in	80.0 kg
	2550 mm	100.39 in	96.9 kg
	3050 mm	120.08 in	116.0 kg
	4050 mm	159.45 in	154.0 kg

on stock

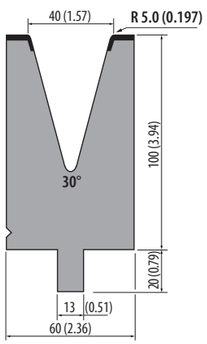
42Cr: 900-1150 N/mm²

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

TMR100.40.30

900 kN/m max.

NEW



FC	500 mm	19.68 in	18.5 kg
	250 mm segmented	9.84 in segmented	9.3 kg
FW	550 mm segmented	21.65 in segmented	20.4 kg
Sectioning FA	1250 mm	49.21 in	46.3 kg
	2050 mm	80.71 in	75.9 kg
	2550 mm	100.39 in	94.4 kg
	3050 mm	120.08 in	112.9 kg
	4050 mm	159.45 in	149.9 kg
Sectioning FB	1250 mm	49.21 in	46.3 kg
	2050 mm	80.71 in	75.9 kg
	2550 mm	100.39 in	94.4 kg
	3050 mm	120.08 in	112.9 kg
	4050 mm	159.45 in	149.9 kg

42Cr: 900-1150 N/mm²

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

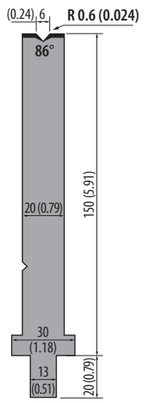
Dies 86°, H=150 (5.91)

ROLLERI® PROFESSIONAL BENDING

TMR150.06.86

400 kN/m max.

NEW



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

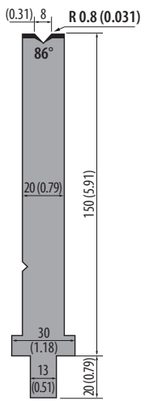
42Cr: 900-1150 N/mm²

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

TMR150.08.86

400 kN/m max.

NEW



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

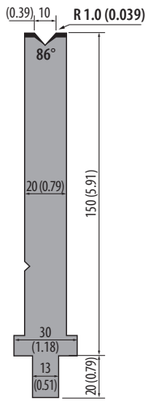
42Cr: 900-1150 N/mm²

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

TMR150.10.86

500 kN/m max.

NEW



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

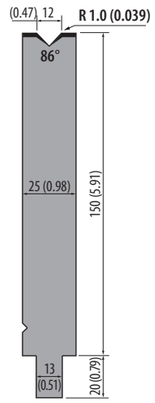
42Cr: 900-1150 N/mm²

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

TMR150.12.86

500 kN/m max.

NEW



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

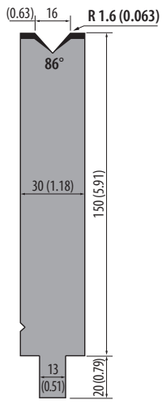
42Cr: 900-1150 N/mm²

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

TMR150.16.86

700 kN/m max.

NEW



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

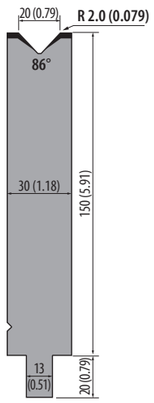
42Cr: 900-1150 N/mm²

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

TMR150.20.86

700 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

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

on stock Article on stock

Please ask for delivery time!

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

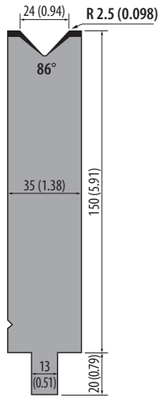
Articles on stock – Please note that delivery time depends on your location.

Dies 86°, H=150 (5.91)

TMR150.24.86

700 kN/m max.

NEW



	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	22.9 kg
Sectioning FA	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg
Sectioning FB	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg

42Cr: 900-1150 N/mm²

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

Rolleri Videos

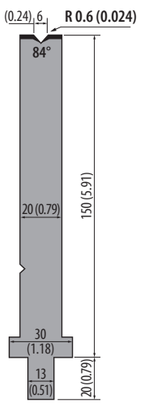
find updated and helpful videos at:
www.rolleritools.com/videos/overview

Dies 84°, H=150 (5.91)

TMR150.06.84

400 kN/m max.

NEW



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

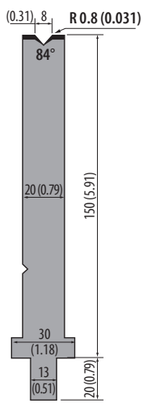
42Cr: 900-1150 N/mm²

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

TMR150.08.84

400 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

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

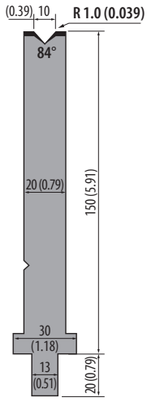
ROLLERI® PROFESSIONAL BENDING

Dies 84°, H=150 (5.91)

TMR150.10.84

500 kN/m max.

NEW



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

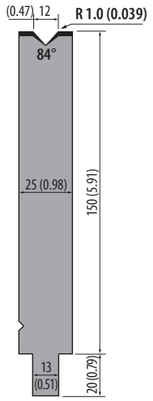
42Cr: 900-1150 N/mm²

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

TMR150.12.84

500 kN/m max.

NEW



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

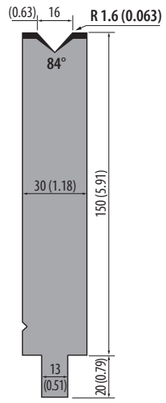
42Cr: 900-1150 N/mm²

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

TMR150.16.84

700 kN/m max.

NEW



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

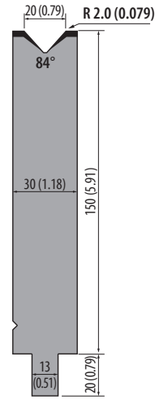
42Cr: 900-1150 N/mm²

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

TMR150.20.84

700 kN/m max.

NEW



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

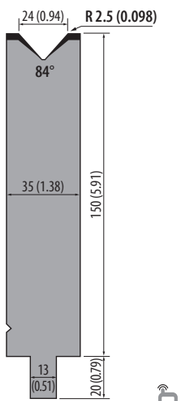
42Cr: 900-1150 N/mm²

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

TMR150.24.84

700 kN/m max.

NEW



	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	22.9 kg
Sectioning FA	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg
Sectioning FB	1250 mm	49.21 in	52.0 kg
	2050 mm	80.71 in	85.3 kg
	2550 mm	100.39 in	106.0 kg
	3050 mm	120.08 in	129.9 kg
	4050 mm	159.45 in	168.5 kg

42Cr: 900-1150 N/mm²

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

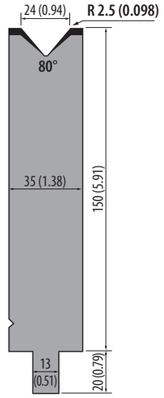
Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

Dies 80°, H=150 (5.91)

TMR150.24.80

700 kN/m max.

NEW



FC	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	22.9 kg
Sectioning FA	1250 mm	49.21 in	52.0 kg
Sectioning FA	2050 mm	80.71 in	85.3 kg
Sectioning FA	2550 mm	100.39 in	106.0 kg
Sectioning FA	3050 mm	120.08 in	129.9 kg
Sectioning FA	4050 mm	159.45 in	168.5 kg
Sectioning FB	1250 mm	49.21 in	52.0 kg
Sectioning FB	2050 mm	80.71 in	85.3 kg
Sectioning FB	2550 mm	100.39 in	106.0 kg
Sectioning FB	3050 mm	120.08 in	129.9 kg
Sectioning FB	4050 mm	159.45 in	168.5 kg

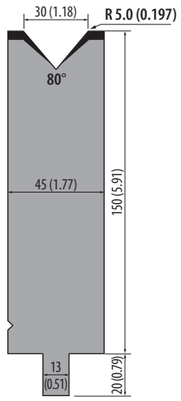
42Cr: 900-1150 N/mm²

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

TMR150.30.80

900 kN/m max.

NEW



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

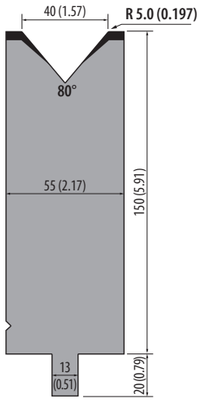
42Cr: 900-1150 N/mm²

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

TMR150.40.80

1200 kN/m max.

NEW



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

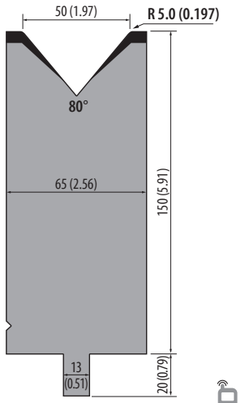
42Cr: 900-1150 N/mm²

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

TMR150.50.80

1500 kN/m max.

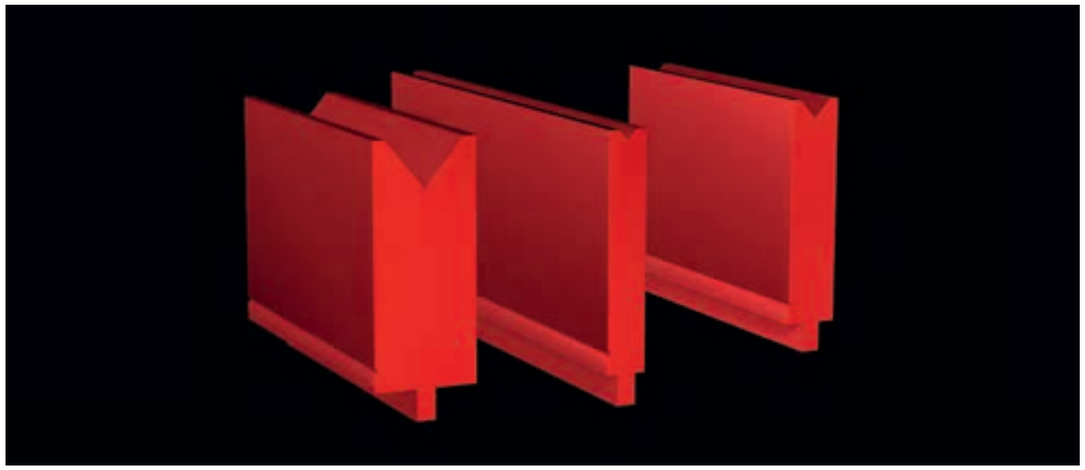
NEW



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

42Cr: 900-1150 N/mm²

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



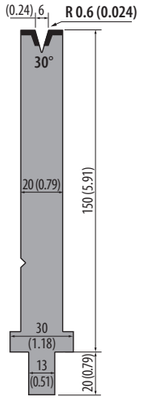
Dies 30°, H=150 (5.91)

ROLLERI® PROFESSIONAL BENDING

TMR150.06.30

400 kN/m max.

NEW



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

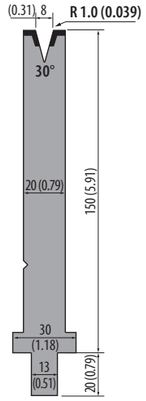
42Cr: 900-1150 N/mm²

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

TMR150.08.30

400 kN/m max.

NEW



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

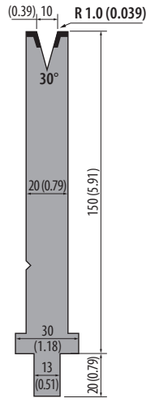
42Cr: 900-1150 N/mm²

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

TMR150.10.30

400 kN/m max.

NEW



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

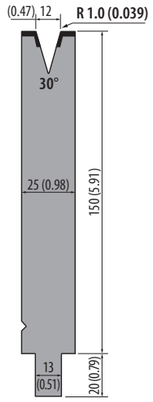
42Cr: 900-1150 N/mm²

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

TMR150.12.30

400 kN/m max.

NEW



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

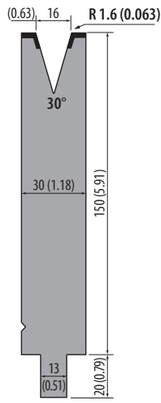
42Cr: 900-1150 N/mm²

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

TMR150.16.30

500 kN/m max.

NEW



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

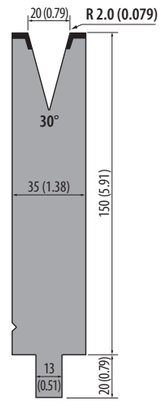
42Cr: 900-1150 N/mm²

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

TMR150.20.30

600 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

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

Article on stock

Please ask for delivery time!

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

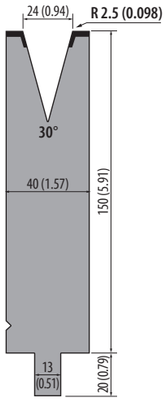
Articles on stock – Please note that delivery time depends on your location.

Dies 30°, H=150 (5.91)

TMR150.24.30

650 kN/m max.

NEW



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

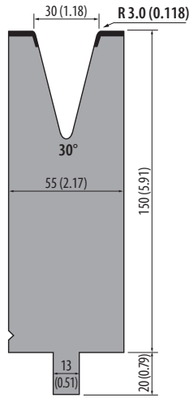
42Cr: 900-1150 N/mm²

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

TMR150.30.30

900 kN/m max.

NEW



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

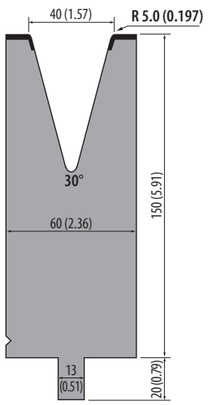
42Cr: 900-1150 N/mm²

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

TMR150.40.30

900 kN/m max.

NEW



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

42Cr: 900-1150 N/mm²

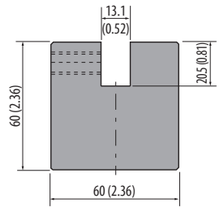
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

Die adapters

ROLLERI® PROFESSIONAL BENDING

AD5

1000 kN/m max.



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

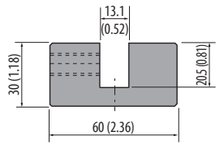
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

on stock

AD6

1000 kN/m max.

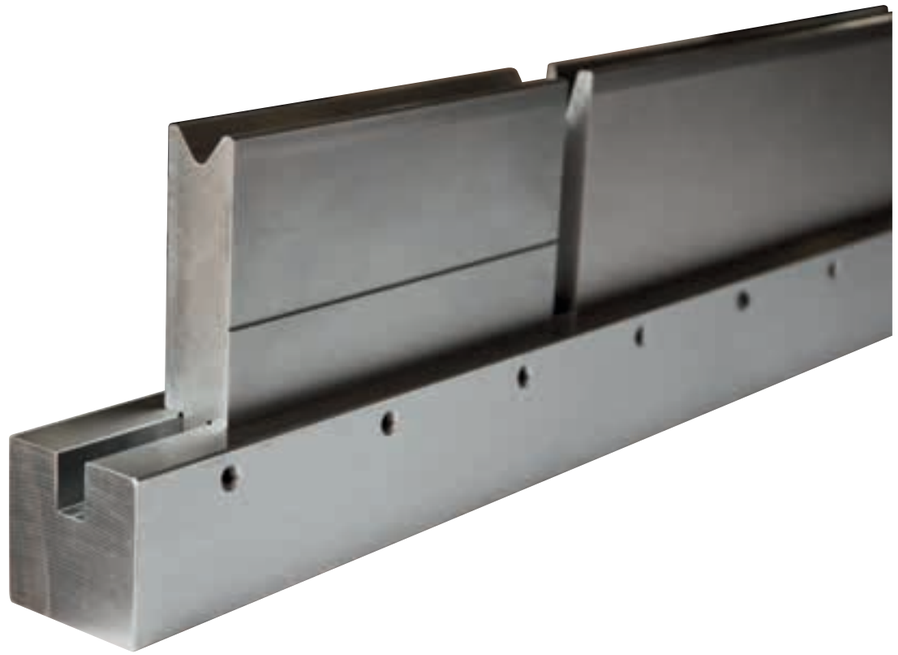


1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

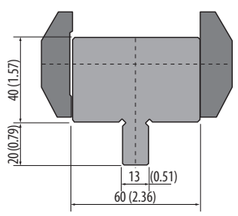
C45: 560-710 N/mm²

on stock



AD7

1000 kN/m max.



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

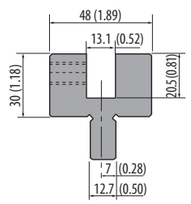
Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²

on stock

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

on stock

on stock Article on stock

Please ask for delivery time!

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

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

R2 ROLLERI TYPE R2

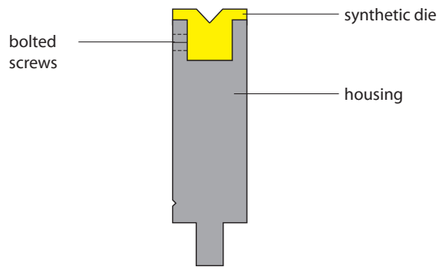
Synthetic dies, H=100 (3.94)

Our Advantages – Your Convenience

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

Mounting example

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



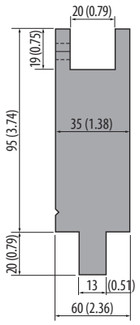
TMN95.20

1000 kN/m max.

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

C45: 560-710 N/mm²

on stock

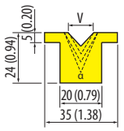


INS20...

200 kN/m max.

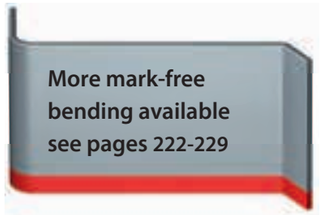
835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg

on stock

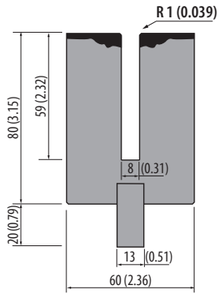


Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

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



TPR.SM.195.28.8 / TPR.SM.195.24.8

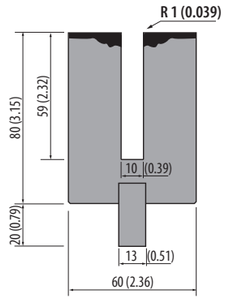


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.4 kg

42Cr: 900-1150 N/mm²

on stock

TPR.SM.195.24.10

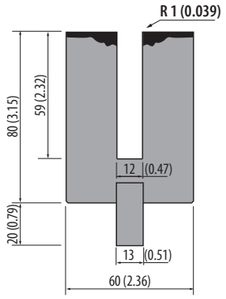


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²

on stock

TPR.SM.195.24.12



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

42Cr: 900-1150 N/mm²

on stock

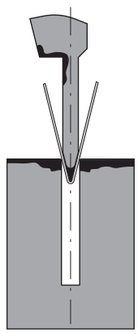
Only for thin material!

Hemming punches
see page 91

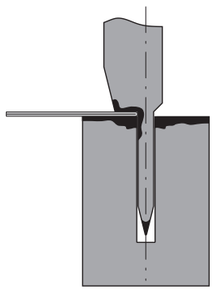
Example of application

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80



500 kN/m max.



1000 kN/m max.

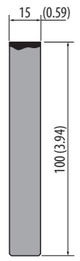
Application

- **movable table necessary**
- used flexibly
- easy mounting

Hemming punches
see page 91

TMI100

1300 kN/m max.



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

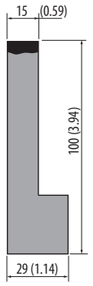
on stock

C45: 560-710 N/mm²

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

TML100

1200 kN/m max.



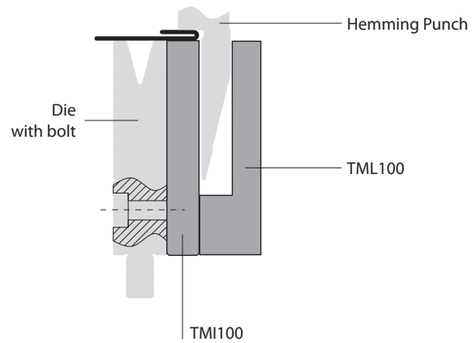
	500 mm	19.68 in	5.0 kg
FC	250 mm segmented	9.84 in segmented	2.5 kg
FW	550 mm segmented	21.65 in segmented	5.5 kg
Sectioning FA	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
	2050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

on stock

C45: 560-710 N/mm²

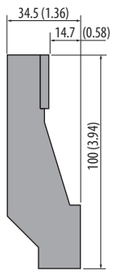
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

Example of application TMI100 + TML100



TMS100

1300 kN/m max.



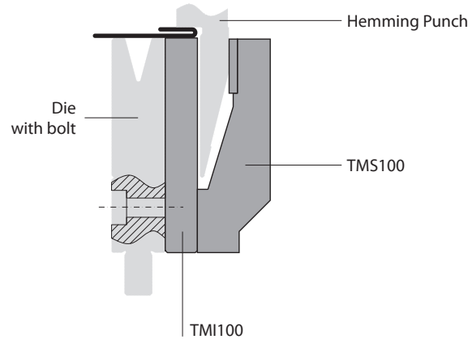
	500 mm	19.68 in	5.0 kg
FC	250 mm segmented	9.84 in segmented	2.5 kg
FW	550 mm segmented	21.65 in segmented	5.5 kg
Sectioning FA	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
	2050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

on stock

C45: 560-710 N/mm²

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

Example of application TMI100 + TMS100



on stock Article on stock

Please ask for delivery time!

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

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

ROLLERI®

PUNCHES ROLLERI TYPE R3

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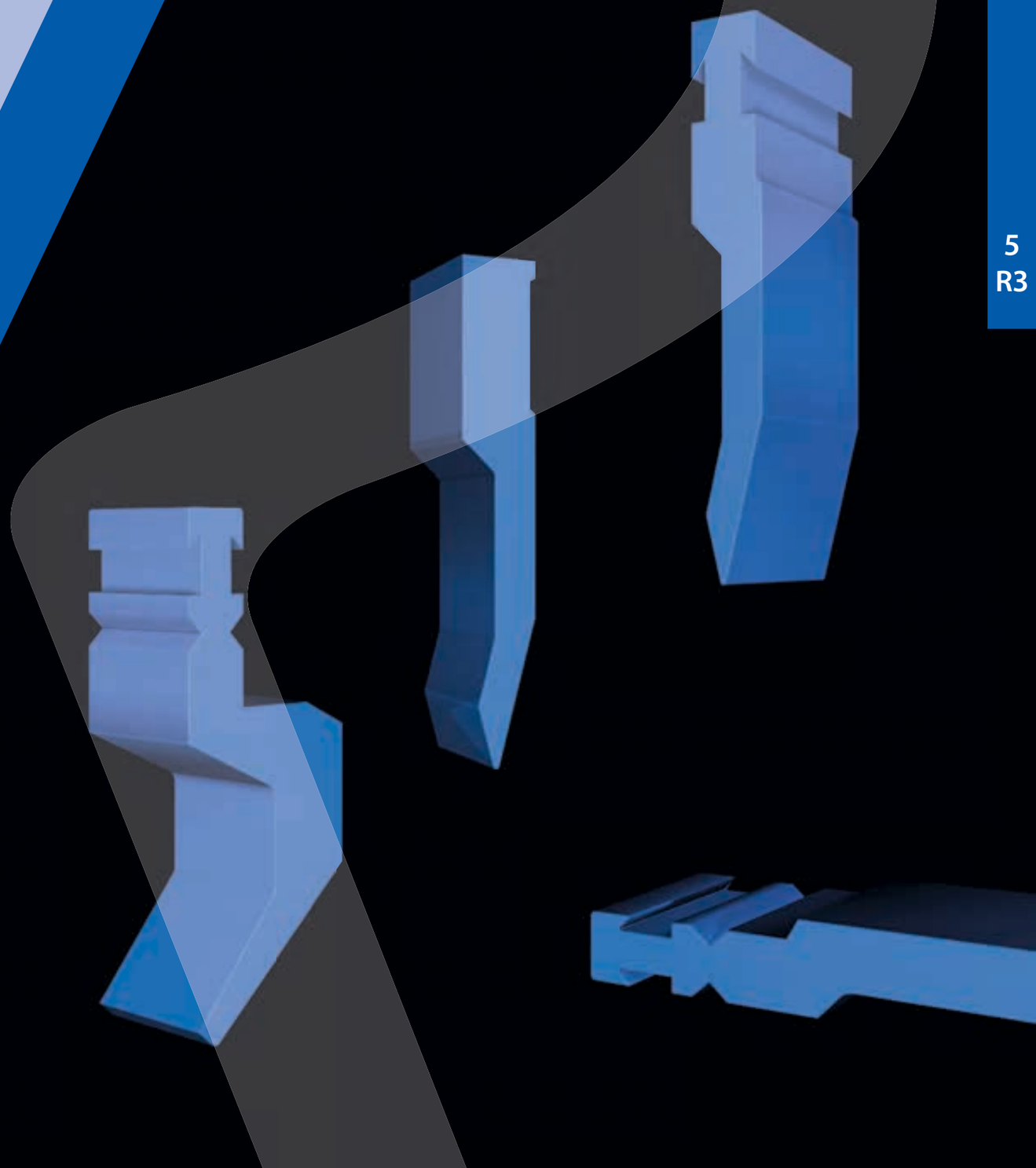
Punches Bystronic-Beyeler R	127
Punches Bystronic-Beyeler S	128
Punch adapters	129
Z-Profile Tools	130 - 131
Radius Tools	132 - 133



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

Compatibility

Punches Rolleri Type R3 are:

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

Our Advantages – Your Convenience

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

Material

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

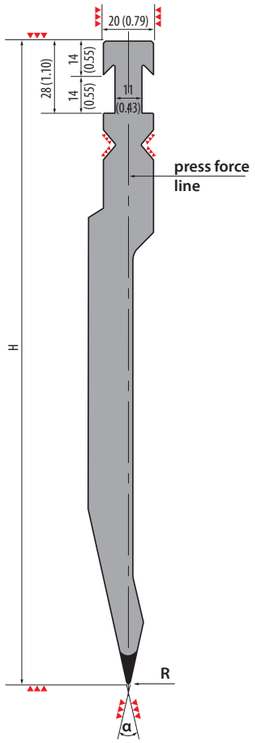
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC

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

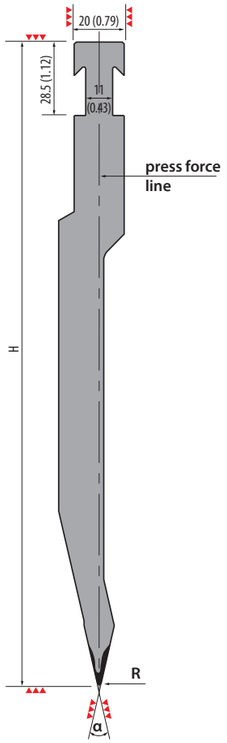
Tang

Punches Rolleri Type R3 have the following tangs:

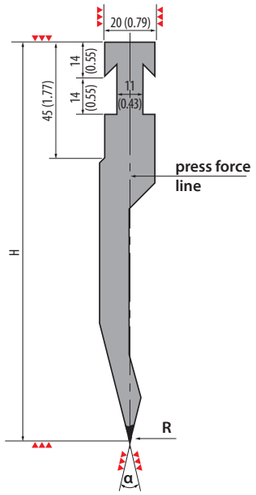
Bystronic-Beyeler RFA



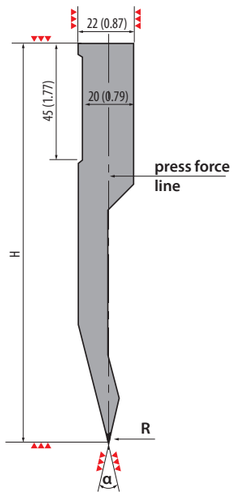
Bystronic-Beyeler RF



Bystronic-Beyeler R



Bystronic-Beyeler S



Indications of precision ground surfaces:
▼▼▼

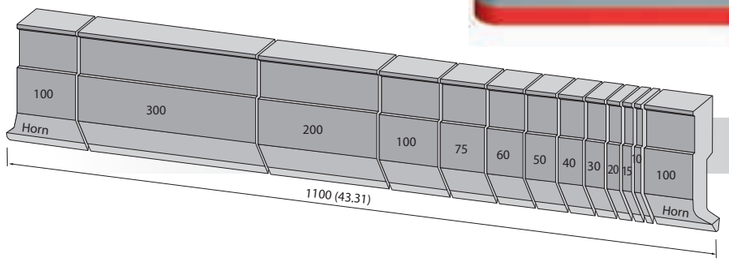
ROLLERI® PROFESSIONAL BENDING

Tool lengths and sectioning

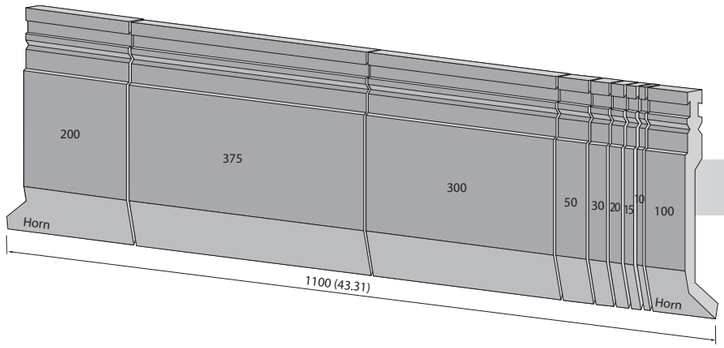
Standard

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

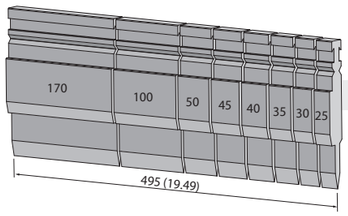
1000 mm (39.36 in)
500 mm (19.68 in)
508 mm (20.00 in)
525 mm (20.67 in)



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

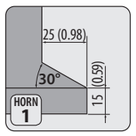


1100 mm (43.30 in) segmented BPR (9 segments)

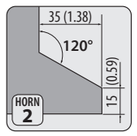


495 mm (19.48 in) segmented (8 segments)

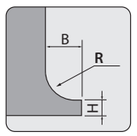
Horn Types



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



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



Individual Horn
production
according
to your
specifications

5
R3

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

Punches Bystronic-Beyeler RFA

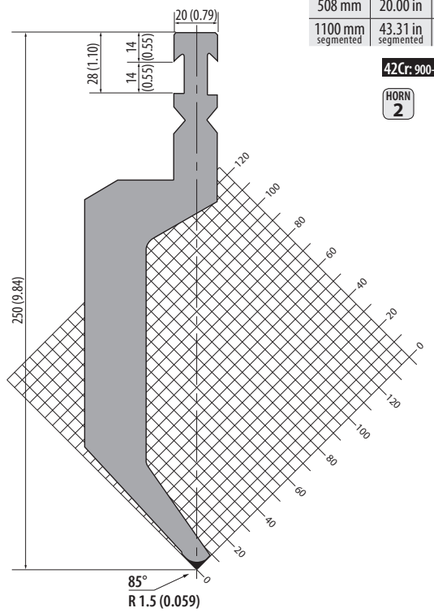
BPR250.P4-RFA

900 kN/m max.

508 mm	20.00 in	27.4 kg
1100 mm segmented	43.31 in segmented	59.0 kg

42Cr: 900-1150 N/mm²

HORN 2 — on stock



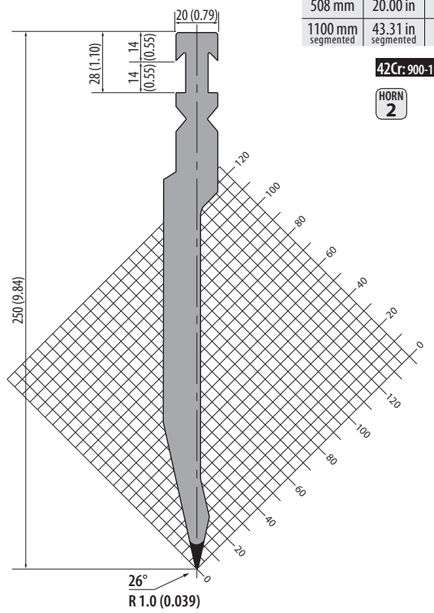
BPR250.P5-RFA

1000 kN/m max.

508 mm	20.00 in	26.0 kg
1100 mm segmented	43.31 in segmented	57.0 kg

42Cr: 900-1150 N/mm²

HORN 2 — on stock



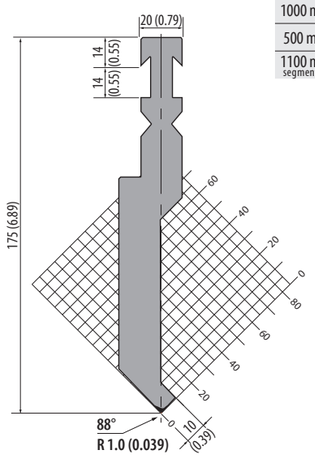
BP175.88.R1-A-RFA

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	25.3 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock



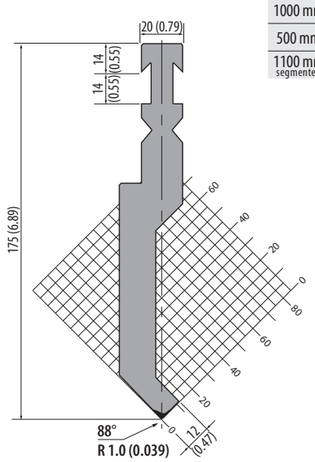
BP175.88.R1-B-RFA

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	25.3 kg

42Cr: 900-1150 N/mm²

HORN 1 — on stock



Punches Bystronic-Beyeler RFA

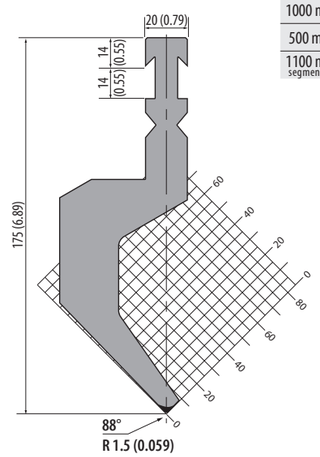
BP175.88.R15-RFA

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

HORN 1 — on stock



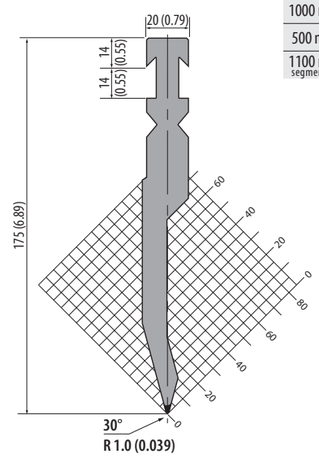
BP175.30.R1-RFA

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

HORN 1 — on stock



Punches Bystronic-Beyeler RF

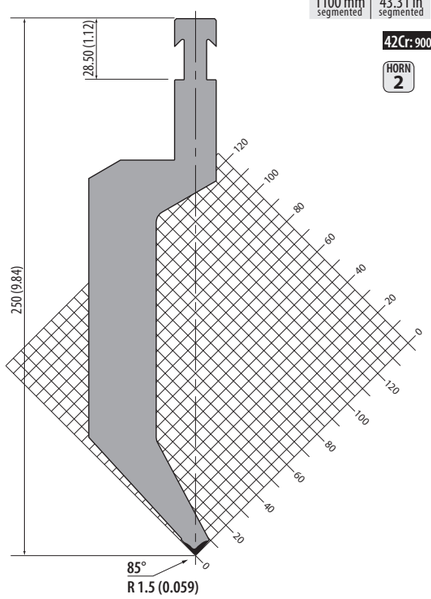
BPR250.P4-RF

1000 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 2 — on stock



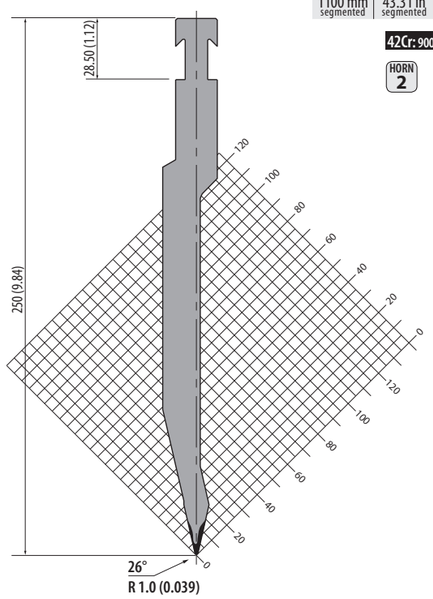
BPR250.P5-RF

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

HORN 2 — on stock



on stock — Article on stock

Please ask for delivery time!

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

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

Hemming Punches Bystronic-Beyeler RFA

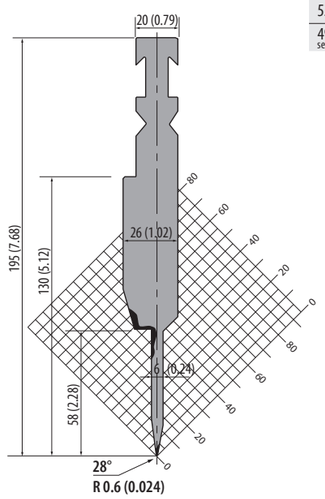
BPR.SP-195.28.6

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

on stock

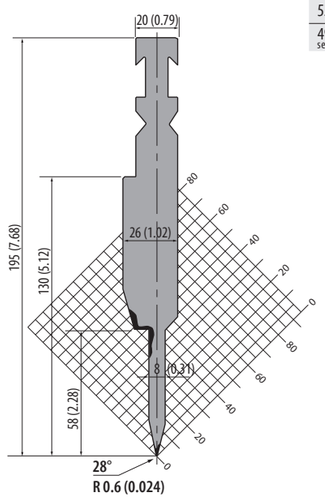


BPR.SP-195.28.8

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

42Cr: 900-1150 N/mm²

on stock

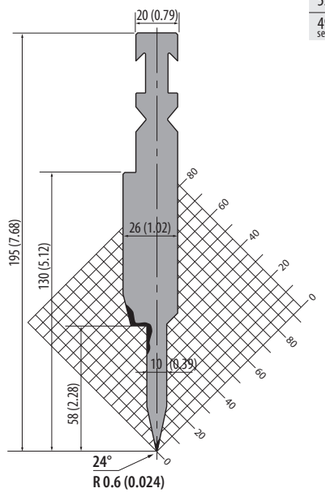


BPR.SP-195.24.10

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

42Cr: 900-1150 N/mm²

on stock



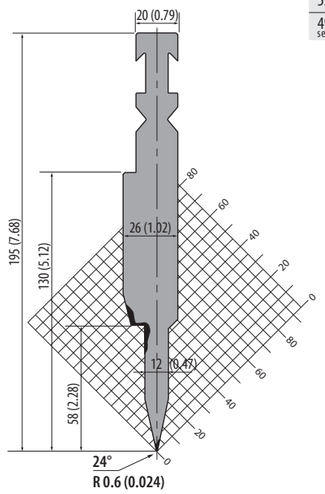
Compatible Hemming Dies on page 146

BPR.SP-195.24.12

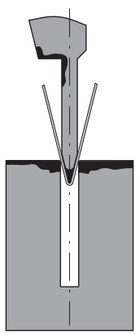
525 mm	20.67 in	9.2 kg
495 mm segmented	19.49 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

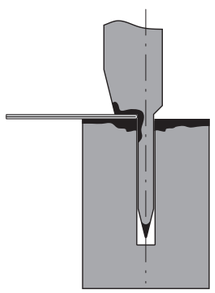
on stock



Example of Application



800 kN/m max.



1000 kN/m max.

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80

Punches Bystronic-Beyeler R

ROLLERI® PROFESSIONAL BENDING

BP155.85.R08-R

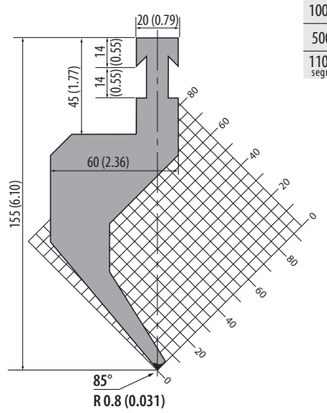
500 kN/m max.

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

HORN 1

on stock



BP155.85.R1-R

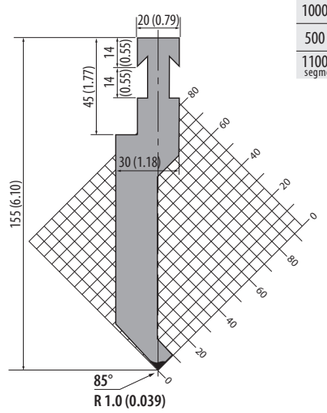
1000 kN/m max.

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

HORN 1

on stock



BP155.85.R15-R

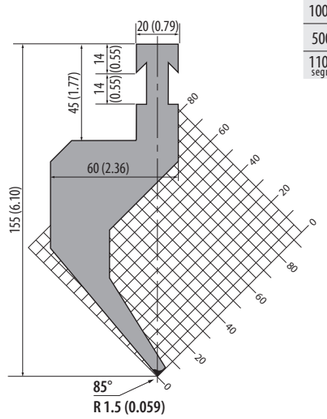
500 kN/m max.

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

HORN 1

on stock



BP155.30.R1-R

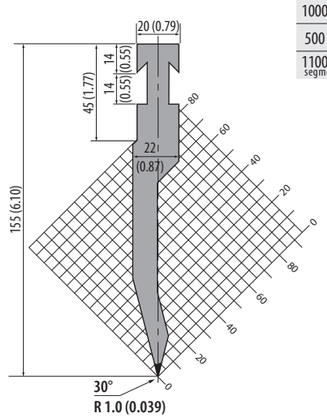
800 kN/m max.

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

HORN 1

on stock



BP155.28.R1-R

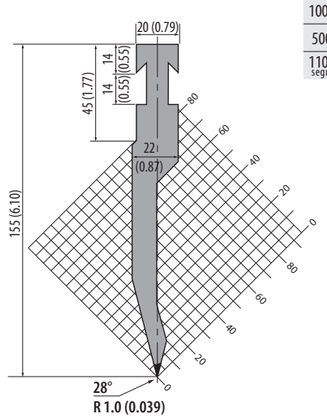
800 kN/m max.

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

HORN 1

on stock



BP155.28.R3-R

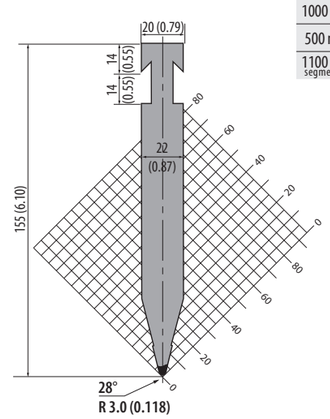
1000 kN/m max.

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

HORN 1

on stock



on stock Article on stock

Please ask for delivery time!

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

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

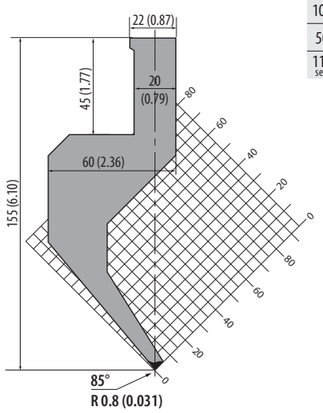
BP155.85.R08-S

500 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock



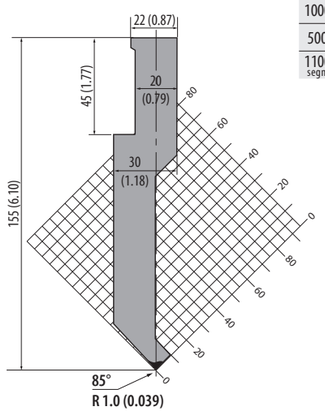
BP155.85.R1-S

1000 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock



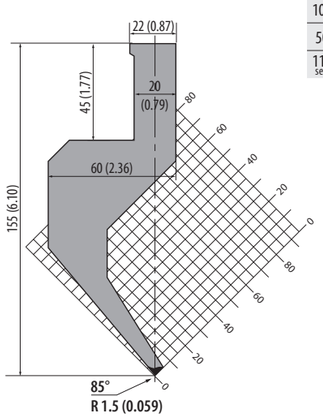
BP155.85.R15-S

500 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock



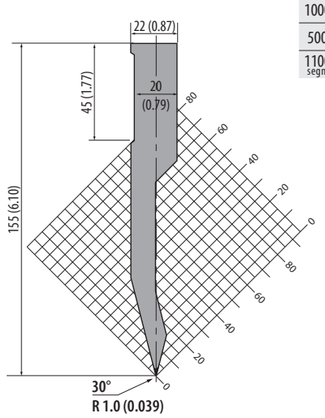
BP155.30.R1-S

800 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock



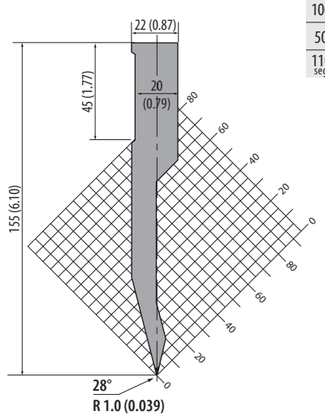
BP155.28.R1-S

800 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1 — on stock



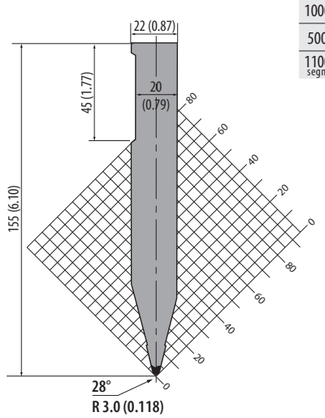
BP155.28.R3-S

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

HORN 1 — on stock



ROLLERI® PROFESSIONAL BENDING

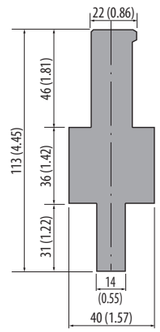
AD3

1000 kN/m max.

150 mm	5.90 in	3.3 kg

Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm² — on stock



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

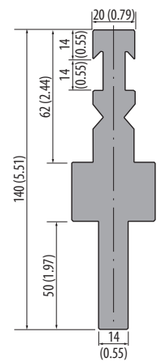
AD10

1000 kN/m max.

150 mm	5.90 in	3.4 kg

Rolleri Type R3 Beyeler RFA → Rolleri Type R1

C45: 560-710 N/mm² — on stock



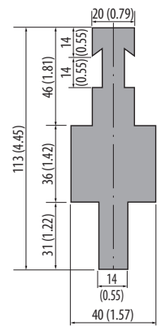
AD22

1000 kN/m max.

150 mm	5.90 in	3.4 kg

Rolleri Type R3 Beyeler R
→ Rolleri Type R1

C45: 560-710 N/mm² — on stock



5 R3

on stock Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

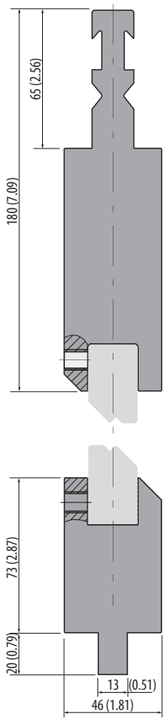
BPZ-RFA

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

on stock



BPZ-R

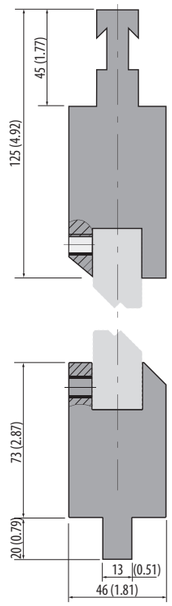
1000 kN/m max.

NEW

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

C45: 560-710 N/mm²

on stock



BPZ-S

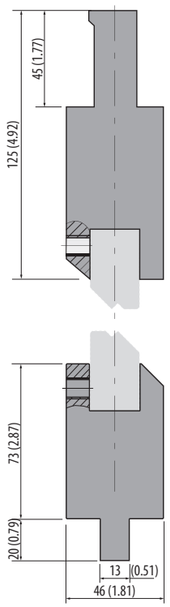
1000 kN/m max.

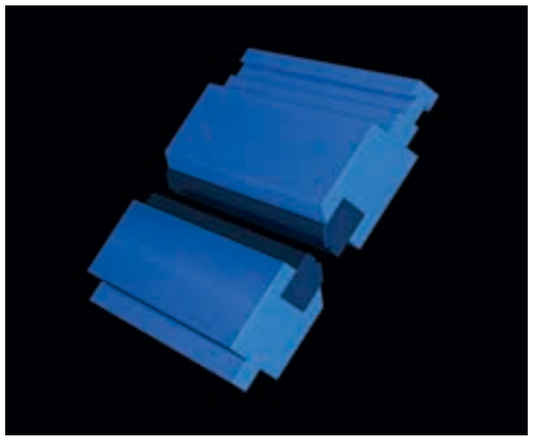
NEW

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

C45: 560-710 N/mm²

on stock



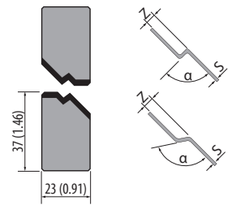


Rolleri Videos

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

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

1000 kN/m max.



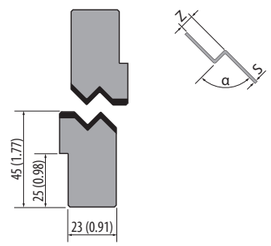
Model	Z mm	Z in	α	S* mm	S* inch	835 mm / 32.87 in Weight	415 mm / 16.34 in Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 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

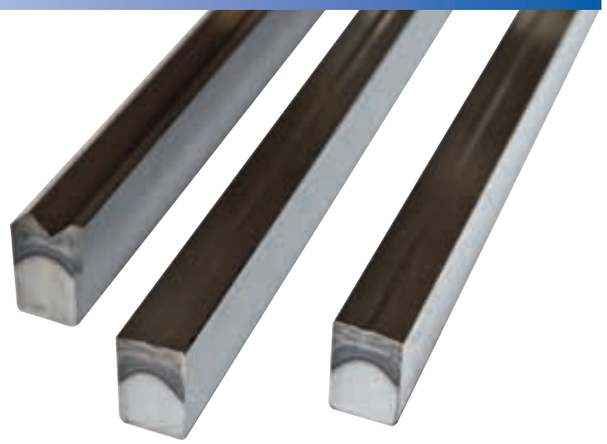
C45: C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

Z-Profile Inserts 90°

1000 kN/m max.





Model	Z mm	Z in	α	S* mm	S* inch	835 mm / 32.87 in Weight	415 mm / 16.34 in 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

on stock

C45: 560-710 N/mm²

5 R3

on stock Article on stock

Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (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

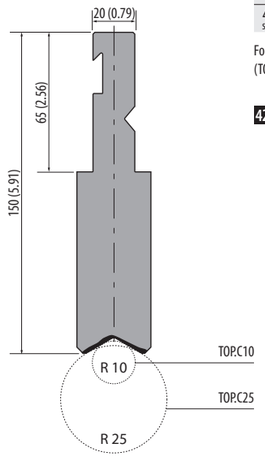
1000 kN/m max.

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

on stock



BPR150.P10.15-RFA

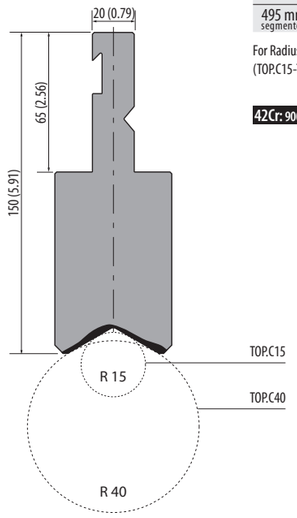
1000 kN/m max.

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

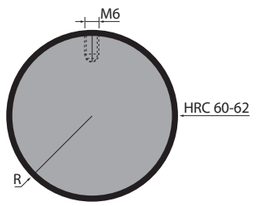
42Cr: 900-1150 N/mm²

on stock



Radius Tools: R10-40

1000 kN/m max.



Material: C53 induction hardened 60-62HRc

on stock

C53: 610-760 N/mm²

Model	R mm	R in		Weight		Weight
TOP.C10	10	0.39	525 mm / 20.67 in	1.3 kg	495 mm / 16.34 in segmented	2.7 kg
TOP.C12.5	12.5	0.49		2.0 kg		2.8 kg
TOP.C15	15	0.59		3.0 kg		3.8 kg
TOP.C17.5	17.5	0.69		4.0 kg		4.7 kg
TOP.C20	20	0.79		5.2 kg		6.6 kg
TOP.C25	25	0.98		8.1 kg		7.5 kg
TOP.C30	30	1.18		11.7 kg		11.3 kg
TOP.C35	35	1.38		16.0 kg		15.1 kg
TOP.C40	40	1.57		20.7 kg		19.5 kg

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

ROLLERI® PROFESSIONAL BENDING

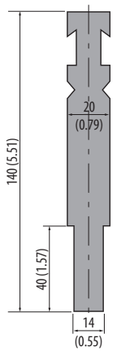
BPU-RFA

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

on stock



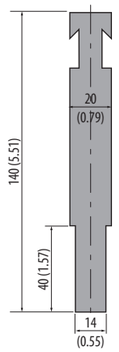
BPU-R

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

on stock



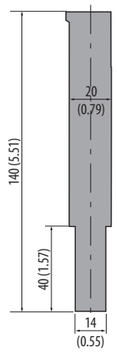
BPU-S

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

on stock



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

800 kN/m max.

on stock

C45: 560-710 N/mm²

Model	Ø mm	Ø in	H mm	H in		Weight		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.

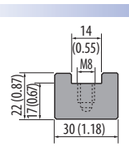
on stock

C45: 560-710 N/mm²

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

E30.22

800 kN/m max.



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

C45: 560-710 N/mm²

on stock

on stock Article on stock

Please ask for delivery time!

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

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

ROLLERI®

DIES ROLLERI TYPE R3

Content Explanation	136 - 137
Dies 90°, H=55 (2.17)	138
Dies 88°, H=55 (2.17)	139
Dies 85°, H=55 (2.17)	139
Dies 80°, H=65 (2.56) / H=85 (3.35)	140
Dies 60°, H=55 (2.17) / H=65 (2.56)	140
Dies 30°, H=55 (2.17) / H=60 (2.36)	141
Dies 30°, H=70 (2.76)	142
Dies, H=100 (3.94) / H=120 (4.72) / H=150 (5.91)	143 - 145
Hemming Dies	146
Synthetic Dies, H=100 (3.94)	147
Die Adapters	147

Compatibility

Dies Rolleri Type R3 are **compatible** with press brake machines from:
- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

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

Compatibility

Dies Rolleri Type R3 are:

- **compatible** with press brake machines with a table groove for pins 13 x 20 mm (0.51 x 0.79 in): Bystronic-Beyeler, Bystronic-Hämmerle, Safan, SMD, Trumpf
- also applicable on all other press brake machines **with Adapter-Systems and Adapter Rails** (see pages 218-221).

Our Advantages – Your Convenience

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

Material

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

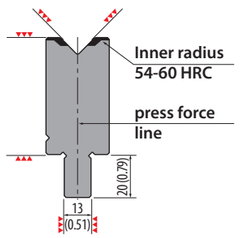
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC

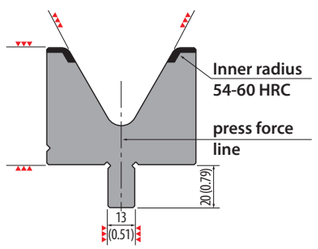
- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

Tang

All dies Rolleri Type R3 are by default equipped with a **13 x 20 mm (0.51 x 0.79 in) tail**.

Indications of precision ground surfaces:
▼▼▼



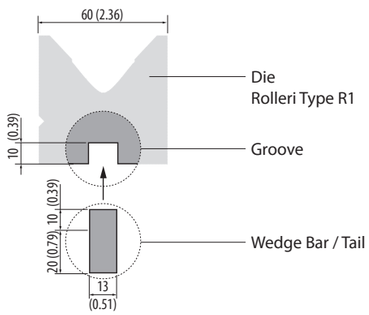


Modification: Wedge Bar / Tail

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

For more specific information and prices go to page 252 in the Service Chapter.

Example of Application



R3 ROLLERI TYPE R3
Content Explanation Dies

ROLLERI® PROFESSIONAL BENDING

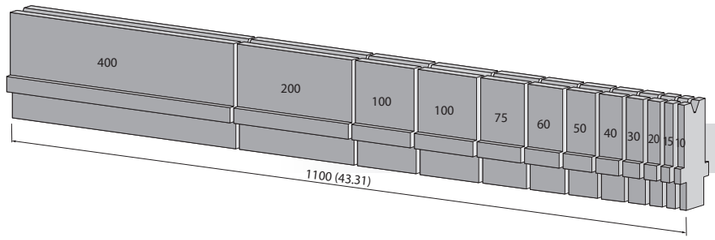
Tool lengths and sectioning

Standard

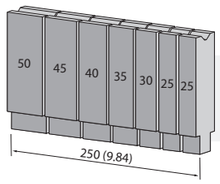
1000 mm (39.37 in)

500 mm (19.68 in)

525 mm (20.67 in)



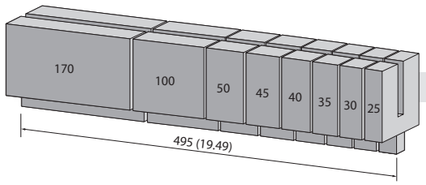
1100 mm (43.31 in) segmented (12 segments)



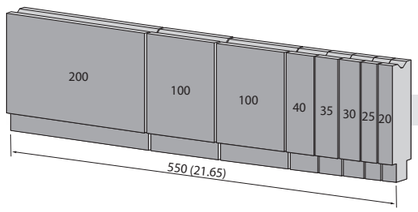
250 mm (9.84 in) segmented / FC (7 segments)

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

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)

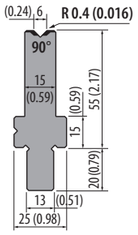
Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

R3 ROLLERI TYPE R3

Dies 90°, H=55 (2.17)

BMR55.06.90

1150 kN/m max.



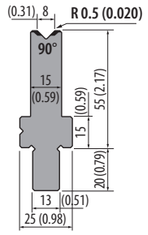
1000 mm	39.37 in	8.5 kg
500 mm	19.68 in	4.2 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.08.90

1100 kN/m max.



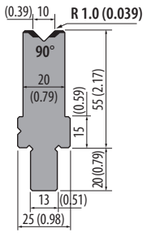
1000 mm	39.37 in	9.0 kg
500 mm	19.68 in	4.5 kg
1100 mm segmented	43.31 in segmented	8.5 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.10.90

1100 kN/m max.



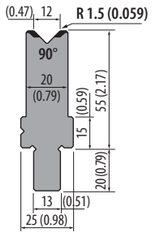
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.12.90

1200 kN/m max.



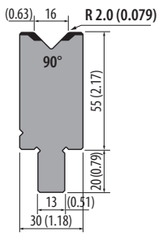
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²

on stock

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

on stock

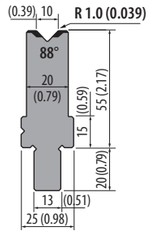
R3 ROLLERI TYPE R3

ROLLERI® PROFESSIONAL BENDING

Dies 88°, H=55 (2.17)

BMR55.10.88

1100 kN/m max.



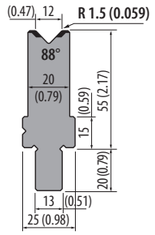
1000 mm	39.37 in	11.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	12.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.12.88

1200 kN/m max.



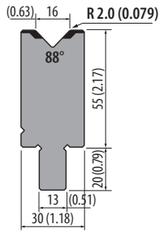
1000 mm	39.37 in	10.5 kg
500 mm	19.68 in	5.2 kg
1100 mm segmented	43.31 in segmented	10.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.16.88

1200 kN/m max.



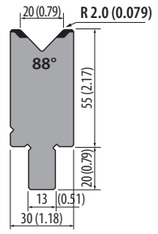
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.20.88

1100 kN/m max.



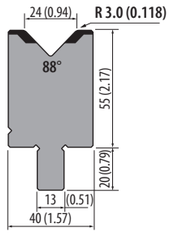
1000 mm	39.37 in	14.5 kg
500 mm	19.68 in	7.2 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.24.88

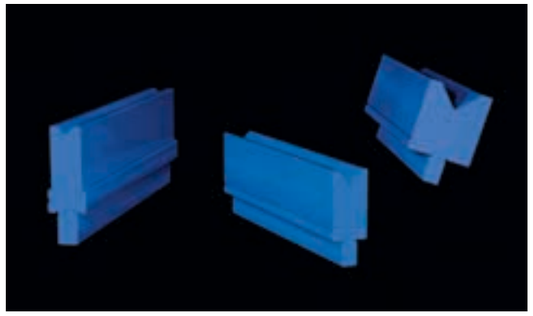
1200 kN/m max.



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

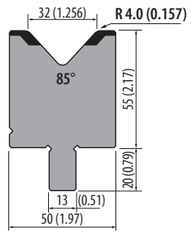
on stock



Dies 85°, H=55 (2.17)

BMR55.32.85

1200 kN/m max.



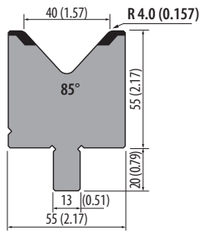
1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	20.5 kg

42Cr: 900-1150 N/mm²

on stock

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

on stock

6 R3

on stock Article on stock

Please ask for delivery time!

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

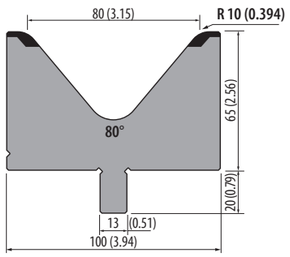
Articles on stock – Please note that delivery time depends on your location.

R3 ROLLERI TYPE R3

Dies 80°, H=65 (2.56) / H=85 (3.35)

BMR65.80.80

1700 kN/m max.



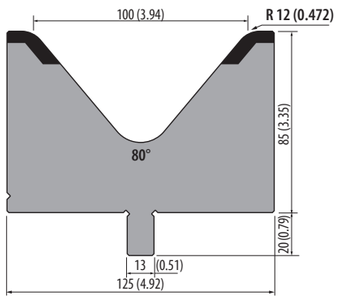
1000 mm	39.37 in	39.0 kg
500 mm	19.68 in	20.0 kg
1100 mm segmented	43.31 in segmented	43.0 kg

42Cr: 900-1150 N/mm²

on stock

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

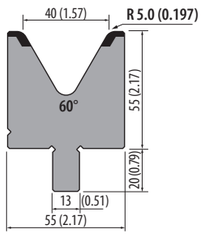
42Cr: 900-1150 N/mm²

on stock

Dies 60°, H=55 (2.17), H=65 (2.56)

BMR55.40.60

1300 kN/m max.



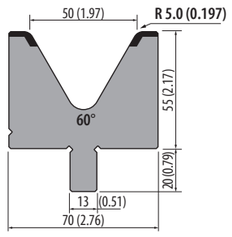
1000 mm	39.37 in	20.3 kg
500 mm	19.68 in	10.5 kg
1100 mm segmented	43.31 in segmented	22.3 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.50.60

1200 kN/m max.



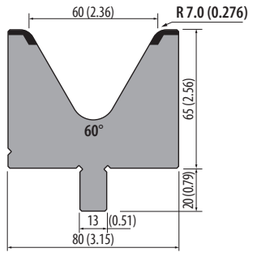
1000 mm	39.37 in	25.0 kg
500 mm	19.68 in	12.0 kg
1100 mm segmented	43.31 in segmented	21.0 kg

42Cr: 900-1150 N/mm²

on stock

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

on stock

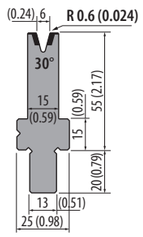
R3 ROLLERI TYPE R3

Dies 30°, H=55 (2.17), H=60 (2.36)

ROLLERI® PROFESSIONAL BENDING

BMR55.06.30

350 kN/m max.



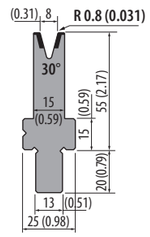
1000 mm	39.37 in	8.0 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	9.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.08.30

200 kN/m max.



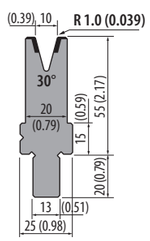
1000 mm	39.37 in	9.2 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	10.1 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.10.30

350 kN/m max.



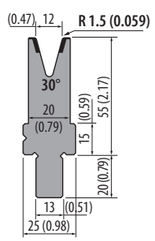
1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.12.30

300 kN/m max.



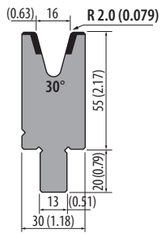
1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.16.30

450 kN/m max.



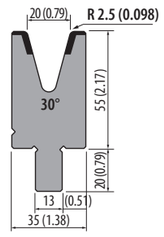
1000 mm	39.37 in	13.5 kg
500 mm	19.68 in	6.7 kg
1100 mm segmented	43.31 in segmented	14.9 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.20.30

500 kN/m max.



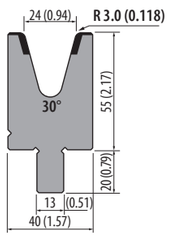
1000 mm	39.37 in	14.0 kg
500 mm	19.68 in	7.0 kg
1100 mm segmented	43.31 in segmented	13.5 kg

42Cr: 900-1150 N/mm²

on stock

BMR55.24.30

550 kN/m max.



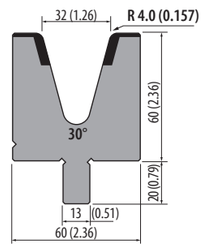
1000 mm	39.37 in	15.5 kg
500 mm	19.68 in	7.8 kg
1100 mm segmented	43.31 in segmented	17.0 kg

42Cr: 900-1150 N/mm²

on stock

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

on stock

Article on stock

Please ask for delivery time!

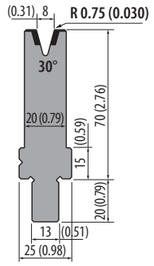
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

Dies 30°, H=70 (2.76)

BMR70.08.30

200 kN/m max.



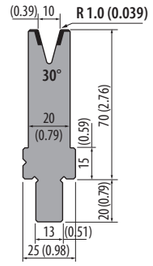
1000 mm	39.37 in	13.1 kg
500 mm	19.68 in	6.5 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²

on stock

BMR70.10.30

350 kN/m max.



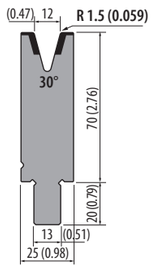
1000 mm	39.37 in	12.8 kg
500 mm	19.68 in	6.4 kg
1100 mm segmented	43.31 in segmented	12.4 kg

42Cr: 900-1150 N/mm²

on stock

BMR70.12.30

300 kN/m max.



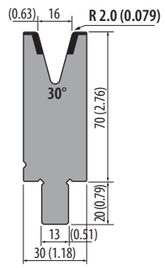
1000 mm	39.37 in	14.7 kg
500 mm	19.68 in	7.3 kg
1100 mm segmented	43.31 in segmented	14.3 kg

42Cr: 900-1150 N/mm²

on stock

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

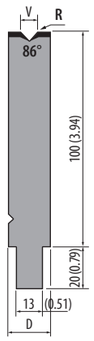
42Cr: 900-1150 N/mm²

on stock

Dies, H=100 (3.94) / H=120 (4.72)

ROLLERI® PROFESSIONAL BENDING

86° Dies, H=100 (3.94)



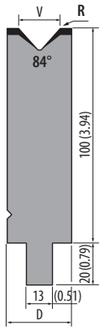
Individual drawings, available lengths and prices see pages 101-103

on stock

42Cr: 900-1150 N/mm²

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.86	4	0.16	0.6	0.02	20	0.79	450
TMR100.06.86	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.86	8	0.31	0.8	0.03	20	0.79	1150
WMR100.08.86	8	0.31	2.5	0.10	25	0.98	400
TMR100.10.86	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.86	12	0.47	1.0	0.04	25	0.98	1200
WMR100.12.86	12	0.47	2.5	0.10	25	0.98	500
TMR100.16.86	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.86	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.86	24	0.94	2.5	0.10	35	1.38	1200
TMR100.30.86	30	1.18	3.0	0.12	45	1.77	1200
TMR100.40.86	40	1.57	3.0	0.12	55	2.17	1200
TMR100.50.86	50	1.97	3.0	0.12	75	2.95	1500

84° Dies, H=100 (3.94)



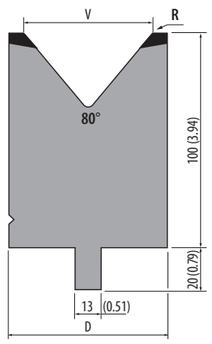
Individual drawings, available lengths and prices see pages 103-104

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

on stock

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

on stock

Individual drawings, available lengths and prices see page 105

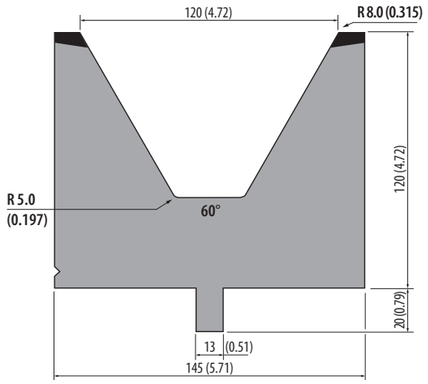
on stock Article on stock

Please ask for delivery time!

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

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

60° Die, H=120 (4.72)

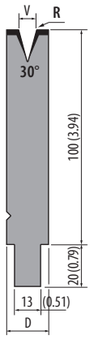


Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR120.120.60	120	4.72	8.0	0.31	145	5.71	1000

42Cr: 900-1150 N/mm²

Individual drawings, available lengths and prices see page 106

30° Dies, H=100 (3.94)

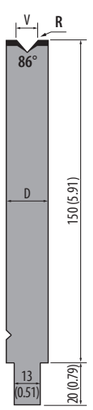


Individual drawings, available lengths and prices see pages 106-108

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.30	4	0.16	0.6	0.02	20	0.79	150
TMR100.06.30	6	0.24	0.6	0.02	20	0.79	400
WMR100.06.30	6	0.24	2.0	0.08	20	0.79	400
TMR100.08.30	8	0.31	1.0	0.04	20	0.79	400
WMR100.08.30	8	0.31	2.5	0.10	20	0.79	400
TMR100.10.30	10	0.39	1.0	0.04	20	0.79	400
WMR100.10.30	10	0.39	2.5	0.10	25	0.98	400
TMR100.12.30	12	0.47	1.0	0.04	25	0.98	400
WMR100.12.30	12	0.47	3.0	0.12	25	0.98	400
TMR100.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR100.20.30	20	0.79	2.0	0.08	30	1.18	600
TMR100.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR100.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR100.40.30	40	1.57	5.0	0.20	60	2.36	900

42Cr: 900-1150 N/mm²

86° Dies, H=150 (5.91)



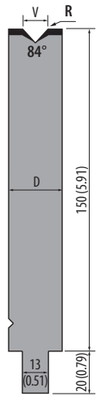
Individual drawings, available lengths and prices see pages 109-110

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.86	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.86	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.86	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.86	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.86	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.86	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.86	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm²

ROLLERI® PROFESSIONAL BENDING

84° Dies, H=150 (5.91)

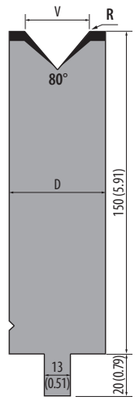


Individual drawings, available lengths and prices see pages 110-111

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.84	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.84	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.84	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.84	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.84	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.84	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.84	24	0.94	2.5	0.10	35	1.38	700

42Cr: 900-1150 N/mm²

80° Dies, H=150 (5.91)

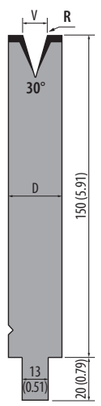


Individual drawings, available lengths and prices see page 112

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.24.80	24	0.94	2.5	0.10	35	1.38	700
TMR150.30.80	30	1.18	5.0	0.20	45	1.77	900
TMR150.40.80	40	1.57	5.0	0.20	55	2.17	1200
TMR150.50.80	50	1.97	5.0	0.20	65	2.56	1500

42Cr: 900-1150 N/mm²

30° Dies, H=150 (5.91)



Individual drawings, available lengths and prices see pages 113-114

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.30	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.30	8	0.31	1.0	0.04	20	0.79	400
TMR150.10.30	10	0.39	1.0	0.04	20	0.79	400
TMR150.12.30	12	0.47	1.0	0.04	25	0.98	400
TMR150.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR150.20.30	20	0.79	2.0	0.08	35	1.38	600
TMR150.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR150.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR150.40.30	40	1.57	5.0	0.20	55	2.17	900

42Cr: 900-1150 N/mm²

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

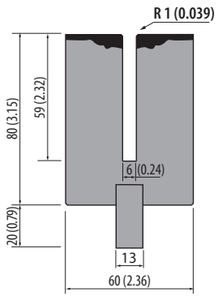
Hemming Dies

BPR.SM.195.28.6

525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

on stock



Only for thin material!

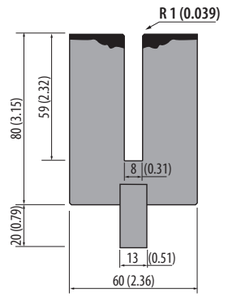
Hemming punches
see page 126

BPR.SM.195.28.8

525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

on stock

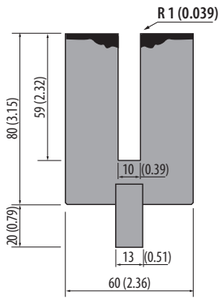


BPR.SM.195.24.10

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

42Cr: 900-1150 N/mm²

on stock

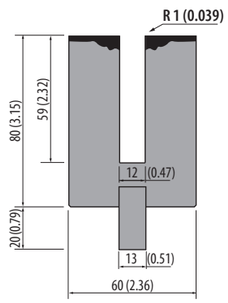


BPR.SM.195.24.12

525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	10.8 kg

42Cr: 900-1150 N/mm²

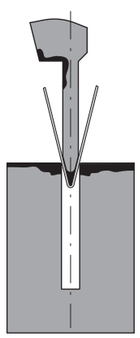
on stock



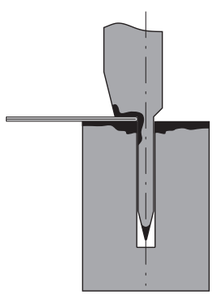
Example of Application

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80



500 kN/m max.



1000 kN/m max.

Synthetic Dies, H=100 (3.94)

ROLLERI® PROFESSIONAL BENDING

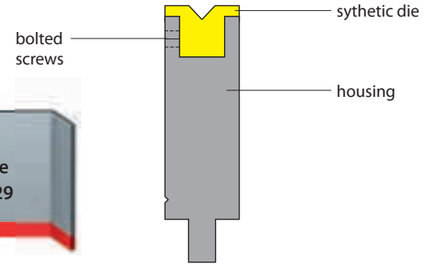
Our Advantages – Your Convenience

- easy handling
- faster and easier exchange
- preventing bending marks
- decrease of post-processing of bended profiles
- no contact of materials
- higher product quality

More mark-free bending available
see pages 222-229

Mounting example

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



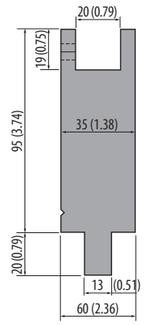
TMN95.20

1000 kN/m max.

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

C45: 560-710 N/mm²

on stock

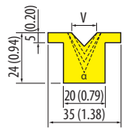


INS20...

200 kN/m max.

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

on stock



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

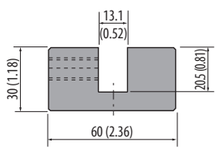
1000 kN/m max.

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

on stock



AD5

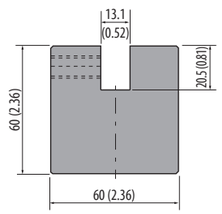
1000 kN/m max.

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

on stock



AD8-12.7

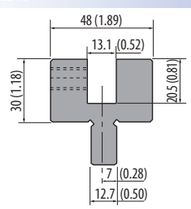
1000 kN/m max.

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

on stock



AD7

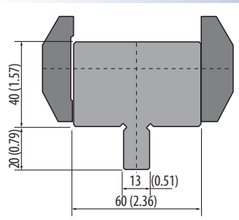
1000 kN/m max.

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

on stock



6 R3

Article on stock

Please ask for delivery time!

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

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

ROLLERI®

TOOLS ROLLERI TYPE RX

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American: Explanation	152
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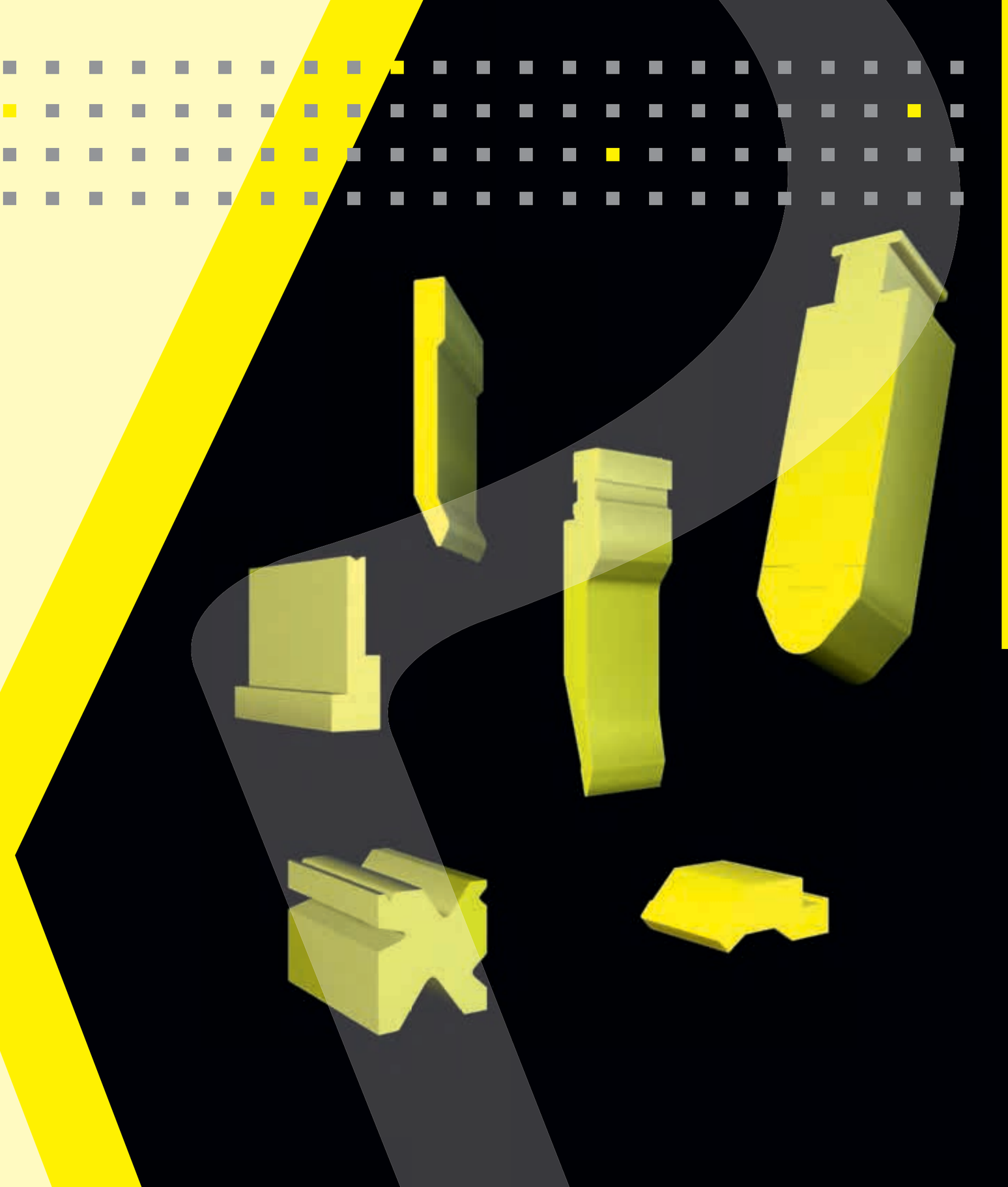
Compatibility

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

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



Compatibility

Tools Rolleri Type RX are:

- **compatible** with press brake machines from: EHT, Weinbrenner, American, Gasparini, Ajial-Axial, Colgar, LVD, Colly, Hämmerle-Bystronic, etc.
- **with Adapter-Systems** (see pages 210-221) also applicable on all other press brake machines.

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modification possible (see pages 248-253)
- very large stock availability

Material

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

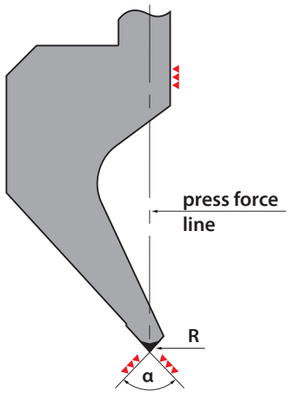
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC

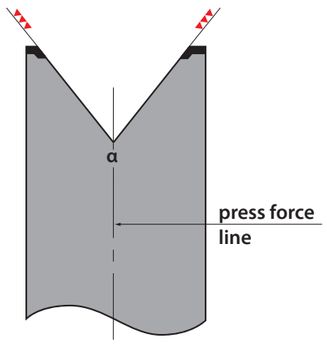
- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

Tang

Punches Rolleri R Type have various tangs.

Indications of precision ground areas:
▼▼▼



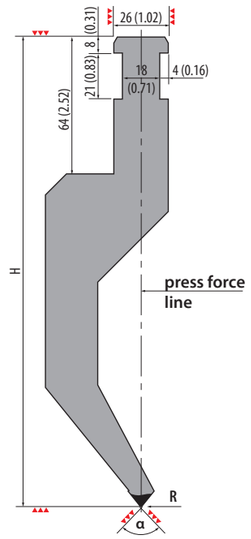


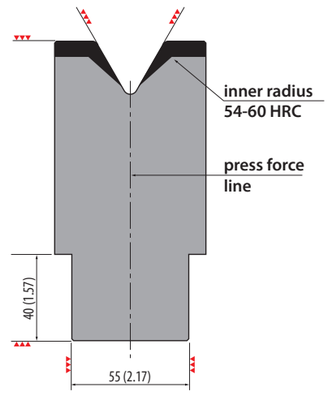
Tool lengths, sectionings and horn types

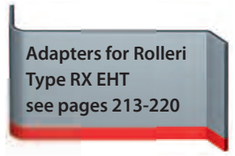
- tools Rolleri type RX are available in any length
- customized sectioning available upon your measurements
- customized horn pieces available upon request

Explanation

We produce for you the Tools Rolleri Type RX EHT in a vast variety – custom, fast, economic and with precision.



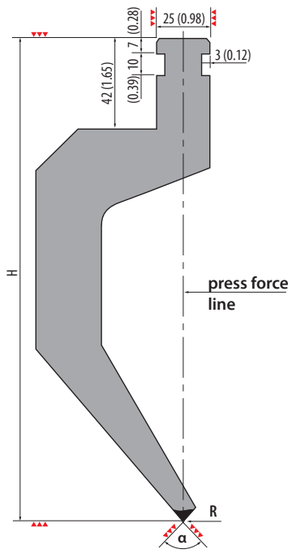


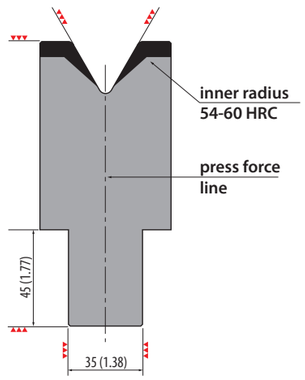


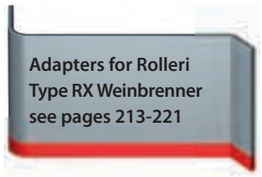
Weinbrenner

Explanation

We produce for you the Tools Rolleri Type RX Weinbrenner in a vast variety – custom, fast, economic and with precision.







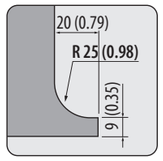
Tool lengths, sectionings and horn types

Punches:

- **838 mm (33 in)**
- **415 mm (16.34 in)**
- **805 mm (31.69 in) segmented**
  9 segments (100 Horn left, 100, 50, 40, 20, 15, 10, 370, 100 Horn right)

Dies:

- **838 mm (33 in)**
- **415 mm (16.34 in)**
- **805 mm (31.69 in) segmented**
  8 segments (200, 50, 40, 20, 15, 10, 370, 100)

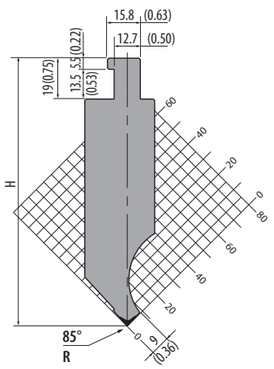


Standard-Horn Type
for all segmented
Punches Rolleri
Type RX American

Punches American

ASP-135

900 kN/m max.

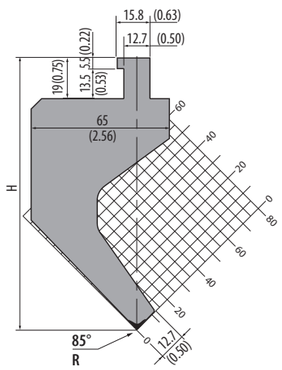


ASP-135-16	H=125 (4.92) / R=0.4 (0.016)		
	838 mm	33.00 in	21.0 kg
	415 mm	16.34 in	10.4 kg
	805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-31	H=125 (4.92) / R=0.8 (0.031)		
	838 mm	33.00 in	21.0 kg
	415 mm	16.34 in	10.4 kg
	805 mm segmented	31.69 in segmented	20.1 kg
ASP-135-62	H=124.5 (4.90) / 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

C45: 560-710 N/mm²

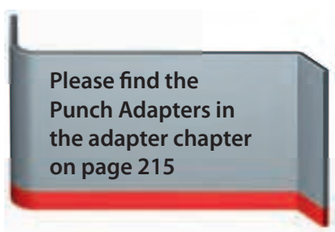
ASP-24

700 kN/m max.



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

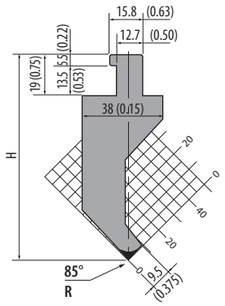
42Cr: 900-1150 N/mm²



ROLLERI® PROFESSIONAL BENDING

ASP-9

660 kN/m max.

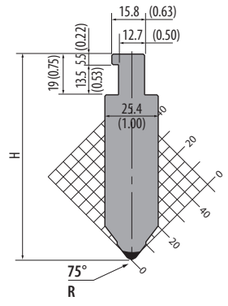


ASP-9-16	H=96 (3.78) / R=0.4 (0.016)		
	838 mm	33.00 in	12.8 kg
	415 mm	16.34 in	6.2 kg
	805 mm segmented	31.69 in segmented	12.1 kg
ASP-9-31	H=96 (3.78) / R=0.8 (0.031)		
	838 mm	33.00 in	12.8 kg
	415 mm	16.34 in	6.2 kg
	805 mm segmented	31.69 in segmented	12.1 kg
ASP-9-63	H=95.5 (3.76) / R=1.6 (0.062)		
	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

42Cr: 900-1150 N/mm²

ASP-15

1000 kN/m max.

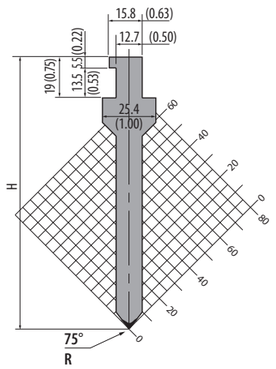


ASP-15-16	H=95.9 (3.78) / R=0.4 (0.016)		
	838 mm	33.00 in	13.4 kg
	415 mm	16.34 in	6.6 kg
	805 mm segmented	31.69 in segmented	12.9 kg
ASP-15-31	H=95.9 (3.78) / R=0.8 (0.031)		
	838 mm	33.00 in	13.4 kg
	415 mm	16.34 in	6.6 kg
	805 mm segmented	31.69 in segmented	12.9 kg
ASP-15-63	H=95.9 (3.78) / R=1.6 (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

42Cr: 900-1150 N/mm²

ASP-14

1000 kN/m max.

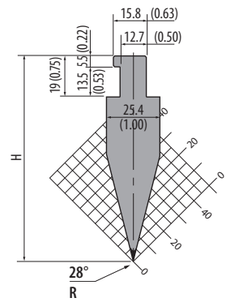


ASP-14-16	H=127 (5.00) / R=0.4 (0.016)		
	838 mm	33.00 in	13.4 kg
	415 mm	16.34 in	6.6 kg
	805 mm segmented	31.69 in segmented	12.9 kg
ASP-14-31	H=127 (5.00) / R=0.8 (0.031)		
	838 mm	33.00 in	13.4 kg
	415 mm	16.34 in	6.6 kg
	805 mm segmented	31.69 in segmented	12.9 kg
ASP-14-62	H=126.5 (4.98) / R=1.6 (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

42Cr: 900-1150 N/mm²

ASP-18

1000 kN/m max.

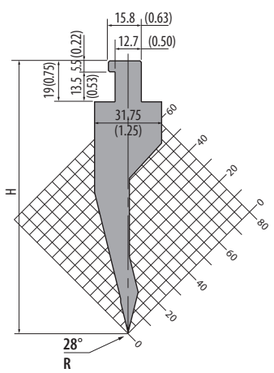


ASP-18-31	H=96 (3.78) / R=0.8 (0.031)		
	838 mm	33.00 in	10.9 kg
	415 mm	16.34 in	5.4 kg
	805 mm segmented	31.69 in segmented	10.5 kg
ASP-18-62	H=93.4 (3.68) / R=1.6 (0.062)		
	838 mm	33.00 in	10.9 kg
	415 mm	16.34 in	5.4 kg
	805 mm segmented	31.69 in segmented	10.5 kg
ASP-18-125	H=87.5 (3.44) / R=3.2 (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

42Cr: 900-1150 N/mm²

ASP-19

860 kN/m max.



ASP-19-31	H=127 (5.00) / R=0.8 (0.031)		
	838 mm	33.00 in	13.8 kg
	415 mm	16.34 in	6.8 kg
	805 mm segmented	31.69 in segmented	13.3 kg
ASP-19-62	H=124.5 (4.90) / R=1.6 (0.062)		
	838 mm	33.00 in	13.8 kg
	415 mm	16.34 in	6.8 kg
	805 mm segmented	31.69 in segmented	13.3 kg
ASP-19-125	H=118.5 (4.67) / R=3.2 (0.125)		
	838 mm	33.00 in	13.8 kg
	415 mm	16.34 in	6.8 kg
	805 mm segmented	31.69 in segmented	13.3 kg

42Cr: 900-1150 N/mm²

Article on stock

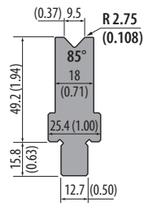
Please ask for delivery time!

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

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

ASD-85-375

1000 kN/m max.

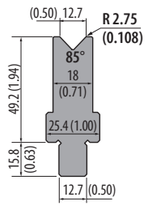


838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm²

ASD-85-500

1000 kN/m max.

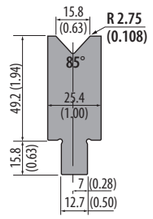


838 mm	33.00 in	8.0 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.6 kg

42Cr: 900-1150 N/mm²

ASD-85-625

1000 kN/m max.

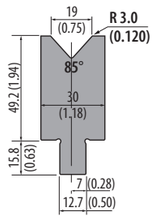


838 mm	33.00 in	9.2 kg
415 mm	16.34 in	4.6 kg
805 mm segmented	31.69 in segmented	8.9 kg

42Cr: 900-1150 N/mm²

ASD-85-750

1080 kN/m max.

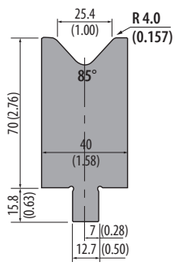


838 mm	33.00 in	10.5 kg
415 mm	16.34 in	5.2 kg
805 mm segmented	31.69 in segmented	10.1 kg

42Cr: 900-1150 N/mm²

ASD-85-100

950 kN/m max.

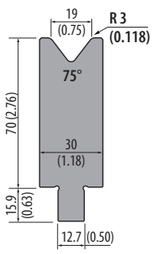


838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	19.9 kg

42Cr: 900-1150 N/mm²

ASD-75-750

1000 kN/m max.

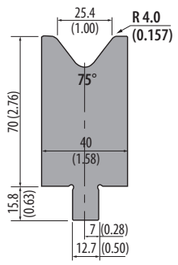


838 mm	33.00 in	14.7 kg
415 mm	16.34 in	7.3 kg
805 mm segmented	31.69 in segmented	14.1 kg

C45: 560-710 N/mm²

ASD-75-100

950 kN/m max.

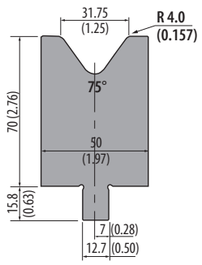


838 mm	33.00 in	17.6 kg
415 mm	16.34 in	8.7 kg
805 mm segmented	31.69 in segmented	16.9 kg

C45: 560-710 N/mm²

ASD-75-125

1000 kN/m max.

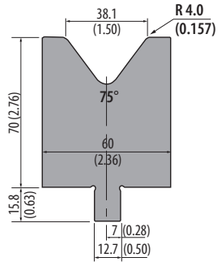


838 mm	33.00 in	22.2 kg
415 mm	16.34 in	11.0 kg
805 mm segmented	31.69 in segmented	21.3 kg

C45: 560-710 N/mm²

ASD-75-150

1000 kN/m max.

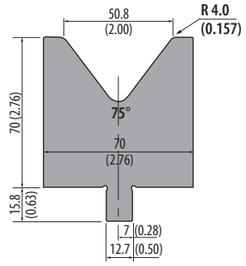


838 mm	33.00 in	25.6 kg
415 mm	16.34 in	12.7 kg
805 mm segmented	31.69 in segmented	24.6 kg

C45: 560-710 N/mm²

ASD-75-200

1000 kN/m max.

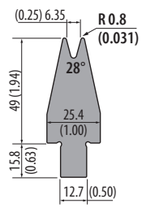


838 mm	33.00 in	27.7 kg
415 mm	16.34 in	13.7 kg
805 mm segmented	31.69 in segmented	25.6 kg

C45: 560-710 N/mm²

ASD-28-250

450 kN/m max.

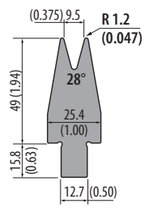


838 mm	33.00 in	7.2 kg
415 mm	16.34 in	3.6 kg
805 mm segmented	31.69 in segmented	6.9 kg

42Cr: 900-1150 N/mm²

ASD-28-375

600 kN/m max.

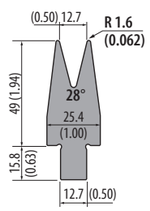


838 mm	33.00 in	7.8 kg
415 mm	16.34 in	3.9 kg
805 mm segmented	31.69 in segmented	7.5 kg

42Cr: 900-1150 N/mm²

ASD-28-500

860 kN/m max.



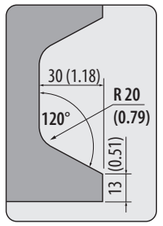
838 mm	33.00 in	8.4 kg
415 mm	16.34 in	4.2 kg
805 mm segmented	31.69 in segmented	8.1 kg

42Cr: 900-1150 N/mm²

Tool lengths, sectionings and horn types

Punches:

- **525 mm (20.67 in)**
- **495 mm (19.49 in) segmented**
  8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- **500 mm (19.68 in) segmented**
  3 segments (100 Horn left, 300, 100 Horn right)



Standard-Horn Type
for all segmented
Punches Rolleri
Type RX Gasparini

Radius Tools Holder:

- **522 mm (20.55 in)**
- **563 mm (22.17 in) segmented**
  9 segments (42, 47, 52, 57, 62, 67, 72, 77, 87)
- **491 mm (19.33 in) segmented**
  3 segments (97, 297, 97)

Radius Tools:

- **525 mm (20.67 in)**
- **590 mm (23.23 in) segmented**
  9 segments (45, 50, 55, 60, 65, 70, 75, 80, 90)
- **500 mm (19.68 in) segmented**
  3 segments (100, 300, 100)

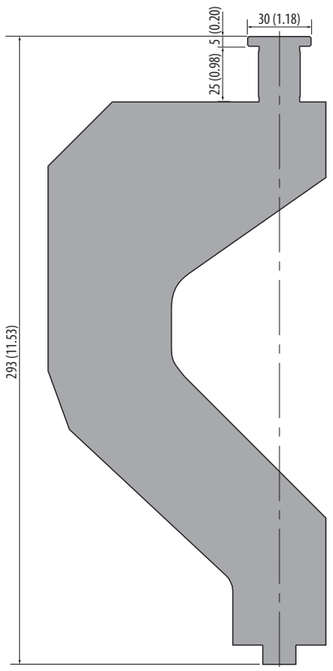
Radius Tools Gasparini

GASP293-16

1000 kN/m max.

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

C45: 560-710 N/mm²

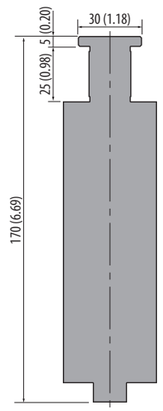


GASP170-16

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

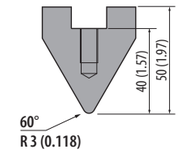
C45: 560-710 N/mm²



ROLLERI® PROFESSIONAL BENDING

GASP40.60.03

1000 kN/m max.

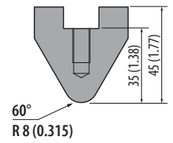


525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²

GASP35.60.08

1000 kN/m max.

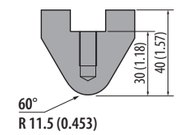


525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²

GASP30.60.11.5

1000 kN/m max.

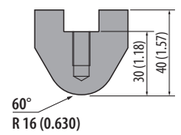


525 mm	20.67 in	4.2 kg
590 mm segmented	23.23 in segmented	4.7 kg
500 mm segmented	19.68 in segmented	4.0 kg

C45: 560-710 N/mm²

GASP30.60.16

1000 kN/m max.

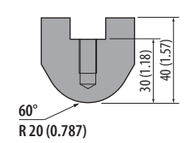


525 mm	20.67 in	4.7 kg
590 mm segmented	23.23 in segmented	5.3 kg
500 mm segmented	19.68 in segmented	4.5 kg

C45: 560-710 N/mm²

GASP30.60.20

1000 kN/m max.

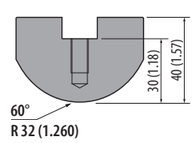


525 mm	20.67 in	5.0 kg
590 mm segmented	23.23 in segmented	5.6 kg
500 mm segmented	19.68 in segmented	4.3 kg

C45: 560-710 N/mm²

GASP30.60.32

1000 kN/m max.

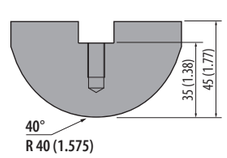


525 mm	20.67 in	7.0 kg
590 mm segmented	23.23 in segmented	7.8 kg
500 mm segmented	19.68 in segmented	6.7 kg

C45: 560-710 N/mm²

GASP35.40.40

1500 kN/m max.

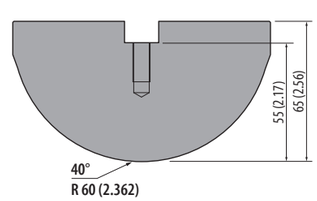


525 mm	20.67 in	10.5 kg
590 mm segmented	23.23 in segmented	11.8 kg
500 mm segmented	19.68 in segmented	10.0 kg

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

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

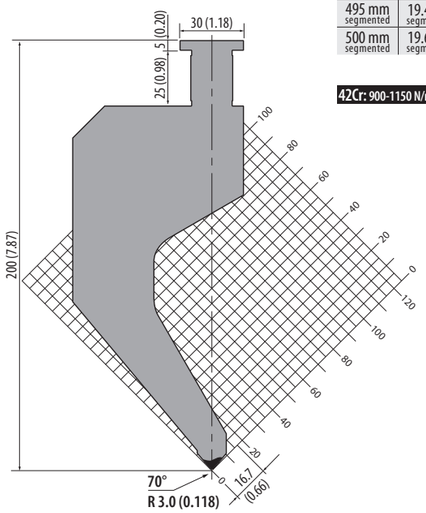
Punches Gasparini

GASP200.70.R3-30

1000 kN/m max.

525 mm	20.67 in	31.8 kg
495 mm segmented	19.49 in segmented	30.0 kg
500 mm segmented	19.68 in segmented	30.3 kg

42Cr: 900-1150 N/mm²



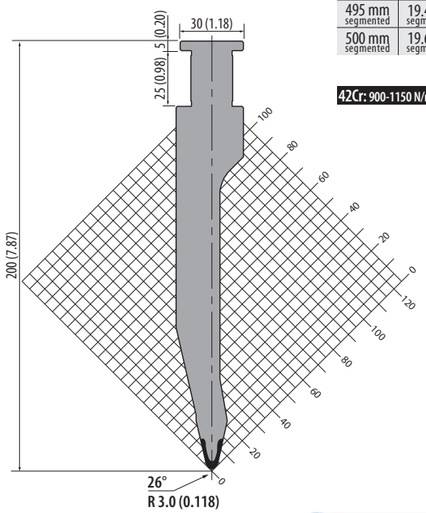
Many more tools available for Heavy Duty on pages 234-235

GASP200.26.R3-30

1300 kN/m max.

525 mm	20.67 in	16.9 kg
495 mm segmented	19.49 in segmented	10.6 kg
500 mm segmented	19.68 in segmented	10.7 kg

42Cr: 900-1150 N/mm²

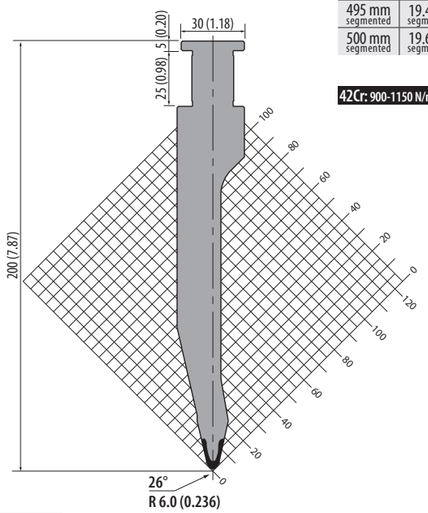


GASP200.26.R6-30

1300 kN/m max.

525 mm	20.67 in	16.9 kg
495 mm segmented	19.49 in segmented	10.6 kg
500 mm segmented	19.68 in segmented	10.7 kg

42Cr: 900-1150 N/mm²



Many more tools available upon request.

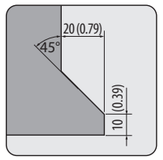
Compatible adapters see pages 213 and 217

Ajial-Axial

Tool lengths, sectionings and horn types

Punches:

- **1020 mm (40.16 in)**
- **990 mm (38.98 in) segmented**
  9 segments (100 Horn left, 500, 100, 50, 45, 40, 35, 20, 100 Horn right)



Standard-Horn Type
for all segmented
Punches Rolleri
Type RX Ajial-Axial

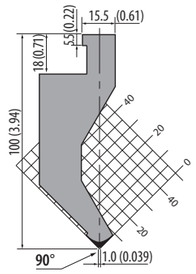
Punches Ajial-Axial

AXP.100.90.1

1000 kN/m max.

1020 mm	40.16 in	16.3 kg
990 mm segmented	38.98 in segmented	15.8 kg

C45: 560-710 N/mm²

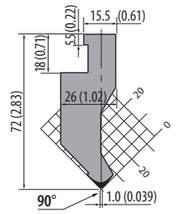


AXP.72.90.1

1000 kN/m max.

1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm²

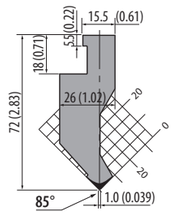


AXP.72.85.1

1000 kN/m max.

1020 mm	40.16 in	10.0 kg
990 mm segmented	38.98 in segmented	9.7 kg

C45: 560-710 N/mm²

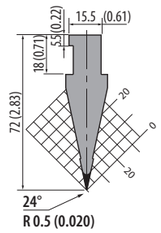


AXP.72.24.R05

1000 kN/m max.

1020 mm	40.16 in	7.1 kg
990 mm segmented	38.98 in segmented	6.9 kg

C45: 560-710 N/mm²



Adapters Ajial-Axial

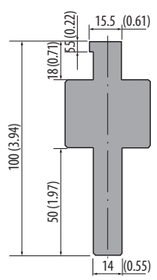
AD15

1000 kN/m max.

150 mm	5.91 in	4.0 kg

Rolleri Type RX Ajial-Axial
→ Rolleri Type R1

C45: 560-710 N/mm²



More Punches and Dies available upon request.

Compatible Adapter see pages 217

Article on stock

Please ask for delivery time!

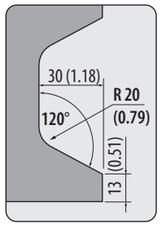
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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-Horn Type
for all segmented
Punches Rolleri
Type RX Colgar

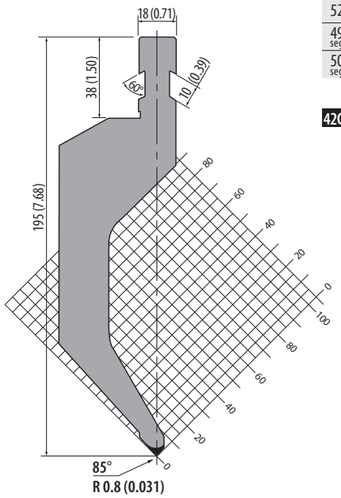
Punches and Radius Tools Colgar

PAC195.85.R08

1000 kN/m max.

525 mm	20.67 in	20.6 kg
495 mm segmented	19.49 in segmented	19.4 kg
500 mm segmented	19.68 in segmented	19.6 kg

42Cr: 900-1150 N/mm²

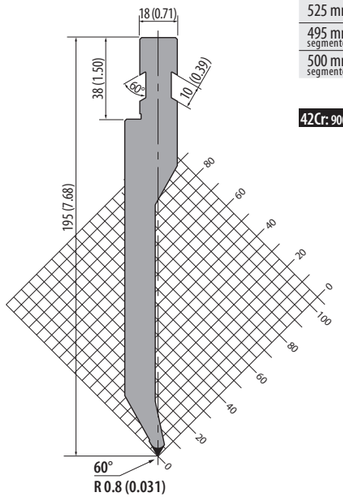


PAC195.60.R08

1000 kN/m max.

525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm²

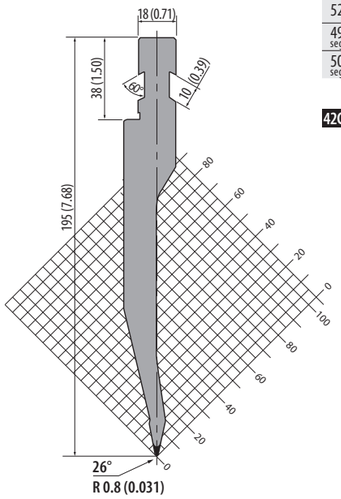


PAC195.26.R08

1000 kN/m max.

525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.3 kg
500 mm segmented	19.68 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



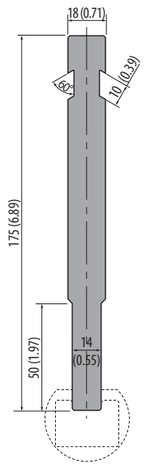
More Punches and Dies available upon request.
Compatible adapter see pages 213, 216

PAC175.14

1000 kN/m max.

830 mm	32.68 in	18.0 kg
412 mm	16.22 in	9.0 kg

C45: 560-710 N/mm²



Compatible Radius holders see page 33

ROLLERI® PROFESSIONAL BENDING

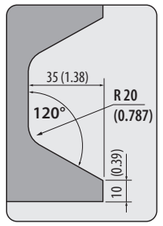
Tool lengths, sectionings and horn types

Punches:

- **508 mm (20.00 in)**
- **550 mm (21.65 in) segmented**
  9 segments
  (100 Horn left, 25, 30, 35, 40, 45, 50, 125, 100 Horn right)

Dies:

- **508 mm (20.00 in)**
- **550 mm (21.65 in) segmented**
  9 segments (25, 25, 30, 35, 40, 45, 50, 100, 200)



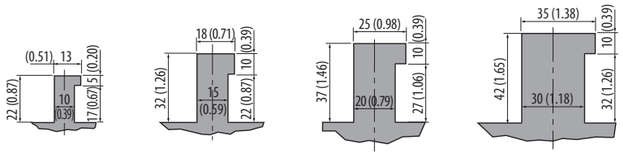
Standard-Horn Type
for all segmented
Punches Rolleri
Type RX LVD

Hemming Tools:

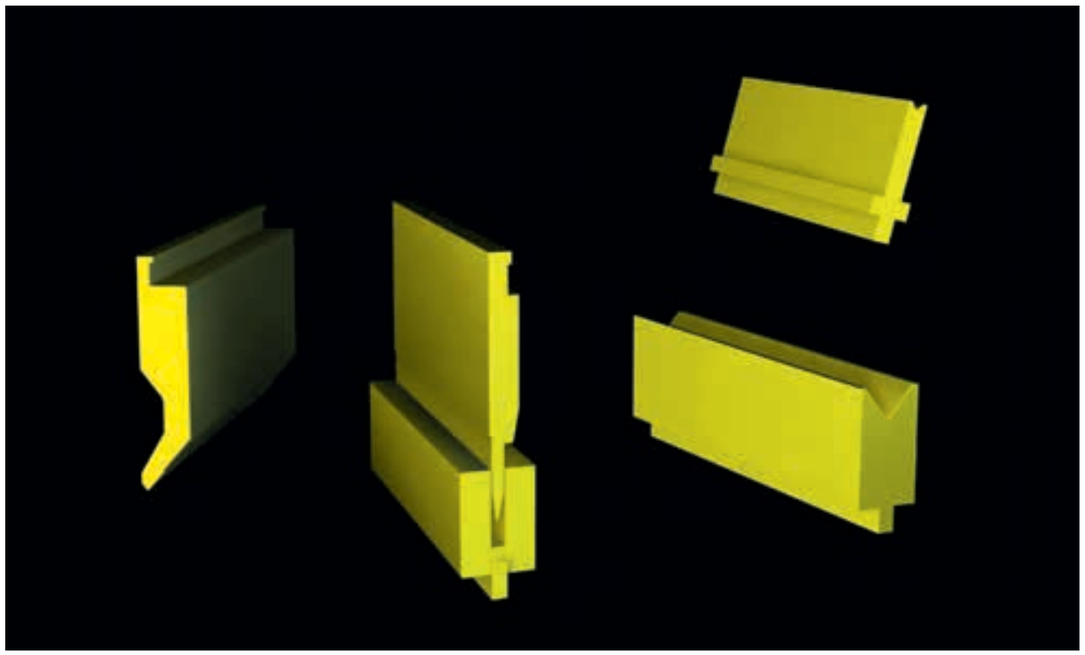
- **525 mm (20.67 in)**
- **495 mm (19.49 in) segmented**
  8 segments (25, 30, 35, 40, 45, 50, 100, 170)

Punch Tangs

Punches LVD have the following
4 different tangs

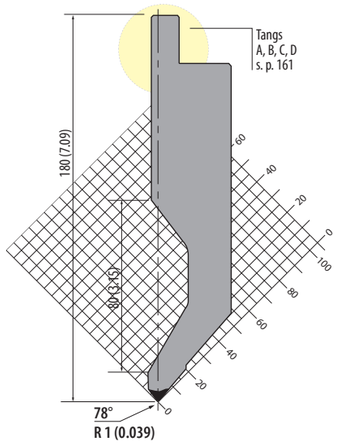


Tang A Tang B Tang C Tang D



LP180.78.R1-A

700 kN/m max.



Tang A: LPA180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg

Tang B: LPB180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg

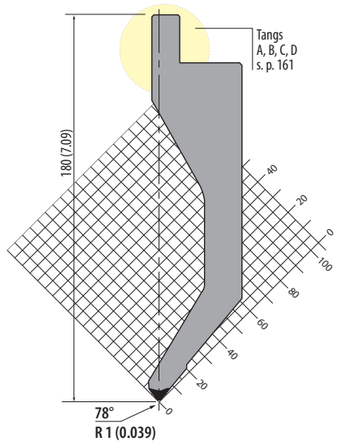
Tang C: LPC180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg

Tang D: LPD180.78.R1-A		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	23.8 kg

42Cr: 900-1150 N/mm²

LP180.78.R1-B

450 kN/m max.



Tang A: LPA180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg

Tang B: LPB180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg

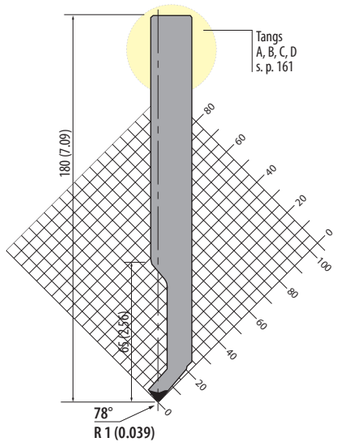
Tang C: LPC180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg

Tang D: LPD180.78.R1-B		
508 mm	20.00 in	22.0 kg
550 mm segmented	21.65 in segmented	24.0 kg

42Cr: 900-1150 N/mm²

LP180.78.R1-C

500 kN/m max.



Tang A: LPA180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg

Tang B: LPB180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg

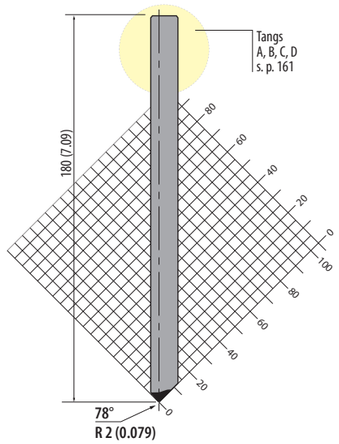
Tang C: LPC180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg

Tang D: LPD180.78.R1-C		
508 mm	20.00 in	11.0 kg
550 mm segmented	21.65 in segmented	12.0 kg

42Cr: 900-1150 N/mm²

LP180.78-R2

1000 kN/m max.



Tang A: LPA180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg

Tang B: LPB180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg

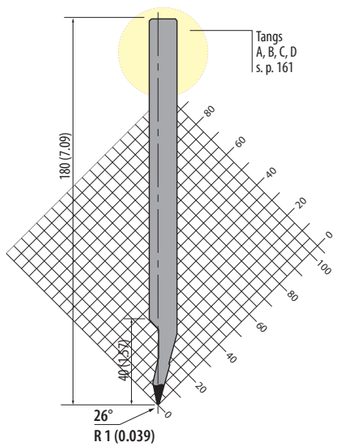
Tang C: LPC180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg

Tang D: LPD180.78-R2		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	9.7 kg

42Cr: 900-1150 N/mm²

LP180.26-R1

500 kN/m max.



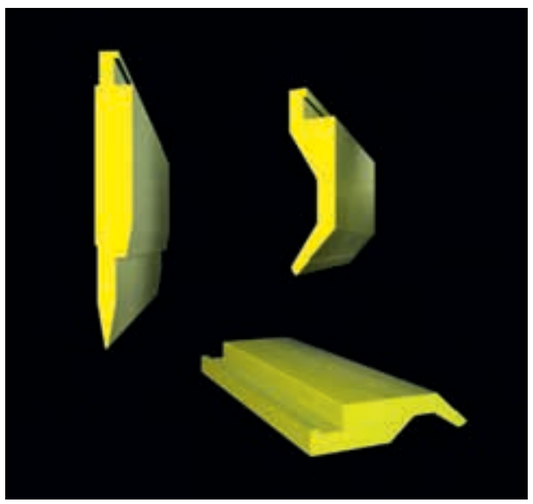
Tang A: LPA180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg

Tang B: LPB180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg

Tang C: LPC180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg

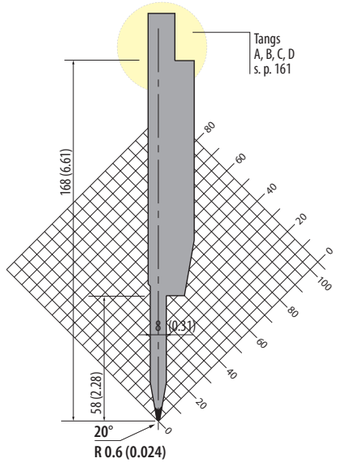
Tang D: LPD180.26-R1		
508 mm	20.00 in	9.0 kg
550 mm segmented	21.65 in segmented	10.0 kg

42Cr: 900-1150 N/mm²



ROLLERI® PROFESSIONAL BENDING

LP.SP-190.20.8



Tang A: LPA.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg

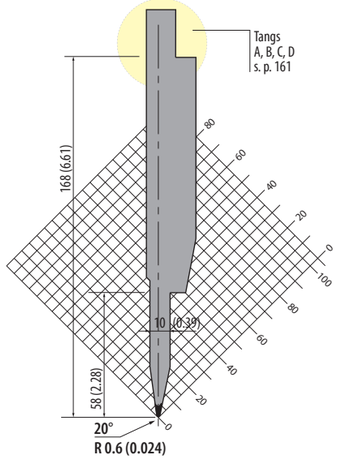
Tang B: LPB.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg

Tang C: LPC.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg

Tang D: LPD.SP-190.20.8		
525 mm	20.67 in	13.4 kg
495 mm segmented	19.49 in segmented	12.6 kg

42Cr: 900-1150 N/mm²

LP.SP-190.20.10



Tang A: LPA.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg

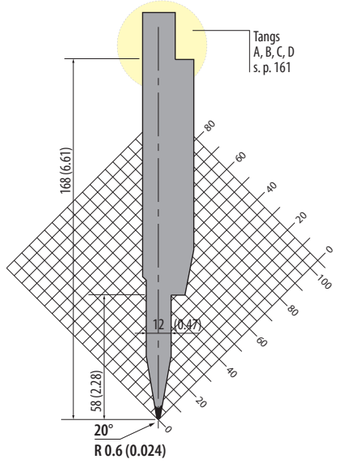
Tang B: LPB.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg

Tang C: LPC.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg

Tang D: LPD.SP-190.20.10		
525 mm	20.67 in	13.1 kg
495 mm segmented	19.49 in segmented	12.3 kg

42Cr: 900-1150 N/mm²

LP.SP-190.20.12



Tang A: LPA.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg

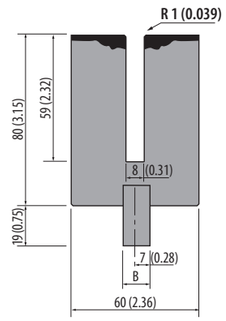
Tang B: LPB.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg

Tang C: LPC.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg

Tang D: LPD.SP-190.20.12		
525 mm	20.67 in	13.6 kg
495 mm segmented	19.49 in segmented	12.8 kg

42Cr: 900-1150 N/mm²

LP.SM-190.20.8-12.7 / -12

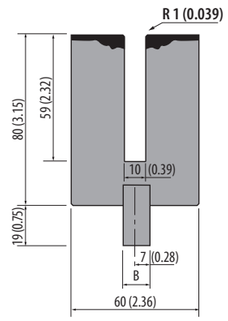


B=12.7 mm (0.50 in)		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg

B=12 mm (0.47 in)		
525 mm	20.67 in	18.7 kg
495 mm segmented	19.49 in segmented	17.7 kg

42Cr: 900-1150 N/mm²

LP.SM-190.20.10-12.7 / -12

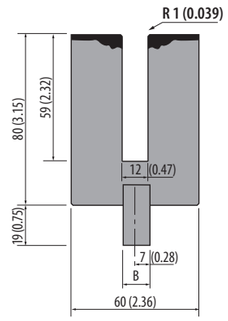


B=12.7 mm (0.50 in)		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg

B=12 mm (0.47 in)		
525 mm	20.67 in	18.3 kg
495 mm segmented	19.49 in segmented	17.2 kg

42Cr: 900-1150 N/mm²

LP.SM-190.20.12-12.7 / -12

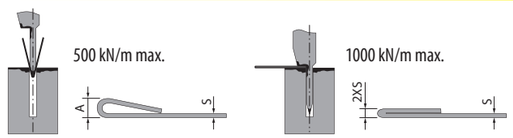


B=12.7 mm (0.50 in)		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg

B=12 mm (0.47 in)		
525 mm	20.67 in	17.8 kg
495 mm segmented	19.49 in segmented	16.7 kg

42Cr: 900-1150 N/mm²

Example of Application



S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	3.0	0.12	9	15
0.8	0.03	3.0	0.12	12	20
1.0	0.04	3.5	0.14	15	25
1.25	0.05	3.5	0.14	17	26

S mm	S in	A mm	A in	R.45 Kgf/mm² t/m	R.70 Kgf/mm² t/m
0.6	0.02	1.2	0.05	23	35
0.8	0.03	1.6	0.06	32	50
1.0	0.04	1.0	0.04	40	60
1.25	0.05	2.5	0.10	50	80

on stock Article on stock

Please ask for delivery time!

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

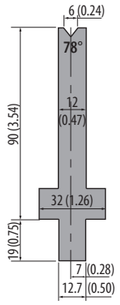
Articles on stock – Please note that delivery time depends on your location.

LM90.06.78

400 kN/m max.

508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

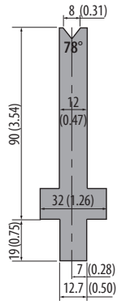


LM90.08.78

400 kN/m max.

508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

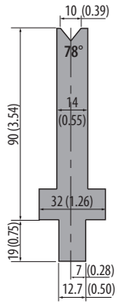


LM90.10.78

500 kN/m max.

508 mm	20.00 in	7.0 kg
550 mm segmented	21.65 in segmented	7.5 kg

42Cr: 900-1150 N/mm²

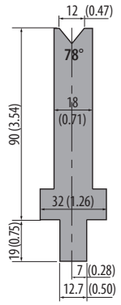


LM90.12.78

600 kN/m max.

508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.7 kg

42Cr: 900-1150 N/mm²

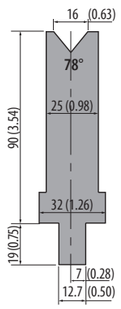


LM90.16.78

800 kN/m max.

508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg

42Cr: 900-1150 N/mm²

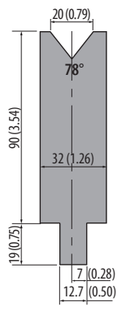


LM90.20.78

1000 kN/m max.

508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.8 kg

42Cr: 900-1150 N/mm²

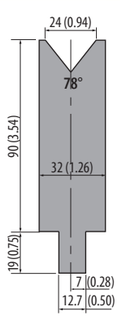


LM90.24.78

1000 kN/m max.

508 mm	20.00 in	10.0 kg
550 mm segmented	21.65 in segmented	10.8 kg

42Cr: 900-1150 N/mm²

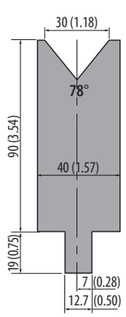


LM90.30.78

1100 kN/m max.

508 mm	20.00 in	12.0 kg
550 mm segmented	21.65 in segmented	13.0 kg

42Cr: 900-1150 N/mm²



RX ROLLERI TYPE RX
Dies 78° LVD

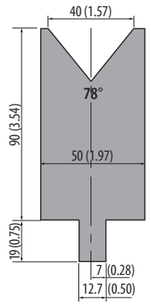
ROLLERI® PROFESSIONAL BENDING

LM90.40.78

1300 kN/m max.

508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg

42Cr: 900-1150 N/mm²

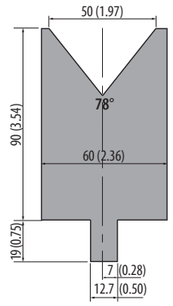


LM90.50.78

1500 kN/m max.

508 mm	20.00 in	19.5 kg
550 mm segmented	21.65 in segmented	21.0 kg

42Cr: 900-1150 N/mm²

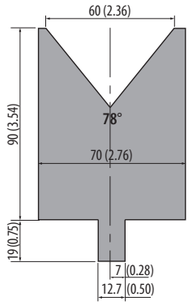


LM90.60.78

1500 kN/m max.

508 mm	20.00 in	23.0 kg
550 mm segmented	21.65 in segmented	24.9 kg

42Cr: 900-1150 N/mm²

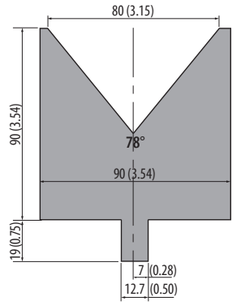


LM90.80.78

1500 kN/m max.

508 mm	20.00 in	25.5 kg
550 mm segmented	21.65 in segmented	27.6 kg

42Cr: 900-1150 N/mm²



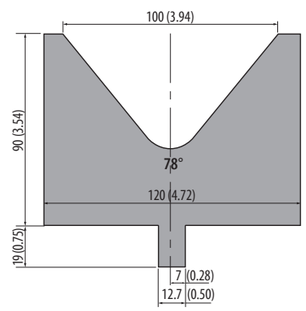
LM90.100.78

1200 kN/m max.

508 mm	20.00 in	31.0 kg
550 mm segmented	21.65 in segmented	33.5 kg

42Cr: 900-1150 N/mm²

NEW



7 RX

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

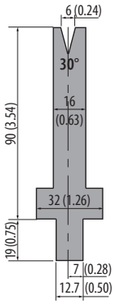
Dies 30° LVD

LM90.06.30

200 kN/m max.

508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

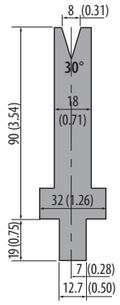


LM90.08.30

220 kN/m max.

508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

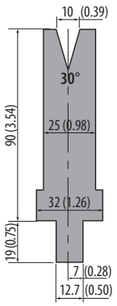


LM90.10.30

300 kN/m max.

508 mm	20.00 in	8.0 kg
550 mm segmented	21.65 in segmented	8.6 kg

42Cr: 900-1150 N/mm²

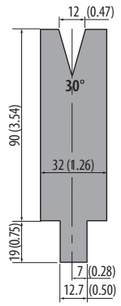


LM90.12.30

380 kN/m max.

508 mm	20.00 in	11.9 kg
550 mm segmented	21.65 in segmented	12.6 kg

42Cr: 900-1150 N/mm²

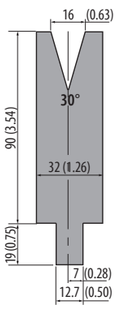


LM90.16.30

380 kN/m max.

508 mm	20.00 in	11.5 kg
550 mm segmented	21.65 in segmented	12.4 kg

42Cr: 900-1150 N/mm²

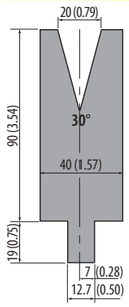


LM90.20.30

380 kN/m max.

508 mm	20.00 in	13.8 kg
550 mm segmented	21.65 in segmented	15.0 kg

42Cr: 900-1150 N/mm²

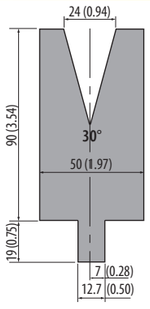


LM90.24.30

550 kN/m max.

508 mm	20.00 in	13.0 kg
550 mm segmented	21.65 in segmented	14.0 kg

42Cr: 900-1150 N/mm²



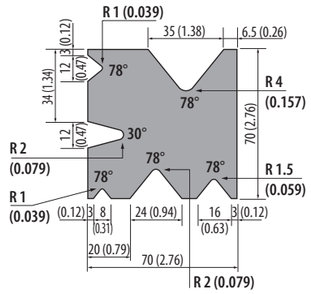
Multi-V Dies LVD

ROLLERI® PROFESSIONAL BENDING

LM70

508 mm	20.00 in	16.8 kg
550 mm segmented	21.65 in segmented	18.2 kg

42Cr: 900-1150 N/mm²

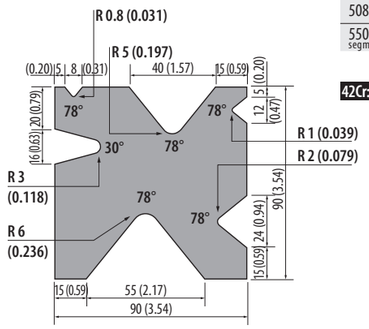


	V1	V2	V3	V4	V5	V6
V mm (in)	12 (0.47)	12 (0.47)	35 (1.38)	24 (0.94)	16 (0.63)	8 (0.31)
Angle	30°	78°	78°	78°	78°	78°
kN/m max.	1300	600	1300	1200	950	500

LM90

508 mm	20.00 in	25.4 kg
550 mm segmented	21.65 in segmented	27.5 kg

42Cr: 900-1150 N/mm²

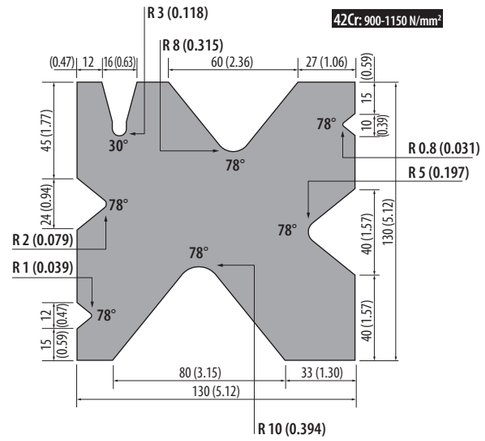


	V1	V2	V3	V4	V5	V6
V mm (in)	8 (0.31)	40 (1.57)	12 (0.47)	24 (0.94)	55 (2.17)	16 (0.63)
Angle	78°	78°	78°	78°	78°	30°
kN/m max.	550	1400	550	650	1000	1000

LM130

508 mm	20.00 in	51.8 kg
550 mm segmented	21.65 in segmented	56.1 kg

42Cr: 900-1150 N/mm²

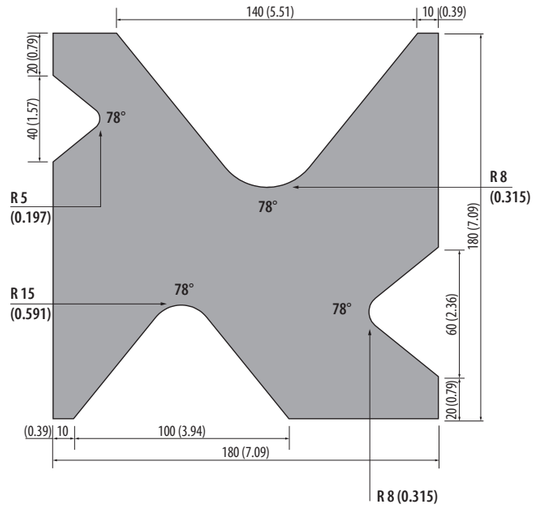


	V1	V2	V3	V4	V5	V6	V7
V mm (in)	16 (0.63)	60 (2.36)	10 (0.39)	80 (3.15)	40 (1.57)	12 (0.47)	24 (0.94)
Angle	30°	78°	78°	78°	78°	78°	78°
kN/m max.	650	1500	650	1250	1500	480	1500

LM180

508 mm	20.00 in	87.9 kg
550 mm segmented	21.65 in segmented	95.2 kg

42Cr: 900-1150 N/mm²



	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

Article on stock

Please ask for delivery time!

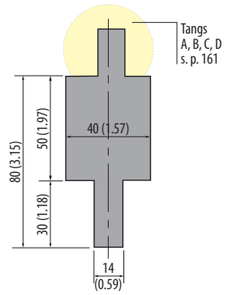
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

Adapters LVD

AD1

1000 kN/m max.



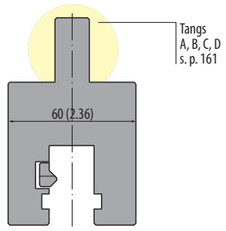
Tang A: **AD1-A**		
150 mm	5.91 in	3.1 kg
Tang B: **AD1-B**		
150 mm	5.91 in	3.1 kg
Tang C: **AD1-C**		
150 mm	5.91 in	3.1 kg
Tang D: **AD1-D**		
150 mm	5.91 in	3.1 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²

AD20 LVD

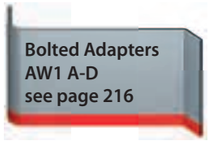
1000 kN/m max.



Tang A: **AD20 LVD-A**		
150 mm	5.91 in	3.6 kg
Tang B: **AD20 LVD-B**		
150 mm	5.91 in	3.8 kg
Tang C: **AD20 LVD-C**		
150 mm	5.91 in	4.0 kg
Tang D: **AD20 LVD-D**		
150 mm	5.91 in	4.0 kg

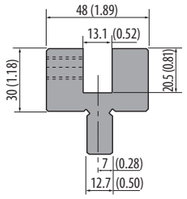
Rolleri Type RX LVD
→ Rolleri Type R2

C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.



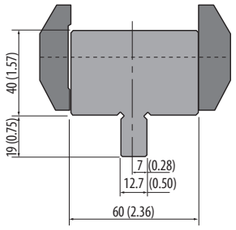
1000 mm	39.37 in	15.0 kg
500 mm	19.68 in	7.5 kg

Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

AD9-12.7

1000 kN/m max.



835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.5 kg

Rolleri Type RX LVD
→ Rolleri Type R1

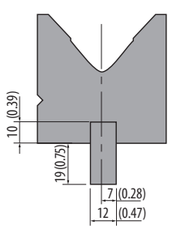
C45: 560-710 N/mm²

Modification: Wedge Bar / Tail

To use Dies Rolleri Type R1, a 10 mm (0.39 in) groove is milled and polished in order to fit a wedge bar / tail of the required measurment.

A31

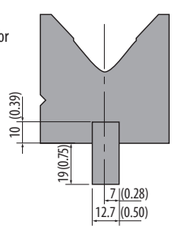
Wedge Bar / Tail:
12 x 29 mm (0.47 x 1.14) for
- Rolleri Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A32

Wedge Bar / Tail:
12.7 x 29 mm (0.50 x 1.14) for
- Rolleri Type RX LVD



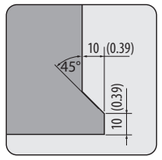
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

Colly

Tool lengths, sectionings and horn types

Punches:
- **1020 mm (40.16 in)**
- **1250 mm (49.21 in) segmented**
  15 segments (100 Horn left, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 100, 100 Horn right)

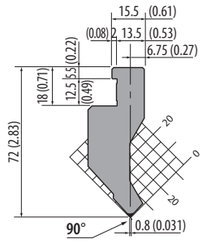
Dies:
- **1020 mm (40.16 in)**
- **1250 mm (49.21 in) segmented**
  14 segments (100, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 200)



Standard-Horn Type
for all segmented
Punches Rolleri
Type RX Colly

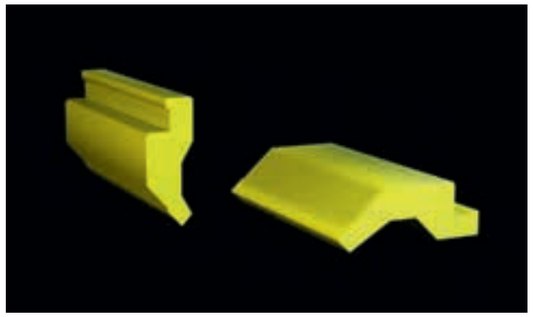
Punches Colly

CP72.90.08

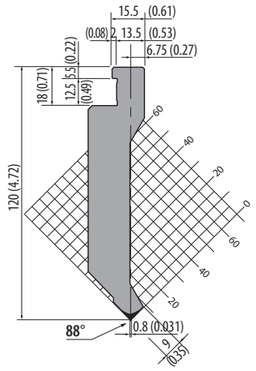


1020 mm	40.16 in	10.2 kg
1250 mm segmented	49.21 in segmented	12.5 kg

C45: 560-710 N/mm²



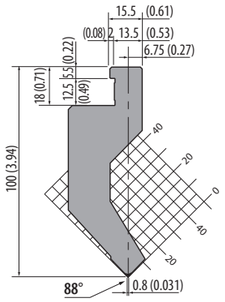
CP120.88.08



1020 mm	40.16 in	18.5 kg
1250 mm segmented	49.21 in segmented	22.6 kg

C45: 560-710 N/mm²

CP100.88.08-A



1020 mm	40.16 in	16.7 kg
1250 mm segmented	49.21 in segmented	20.4 kg

C45: 560-710 N/mm²

Article on stock

Please ask for delivery time!

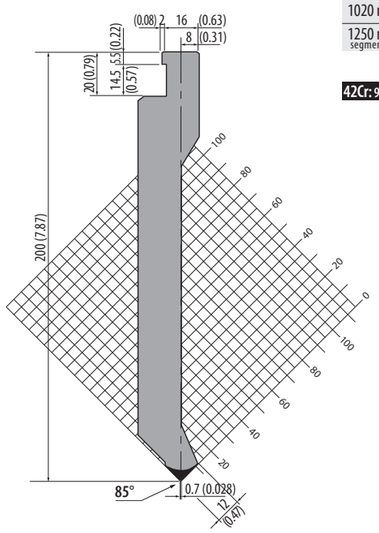
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

CP200.85.07

1020 mm	40.16 in	31.6 kg
1250 mm segmented	49.21 in segmented	49.0 kg

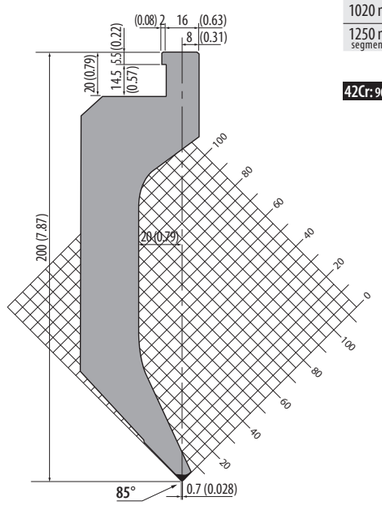
42Cr: 900-1150 N/mm²



CP200.85.07-A

1020 mm	40.16 in	49.0 kg
1250 mm segmented	49.21 in segmented	60.0 kg

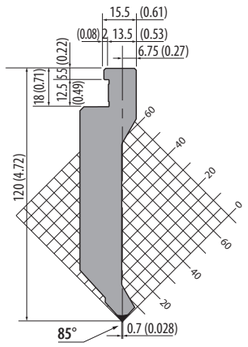
42Cr: 900-1150 N/mm²



CP120.85.07

1020 mm	40.16 in	17.9 kg
1250 mm segmented	49.21 in segmented	21.9 kg

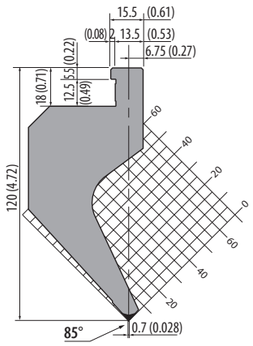
C45: 560-710 N/mm²



CP120.85.07-A

1020 mm	40.16 in	25.5 kg
1250 mm segmented	49.21 in segmented	31.3 kg

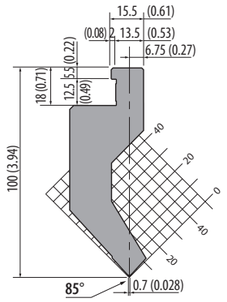
C45: 560-710 N/mm²



CP100.85.07-A

1020 mm	40.16 in	16.7 kg
1250 mm segmented	49.21 in segmented	20.4 kg

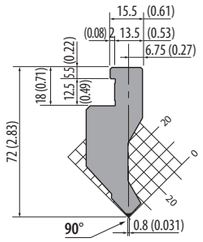
C45: 560-710 N/mm²



CP72.85.07

1020 mm	40.16 in	10.0 kg
1250 mm segmented	49.21 in segmented	12.3 kg

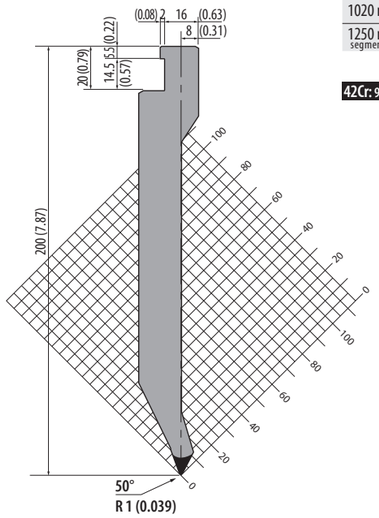
C45: 560-710 N/mm²



CP200.50.R1

1020 mm	40.16 in	31.0 kg
1250 mm segmented	49.21 in segmented	38.0 kg

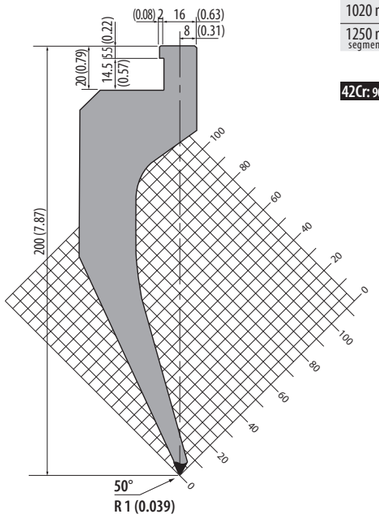
42Cr: 900-1150 N/mm²



CP200.50.R1-A

1020 mm	40.16 in	52.0 kg
1250 mm segmented	49.21 in segmented	63.7 kg

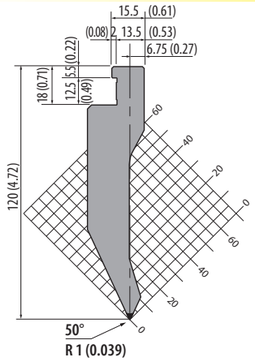
42Cr: 900-1150 N/mm²



CP120.50.R1

1020 mm	40.16 in	17.0 kg
1250 mm segmented	49.21 in segmented	20.8 kg

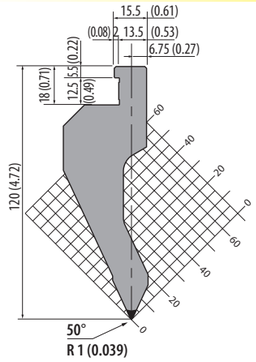
C45: 560-710 N/mm²



CP120.50.R1-A

1020 mm	40.16 in	31.0 kg
1250 mm segmented	49.21 in segmented	38.0 kg

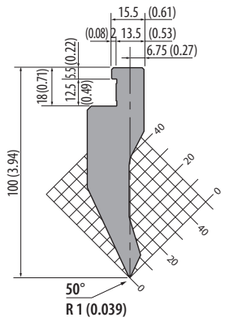
42Cr: 900-1150 N/mm²



CP100.50.R1

1020 mm	40.16 in	13.0 kg
1250 mm segmented	49.21 in segmented	16.0 kg

42Cr: 900-1150 N/mm²

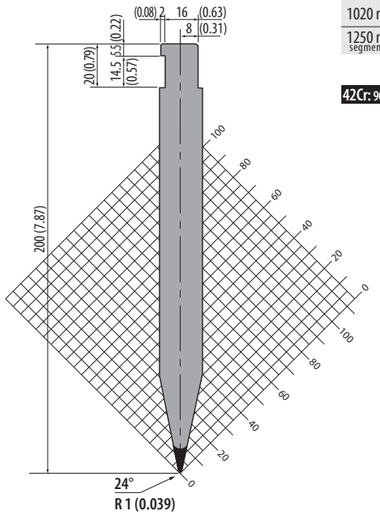


Bolted Adapters
see page 217

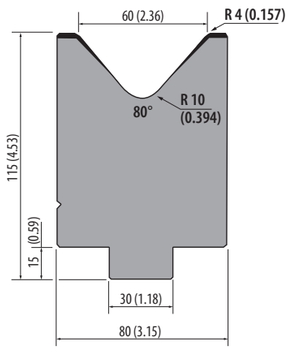
CP200.24.R1

1020 mm	40.16 in	22.0 kg
1250 mm segmented	49.21 in segmented	26.9 kg

42Cr: 900-1150 N/mm²



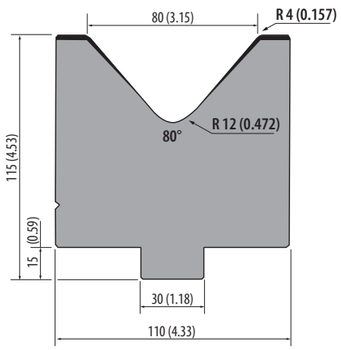
M115.80.60



1020 mm	40.16 in	60.0 kg
1250 mm segmented	49.21 in segmented	73.6 kg

C45: 560-710 N/mm²

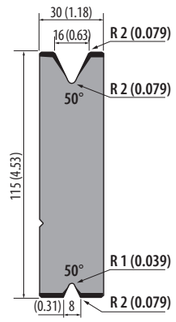
M115.80.80



1020 mm	40.16 in	80.0 kg
1250 mm segmented	49.21 in segmented	98.0 kg

C45: 560-710 N/mm²

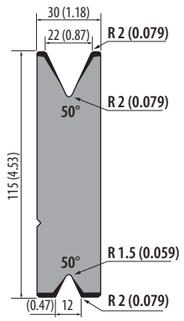
M115.50.16



1020 mm	40.16 in	26.5 kg
1250 mm segmented	49.21 in segmented	32.4 kg

C45: 560-710 N/mm²

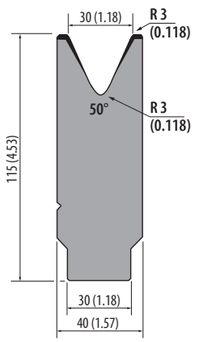
M115.50.22



1020 mm	40.16 in	25.5 kg
1250 mm segmented	49.21 in segmented	31.2 kg

C45: 560-710 N/mm²

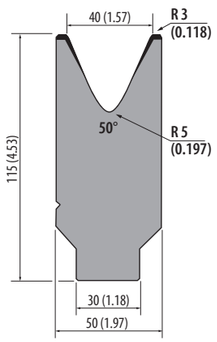
M115.50.30



1020 mm	40.16 in	34.5 kg
1250 mm segmented	49.21 in segmented	43.0 kg

C45: 560-710 N/mm²

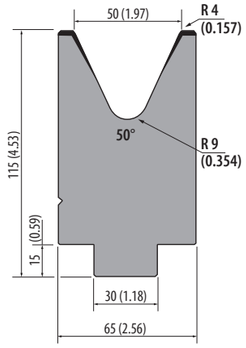
M115.50.40



1020 mm	40.16 in	36.0 kg
1250 mm segmented	49.21 in segmented	44.0 kg

C45: 560-710 N/mm²

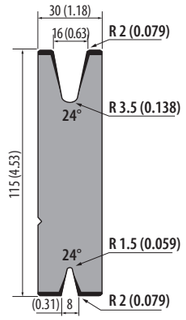
M115.50.50



1020 mm	40.16 in	45.5 kg
1250 mm segmented	49.21 in segmented	55.7 kg

C45: 560-710 N/mm²

M115.24.16



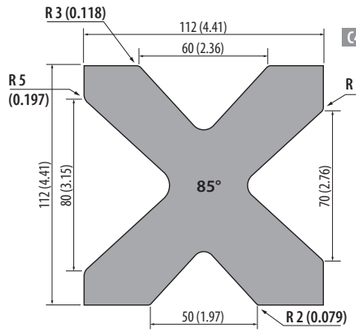
1020 mm	40.16 in	24.9 kg
1250 mm segmented	49.21 in segmented	31.0 kg

C45: 560-710 N/mm²

MC112.3050

3050 mm	120.08 in	188.0 kg

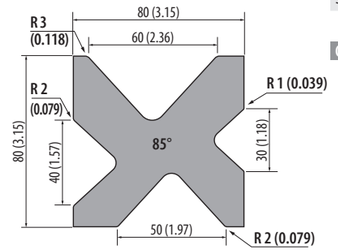
C45: 560-710 N/mm²



MC80.2050 / MC80.3050

2050 mm	80.71 in	66.0 kg
3050 mm	120.08 in	98.0 kg

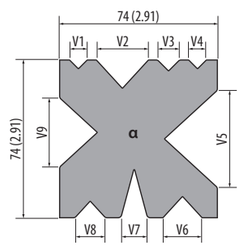
C45: 560-710 N/mm²



MC74.2050 / MC74.3050

2050 mm	80.71 in	67.0 kg
3050 mm	120.08 in	101.0 kg

C45: 560-710 N/mm²

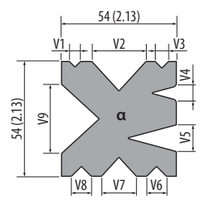


	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm (in)	8 (0.31)	24 (0.94)	10 (0.39)	8 (0.31)	45 (1.77)	18 (0.71)	12 (0.47)	14 (0.55)	32 (1.26)
Angle	90°	85°	90°	90°	85°	85°	30°	85°	85°
R mm (in)	0.8 (0.031)	0.8 (0.031)	2.0 (0.079)	0.8 (0.031)	2.0 (0.079)	1.0 (0.039)	2.0 (0.079)	2.0 (0.079)	2.0 (0.079)

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

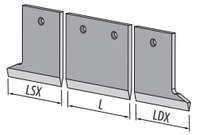


	V1	V2	V3	V4	V5	V6	V7	V8	V9
V mm (in)	6 (0.24)	25 (0.98)	6 (0.24)	6 (0.24)	12 (0.47)	9 (0.35)	16 (0.63)	9 (0.35)	32 (1.26)
Angle	90°	85°	90°	30°	30°	90°	85°	90°	85°
R mm (in)	0.5 (0.020)	1.0 (0.039)	0.5 (0.020)	2.0 (0.079)	0.5 (0.020)	1.0 (0.039)	0.5 (0.020)	1.5 (0.059)	1.0 (0.039)

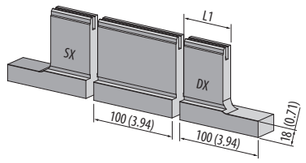
Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

Tool lengths, sectionings and horn types

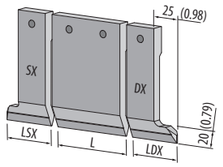
Punches H11:



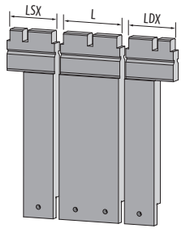
Dies H31, H41:



Punches H12:



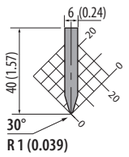
Punches H21:



Punches Hämmerle-Bystronic

H11.010.0

600 kN/m max.

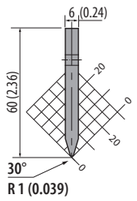


Model	Length		Weight
H11.010.01.01	100	3.94	0.17 kg
H11.010.02.01	50	1.97	0.09 kg
H11.010.02.02	55	2.17	0.09 kg
H11.010.02.03	60	2.36	0.10 kg
H11.010.02.04	65	2.56	0.11 kg
H11.010.02.05	70	2.76	0.12 kg
H11.010.02.06	75	2.95	0.13 kg
H11.010.02.07	80	3.15	0.14 kg
H11.010.02.08	85	3.35	0.14 kg
H11.010.02.09	90	3.54	0.15 kg
H11.010.02.10	95	3.74	0.16 kg
H11.010.04.01	75 DX	2.95 DX	0.12 kg
H11.010.04.02	85 DX	3.35 DX	0.14 kg
H11.010.04.03	95 DX	3.74 DX	0.15 kg
H11.010.04.04	105 DX	4.13 DX	0.17 kg
H11.010.04.05	115 DX	4.53 DX	0.19 kg
H11.010.04.06	80 SX	3.15 SX	0.13 kg
H11.010.05.01	75 SX	2.95 SX	0.12 kg
H11.010.05.02	85 SX	3.35 SX	0.14 kg
H11.010.05.03	95 SX	3.74 SX	0.15 kg
H11.010.05.04	105 SX	4.13 SX	0.17 kg
H11.010.05.05	115 SX	4.53 SX	0.19 kg
H11.010.05.06	80 DX	3.15 DX	0.13 kg

HRc 58-60

H11.007.0

1000 kN/m max.



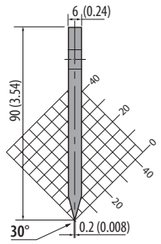
Model	Length		Weight
H11.007.01.01	100	3.94	0.26 kg
H11.007.02.01	50	1.97	0.13 kg
H11.007.02.02	55	2.17	0.14 kg
H11.007.02.03	60	2.36	0.16 kg
H11.007.02.04	65	2.56	0.17 kg
H11.007.02.05	70	2.76	0.18 kg
H11.007.02.06	75	2.95	0.20 kg
H11.007.02.07	80	3.15	0.21 kg
H11.007.02.08	85	3.35	0.22 kg
H11.007.02.09	90	3.54	0.23 kg
H11.007.02.10	95	3.74	0.25 kg
H11.007.04.01	75 DX	2.95 DX	0.18 kg
H11.007.04.02	85 DX	3.35 DX	0.21 kg
H11.007.04.03	95 DX	3.74 DX	0.23 kg
H11.007.04.04	105 DX	4.13 DX	0.25 kg
H11.007.04.05	115 DX	4.53 DX	0.29 kg
H11.007.04.06	80 SX	3.15 SX	0.20 kg
H11.007.05.01	75 SX	2.95 SX	0.18 kg
H11.007.05.02	85 SX	3.35 SX	0.21 kg
H11.007.05.03	95 SX	3.74 SX	0.23 kg
H11.007.05.04	105 SX	4.13 SX	0.25 kg
H11.007.05.05	115 SX	4.53 SX	0.29 kg
H11.007.05.06	80 DX	3.15 DX	0.20 kg

HRc 58-60

ROLLERI® PROFESSIONAL BENDING

H11.002.0

1000 kN/m max.

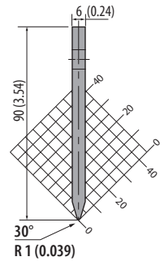


Model	Length		Weight
H11.002.01.01	100	3.94	0.40 kg
H11.002.02.01	50	1.97	0.20 kg
H11.002.02.02	55	2.17	0.22 kg
H11.002.02.03	60	2.36	0.24 kg
H11.002.02.04	65	2.56	0.26 kg
H11.002.02.05	70	2.76	0.28 kg
H11.002.02.06	75	2.95	0.30 kg
H11.002.02.07	80	3.15	0.32 kg
H11.002.02.08	85	3.35	0.34 kg
H11.002.02.09	90	3.54	0.36 kg
H11.002.02.10	95	3.74	0.38 kg
H11.002.04.01	75 DX	2.95 DX	0.28 kg
H11.002.04.02	85 DX	3.35 DX	0.32 kg
H11.002.04.03	95 DX	3.74 DX	0.36 kg
H11.002.04.04	105 DX	4.13 DX	0.38 kg
H11.002.04.05	115 DX	4.53 DX	0.44 kg
H11.002.04.06	80 SX	3.15 SX	0.30 kg
H11.002.05.01	75 SX	2.95 SX	0.28 kg
H11.002.05.02	85 SX	3.35 SX	0.32 kg
H11.002.05.03	95 SX	3.74 SX	0.36 kg
H11.002.05.04	105 SX	4.13 SX	0.38 kg
H11.002.05.05	115 SX	4.53 SX	0.44 kg
H11.002.05.06	80 DX	3.15 DX	0.30 kg

HRc 58-60

H11.001.0

1000 kN/m max.

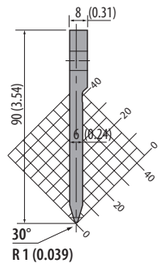


Model	Length		Weight
H11.001.01.01	100	3.94	0.40 kg
H11.001.02.01	50	1.97	0.20 kg
H11.001.02.02	55	2.17	0.22 kg
H11.001.02.03	60	2.36	0.24 kg
H11.001.02.04	65	2.56	0.26 kg
H11.001.02.05	70	2.76	0.28 kg
H11.001.02.06	75	2.95	0.30 kg
H11.001.02.07	80	3.15	0.32 kg
H11.001.02.08	85	3.35	0.34 kg
H11.001.02.09	90	3.54	0.36 kg
H11.001.02.10	95	3.74	0.38 kg
H11.001.04.01	75 DX	2.95 DX	0.28 kg
H11.001.04.02	85 DX	3.35 DX	0.32 kg
H11.001.04.03	95 DX	3.74 DX	0.36 kg
H11.001.04.04	105 DX	4.13 DX	0.38 kg
H11.001.04.05	115 DX	4.53 DX	0.44 kg
H11.001.04.06	80 SX	3.15 SX	0.30 kg
H11.001.05.01	75 SX	2.95 SX	0.28 kg
H11.001.05.02	85 SX	3.35 SX	0.32 kg
H11.001.05.03	95 SX	3.74 SX	0.36 kg
H11.001.05.04	105 SX	4.13 SX	0.38 kg
H11.001.05.05	115 SX	4.53 SX	0.44 kg
H11.001.05.06	80 DX	3.15 DX	0.30 kg

HRc 58-60

H11.008.0

1000 kN/m max.

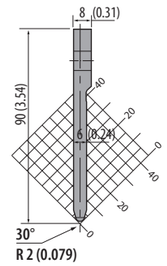


Model	Length		Weight
H11.008.01.01	100	3.94	0.44 kg
H11.008.02.01	50	1.97	0.22 kg
H11.008.02.02	55	2.17	0.24 kg
H11.008.02.03	60	2.36	0.26 kg
H11.008.02.04	65	2.56	0.29 kg
H11.008.02.05	70	2.76	0.31 kg
H11.008.02.06	75	2.95	0.33 kg
H11.008.02.07	80	3.15	0.35 kg
H11.008.02.08	85	3.35	0.37 kg
H11.008.02.09	90	3.54	0.40 kg
H11.008.02.10	95	3.74	0.42 kg
H11.008.04.01	75 DX	2.95 DX	0.31 kg
H11.008.04.02	85 DX	3.35 DX	0.35 kg
H11.008.04.03	95 DX	3.74 DX	0.40 kg
H11.008.04.04	105 DX	4.13 DX	0.46 kg
H11.008.04.05	115 DX	4.53 DX	0.48 kg
H11.008.04.06	80 SX	3.15 SX	0.33 kg
H11.008.05.01	75 SX	2.95 SX	0.31 kg
H11.008.05.02	85 SX	3.35 SX	0.35 kg
H11.008.05.03	95 SX	3.74 SX	0.40 kg
H11.008.05.04	105 SX	4.13 SX	0.46 kg
H11.008.05.05	115 SX	4.53 SX	0.48 kg
H11.008.05.06	80 DX	3.15 DX	0.33 kg

HRc 58-60

H11.006.0

1000 kN/m max.



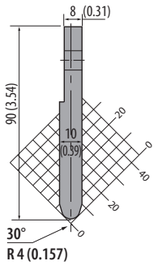
Model	Length		Weight
H11.006.01.01	100	3.94	0.44 kg
H11.006.02.01	50	1.97	0.23 kg
H11.006.02.02	55	2.17	0.25 kg
H11.006.02.03	60	2.36	0.27 kg
H11.006.02.04	65	2.56	0.29 kg
H11.006.02.05	70	2.76	0.32 kg
H11.006.02.06	75	2.95	0.34 kg
H11.006.02.07	80	3.15	0.36 kg
H11.006.02.08	85	3.35	0.38 kg
H11.006.02.09	90	3.54	0.41 kg
H11.006.02.10	95	3.74	0.43 kg
H11.006.04.01	75 DX	2.95 DX	0.32 kg
H11.006.04.02	85 DX	3.35 DX	0.36 kg
H11.006.04.03	95 DX	3.74 DX	0.41 kg
H11.006.04.04	105 DX	4.13 DX	0.44 kg
H11.006.04.05	115 DX	4.53 DX	0.50 kg
H11.006.04.06	80 SX	3.15 SX	0.34 kg
H11.006.05.01	75 SX	2.95 SX	0.32 kg
H11.006.05.02	85 SX	3.35 SX	0.36 kg
H11.006.05.03	95 SX	3.74 SX	0.41 kg
H11.006.05.04	105 SX	4.13 SX	0.44 kg
H11.006.05.05	115 SX	4.53 SX	0.50 kg
H11.006.05.06	80 DX	3.15 DX	0.34 kg

HRc 58-60

on stock Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

H11.034.0

1000 kN/m max.

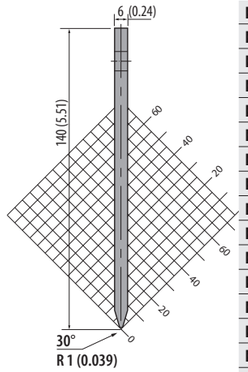


Model	Length		Weight
H11.034.01.01	100	3.94	0.63 kg
H11.034.02.01	50	1.97	0.32 kg
H11.034.02.02	55	2.17	0.35 kg
H11.034.02.03	60	2.36	0.38 kg
H11.034.02.04	65	2.56	0.41 kg
H11.034.02.05	70	2.76	0.44 kg
H11.034.02.06	75	2.95	0.47 kg
H11.034.02.07	80	3.15	0.50 kg
H11.034.02.08	85	3.35	0.54 kg
H11.034.02.09	90	3.54	0.57 kg
H11.034.02.10	95	3.74	0.60 kg
H11.034.04.01	75 DX	2.95 DX	0.44 kg
H11.034.04.02	85 DX	3.35 DX	0.50 kg
H11.034.04.03	95 DX	3.74 DX	0.57 kg
H11.034.04.04	105 DX	4.13 DX	0.63 kg
H11.034.04.05	115 DX	4.53 DX	0.69 kg
H11.034.04.06	80 SX	3.15 SX	0.47 kg
H11.034.05.01	75 SX	2.95 SX	0.44 kg
H11.034.05.02	85 SX	3.35 SX	0.50 kg
H11.034.05.03	95 SX	3.74 SX	0.57 kg
H11.034.05.04	105 SX	4.13 SX	0.63 kg
H11.034.05.05	115 SX	4.53 SX	0.69 kg
H11.034.05.06	80 DX	3.15 DX	0.47 kg

HRc 58-60

H11.003.0

1000 kN/m max.

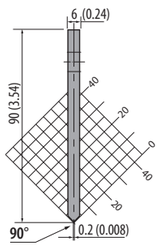


Model	Length		Weight
H11.003.01.01	100	3.94	0.63 kg
H11.003.02.01	50	1.97	0.32 kg
H11.003.02.02	55	2.17	0.35 kg
H11.003.02.03	60	2.36	0.38 kg
H11.003.02.04	65	2.56	0.41 kg
H11.003.02.05	70	2.76	0.44 kg
H11.003.02.06	75	2.95	0.47 kg
H11.003.02.07	80	3.15	0.50 kg
H11.003.02.08	85	3.35	0.54 kg
H11.003.02.09	90	3.54	0.57 kg
H11.003.02.10	95	3.74	0.60 kg
H11.003.04.01	75 DX	2.95 DX	0.44 kg
H11.003.04.02	85 DX	3.35 DX	0.50 kg
H11.003.04.03	95 DX	3.74 DX	0.57 kg
H11.003.04.04	105 DX	4.13 DX	0.63 kg
H11.003.04.05	115 DX	4.53 DX	0.69 kg
H11.003.04.06	80 SX	3.15 SX	0.47 kg
H11.003.05.01	75 SX	2.95 SX	0.44 kg
H11.003.05.02	85 SX	3.35 SX	0.50 kg
H11.003.05.03	95 SX	3.74 SX	0.57 kg
H11.003.05.04	105 SX	4.13 SX	0.63 kg
H11.003.05.05	115 SX	4.53 SX	0.69 kg
H11.003.05.06	80 DX	3.15 DX	0.47 kg

HRc 58-60

H11.005.0

1000 kN/m max.

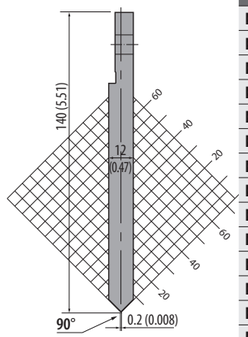


Model	Length		Weight
H11.005.01.01	100	3.94	0.43 kg
H11.005.02.01	50	1.97	0.22 kg
H11.005.02.02	55	2.17	0.24 kg
H11.005.02.03	60	2.36	0.26 kg
H11.005.02.04	65	2.56	0.28 kg
H11.005.02.05	70	2.76	0.30 kg
H11.005.02.06	75	2.95	0.32 kg
H11.005.02.07	80	3.15	0.34 kg
H11.005.02.08	85	3.35	0.37 kg
H11.005.02.09	90	3.54	0.39 kg
H11.005.02.10	95	3.74	0.41 kg
H11.005.04.01	75 DX	2.95 DX	0.30 kg
H11.005.04.02	85 DX	3.35 DX	0.34 kg
H11.005.04.03	95 DX	3.74 DX	0.39 kg
H11.005.04.04	105 DX	4.13 DX	0.40 kg
H11.005.04.05	115 DX	4.53 DX	0.47 kg
H11.005.04.06	80 SX	3.15 SX	0.32 kg
H11.005.05.01	75 SX	2.95 SX	0.30 kg
H11.005.05.02	85 SX	3.35 SX	0.34 kg
H11.005.05.03	95 SX	3.74 SX	0.39 kg
H11.005.05.04	105 SX	4.13 SX	0.40 kg
H11.005.05.05	115 SX	4.53 SX	0.47 kg
H11.005.05.06	80 DX	3.15 DX	0.32 kg

HRc 58-60

H11.009.1

1000 kN/m max.



Model	Length		Weight
H11.009.10.01	100	3.94	1.20 kg
H11.009.12.01	50	1.97	0.60 kg
H11.009.12.02	55	2.17	0.66 kg
H11.009.12.03	60	2.36	0.72 kg
H11.009.12.04	65	2.56	0.78 kg
H11.009.12.05	70	2.76	0.84 kg
H11.009.12.06	75	2.95	0.90 kg
H11.009.12.07	80	3.15	0.96 kg
H11.009.12.08	85	3.35	1.02 kg
H11.009.12.09	90	3.54	1.08 kg
H11.009.12.10	95	3.74	1.14 kg
H11.009.14.01	75 DX	2.95 DX	0.84 kg
H11.009.14.02	85 DX	3.35 DX	0.96 kg
H11.009.14.03	95 DX	3.74 DX	1.08 kg
H11.009.14.04	105 DX	4.13 DX	1.21 kg
H11.009.14.05	115 DX	4.53 DX	1.32 kg
H11.009.14.06	80 SX	3.15 SX	0.90 kg
H11.009.15.01	75 SX	2.95 SX	0.84 kg
H11.009.15.02	85 SX	3.35 SX	0.96 kg
H11.009.15.03	95 SX	3.74 SX	1.08 kg
H11.009.15.04	105 SX	4.13 SX	1.21 kg
H11.009.15.05	115 SX	4.53 SX	1.32 kg
H11.009.15.06	80 DX	3.15 DX	0.90 kg

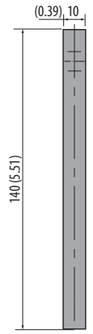
HRc 58-60

RX ROLLERI TYPE RX
Punches Hämmerle-Bystronic

ROLLERI® PROFESSIONAL BENDING

H14.021.0

1000 kN/m max.

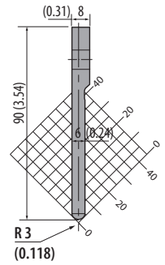


Model	Length		Weight
H14.021.01.01	100	3.94	1.09 kg
H14.021.02.01	50	1.97	0.55 kg
H14.021.02.02	55	2.17	0.60 kg
H14.021.02.03	60	2.36	0.65 kg
H14.021.02.04	65	2.56	0.71 kg
H14.021.02.05	70	2.76	0.76 kg
H14.021.02.06	75	2.95	0.82 kg
H14.021.02.07	80	3.15	0.87 kg
H14.021.02.08	85	3.35	0.93 kg
H14.021.02.09	90	3.54	0.98 kg
H14.021.02.10	95	3.74	1.04 kg

HRc 58-60

H11.033.1

1000 kN/m max.

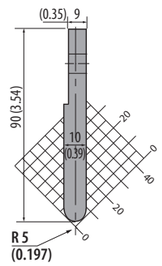


Model	Length		Weight
H11.033.11.01	100	3.94	0.46 kg
H11.033.12.01	50	1.97	0.23 kg
H11.033.12.02	55	2.17	0.25 kg
H11.033.12.03	60	2.36	0.28 kg
H11.033.12.04	65	2.56	0.30 kg
H11.033.12.05	70	2.76	0.32 kg
H11.033.12.06	75	2.95	0.35 kg
H11.033.12.07	80	3.15	0.37 kg
H11.033.12.08	85	3.35	0.39 kg
H11.033.12.09	90	3.54	0.41 kg
H11.033.12.10	95	3.74	0.44 kg
H11.033.14.01	75 DX	2.95 DX	0.32 kg
H11.033.14.02	85 DX	3.35 DX	0.37 kg
H11.033.14.03	95 DX	3.74 DX	0.41 kg
H11.033.14.04	105 DX	4.13 DX	0.44 kg
H11.033.14.05	115 DX	4.53 DX	0.51 kg
H11.033.14.06	80 SX	3.15 SX	0.35 kg
H11.033.15.01	75 SX	2.95 SX	0.32 kg
H11.033.15.02	85 SX	3.35 SX	0.37 kg
H11.033.15.03	95 SX	3.74 SX	0.41 kg
H11.033.15.04	105 SX	4.13 SX	0.44 kg
H11.033.15.05	115 SX	4.53 SX	0.51 kg
H11.033.15.06	80 DX	3.15 DX	0.35 kg

HRc 58-60

H11.035.0

1000 kN/m max.

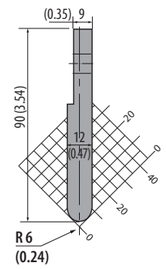


Model	Length		Weight
H11.035.01.01	100	3.94	0.63 kg
H11.035.02.01	50	1.97	0.32 kg
H11.035.02.02	55	2.17	0.35 kg
H11.035.02.03	60	2.36	0.38 kg
H11.035.02.04	65	2.56	0.41 kg
H11.035.02.05	70	2.76	0.44 kg
H11.035.02.06	75	2.95	0.47 kg
H11.035.02.07	80	3.15	0.50 kg
H11.035.02.08	85	3.35	0.54 kg
H11.035.02.09	90	3.54	0.57 kg
H11.035.02.10	95	3.74	0.60 kg
H11.035.04.01	75 DX	2.95 DX	0.44 kg
H11.035.04.02	85 DX	3.35 DX	0.50 kg
H11.035.04.03	95 DX	3.74 DX	0.57 kg
H11.035.04.04	105 DX	4.13 DX	0.63 kg
H11.035.04.05	115 DX	4.53 DX	0.69 kg
H11.035.04.06	80 SX	3.15 SX	0.47 kg
H11.035.05.01	75 SX	2.95 SX	0.44 kg
H11.035.05.02	85 SX	3.35 SX	0.50 kg
H11.035.05.03	95 SX	3.74 SX	0.57 kg
H11.035.05.04	105 SX	4.13 SX	0.63 kg
H11.035.05.05	115 SX	4.53 SX	0.69 kg
H11.035.05.06	80 DX	3.15 DX	0.47 kg

HRc 58-60

H11.036.0

1000 kN/m max.



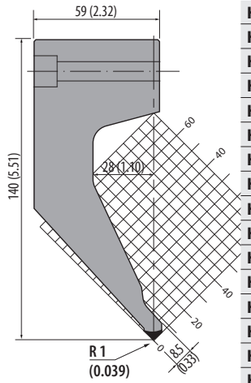
Model	Length		Weight
H11.036.01.01	100	3.94	0.74 kg
H11.036.02.01	50	1.97	0.37 kg
H11.036.02.02	55	2.17	0.41 kg
H11.036.02.03	60	2.36	0.44 kg
H11.036.02.04	65	2.56	0.48 kg
H11.036.02.05	70	2.76	0.52 kg
H11.036.02.06	75	2.95	0.56 kg
H11.036.02.07	80	3.15	0.59 kg
H11.036.02.08	85	3.35	0.63 kg
H11.036.02.09	90	3.54	0.67 kg
H11.036.02.10	95	3.74	0.70 kg
H11.036.04.01	75 DX	2.95 DX	0.52 kg
H11.036.04.02	85 DX	3.35 DX	0.59 kg
H11.036.04.03	95 DX	3.74 DX	0.67 kg
H11.036.04.04	105 DX	4.13 DX	0.74 kg
H11.036.04.05	115 DX	4.53 DX	0.81 kg
H11.036.04.06	80 SX	3.15 SX	0.56 kg
H11.036.05.01	75 SX	2.95 SX	0.52 kg
H11.036.05.02	85 SX	3.35 SX	0.59 kg
H11.036.05.03	95 SX	3.74 SX	0.67 kg
H11.036.05.04	105 SX	4.13 SX	0.74 kg
H11.036.05.05	115 SX	4.53 SX	0.81 kg
H11.036.05.06	80 DX	3.15 DX	0.56 kg

HRc 58-60

Punches Hämmerle-Bystronic

H12.014.0

975 kN/m max.

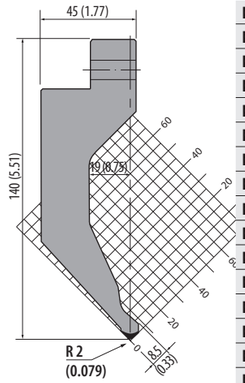


Model	Length		Weight
H12.014.01.01	100	3.94	3.36 kg
H12.014.02.01	50	1.97	1.68 kg
H12.014.02.02	55	2.17	1.85 kg
H12.014.02.03	60	2.36	2.02 kg
H12.014.02.04	65	2.56	2.18 kg
H12.014.02.05	70	2.76	2.35 kg
H12.014.02.06	75	2.95	2.52 kg
H12.014.02.07	80	3.15	2.69 kg
H12.014.02.08	85	3.35	2.86 kg
H12.014.02.09	90	3.54	3.02 kg
H12.014.02.10	95	3.74	3.19 kg
H12.014.04.01	75 DX	2.95 DX	2.35 kg
H12.014.04.02	85 DX	3.35 DX	2.69 kg
H12.014.04.03	95 DX	3.74 DX	3.02 kg
H12.014.04.04	105 DX	4.13 DX	3.03 kg
H12.014.04.05	115 DX	4.53 DX	3.70 kg
H12.014.04.06	80 SX	3.15 SX	2.52 kg
H12.014.05.01	75 SX	2.95 SX	2.35 kg
H12.014.05.02	85 SX	3.35 SX	2.69 kg
H12.014.05.03	95 SX	3.74 SX	3.02 kg
H12.014.05.04	105 SX	4.13 SX	3.03 kg
H12.014.05.05	115 SX	4.53 SX	3.70 kg
H12.014.05.06	80 DX	3.15 DX	2.52 kg

42Cr: 900-1150 N/mm²

H12.052.0

975 kN/m max.

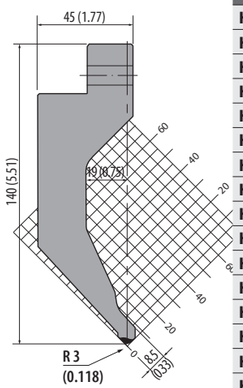


Model	Length		Weight
H12.052.01.01	100	3.94	2.63 kg
H12.052.02.01	50	1.97	1.32 kg
H12.052.02.02	55	2.17	1.45 kg
H12.052.02.03	60	2.36	1.58 kg
H12.052.02.04	65	2.56	1.71 kg
H12.052.02.05	70	2.76	1.84 kg
H12.052.02.06	75	2.95	1.97 kg
H12.052.02.07	80	3.15	2.10 kg
H12.052.02.08	85	3.35	2.24 kg
H12.052.02.09	90	3.54	2.37 kg
H12.052.02.10	95	3.74	2.50 kg
H12.052.04.01	75 DX	2.95 DX	1.84 kg
H12.052.04.02	85 DX	3.35 DX	2.10 kg
H12.052.04.03	95 DX	3.74 DX	2.37 kg
H12.052.04.04	105 DX	4.13 DX	2.50 kg
H12.052.04.05	115 DX	4.53 DX	2.89 kg
H12.052.04.06	80 SX	3.15 SX	1.97 kg
H12.052.05.01	75 SX	2.95 SX	1.84 kg
H12.052.05.02	85 SX	3.35 SX	2.10 kg
H12.052.05.03	95 SX	3.74 SX	2.37 kg
H12.052.05.04	105 SX	4.13 SX	2.50 kg
H12.052.05.05	115 SX	4.53 SX	2.89 kg
H12.052.05.06	80 DX	3.15 DX	1.97 kg

42Cr: 900-1150 N/mm²

H12.053.0

975 kN/m max.

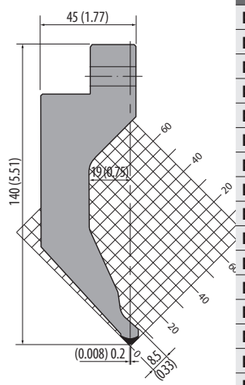


Model	Length		Weight
H12.053.01.01	100	3.94	2.65 kg
H12.053.02.01	50	1.97	1.33 kg
H12.053.02.02	55	2.17	1.46 kg
H12.053.02.03	60	2.36	1.59 kg
H12.053.02.04	65	2.56	1.72 kg
H12.053.02.05	70	2.76	1.86 kg
H12.053.02.06	75	2.95	1.99 kg
H12.053.02.07	80	3.15	2.12 kg
H12.053.02.08	85	3.35	2.25 kg
H12.053.02.09	90	3.54	2.39 kg
H12.053.02.10	95	3.74	2.52 kg
H12.053.04.01	75 DX	2.95 DX	1.86 kg
H12.053.04.02	85 DX	3.35 DX	2.12 kg
H12.053.04.03	95 DX	3.74 DX	2.39 kg
H12.053.04.04	105 DX	4.13 DX	2.60 kg
H12.053.04.05	115 DX	4.53 DX	2.92 kg
H12.053.04.06	80 SX	3.15 SX	1.99 kg
H12.053.05.01	75 SX	2.95 SX	1.86 kg
H12.053.05.02	85 SX	3.35 SX	2.12 kg
H12.053.05.03	95 SX	3.74 SX	2.39 kg
H12.053.05.04	105 SX	4.13 SX	2.60 kg
H12.053.05.05	115 SX	4.53 SX	2.92 kg
H12.053.05.06	80 DX	3.15 DX	1.99 kg

42Cr: 900-1150 N/mm²

H12.019.0

975 kN/m max.



Model	Length		Weight
H12.019.01.01	100	3.94	2.60 kg
H12.019.02.01	50	1.97	1.30 kg
H12.019.02.02	55	2.17	1.43 kg
H12.019.02.03	60	2.36	1.56 kg
H12.019.02.04	65	2.56	1.69 kg
H12.019.02.05	70	2.76	1.82 kg
H12.019.02.06	75	2.95	1.95 kg
H12.019.02.07	80	3.15	2.08 kg
H12.019.02.08	85	3.35	2.21 kg
H12.019.02.09	90	3.54	2.34 kg
H12.019.02.10	95	3.74	2.47 kg
H12.019.04.01	75 DX	2.95 DX	1.82 kg
H12.019.04.02	85 DX	3.35 DX	2.08 kg
H12.019.04.03	95 DX	3.74 DX	2.34 kg
H12.019.04.04	105 DX	4.13 DX	2.46 kg
H12.019.04.05	115 DX	4.53 DX	2.86 kg
H12.019.04.06	80 SX	3.15 SX	1.95 kg
H12.019.05.01	75 SX	2.95 SX	1.82 kg
H12.019.05.02	85 SX	3.35 SX	2.08 kg
H12.019.05.03	95 SX	3.74 SX	2.34 kg
H12.019.05.04	105 SX	4.13 SX	2.46 kg
H12.019.05.05	115 SX	4.53 SX	2.86 kg
H12.019.05.06	80 DX	3.15 DX	1.95 kg

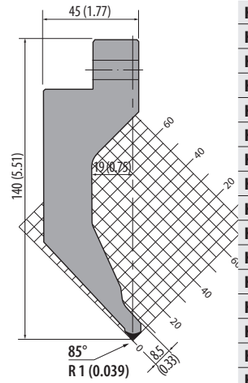
42Cr: 900-1150 N/mm²

Punches Hämmerle-Bystronic

ROLLERI® PROFESSIONAL BENDING

H12.015.0

975 kN/m max.

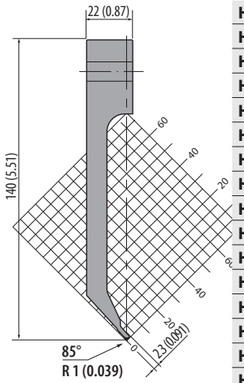


Model	Length		Weight
H12.015.01.01	100	3.94	2.63 kg
H12.015.02.01	50	1.97	1.32 kg
H12.015.02.02	55	2.17	1.45 kg
H12.015.02.03	60	2.36	1.58 kg
H12.015.02.04	65	2.56	1.71 kg
H12.015.02.05	70	2.76	1.84 kg
H12.015.02.06	75	2.95	1.97 kg
H12.015.02.07	80	3.15	2.10 kg
H12.015.02.08	85	3.35	2.24 kg
H12.015.02.09	90	3.54	2.37 kg
H12.015.02.10	95	3.74	2.50 kg
H12.015.04.01	75 DX	2.95 DX	1.84 kg
H12.015.04.02	85 DX	3.35 DX	2.10 kg
H12.015.04.03	95 DX	3.74 DX	2.37 kg
H12.015.04.04	105 DX	4.13 DX	2.30 kg
H12.015.04.05	115 DX	4.53 DX	2.89 kg
H12.015.04.06	80 SX	3.15 SX	1.97 kg
H12.015.05.01	75 SX	2.95 SX	1.84 kg
H12.015.05.02	85 SX	3.35 SX	2.10 kg
H12.015.05.03	95 SX	3.74 SX	2.37 kg
H12.015.05.04	105 SX	4.13 SX	2.30 kg
H12.015.05.05	115 SX	4.53 SX	2.89 kg
H12.015.05.06	80 DX	3.15 DX	1.97 kg

42Cr: 900-1150 N/mm²

H12.025.0

250 kN/m max.

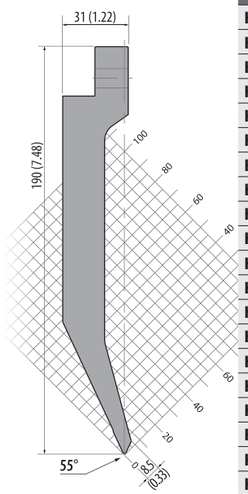


Model	Length		Weight
H12.025.01.01	100	3.94	1.36 kg
H12.025.02.01	50	1.97	0.68 kg
H12.025.02.02	55	2.17	0.75 kg
H12.025.02.03	60	2.36	0.82 kg
H12.025.02.04	65	2.56	0.88 kg
H12.025.02.05	70	2.76	0.95 kg
H12.025.02.06	75	2.95	1.02 kg
H12.025.02.07	80	3.15	1.09 kg
H12.025.02.08	85	3.35	1.16 kg
H12.025.02.09	90	3.54	1.22 kg
H12.025.02.10	95	3.74	1.29 kg
H12.025.04.01	75 DX	2.95 DX	0.95 kg
H12.025.04.02	85 DX	3.35 DX	1.09 kg
H12.025.04.03	95 DX	3.74 DX	1.22 kg
H12.025.04.04	105 DX	4.13 DX	1.35 kg
H12.025.04.05	115 DX	4.53 DX	1.50 kg
H12.025.04.06	80 SX	3.15 SX	1.02 kg
H12.025.05.01	75 SX	2.95 SX	0.95 kg
H12.025.05.02	85 SX	3.35 SX	1.09 kg
H12.025.05.03	95 SX	3.74 SX	1.22 kg
H12.025.05.04	105 SX	4.13 SX	1.35 kg
H12.025.05.05	115 SX	4.53 SX	1.50 kg
H12.025.05.06	80 DX	3.15 DX	1.02 kg

42Cr: 900-1150 N/mm²

H12.017.0

750 kN/m max.

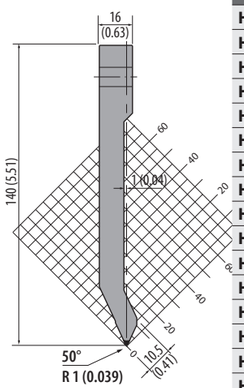


Model	Length		Weight
H12.017.01.01	100	3.94	2.76 kg
H12.017.02.01	50	1.97	1.38 kg
H12.017.02.02	55	2.17	1.52 kg
H12.017.02.03	60	2.36	1.66 kg
H12.017.02.04	65	2.56	1.79 kg
H12.017.02.05	70	2.76	1.93 kg
H12.017.02.06	75	2.95	2.07 kg
H12.017.02.07	80	3.15	2.21 kg
H12.017.02.08	85	3.35	2.35 kg
H12.017.02.09	90	3.54	2.48 kg
H12.017.02.10	95	3.74	2.62 kg
H12.017.04.01	75 DX	2.95 DX	1.93 kg
H12.017.04.02	85 DX	3.35 DX	2.21 kg
H12.017.04.03	95 DX	3.74 DX	2.48 kg
H12.017.04.04	105 DX	4.13 DX	3.03 kg
H12.017.04.05	115 DX	4.53 DX	3.04 kg
H12.017.04.06	80 SX	3.15 SX	2.07 kg
H12.017.05.01	75 SX	2.95 SX	1.93 kg
H12.017.05.02	85 SX	3.35 SX	2.21 kg
H12.017.05.03	95 SX	3.74 SX	2.48 kg
H12.017.05.04	105 SX	4.13 SX	3.03 kg
H12.017.05.05	115 SX	4.53 SX	3.04 kg
H12.017.05.06	80 DX	3.15 DX	2.07 kg

42Cr: 900-1150 N/mm²

H12.065.0

1000 kN/m max.



Model	Length		Weight
H12.065.01.01	100	3.94	1.36 kg
H12.065.02.01	50	1.97	0.68 kg
H12.065.02.02	55	2.17	0.75 kg
H12.065.02.03	60	2.36	0.82 kg
H12.065.02.04	65	2.56	0.88 kg
H12.065.02.05	70	2.76	0.95 kg
H12.065.02.06	75	2.95	1.02 kg
H12.065.02.07	80	3.15	1.09 kg
H12.065.02.08	85	3.35	1.16 kg
H12.065.02.09	90	3.54	1.22 kg
H12.065.02.10	95	3.74	1.29 kg
H12.065.04.01	75 DX	2.95 DX	0.95 kg
H12.065.04.02	85 DX	3.35 DX	1.09 kg
H12.065.04.03	95 DX	3.74 DX	1.22 kg
H12.065.04.04	105 DX	4.13 DX	1.35 kg
H12.065.04.05	115 DX	4.53 DX	1.50 kg
H12.065.04.06	80 SX	3.15 SX	1.02 kg
H12.065.05.01	75 SX	2.95 SX	0.95 kg
H12.065.05.02	85 SX	3.35 SX	1.09 kg
H12.065.05.03	95 SX	3.74 SX	1.22 kg
H12.065.05.04	105 SX	4.13 SX	1.35 kg
H12.065.05.05	115 SX	4.53 SX	1.50 kg
H12.065.05.06	80 DX	3.15 DX	1.02 kg

42Cr: 900-1150 N/mm²

Article on stock

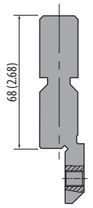
Please ask for delivery time!

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

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

H21.003.0

1000 kN/m max.

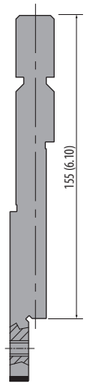


Model	Length		Weight
H21.003.01.01	100	3.94	1.18 kg
H21.003.01.03	200	7.87	2.36 kg
H21.003.02.01	50	1.97	0.59 kg
H21.003.02.02	55	2.17	0.65 kg
H21.003.02.03	60	2.36	0.71 kg
H21.003.02.04	65	2.56	0.77 kg
H21.003.02.05	70	2.76	0.83 kg
H21.003.02.06	75	2.95	0.89 kg
H21.003.02.07	80	3.15	0.94 kg
H21.003.02.08	85	3.35	1.00 kg
H21.003.02.09	90	3.54	1.06 kg
H21.003.02.10	95	3.74	1.12 kg
H21.003.04.01	75 DX	2.95 DX	0.83 kg
H21.003.04.02	85 DX	3.35 DX	0.94 kg
H21.003.04.03	95 DX	3.74 DX	1.06 kg
H21.003.04.04	105 DX	4.13 DX	1.15 kg
H21.003.04.05	115 DX	4.53 DX	1.30 kg
H21.003.04.06	80 SX	3.15 SX	0.89 kg
H21.003.05.01	75 SX	2.95 SX	0.83 kg
H21.003.05.02	85 SX	3.35 SX	0.94 kg
H21.003.05.03	95 SX	3.74 SX	1.06 kg
H21.003.05.04	105 SX	4.13 SX	1.12 kg
H21.003.05.05	115 SX	4.53 SX	1.30 kg
H21.003.05.06	80 DX	3.15 DX	0.89 kg

C45: 560-710 N/mm²

H21.002.0

1000 kN/m max.



Model	Length		Weight
H21.002.01.01	100	3.94	2.44 kg
H21.002.01.03	200	7.87	4.88 kg
H21.002.02.01	50	1.97	1.22 kg
H21.002.02.02	55	2.17	1.34 kg
H21.002.02.03	60	2.36	1.46 kg
H21.002.02.04	65	2.56	1.59 kg
H21.002.02.05	70	2.76	1.71 kg
H21.002.02.06	75	2.95	1.83 kg
H21.002.02.07	80	3.15	1.95 kg
H21.002.02.08	85	3.35	2.07 kg
H21.002.02.09	90	3.54	2.20 kg
H21.002.02.10	95	3.74	2.32 kg
H21.002.04.01	75 DX	2.95 DX	1.71 kg
H21.002.04.02	85 DX	3.35 DX	1.95 kg
H21.002.04.03	95 DX	3.74 DX	2.20 kg
H21.002.04.04	105 DX	4.13 DX	2.40 kg
H21.002.04.05	115 DX	4.53 DX	2.68 kg
H21.002.04.06	80 SX	3.15 SX	1.83 kg
H21.002.05.01	75 SX	2.95 SX	1.70 kg
H21.002.05.02	85 SX	3.35 SX	1.95 kg
H21.002.05.03	95 SX	3.74 SX	2.20 kg
H21.002.05.04	105 SX	4.13 SX	2.40 kg
H21.002.05.05	115 SX	4.53 SX	2.68 kg
H21.002.05.06	80 DX	3.15 DX	1.83 kg

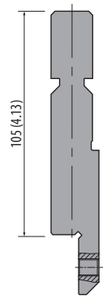
C45: 560-710 N/mm²

RX ROLLERI TYPE RX
Punch holders Hämmerle-Bystronic

ROLLERI® PROFESSIONAL BENDING

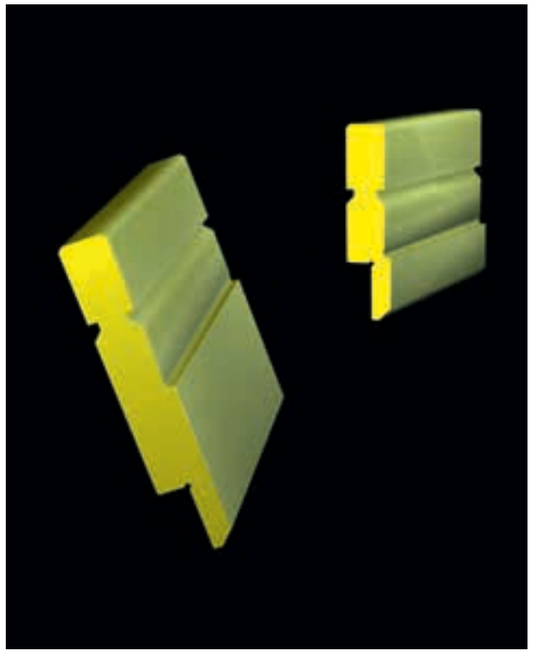
H21.004.0

1000 kN/m max.



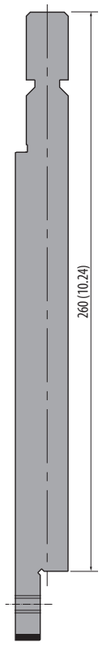
Model	Length		Weight
H21.004.01.01	100	3.94	1.82 kg
H21.004.01.03	200	7.87	3.64 kg
H21.004.02.01	50	1.97	0.91 kg
H21.004.02.02	55	2.17	1.00 kg
H21.004.02.03	60	2.36	1.09 kg
H21.004.02.04	65	2.56	1.18 kg
H21.004.02.05	70	2.76	1.27 kg
H21.004.02.06	75	2.95	1.37 kg
H21.004.02.07	80	3.15	1.46 kg
H21.004.02.08	85	3.35	1.55 kg
H21.004.02.09	90	3.54	1.64 kg
H21.004.02.10	95	3.74	1.73 kg
H21.004.04.01	75 DX	2.95 DX	1.27 kg
H21.004.04.02	85 DX	3.35 DX	1.46 kg
H21.004.04.03	95 DX	3.74 DX	1.64 kg
H21.004.04.04	105 DX	4.13 DX	1.80 kg
H21.004.04.05	115 DX	4.53 DX	2.00 kg
H21.004.04.06	80 SX	3.15 SX	1.37 kg
H21.004.05.01	75 SX	2.95 SX	1.27 kg
H21.004.05.02	85 SX	3.35 SX	1.46 kg
H21.004.05.03	95 SX	3.74 SX	1.64 kg
H21.004.05.04	105 SX	4.13 SX	1.80 kg
H21.004.05.05	115 SX	4.53 SX	2.00 kg
H21.004.05.06	80 DX	3.15 DX	1.37 kg

C45: 560-710 N/mm²



H21.005.0

1000 kN/m max.

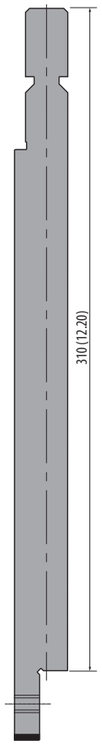


Model	Length		Weight
H21.005.01.01	100	3.94	5.06 kg
H21.005.01.03	200	7.87	10.12 kg
H21.005.02.01	50	1.97	2.53 kg
H21.005.02.02	55	2.17	2.78 kg
H21.005.02.03	60	2.36	3.04 kg
H21.005.02.04	65	2.56	3.29 kg
H21.005.02.05	70	2.76	3.54 kg
H21.005.02.06	75	2.95	3.80 kg
H21.005.02.07	80	3.15	4.05 kg
H21.005.02.08	85	3.35	4.30 kg
H21.005.02.09	90	3.54	4.55 kg
H21.005.02.10	95	3.74	4.81 kg
H21.005.04.01	75 DX	2.95 DX	3.54 kg
H21.005.04.02	85 DX	3.35 DX	4.05 kg
H21.005.04.03	95 DX	3.74 DX	4.55 kg
H21.005.04.04	105 DX	4.13 DX	5.00 kg
H21.005.04.05	115 DX	4.53 DX	5.57 kg
H21.005.04.06	80 SX	3.15 SX	3.80 kg
H21.005.05.01	75 SX	2.95 SX	3.54 kg
H21.005.05.02	85 SX	3.35 SX	4.05 kg
H21.005.05.03	95 SX	3.74 SX	4.55 kg
H21.005.05.04	105 SX	4.13 SX	5.00 kg
H21.005.05.05	115 SX	4.53 SX	5.57 kg
H21.005.05.06	80 DX	3.15 DX	3.80 kg

C45: 560-710 N/mm²

H21.010.0

1000 kN/m max.

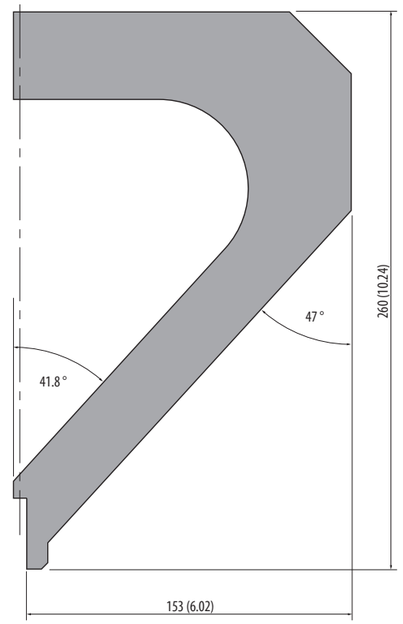


Model	Length		Weight
H21.010.01.01	100	3.94	6.04 kg
H21.010.01.03	200	7.87	12.00 kg
H21.010.02.01	50	1.97	3.00 kg
H21.010.02.02	55	2.17	3.32 kg
H21.010.02.03	60	2.36	3.60 kg
H21.010.02.04	65	2.56	3.93 kg
H21.010.02.05	70	2.76	4.23 kg
H21.010.02.06	75	2.95	4.53 kg
H21.010.02.07	80	3.15	4.83 kg
H21.010.02.08	85	3.35	5.13 kg
H21.010.02.09	90	3.54	5.44 kg
H21.010.02.10	95	3.74	5.74 kg
H21.010.04.01	75 DX	2.95 DX	4.23 kg
H21.010.04.02	85 DX	3.35 DX	4.83 kg
H21.010.04.03	95 DX	3.74 DX	5.44 kg
H21.010.04.04	105 DX	4.13 DX	6.10 kg
H21.010.04.05	115 DX	4.53 DX	6.64 kg
H21.010.04.06	80 SX	3.15 SX	4.53 kg
H21.010.05.01	75 SX	2.95 SX	4.23 kg
H21.010.05.02	85 SX	3.35 SX	4.83 kg
H21.010.05.03	95 SX	3.74 SX	5.44 kg
H21.010.05.04	105 SX	4.13 SX	6.10 kg
H21.010.05.05	115 SX	4.53 SX	6.64 kg
H21.010.05.06	80 DX	3.15 DX	4.53 kg

C45: 560-710 N/mm²

H22.006.0

600 kN/m max.



Model	Length		Weight
H22.006.01.01	100	3.94	10.3 kg
H22.006.02.01	50	1.97	5.15 kg
H22.006.02.02	55	2.17	5.67 kg
H22.006.02.03	60	2.36	6.18 kg
H22.006.02.04	65	2.56	6.70 kg
H22.006.02.05	70	2.76	7.21 kg
H22.006.02.06	75	2.95	7.73 kg
H22.006.02.07	80	3.15	8.24 kg
H22.006.02.08	85	3.35	8.76 kg
H22.006.02.09	90	3.54	9.27 kg
H22.006.02.10	95	3.74	9.79 kg

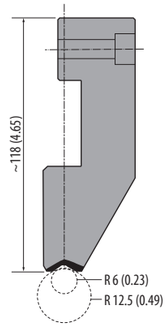
42Cr: 900-1150 N/mm²

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

Radius Tools Hämmerle-Bystronic

H22.013.0

1000 kN/m max.

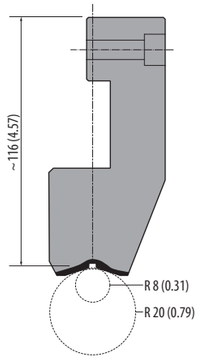


Model	Length		Weight
H22.013.01.01	100	3.94	2.82 kg
H22.013.02.01	50	1.97	1.41 kg
H22.013.02.02	55	2.17	1.55 kg
H22.013.02.03	60	2.36	1.69 kg
H22.013.02.04	65	2.56	1.83 kg
H22.013.02.05	70	2.76	1.97 kg
H22.013.02.06	75	2.95	2.12 kg
H22.013.02.07	80	3.15	2.26 kg
H22.013.02.08	85	3.35	2.40 kg
H22.013.02.09	90	3.54	2.54 kg
H22.013.02.10	95	3.74	2.68 kg

C45: 560-710 N/mm²

H22.014.0

1000 kN/m max.

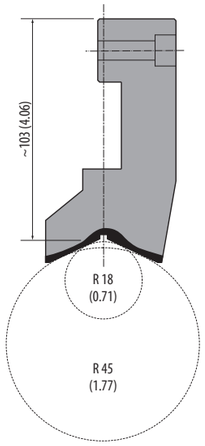


Model	Length		Weight
H22.014.01.01	100	3.94	3.06 kg
H22.014.02.01	50	1.97	1.53 kg
H22.014.02.02	55	2.17	1.68 kg
H22.014.02.03	60	2.36	1.83 kg
H22.014.02.04	65	2.56	1.98 kg
H22.014.02.05	70	2.76	2.14 kg
H22.014.02.06	75	2.95	2.29 kg
H22.014.02.07	80	3.15	2.44 kg
H22.014.02.08	85	3.35	2.59 kg
H22.014.02.09	90	3.54	2.75 kg
H22.014.02.10	95	3.74	2.90 kg

C45: 560-710 N/mm²

H22.015.0

1000 kN/m max.



Model	Length		Weight
H22.015.01.01	100	3.94	3.28 kg
H22.015.02.01	50	1.97	1.64 kg
H22.015.02.02	55	2.17	1.80 kg
H22.015.02.03	60	2.36	1.97 kg
H22.015.02.04	65	2.56	2.13 kg
H22.015.02.05	70	2.76	2.30 kg
H22.015.02.06	75	2.95	2.46 kg
H22.015.02.07	80	3.15	2.62 kg
H22.015.02.08	85	3.35	2.79 kg
H22.015.02.09	90	3.54	2.95 kg
H22.015.02.10	95	3.74	3.12 kg

C45: 560-710 N/mm²

Die holders Hämmerle-Bystronic

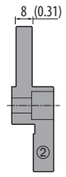
ROLLERI® PROFESSIONAL BENDING

H61.100.01 / H61.500.01

Model	Length		Weight
H61.100.01	100	3.94	0.63 kg
H61.500.01	500	19.68	3.15 kg

C45: 560-710 N/mm²

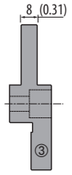
H61.100.02 / H61.500.02



Model	Length		Weight
H61.100.02	100	3.94	0.70 kg
H61.500.02	500	19.68	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	3.94	0.63 kg
H61.500.04	500	19.68	3.15 kg

C45: 560-710 N/mm²

H61.100.05 / H61.500.05

Model	Length		Weight
H61.100.05	100	3.94	0.30 kg
H61.500.05	500	19.68	1.50 kg

C45: 560-710 N/mm²

H61.100.06 / H61.500.06

Model	Length		Weight
H61.100.06	100	3.94	0.63 kg
H61.500.06	500	19.68	3.15 kg

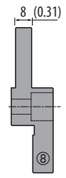
C45: 560-710 N/mm²

H61.100.07

Model	Length		Weight
H61.100.07	100	3.94	0.65 kg

C45: 560-710 N/mm²

H61.100.08 / H61.500.08



Model	Length		Weight
H61.100.08	100	3.94	0.70 kg
H61.500.08	500	19.68	3.50 kg

C45: 560-710 N/mm²

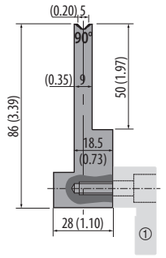
Rolleri Videos

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

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

H41.005.0

1000 kN/m max.

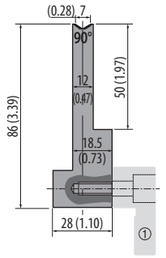


42Cr: 900-1150 N/mm²

Model	Length		Weight
H41.005.01.01	100	3.94	0.94 kg
H41.005.02.01	50 SX	1.97 SX	0.71 kg
H41.005.02.02	55 DX	2.17 DX	0.71 kg
H41.005.02.03	60 DX	2.36 DX	0.75 kg
H41.005.02.04	65 DX	2.56 DX	0.75 kg
H41.005.02.05	70 DX	2.76 DX	0.75 kg
H41.005.02.06	75 DX	2.95 DX	0.85 kg
H41.005.02.07	80 DX	3.15 DX	0.85 kg
H41.005.02.08	85 DX	3.35 DX	0.85 kg
H41.005.02.09	90 DX	3.54 DX	0.94 kg
H41.005.02.10	95 DX	3.74 DX	0.94 kg
H41.005.03.01	50 DX	1.97 DX	0.71 kg
H41.005.03.02	55 SX	2.17 SX	0.71 kg
H41.005.03.03	60 SX	2.36 SX	0.75 kg
H41.005.03.04	65 SX	2.56 SX	0.75 kg
H41.005.03.05	70 SX	2.76 SX	0.75 kg
H41.005.03.06	75 SX	2.95 SX	0.85 kg
H41.005.03.07	80 SX	3.15 SX	0.85 kg
H41.005.03.08	85 SX	3.35 SX	0.85 kg
H41.005.03.09	90 SX	3.54 SX	0.94 kg
H41.005.03.10	95 SX	3.74 SX	0.94 kg

H41.007.0

1000 kN/m max.

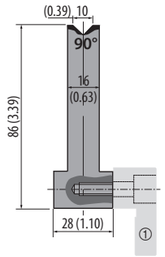


42Cr: 900-1150 N/mm²

Model	Length		Weight
H41.007.01.01	100	3.94	1.12 kg
H41.007.02.01	50 SX	1.97 SX	0.84 kg
H41.007.02.02	55 DX	2.17 DX	0.84 kg
H41.007.02.03	60 DX	2.36 DX	0.90 kg
H41.007.02.04	65 DX	2.56 DX	0.90 kg
H41.007.02.05	70 DX	2.76 DX	0.90 kg
H41.007.02.06	75 DX	2.95 DX	1.01 kg
H41.007.02.07	80 DX	3.15 DX	1.01 kg
H41.007.02.08	85 DX	3.35 DX	1.01 kg
H41.007.02.09	90 DX	3.54 DX	1.12 kg
H41.007.02.10	95 DX	3.74 DX	1.12 kg
H41.007.03.01	50 DX	1.97 DX	0.84 kg
H41.007.03.02	55 SX	2.17 SX	0.84 kg
H41.007.03.03	60 SX	2.36 SX	0.90 kg
H41.007.03.04	65 SX	2.56 SX	0.90 kg
H41.007.03.05	70 SX	2.76 SX	0.90 kg
H41.007.03.06	75 SX	2.95 SX	1.01 kg
H41.007.03.07	80 SX	3.15 SX	1.01 kg
H41.007.03.08	85 SX	3.35 SX	1.01 kg
H41.007.03.09	90 SX	3.54 SX	1.12 kg
H41.007.03.10	95 SX	3.74 SX	1.12 kg

H41.010.0

1000 kN/m max.

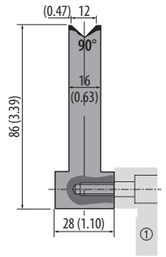


42Cr: 900-1150 N/mm²

Model	Length		Weight
H41.010.01.01	100	3.94	1.22 kg
H41.010.02.01	50 SX	1.97 SX	0.92 kg
H41.010.02.02	55 DX	2.17 DX	0.92 kg
H41.010.02.03	60 DX	2.36 DX	0.98 kg
H41.010.02.04	65 DX	2.56 DX	0.98 kg
H41.010.02.05	70 DX	2.76 DX	0.98 kg
H41.010.02.06	75 DX	2.95 DX	1.10 kg
H41.010.02.07	80 DX	3.15 DX	1.10 kg
H41.010.02.08	85 DX	3.35 DX	1.10 kg
H41.010.02.09	90 DX	3.54 DX	1.22 kg
H41.010.02.10	95 DX	3.74 DX	1.22 kg
H41.010.03.01	50 DX	1.97 DX	0.92 kg
H41.010.03.02	55 SX	2.17 SX	0.92 kg
H41.010.03.03	60 SX	2.36 SX	0.98 kg
H41.010.03.04	65 SX	2.56 SX	0.98 kg
H41.010.03.05	70 SX	2.76 SX	0.98 kg
H41.010.03.06	75 SX	2.95 SX	1.10 kg
H41.010.03.07	80 SX	3.15 SX	1.10 kg
H41.010.03.08	85 SX	3.35 SX	1.10 kg
H41.010.03.09	90 SX	3.54 SX	1.22 kg
H41.010.03.10	95 SX	3.74 SX	1.22 kg

H41.012.0

1000 kN/m max.

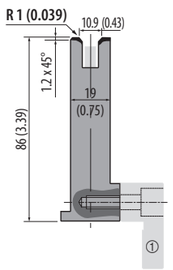


42Cr: 900-1150 N/mm²

Model	Length		Weight
H41.012.01.01	100	3.94	1.20 kg
H41.012.02.01	50 SX	1.97 SX	0.90 kg
H41.012.02.02	55 DX	2.17 DX	0.90 kg
H41.012.02.03	60 DX	2.36 DX	0.96 kg
H41.012.02.04	65 DX	2.56 DX	0.96 kg
H41.012.02.05	70 DX	2.76 DX	0.96 kg
H41.012.02.06	75 DX	2.95 DX	1.08 kg
H41.012.02.07	80 DX	3.15 DX	1.08 kg
H41.012.02.08	85 DX	3.35 DX	1.08 kg
H41.012.02.09	90 DX	3.54 DX	1.20 kg
H41.012.02.10	95 DX	3.74 DX	1.20 kg
H41.012.03.01	50 DX	1.97 DX	0.90 kg
H41.012.03.02	55 SX	2.17 SX	0.90 kg
H41.012.03.03	60 SX	2.36 SX	0.96 kg
H41.012.03.04	65 SX	2.56 SX	0.96 kg
H41.012.03.05	70 SX	2.76 SX	0.96 kg
H41.012.03.06	75 SX	2.95 SX	1.08 kg
H41.012.03.07	80 SX	3.15 SX	1.08 kg
H41.012.03.08	85 SX	3.35 SX	1.08 kg
H41.012.03.09	90 SX	3.54 SX	1.20 kg
H41.012.03.10	95 SX	3.74 SX	1.20 kg

H31.010.2

550 kN/m max.

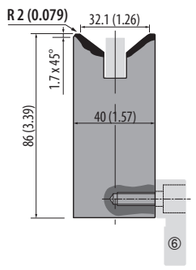


42Cr: 900-1150 N/mm²

Model	Length		Weight
H31.010.21.01	100	3.94	1.07 kg
H31.010.22.01	50 SX	1.97 SX	0.80 kg
H31.010.22.02	55 DX	2.17 DX	0.80 kg
H31.010.22.03	60 DX	2.36 DX	0.86 kg
H31.010.22.04	65 DX	2.56 DX	0.86 kg
H31.010.22.05	70 DX	2.76 DX	0.86 kg
H31.010.22.06	75 DX	2.95 DX	0.96 kg
H31.010.22.07	80 DX	3.15 DX	0.96 kg
H31.010.22.08	85 DX	3.35 DX	0.96 kg
H31.010.22.09	90 DX	3.54 DX	1.07 kg
H31.010.22.10	95 DX	3.74 DX	1.07 kg
H31.010.23.01	50 DX	1.97 DX	0.80 kg
H31.010.23.02	55 SX	2.17 SX	0.80 kg
H31.010.23.03	60 SX	2.36 SX	0.86 kg
H31.010.23.04	65 SX	2.56 SX	0.86 kg
H31.010.23.05	70 SX	2.76 SX	0.86 kg
H31.010.23.06	75 SX	2.95 SX	0.96 kg
H31.010.23.07	80 SX	3.15 SX	0.96 kg
H31.010.23.08	85 SX	3.35 SX	0.96 kg
H31.010.23.09	90 SX	3.54 SX	1.07 kg
H31.010.23.10	95 SX	3.74 SX	1.07 kg

H31.032.1

1200 kN/m max.

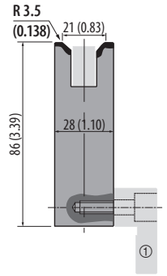


C45: 560-710 N/mm²

Model	Length		Weight
H31.032.11.01	100	3.94	2.17 kg
H31.032.12.01	50 SX	1.97 SX	1.63 kg
H31.032.12.02	55 DX	2.17 DX	1.63 kg
H31.032.12.03	60 DX	2.36 DX	1.74 kg
H31.032.12.04	65 DX	2.56 DX	1.74 kg
H31.032.12.05	70 DX	2.76 DX	1.74 kg
H31.032.12.06	75 DX	2.95 DX	1.95 kg
H31.032.12.07	80 DX	3.15 DX	1.95 kg
H31.032.12.08	85 DX	3.35 DX	1.95 kg
H31.032.12.09	90 DX	3.54 DX	2.17 kg
H31.032.12.10	95 DX	3.74 DX	2.17 kg
H31.032.13.01	50 DX	1.97 DX	1.63 kg
H31.032.13.02	55 SX	2.17 SX	1.63 kg
H31.032.13.03	60 SX	2.36 SX	1.74 kg
H31.032.13.04	65 SX	2.56 SX	1.74 kg
H31.032.13.05	70 SX	2.76 SX	1.74 kg
H31.032.13.06	75 SX	2.95 SX	1.95 kg
H31.032.13.07	80 SX	3.15 SX	1.95 kg
H31.032.13.08	85 SX	3.35 SX	1.95 kg
H31.032.13.09	90 SX	3.54 SX	2.17 kg
H31.032.13.10	95 SX	3.74 SX	2.17 kg

H31.021.0

500 kN/m max.

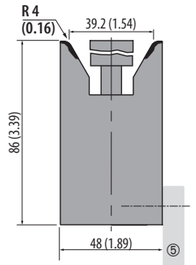


C45: 560-710 N/mm²

Model	Length		Weight
H31.021.01.01	100	3.94	1.51 kg
H31.021.02.01	50 SX	1.97 SX	1.13 kg
H31.021.02.02	55 DX	2.17 DX	1.13 kg
H31.021.02.03	60 DX	2.36 DX	1.21 kg
H31.021.02.04	65 DX	2.56 DX	1.21 kg
H31.021.02.05	70 DX	2.76 DX	1.21 kg
H31.021.02.06	75 DX	2.95 DX	1.36 kg
H31.021.02.07	80 DX	3.15 DX	1.36 kg
H31.021.02.08	85 DX	3.35 DX	1.36 kg
H31.021.02.09	90 DX	3.54 DX	1.51 kg
H31.021.02.10	95 DX	3.74 DX	1.51 kg
H31.021.03.01	50 DX	1.97 DX	1.13 kg
H31.021.03.02	55 SX	2.17 SX	1.13 kg
H31.021.03.03	60 SX	2.36 SX	1.21 kg
H31.021.03.04	65 SX	2.56 SX	1.21 kg
H31.021.03.05	70 SX	2.76 SX	1.21 kg
H31.021.03.06	75 SX	2.95 SX	1.36 kg
H31.021.03.07	80 SX	3.15 SX	1.36 kg
H31.021.03.08	85 SX	3.35 SX	1.36 kg
H31.021.03.09	90 SX	3.54 SX	1.51 kg
H31.021.03.10	95 SX	3.74 SX	1.51 kg

H31.040.1

750 kN/m max.

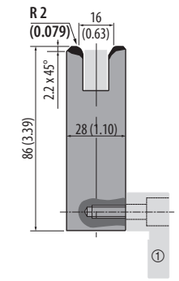


C45: 560-710 N/mm²

Model	Length		Weight
H31.040.11.01	100	3.94	2.66 kg
H31.040.12.01	50 SX	1.97 SX	2.00 kg
H31.040.12.02	55 DX	2.17 DX	2.00 kg
H31.040.12.03	60 DX	2.36 DX	2.13 kg
H31.040.12.04	65 DX	2.56 DX	2.13 kg
H31.040.12.05	70 DX	2.76 DX	2.13 kg
H31.040.12.06	75 DX	2.95 DX	2.39 kg
H31.040.12.07	80 DX	3.15 DX	2.39 kg
H31.040.12.08	85 DX	3.35 DX	2.39 kg
H31.040.12.09	90 DX	3.54 DX	2.66 kg
H31.040.12.10	95 DX	3.74 DX	2.66 kg
H31.040.13.01	50 DX	1.97 DX	2.00 kg
H31.040.13.02	55 SX	2.17 SX	2.00 kg
H31.040.13.03	60 SX	2.36 SX	2.13 kg
H31.040.13.04	65 SX	2.56 SX	2.13 kg
H31.040.13.05	70 SX	2.76 SX	2.13 kg
H31.040.13.06	75 SX	2.95 SX	2.39 kg
H31.040.13.07	80 SX	3.15 SX	2.39 kg
H31.040.13.08	85 SX	3.35 SX	2.39 kg
H31.040.13.09	90 SX	3.54 SX	2.66 kg
H31.040.13.10	95 SX	3.74 SX	2.66 kg

H31.016.0

500 kN/m max.

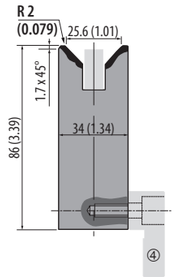


C45: 560-710 N/mm²

Model	Length		Weight
H31.016.01.01	100	3.94	1.51 kg
H31.016.02.01	50 SX	1.97 SX	1.13 kg
H31.016.02.02	55 DX	2.17 DX	1.13 kg
H31.016.02.03	60 DX	2.36 DX	1.21 kg
H31.016.02.04	65 DX	2.56 DX	1.21 kg
H31.016.02.05	70 DX	2.76 DX	1.21 kg
H31.016.02.06	75 DX	2.95 DX	1.36 kg
H31.016.02.07	80 DX	3.15 DX	1.36 kg
H31.016.02.08	85 DX	3.35 DX	1.36 kg
H31.016.02.09	90 DX	3.54 DX	1.51 kg
H31.016.02.10	95 DX	3.74 DX	1.51 kg
H31.016.03.01	50 DX	1.97 DX	1.13 kg
H31.016.03.02	55 SX	2.17 SX	1.13 kg
H31.016.03.03	60 SX	2.36 SX	1.21 kg
H31.016.03.04	65 SX	2.56 SX	1.21 kg
H31.016.03.05	70 SX	2.76 SX	1.21 kg
H31.016.03.06	75 SX	2.95 SX	1.36 kg
H31.016.03.07	80 SX	3.15 SX	1.36 kg
H31.016.03.08	85 SX	3.35 SX	1.36 kg
H31.016.03.09	90 SX	3.54 SX	1.51 kg
H31.016.03.10	95 SX	3.74 SX	1.51 kg

H31.024.0

750 kN/m max.

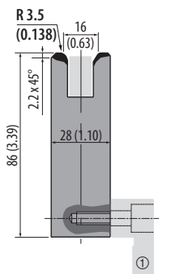


C45: 560-710 N/mm²

Model	Length		Weight
H31.024.01.01	100	3.94	1.81 kg
H31.024.02.01	50 SX	1.97 SX	1.36 kg
H31.024.02.02	55 DX	2.17 DX	1.36 kg
H31.024.02.03	60 DX	2.36 DX	1.45 kg
H31.024.02.04	65 DX	2.56 DX	1.45 kg
H31.024.02.05	70 DX	2.76 DX	1.45 kg
H31.024.02.06	75 DX	2.95 DX	1.63 kg
H31.024.02.07	80 DX	3.15 DX	1.63 kg
H31.024.02.08	85 DX	3.35 DX	1.63 kg
H31.024.02.09	90 DX	3.54 DX	1.81 kg
H31.024.02.10	95 DX	3.74 DX	1.81 kg
H31.024.03.01	50 DX	1.97 DX	1.36 kg
H31.024.03.02	55 SX	2.17 SX	1.36 kg
H31.024.03.03	60 SX	2.36 SX	1.45 kg
H31.024.03.04	65 SX	2.56 SX	1.45 kg
H31.024.03.05	70 SX	2.76 SX	1.45 kg
H31.024.03.06	75 SX	2.95 SX	1.63 kg
H31.024.03.07	80 SX	3.15 SX	1.63 kg
H31.024.03.08	85 SX	3.35 SX	1.63 kg
H31.024.03.09	90 SX	3.54 SX	1.81 kg
H31.024.03.10	95 SX	3.74 SX	1.81 kg

H31.016.1

500 kN/m max.

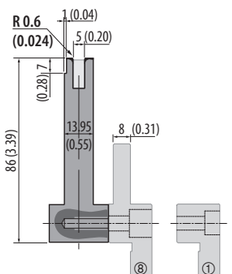


C45: 560-710 N/mm²

Model	Length		Weight
H31.016.11.01	100	3.94	1.55 kg
H31.016.12.01	50 SX	1.97 SX	1.16 kg
H31.016.12.02	55 DX	2.17 DX	1.16 kg
H31.016.12.03	60 DX	2.36 DX	1.24 kg
H31.016.12.04	65 DX	2.56 DX	1.24 kg
H31.016.12.05	70 DX	2.76 DX	1.24 kg
H31.016.12.06	75 DX	2.95 DX	1.40 kg
H31.016.12.07	80 DX	3.15 DX	1.40 kg
H31.016.12.08	85 DX	3.35 DX	1.40 kg
H31.016.12.09	90 DX	3.54 DX	1.55 kg
H31.016.12.10	95 DX	3.74 DX	1.55 kg
H31.016.13.01	50 DX	1.97 DX	1.16 kg
H31.016.13.02	55 SX	2.17 SX	1.16 kg
H31.016.13.03	60 SX	2.36 SX	1.24 kg
H31.016.13.04	65 SX	2.56 SX	1.24 kg
H31.016.13.05	70 SX	2.76 SX	1.24 kg
H31.016.13.06	75 SX	2.95 SX	1.40 kg
H31.016.13.07	80 SX	3.15 SX	1.40 kg
H31.016.13.08	85 SX	3.35 SX	1.40 kg
H31.016.13.09	90 SX	3.54 SX	1.55 kg
H31.016.13.10	95 SX	3.74 SX	1.55 kg

H31.005.0

250 kN/m max.



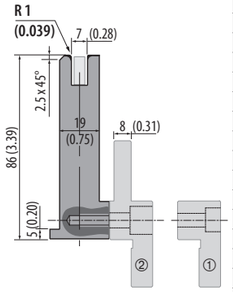
42Cr: 900-1150 N/mm²

Model	Length		Weight
H31.005.01.01	100	3.94	1.07 kg
H31.005.02.01	50 SX	1.97 SX	0.80 kg
H31.005.02.02	55 DX	2.17 DX	0.80 kg
H31.005.02.03	60 DX	2.36 DX	0.86 kg
H31.005.02.04	65 DX	2.56 DX	0.86 kg
H31.005.02.05	70 DX	2.76 DX	0.86 kg
H31.005.02.06	75 DX	2.95 DX	0.96 kg
H31.005.02.07	80 DX	3.15 DX	0.96 kg
H31.005.02.08	85 DX	3.35 DX	0.96 kg
H31.005.02.09	90 DX	3.54 DX	1.07 kg
H31.005.02.10	95 DX	3.74 DX	1.07 kg
H31.005.03.01	50 DX	1.97 DX	0.80 kg
H31.005.03.02	55 SX	2.17 SX	0.80 kg
H31.005.03.03	60 SX	2.36 SX	0.86 kg
H31.005.03.04	65 SX	2.56 SX	0.86 kg
H31.005.03.05	70 SX	2.76 SX	0.86 kg
H31.005.03.06	75 SX	2.95 SX	0.96 kg
H31.005.03.07	80 SX	3.15 SX	0.96 kg
H31.005.03.08	85 SX	3.35 SX	0.96 kg
H31.005.03.09	90 SX	3.54 SX	1.07 kg
H31.005.03.10	95 SX	3.74 SX	1.07 kg

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

H31.007.0

500 kN/m max.

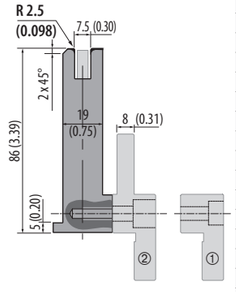


42Cr: 900-1150 N/mm²

Model	Length		Weight
H31.007.01.01	100	3.94	1.24 kg
H31.007.02.01	50 SX	1.97 SX	0.93 kg
H31.007.02.02	55 DX	2.17 DX	0.93 kg
H31.007.02.03	60 DX	2.36 DX	0.99 kg
H31.007.02.04	65 DX	2.56 DX	0.99 kg
H31.007.02.05	70 DX	2.76 DX	0.99 kg
H31.007.02.06	75 DX	2.95 DX	1.12 kg
H31.007.02.07	80 DX	3.15 DX	1.12 kg
H31.007.02.08	85 DX	3.35 DX	1.12 kg
H31.007.02.09	90 DX	3.54 DX	1.24 kg
H31.007.02.10	95 DX	3.74 DX	1.24 kg
H31.007.03.01	50 DX	1.97 DX	0.93 kg
H31.007.03.02	55 SX	2.17 SX	0.93 kg
H31.007.03.03	60 SX	2.36 SX	0.99 kg
H31.007.03.04	65 SX	2.56 SX	0.99 kg
H31.007.03.05	70 SX	2.76 SX	0.99 kg
H31.007.03.06	75 SX	2.95 SX	1.12 kg
H31.007.03.07	80 SX	3.15 SX	1.12 kg
H31.007.03.08	85 SX	3.35 SX	1.12 kg
H31.007.03.09	90 SX	3.54 SX	1.24 kg
H31.007.03.10	95 SX	3.74 SX	1.24 kg

H31.007.2

500 kN/m max.

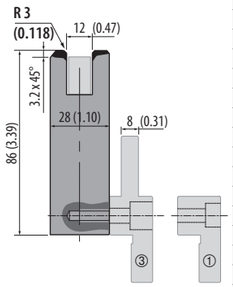


42Cr: 900-1150 N/mm²

Model	Length		Weight
H31.007.21.01	100	3.94	1.23 kg
H31.007.22.01	50 SX	1.97 SX	0.92 kg
H31.007.22.02	55 DX	2.17 DX	0.92 kg
H31.007.22.03	60 DX	2.36 DX	0.98 kg
H31.007.22.04	65 DX	2.56 DX	0.98 kg
H31.007.22.05	70 DX	2.76 DX	0.98 kg
H31.007.22.06	75 DX	2.95 DX	1.11 kg
H31.007.22.07	80 DX	3.15 DX	1.11 kg
H31.007.22.08	85 DX	3.35 DX	1.11 kg
H31.007.22.09	90 DX	3.54 DX	1.23 kg
H31.007.22.10	95 DX	3.74 DX	1.23 kg
H31.007.23.01	50 DX	1.97 DX	0.92 kg
H31.007.23.02	55 SX	2.17 SX	0.92 kg
H31.007.23.03	60 SX	2.36 SX	0.98 kg
H31.007.23.04	65 SX	2.56 SX	0.98 kg
H31.007.23.05	70 SX	2.76 SX	0.98 kg
H31.007.23.06	75 SX	2.95 SX	1.11 kg
H31.007.23.07	80 SX	3.15 SX	1.11 kg
H31.007.23.08	85 SX	3.35 SX	1.11 kg
H31.007.23.09	90 SX	3.54 SX	1.23 kg
H31.007.23.10	95 SX	3.74 SX	1.23 kg

H31.013.0

500 kN/m max.

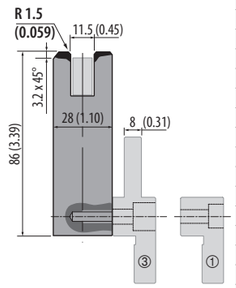


C45: 560-710 N/mm²

Model	Length		Weight
H31.013.01.01	100	3.94	1.77 kg
H31.013.02.01	50 SX	1.97 SX	1.33 kg
H31.013.02.02	55 DX	2.17 DX	1.33 kg
H31.013.02.03	60 DX	2.36 DX	1.42 kg
H31.013.02.04	65 DX	2.56 DX	1.42 kg
H31.013.02.05	70 DX	2.76 DX	1.42 kg
H31.013.02.06	75 DX	2.95 DX	1.59 kg
H31.013.02.07	80 DX	3.15 DX	1.59 kg
H31.013.02.08	85 DX	3.35 DX	1.59 kg
H31.013.02.09	90 DX	3.54 DX	1.77 kg
H31.013.02.10	95 DX	3.74 DX	1.77 kg
H31.013.03.01	50 DX	1.97 DX	1.33 kg
H31.013.03.02	55 SX	2.17 SX	1.33 kg
H31.013.03.03	60 SX	2.36 SX	1.42 kg
H31.013.03.04	65 SX	2.56 SX	1.42 kg
H31.013.03.05	70 SX	2.76 SX	1.42 kg
H31.013.03.06	75 SX	2.95 SX	1.59 kg
H31.013.03.07	80 SX	3.15 SX	1.59 kg
H31.013.03.08	85 SX	3.35 SX	1.59 kg
H31.013.03.09	90 SX	3.54 SX	1.77 kg
H31.013.03.10	95 SX	3.74 SX	1.77 kg

H31.012.0

500 kN/m max.

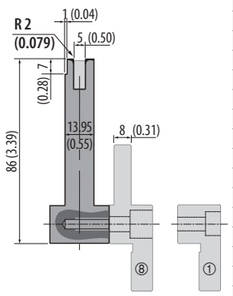


C45: 560-710 N/mm²

Model	Length		Weight
H31.012.01.01	100	3.94	1.76 kg
H31.012.02.01	50 SX	1.97 SX	1.32 kg
H31.012.02.02	55 DX	2.17 DX	1.32 kg
H31.012.02.03	60 DX	2.36 DX	1.41 kg
H31.012.02.04	65 DX	2.56 DX	1.41 kg
H31.012.02.05	70 DX	2.76 DX	1.41 kg
H31.012.02.06	75 DX	2.95 DX	1.58 kg
H31.012.02.07	80 DX	3.15 DX	1.58 kg
H31.012.02.08	85 DX	3.35 DX	1.58 kg
H31.012.02.09	90 DX	3.54 DX	1.76 kg
H31.012.02.10	95 DX	3.74 DX	1.76 kg
H31.012.03.01	50 DX	1.97 DX	1.32 kg
H31.012.03.02	55 SX	2.17 SX	1.32 kg
H31.012.03.03	60 SX	2.36 SX	1.41 kg
H31.012.03.04	65 SX	2.56 SX	1.41 kg
H31.012.03.05	70 SX	2.76 SX	1.41 kg
H31.012.03.06	75 SX	2.95 SX	1.58 kg
H31.012.03.07	80 SX	3.15 SX	1.58 kg
H31.012.03.08	85 SX	3.35 SX	1.58 kg
H31.012.03.09	90 SX	3.54 SX	1.76 kg
H31.012.03.10	95 SX	3.74 SX	1.76 kg

H31.006.0

350 kN/m max.

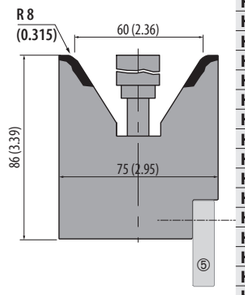


42Cr: 900-1150 N/mm²

Model	Length		Weight
H31.006.01.01	100	3.94	1.08 kg
H31.006.02.01	50 SX	1.97 SX	0.81 kg
H31.006.02.02	55 DX	2.17 DX	0.81 kg
H31.006.02.03	60 DX	2.36 DX	0.86 kg
H31.006.02.04	65 DX	2.56 DX	0.86 kg
H31.006.02.05	70 DX	2.76 DX	0.86 kg
H31.006.02.06	75 DX	2.95 DX	0.97 kg
H31.006.02.07	80 DX	3.15 DX	0.97 kg
H31.006.02.08	85 DX	3.35 DX	0.97 kg
H31.006.02.09	90 DX	3.54 DX	1.08 kg
H31.006.02.10	95 DX	3.74 DX	1.08 kg
H31.006.03.01	50 DX	1.97 DX	0.81 kg
H31.006.03.02	55 SX	2.17 SX	0.81 kg
H31.006.03.03	60 SX	2.36 SX	0.86 kg
H31.006.03.04	65 SX	2.56 SX	0.86 kg
H31.006.03.05	70 SX	2.76 SX	0.86 kg
H31.006.03.06	75 SX	2.95 SX	0.97 kg
H31.006.03.07	80 SX	3.15 SX	0.97 kg
H31.006.03.08	85 SX	3.35 SX	0.97 kg
H31.006.03.09	90 SX	3.54 SX	1.08 kg
H31.006.03.10	95 SX	3.74 SX	1.08 kg

H31.060.0

1500 kN/m max.



C45: 560-710 N/mm²

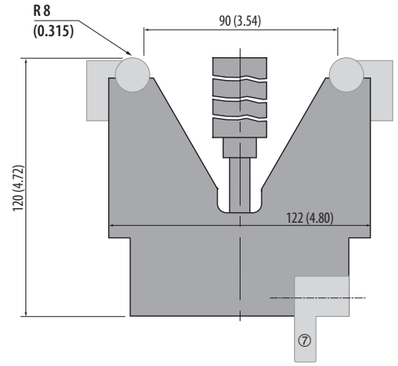
Model	Length		Weight
H31.060.01.01	100	3.94	3.76 kg
H31.060.02.01	50 SX	1.97 SX	2.82 kg
H31.060.02.02	55 DX	2.17 DX	2.82 kg
H31.060.02.03	60 DX	2.36 DX	3.01 kg
H31.060.02.04	65 DX	2.56 DX	3.01 kg
H31.060.02.05	70 DX	2.76 DX	3.01 kg
H31.060.02.06	75 DX	2.95 DX	3.38 kg
H31.060.02.07	80 DX	3.15 DX	3.38 kg
H31.060.02.08	85 DX	3.35 DX	3.38 kg
H31.060.02.09	90 DX	3.54 DX	3.76 kg
H31.060.02.10	95 DX	3.74 DX	3.76 kg
H31.060.03.01	50 DX	1.97 DX	2.82 kg
H31.060.03.02	55 SX	2.17 SX	2.82 kg
H31.060.03.03	60 SX	2.36 SX	3.01 kg
H31.060.03.04	65 SX	2.56 SX	3.01 kg
H31.060.03.05	70 SX	2.76 SX	3.01 kg
H31.060.03.06	75 SX	2.95 SX	3.38 kg
H31.060.03.07	80 SX	3.15 SX	3.38 kg
H31.060.03.08	85 SX	3.35 SX	3.38 kg
H31.060.03.09	90 SX	3.54 SX	3.76 kg
H31.060.03.10	95 SX	3.74 SX	3.76 kg

RX ROLLERI TYPE RX
Dies Hämmerle-Bystronic

ROLLERI® PROFESSIONAL BENDING

H31.090.01.01

1500 kN/m max.

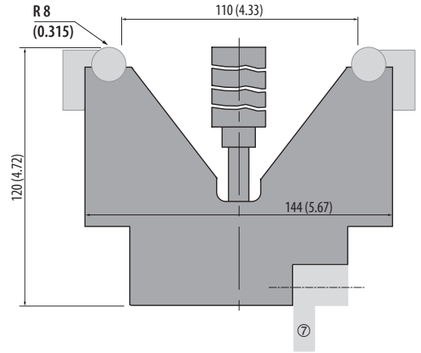


Model	Length		Weight
H31.090.01.01	100	3.94	8.15 kg

C45: 560-710 N/mm²

H31.110.01.01

1500 kN/m max.



Model	Length		Weight
H31.110.01.01	100	3.94	8.83 kg

C45: 560-710 N/mm²

7 RX

Article on stock

Please ask for delivery time!

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

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

ROLLERI®

ROLLERI **DIES ROLLA-V**

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Model 2.5	193
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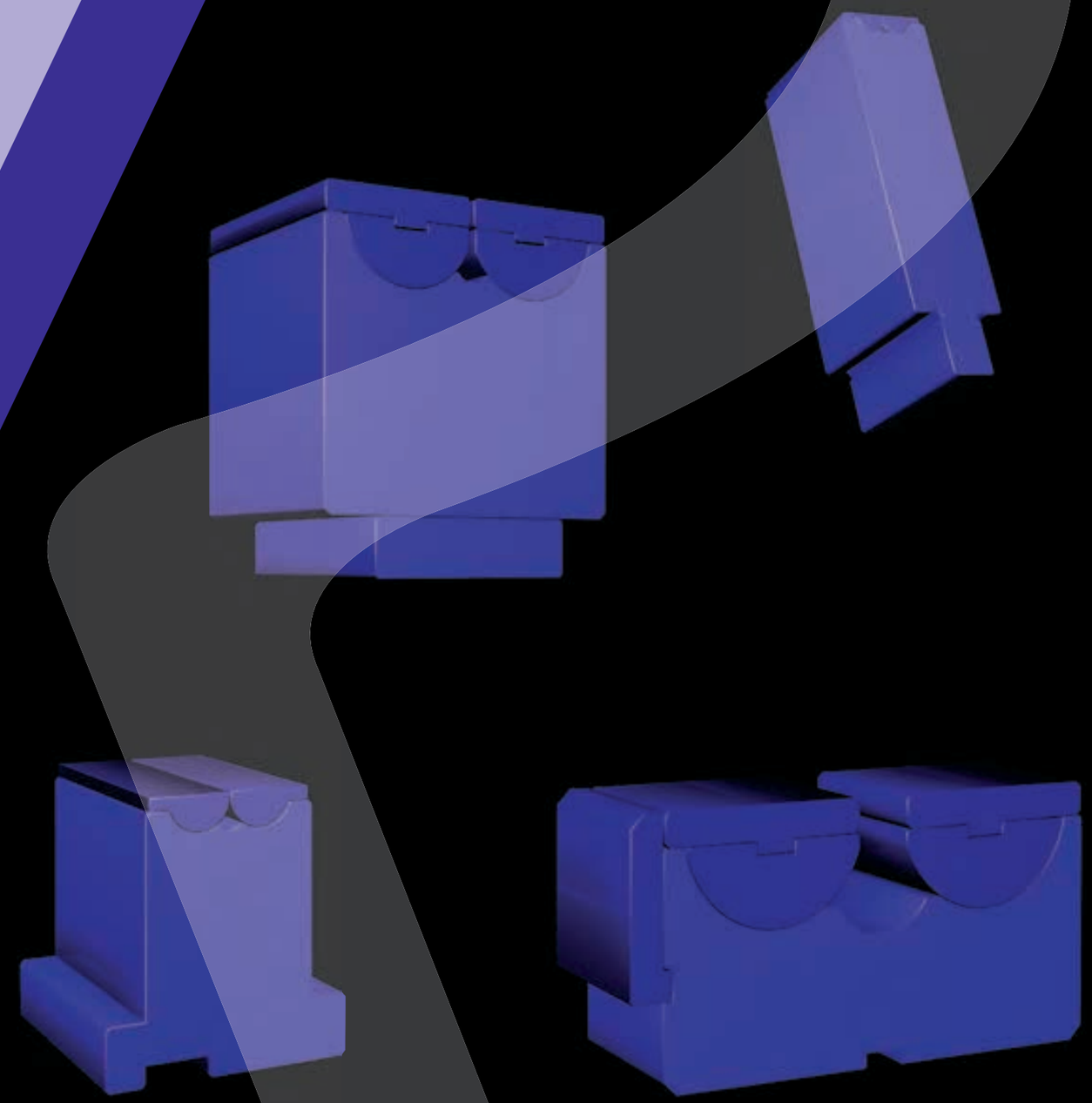
Hemming- and Joggle Tools	195



Compatibility

- **RVP Dies (Models 1, 2, 3)** are **compatible** with press brake machines (60 mm / 2.36 in die holder) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- **RVS Dies (Models 1, 2, 3)** are **compatible** with press brake machines (14 mm / 0.55 in pins) from: Amada Single V style
- **RVT Dies (Models 1, 2, 3)** are **compatible** with press brake machines (12.7 mm / 0.50 in / 13 mm / 0.51 in pins) from: Bystronic, Hämmerle, Beyeler, Edwards, Safan, SMD, Trumpf
- **RVT90 Dies (Models 1, 2, 3)** are **compatible** with press brakes machines (12.7 mm / 0.50 in pins) from: LVD
- **RVM Dies (Models 2.5, 3, 4)** are **compatible** with all press brake machines (various die holders)
- all dies are compatible on other press brakes machines with the means of adapter-systems or customized die holders.

Our Advantages – Your Convenience

- high precision grounded
- Interchangability guaranteed
- exact Parallelism
- avoiding bending marks on the sheet metals
- minimum borders bending mark free
- no tool contamination throughout the bending of galvanized sheet metal or aluminum
- extremely short flanges
- less tool exchange
- ideal for diagonal or tapered edges

Material

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

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4	1100-1200 N/mm²	50 - 55 HRC
Inserts	1	Toolox 44	1450 N/mm²	through hardened 44 HRC
Inserts	2 / 2.5 / 3 / 4	Toolox 33	1100 N/mm²	55 - 58 HRC

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

	Equivalent V size mm (in)	Material Thickness mm (in)		min. outside flange mm (in)		needed press force (kN)	max. tool load (kN/m)	min. bending angle
Model 1 Max. recommended thickness =1.5 mm (0.06 in) (2.0 mm / 0.08 in possible)	8 (0.31)	0.70	(0.03)	3.0	(0.12)	60	1000	40°
		1.10	(0.04)	3.9	(0.15)	110	1000	35°
		1.50	(0.06)	4.2	(0.17)	260	1000	35°
Model 2 Max. recommended thickness =3.0 mm (0.12 in) (4.0 mm / 0.15 in possible)	15 (0.59)	2.00	(0.08)	8.5	(0.33)	200	1500	59°
		3.00	(0.12)	9.3	(0.37)	460	1500	46°
		3.20	(0.13)	9.3	(0.37)	550	1500	47°
Model 2.5 Max. recommended thickness =5.0 mm (0.20 in) (6.35 mm / 0.24 in possible)	28 (1.10)	3.00	(0.12)	18.7	(0.74)	230	2000	67°
		4.00	(0.16)	18.7	(0.74)	450	2000	60°
		5.00	(0.20)	18.7	(0.74)	770	2000	57°
		6.00	(0.24)	18.7	(0.74)	1200	2000	51°
Model 3 Max. recommended thickness =6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)	38 (1.50)	4.00	(0.16)	22.5	(0.89)	270	2500	47°
		6.00	(0.24)	22.5	(0.89)	800	2500	50°

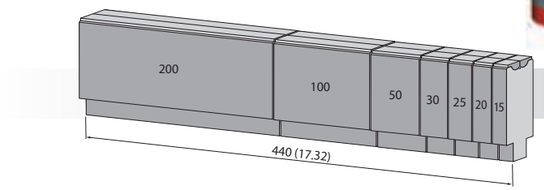
Tool lengths and sectioning

Standard

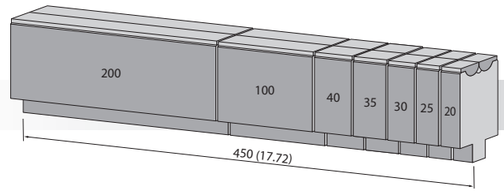
Segmented tools are delivered in complete sets. Single pieces are also available!
More lengths and sectionings are possible upon request.

500 mm (19.68 in)

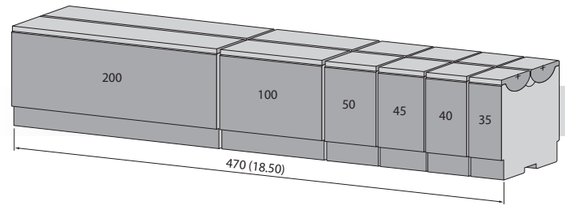
200 mm (7.87 in)



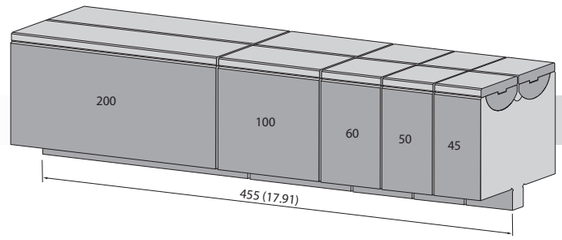
Model 1, 440 mm (17.32 in) segmented
(7 segments)



Model 2, 450 mm (17.72 in) segmented
(7 segments)



Model 2.5, 470 mm (18.50 in) segmented
(6 segments)



Model 3, 455 mm (17.91 in) segmented
(5 segments)

8

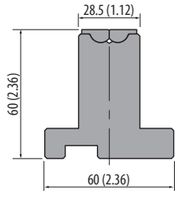
Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

Model 1

RVP60-1

1000 kN/m max.

NEW



500 mm	16.68 in	6.9 kg
440 mm segmented	17.32 in segmented	6.1 kg

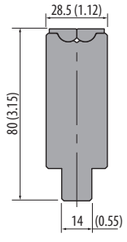
42Cr: 1100-1200 N/mm²

on stock

RVS80-1

1000 kN/m max.

NEW



500 mm	16.68 in	6.3 kg
440 mm segmented	17.32 in segmented	5.8 kg

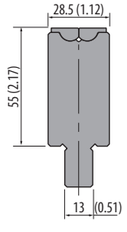
42Cr: 1100-1200 N/mm²

on stock

RVT55-1

1000 kN/m max.

NEW



500 mm	16.68 in	5.5 kg
440 mm segmented	17.32 in segmented	5.0 kg

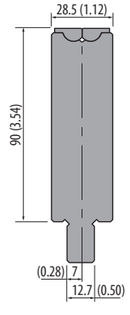
42Cr: 1100-1200 N/mm²

on stock

RVT90-1

1000 kN/m max.

NEW



500 mm	16.68 in	8.5 kg
440 mm segmented	17.32 in segmented	7.8 kg

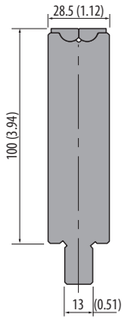
42Cr: 1100-1200 N/mm²

on stock

RVT100-1

1000 kN/m max.

NEW



500 mm	16.68 in	9.4 kg
440 mm segmented	17.32 in segmented	8.6 kg

42Cr: 1100-1200 N/mm²

on stock

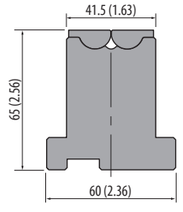
ROLLERI® PROFESSIONAL BENDING

Model 2

RVP65-2

1500 kN/m max.

NEW



500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

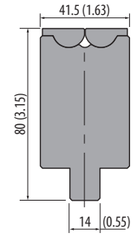
42Cr: 1100-1200 N/mm²

on stock

RVS80-2

1500 kN/m max.

NEW



500 mm	16.68 in	8.3 kg
450 mm segmented	17.72 in segmented	7.8 kg

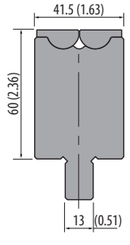
42Cr: 1100-1200 N/mm²

on stock

RVT60-2

1500 kN/m max.

NEW



500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

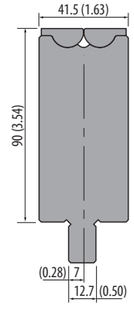
42Cr: 1100-1200 N/mm²

on stock

RVT90-2

1500 kN/m max.

NEW



500 mm	16.68 in	11.3 kg
450 mm segmented	17.72 in segmented	10.6 kg

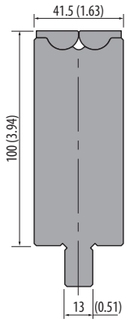
42Cr: 1100-1200 N/mm²

on stock

RVT100-2

1500 kN/m max.

NEW



500 mm	16.68 in	12.4 kg
450 mm segmented	17.72 in segmented	11.7 kg

42Cr: 1100-1200 N/mm²

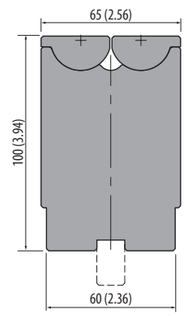
on stock

Model 2.5

RVM2.5

2000 kN/m max.

NEW



500 mm	16.68 in	22.0 kg
470 mm segmented	18.50 in segmented	21.0 kg

42Cr: 1100-1200 N/mm²

on stock

Rolleri Videos

Use and application of Rolla-V dies
www.rolleritools.com/videos/rolla-v

8

on stock Article on stock

Please ask for delivery time!

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

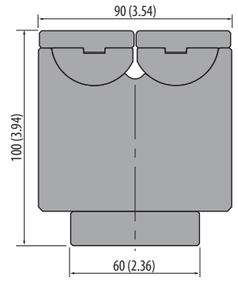
Articles on stock – Please note that delivery time depends on your location.

Model 3

RVP100-3

2500 kN/m max.

NEW



500 mm	16.68 in	28.8 kg
455 mm segmented	17.91 in segmented	26.2 kg

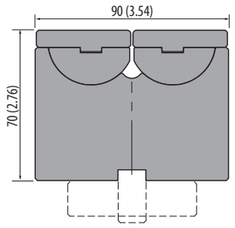
42Cr: 1100-1200 N/mm²

on stock

RVM70-3

2500 kN/m max.

NEW



500 mm	16.68 in	20.6 kg
455 mm segmented	17.91 in segmented	18.7 kg

42Cr: 1100-1200 N/mm²

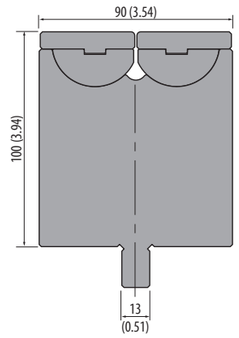
on stock

Possible Die Holders:
- 60 mm (2.36 in)
- 13 mm (0.51 in) pin
- 12.7 mm (0.50 in) pin
- 12.8 mm (0.50 in) offset pin

RVT100-3

2500 kN/m max.

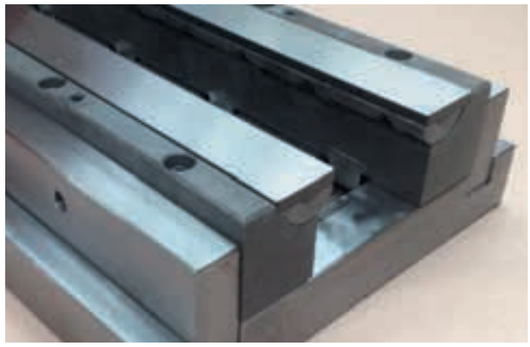
NEW



500 mm	16.68 in	30.9 kg
455 mm segmented	17.91 in segmented	28.5 kg

42Cr: 1100-1200 N/mm²

on stock



Model 4

Our Advantages – Your Convenience

The **model 4 tools** and the **adjustable dies** are for bending thick material and large radii. Material specifications vary greatly, therefore no specific data can be given.

- Minimum borders are highly dependant on the squareness of the component.
- Enlargement and hole distortion will be greatly reduced, however will be influenced depending on the type of material
- Radius bending is strongly influenced by the elastic return of specific material and flange-size.

For advice please contact us!

RVM90-4

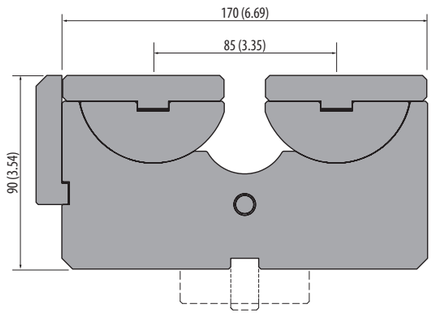
3000 kN/m max.

NEW

500 mm	16.68 in	56.6 kg
200 mm	7.87 in	22.7 kg

42Cr: 1100-1200 N/mm²

on stock



Possible Die Holders:
- 60 mm (2.36 in)
- 13 mm (0.51 in) pin
- 12.7 mm (0.50 in) pin
- 12.8 mm (0.50 in) offset pin

ROLLERI® PROFESSIONAL BENDING

Adjustable Dies

Our advantages – Your Convenience

- bending possible up to the thickness of 30 mm (1.18 in)
- inserts hardened
- no bending marks
- adjustable openings
  RVPV3 = 39-94 mm (1.54-3.70 in)
  RVHD3 = 39-118 mm (1.54-4.65 in)
  RVPV4 = 69-180 mm (2.72-7.09 in)
- bends laser-cut sheet metal without damaging the tool
- exact inner radius

RVPV3

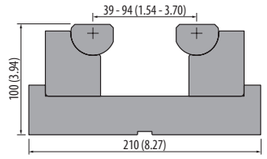
2500 kN/m max.

NEW

42Cr: 1100-1200 N/mm²

on stock

500 mm	16.68 in	50.0 kg
200 mm	7.87 in	20.0 kg



RVHD3

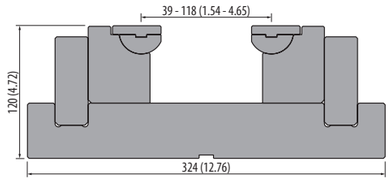
3500 kN/m max.

NEW

42Cr: 1100-1200 N/mm²

on stock

500 mm	16.68 in	98.0 kg
200 mm	7.87 in	38.1 kg



RVHD4

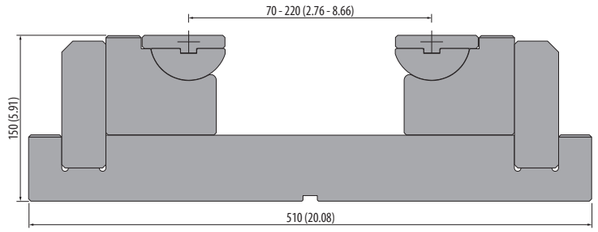
4000 kN/m max.

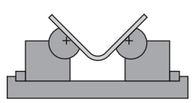
NEW

42Cr: 1100-1200 N/mm²

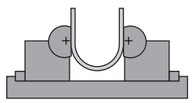
on stock

500 mm	16.68 in	200.0 kg
200 mm	7.87 in	80.0 kg

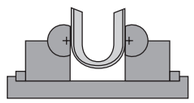




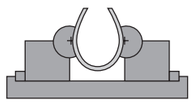
- V-Bending
- flat inserts



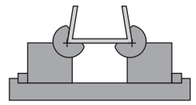
- Radius-Bending
- flat inserts



- Conical Bending
- flat inserts



- Radius-Overbending
- concave inserts

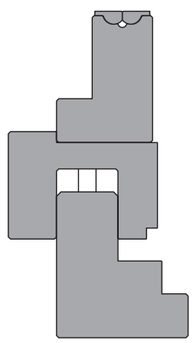


- U-Bending
- V-inserts

Hemming- and Z-Tools

Hemming Tool

NEW



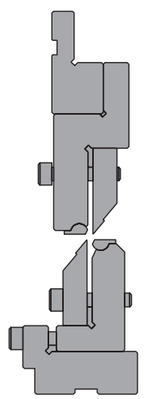
per piece	Price upon request

Production according to your specifications

42Cr: 1100-1200 N/mm²

Joggle Tool

NEW



per piece	Price upon request

Production according to your specifications

42Cr: 1100-1200 N/mm²

on stock Article on stock

Please ask for delivery time!

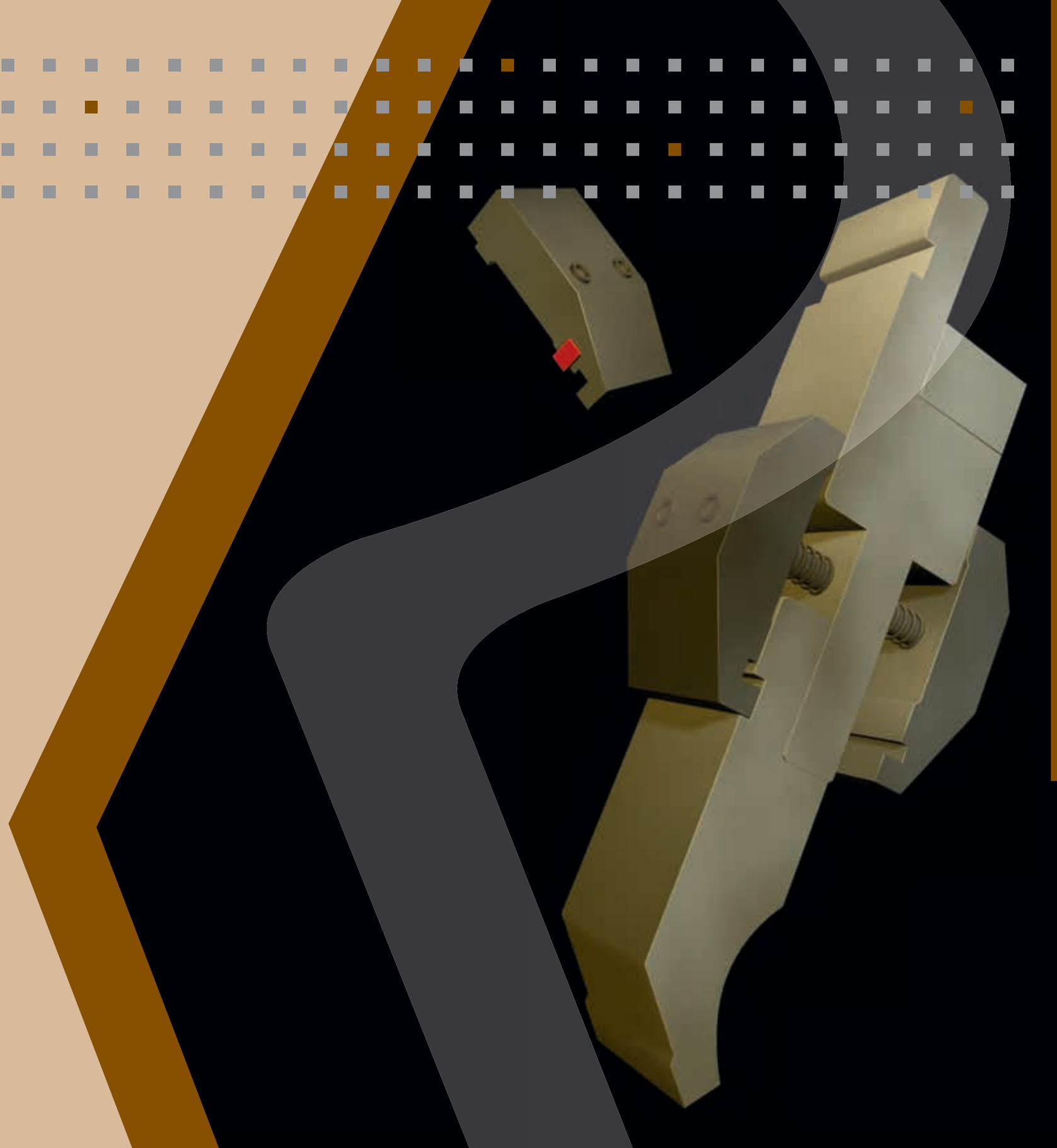
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

ROLLERI®

ROLLERI **CLAMPING SYSTEMS**

Content Explanation	198
Intermediates	199
Clamps	200 - 201
ROL100-System for Punches Rolleri Type R1	202 - 203
ROL1-System for Punches Rolleri Type R1	204 - 205
ROL4-System for Punches Rolleri Type R1	205
W-ROL PN-System for Punches Rolleri Type R2	206
ROL3-System for Punches Rolleri Type R3 and RX	207
ROL2-System for Dies Rolleri Type R1	208 - 209
Movable Die Clamps for Dies Rolleri Type R1	209

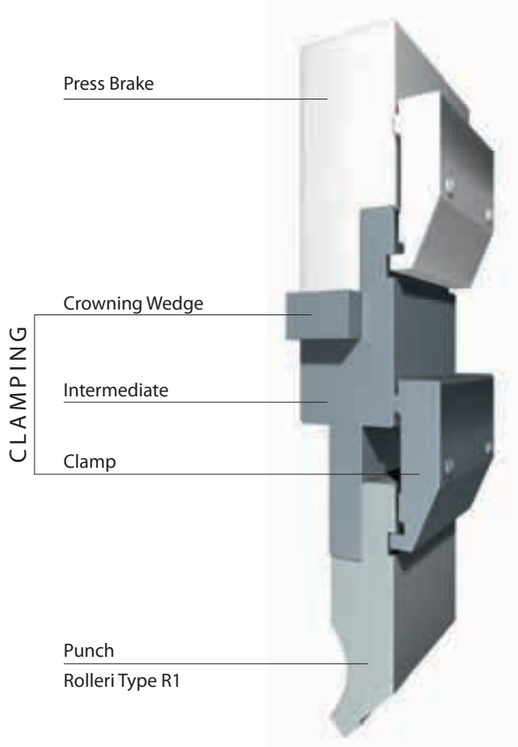


Content Explanation

Standard-Clamping

horizontal

- for **Punches Rolleri Type R1**
- made of: Tensioning device + intermediate
- dual sided clamping (KDS-System)
- **horizontal tool exchange**
- see pages 199-201



ROL100 Clamping

NEW

vertical

- for **Punches Rolleri Type R1**
- **vertical tool exchange**
- can be used **without modifying** Punches Rolleri Type R1
- safety guard
- including selectable intermediates
- manual and pneumatic models available
- see pages 202-203

ROL1 Clamping

vertical

- for **Punches Rolleri Type R1**
- **vertical tool exchange**
- **modification necessary:** Punches Rolleri Type R1 are equipped with spring-loaded balls
- safety guard
- including selectable intermediates
- manual, pneumatic and hydraulic models available
- dual sided clamping (KDS-System)
- see pages 204-205

ROL4 Clamping

horizontal

- for **Punches Rolleri Type R1**
- **horizontal tool exchange**
- can be used **without modifying** Punches Rolleri Type R1
- safety guard
- including selectable intermediates
- manual and hydraulic models available
- dual sided clamping integrated
- see page 205

W-ROL PN Clamping

vertical horizontal

- for **Punches Rolleri Type R2**
- **vertical tool exchange** with ROL1-System and QuickLock-System
- Punches with Safety-Pins are inserted **horizontal**
- safety guard
- pneumatic model available only
- see page 206

ROL3 Clamping

vertical horizontal

- for **Punches Rolleri Type R3/RX**
- **vertical or horizontal tool exchange**
- custom manufacturing
- safety guard
- hydraulic model available only
- see page 207

ROL2 Clamping

- for **Dies Rolleri Type R1**
- manual, pneumatic and hydraulic models available
- see pages 208-209

Movable Die Clamps

- for **Dies Rolleri Type R1**
- manual model available only
- see page 209

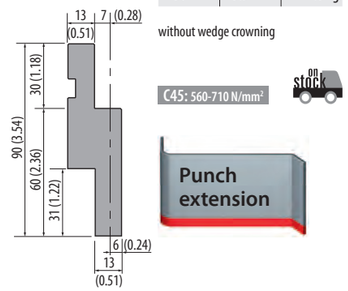
Intermediates

ROLLERI® PROFESSIONAL BENDING

AD4

1000 kN/m max.

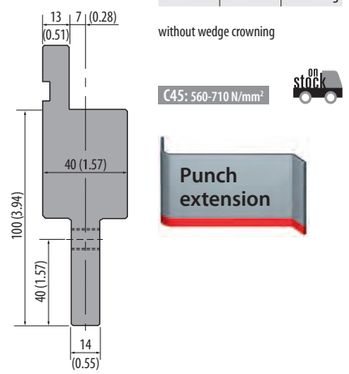
150 mm	5.91 in	1.8 kg



INT100 FISSO

1000 kN/m max.

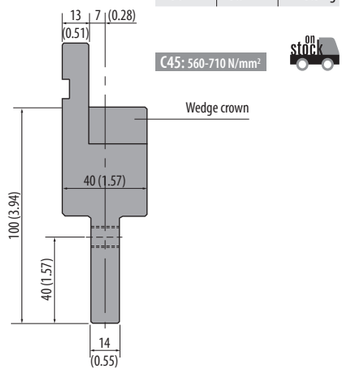
150 mm	5.91 in	4.0 kg



INT100

1000 kN/m max.

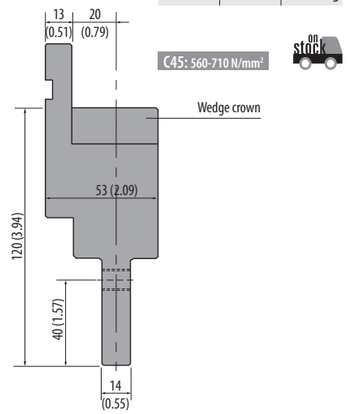
150 mm	5.91 in	3.5 kg



INT120-40

1000 kN/m max.

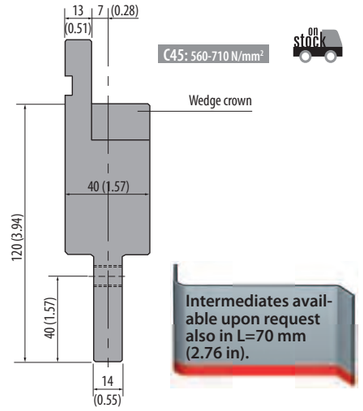
150 mm	5.91 in	5.2 kg



INT120

1000 kN/m max.

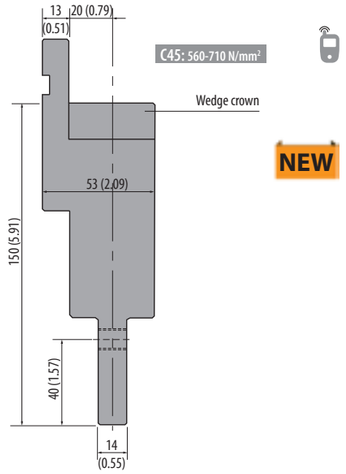
150 mm	5.91 in	4.5 kg



INT150-40

1000 kN/m max.

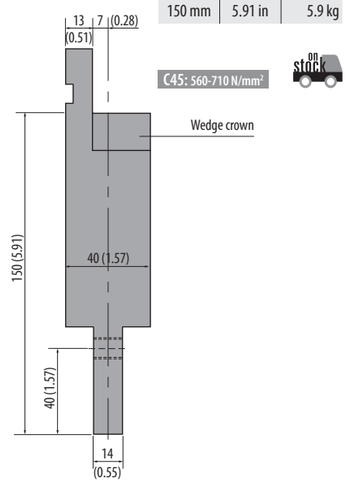
150 mm	5.91 in	8.0 kg



INT150

1000 kN/m max.

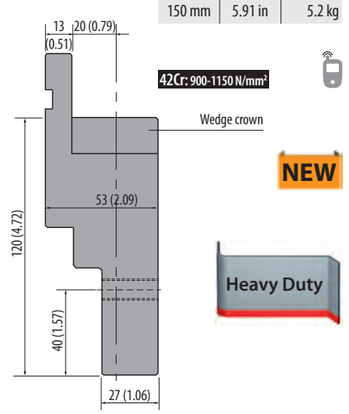
150 mm	5.91 in	5.9 kg



INT120-40-HD

1600 kN/m max.

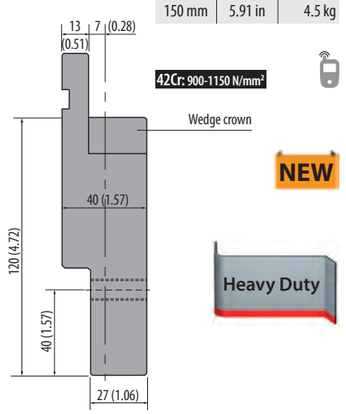
150 mm	5.91 in	5.2 kg



INT120-HD

1600 kN/m max.

150 mm	5.91 in	4.5 kg



9

on stock — Article on stock

Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (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

- **Rapid Clamping Systems** allow a fast horizontal tool exchange
- **Plastic Pressure Strip** improves the clamping especially with short tool pieces.

needed clamps	Length of press brake
4 pieces	835 mm (32.87 in)
6 pieces	1250 mm (49.21 in)
11 pieces	2100 mm (82.68 in)
14 pieces	2600 mm (102.36 in)
16 pieces	3100 mm (122.05 in)
21 pieces	4100 mm (161.42 in)

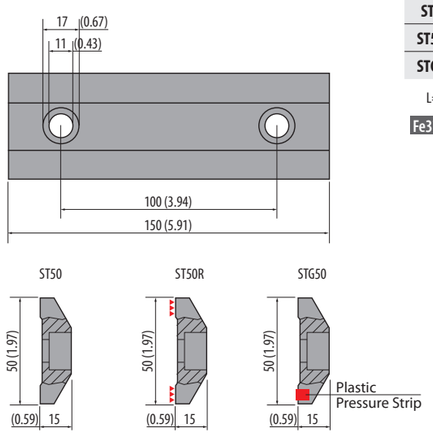
ST50 / ST50R / STG50

ST50	0.70 kg
ST50R	0.50 kg
STG50	0.70 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²

on stock



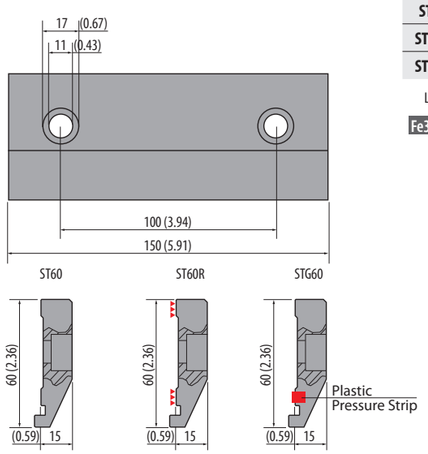
ST60 / ST60R / STG60

ST60	0.80 kg
ST60R	0.85 kg
STG60	0.80 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²

on stock



Compatible Intermediates on page 199

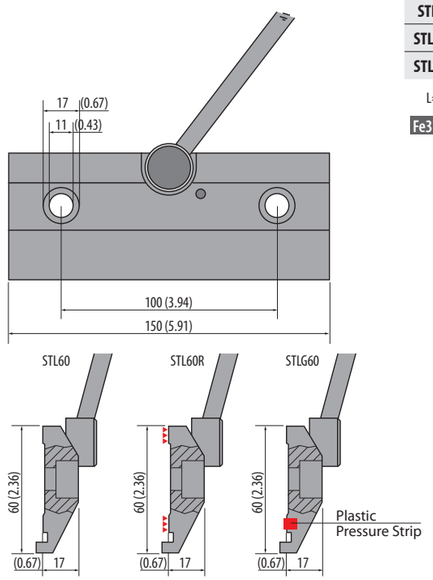
STL60 / STL60R / STLG60

STL60	1.00 kg
STL60R	0.80 kg
STLG60	1.00 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm²

on stock



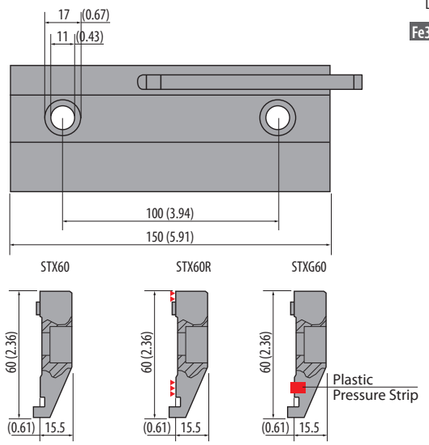
STX60 / STX60R / STXG60

STX60	0.85 kg
STX60R	0.50 kg
STXG60	1.00 kg

L=150 mm (5.91 in)

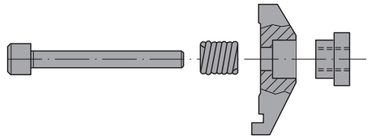
Fe37: 370-470 N/mm²

on stock



KDS

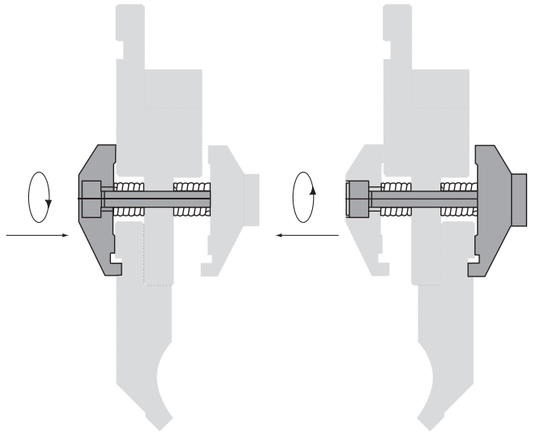
per piece	0.5 kg

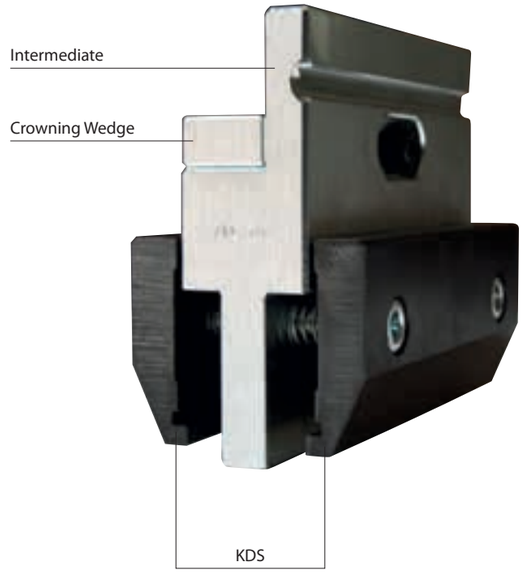


includes a tensioning device without intermediates

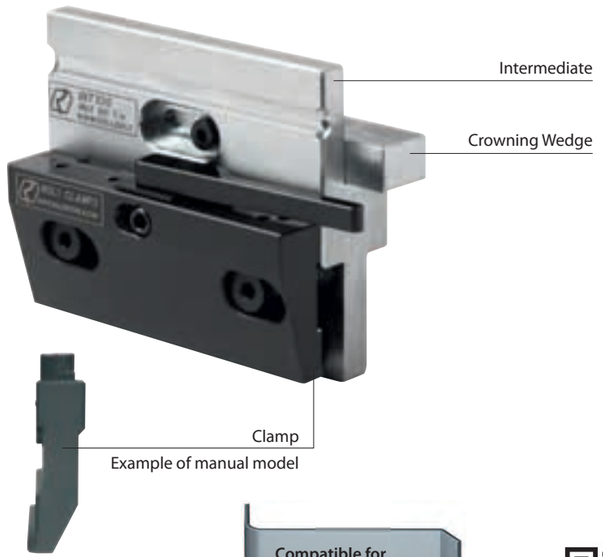
Fe37: 370-470 N/mm²

on stock





ROL1 CLAMP3 – manual – hydraulic – pneumatic



horizontal

Model	with Intermediate
ROL1 CLAMP3 manual	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

ROL1 CLAMP3 manual
without Intermediate

horizontal

Model	with Intermediate
ROL1 CLAMP3 hydraulic	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

horizontal

Model	with Intermediate
ROL1 CLAMP3 pneumatic	INT120
	INT150

on stock

L=150 mm (5.91 in)
horizontal tool exchange
including selectable intermediates

Compatible for Standard Punches Rolleri Type R1

Rolleri Videos

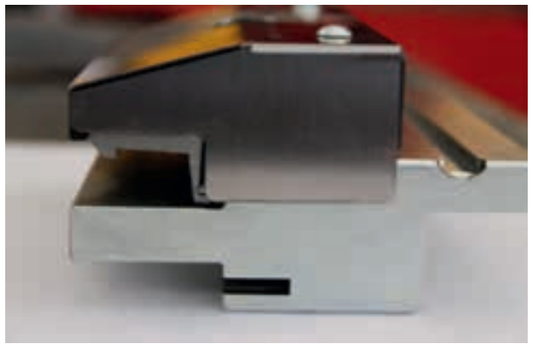
Application of Clamping System ROL1 CLAMP3: **www.rolleritools.com/videos/rol1-clamp3**

9

on stock Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

… the newest innovation from our Research and Development Department

- fast **vertical** tool exchange for all Punches Rolleri Type R1
- can be used without modifying Punches Rolleri Type R1
- safe and fast tool exchange
- significant savings on your setup costs
- no falling out of tools
- available in manual and pneumatic models
- Mounting:
  Simply from the bottom into the housing, tighten – DONE!
- Disassembly:
  Untighten, gently lift tool and remove downwards.
- Easy to mount on your press brake.
  A conversion of the press brake is not necessary.
- For Press Brake Machines and Punches Rolleri Type R1:
  (ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.)



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

ROLLERI® PROFESSIONAL BENDING

ROL100 – manual

NEW

Model	with Intermediate
ROL100 manual	INT100
	INT120
	INT150
	INT100 FISSO

vertical

L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates

on stock

The ROL100-System is suited for Standard-Punches. There are no modifications necessary!

ROL100 – pneumatic

NEW

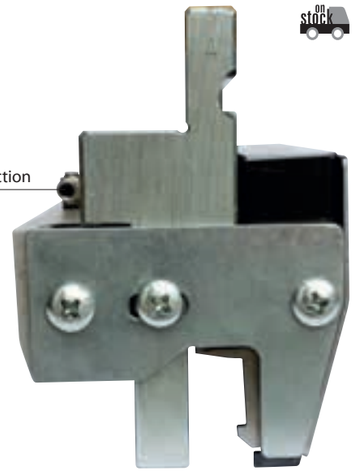
Model	with Intermediate
ROL100 pneumatic	INT100
	INT120
	INT150
	INT100 FISSO

vertical

L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates

on stock

Pneumatic connection



9

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (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

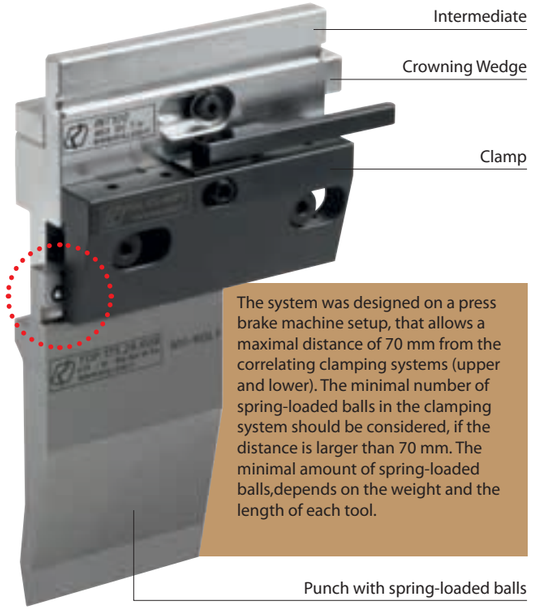
ROL1-System for Punches Rolleri Type R1

In order to use the ROL1 System, the punches are modified and equipped with spring-loaded balls.

ROL1 can be used on all press brakes with standard tang intermediates of Rolleri Type R1.

Our Advantages – Your Convenience

- **vertical clamping** of tools is possible on press brakes thanks to a row of **spring-loaded balls** which are also used as **safety guards** to prevent the falling out of tools.
- complete mechanic functioning fast clamping system for press brake machines.
- Productivity and Versatility of the press brake machines will be increased.
- Significant **reduction in the set-up times** when changing tools



The system was designed on a press brake machine setup, that allows a maximal distance of 70 mm from the correlating clamping systems (upper and lower). The minimal number of spring-loaded balls in the clamping system should be considered, if the distance is larger than 70 mm. The minimal amount of spring-loaded balls,depends on the weight and the length of each tool.

ROL1 CLAMP1 – manual

Model	with Intermediate
ROL1 CLAMP1	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates

vertical

on stock

ROL1 CLAMP1
without Intermediate

ROL1 PN CLAMP1 – pneumatic

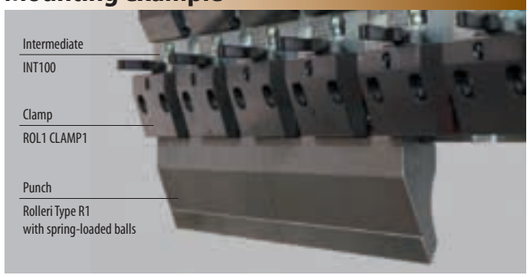
Model	with Intermediate
ROL1 PN CLAMP1	INT120
	INT150

L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates

vertical

on stock

Mounting example



Rolleri Videos

Application of Clamping Systems
ROL1 CLAMP1: **www.rolleritools.com/videos/rol1-clamp1**

R1 ROLLERI CLAMPING SYSTEMS

ROL1-System for Punches Rolleri Type R1

ROLLERI® PROFESSIONAL BENDING

ROL1 HYD CLAMP1 – hydraulic

Model	with Intermediate
ROL1 HYD CLAMP1	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates

vertical

on stock

ROL1 KDS

Model	with Intermediate		
ROL1 KDS	INT100	with Clamp1	with Clamp3
	INT120		
	INT150		
	INT100 FISSO		
	INT120-40		

L=150 mm
vertical tool exchange
including selectable intermediates

on stock

vertical horizontal

Detailed information about intermediates on page 199

ROL4-System for Punches Rolleri Type R1

ROL4 – manual

Model	with Intermediate
ROL4 manual	INT100
	INT120
	INT150
	INT100 FISSO

L=150 mm (5.91 in)
horizontal tool exchange
including selectable intermediates
integrated KDS-System

horizontal

on stock

ROL4 – hydraulic

Model	with Intermediate
ROL4 hydraulic	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

L=150 mm (5.91 in)
horizontal tool exchange
including selectable intermediates
integrated KDS-System

horizontal

on stock

The ROL4-System is suitable for Standard-Punches Rolleri Type R1. There are no modifications necessary!

Rolleri Videos

Application of hydraulic clamping ROL4
www.rolleritools.com/videos/rol4-hydraulic-clamping

9

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

R2 ROLLERI CLAMPING SYSTEMS

W-ROL PN for Punches Rolleri Type R2

W-ROL PN – pneumatic

515 mm	20.28 in	26.8 kg/m

L=515 mm

vertical

Our Advantages – Your Convenience

- vertical tool exchange of punches with:
  - ROL1-System
  - QuickLock-System
- Horizontal tool exchange of punches with safety pins
- significanly more efficient bending productivity

R3/RX ROLLERI CLAMPING SYSTEMS

ROL3-System for Punches Rolleri Type R3 and RX

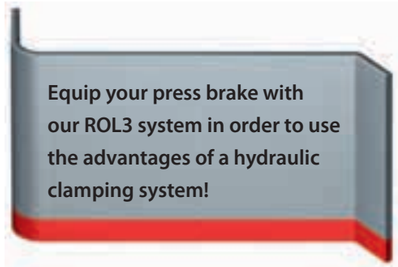
ROL3 HYD – hydraulic

500 mm	19.68 in

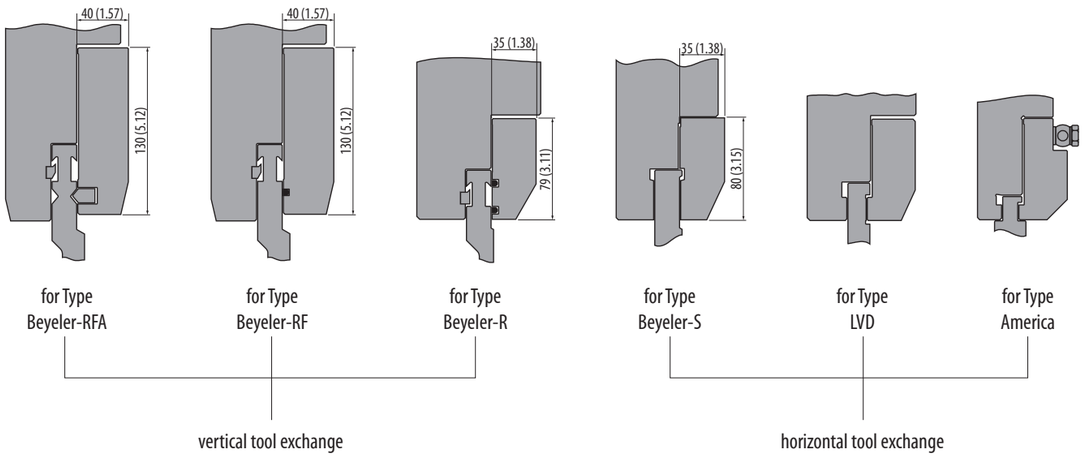
vertical horizontal

Our Advantages – Your Convenience

- can be used on press brake machines with different tang types
- custom manufacturing possible upon request
- significantly more efficient bending productivity



Examples of ROL3 with various systems



9

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

ROL2-System for Dies Rolleri Type R1

Explanations

The **ROL2 System** is a system which is used to secure the die into place. It is made up of a special bar (known as **ROL2 CLAMP1**, L=500 mm / 19.68 in), which is operated through a centralized lever.

The **ROL2 System** has a built in spring mechanism and the clamp plates **ROL2 CLAMP1** are positioned in the inner lining of the system, which can be opened or tightened for the die to be perfectly secured.

A special rubber insert inside the clamp plates grants the best positioning for the tools. The press force of the clamp plates is evenly distribuited along the complete length. Therefore short tools are also securely fastened.

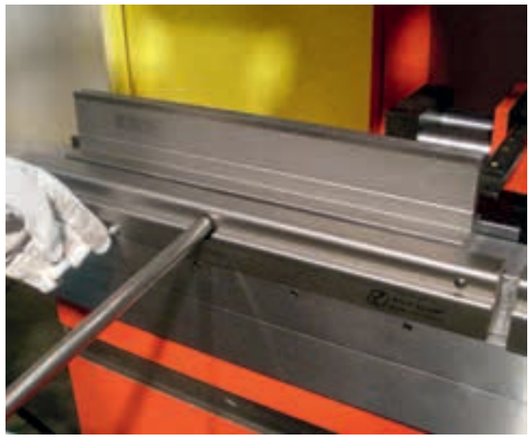
At a press brake of 3 meters (118.11 in), for example; all dies are secured with 6 simple hand movements.

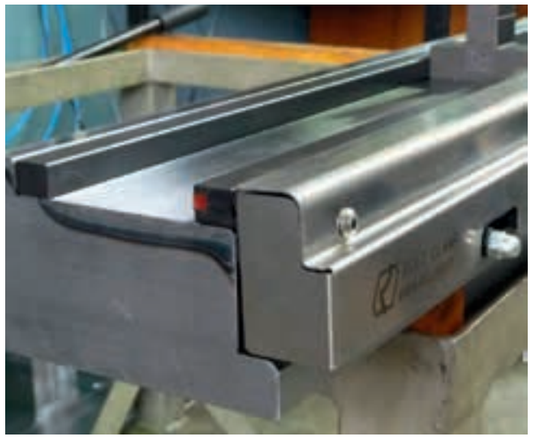
Application

- **Directly on the die holder with 60 mm / 2.36 in width**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - alternatively modifications of the existing threaded holes necessary
  - system is compatible for press brakes with automatic cowing tables
- **Directly on the die holder with 90 mm / 3.54 in width**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - altertively modifications of the existing threaded holes necessary
  - for the use of dies Rolleri Type R1, two 15 mm / 0.59 in wide inserts are mounted and ground (securing with pins)
  - with rubber corners, the use of short tools is possible and are perfectly secured.
- **With Die Holder on the Die Rail**
  - 60 x 55 mm / 2.36 x 2.167 in die holder, ground and induction hardened.

Our Advantages – Your Convenience

- fast exchange of tools
- very time saving
- reduced production costs
- significantly increased profitability
- improved competitiveness





ROL2-System for Dies Rolleri Type R1

ROLLERI® PROFESSIONAL BENDING

ROL2 – manual

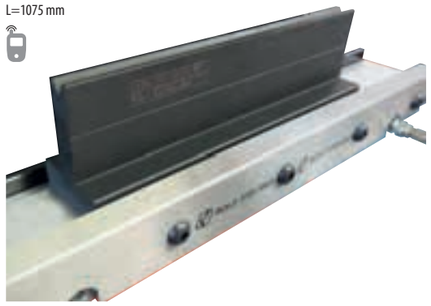
Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	38.0 kg	table: 60 mm	2.36 in	4.0 kg
table: 90 mm	3.54 in	58.0 kg	table: 90 mm	3.54 in	4.5 kg

L=1075 mm L=500 mm

ROL2 – hydraulic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

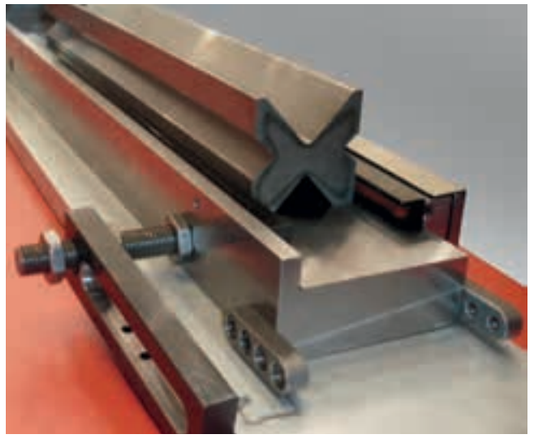
L=1075 mm L=500 mm



ROL2 – pneumatic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

L=1075 mm L=500 mm



Movable Die Clamps for Dies Rolleri Type R1

Our Advantages – Your Convenience

- lowerable clamping plate
- significantly easier exchange of tools, due the possibility of removing the tool by sliding it out and not lifting the tool.

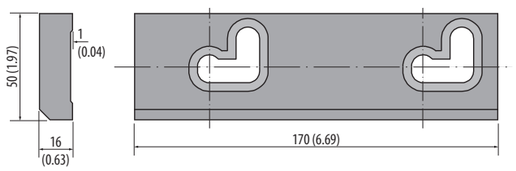
Rolleri Videos

movable die holders ST50-S:
www.rolleritools.com/videos/movable-die-holders

ST50-S

per piece	0.70 kg

Fe37: 370-470 N/mm²



9

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

ROLLERI®

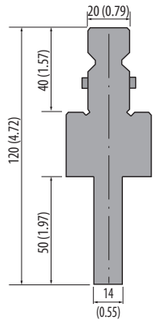
ROLLERI **ADAPTERS**

Punch Adapters	212 - 215
Bolted Adapters	216 - 217
Die Adapter Rails	218
Die Adapters	219 - 221
Modification: Wedge Bar / Tail	221

AD11

1000 kN/m max.

150 mm	5.91 in	3.0 kg



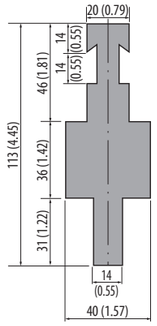
Rolleri Type R2
→ Rolleri Type R1

C45: 560-710 N/mm²

AD22

1000 kN/m max.

150 mm	5.91 in	3.4 kg



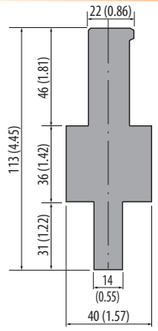
Rolleri Type R3 Beyeler R
→ Rolleri Type R1

C45: 560-710 N/mm²

AD3

1000 kN/m max.

150 mm	5.91 in	3.3 kg



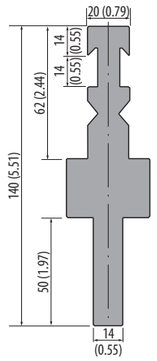
Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²

AD10

1000 kN/m max.

150 mm	5.91 in	3.4 kg

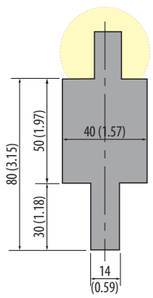


Rolleri Type R3 Beyeler
RFA → Rolleri Type R1

C45: 560-710 N/mm²

AD1

1000 kN/m max.

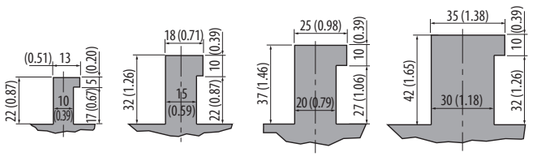


Tang A: **AD1-A**		
150 mm	5.91 in	3.1 kg
Tang B: **AD1-B**		
150 mm	5.91 in	3.1 kg
Tang C: **AD1-C**		
150 mm	5.91 in	3.1 kg
Tang D: **AD1-D**		
150 mm	5.91 in	3.1 kg

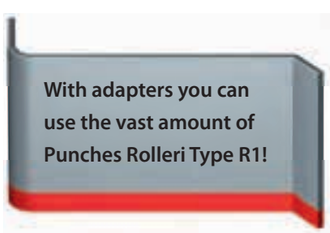
Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²

Tangs LVD



Tang A | Tang B | Tang C | Tang D

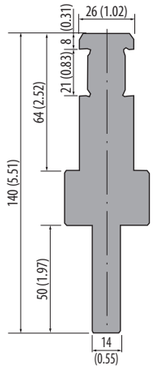


ROLLERI® PROFESSIONAL BENDING

AD13

1000 kN/m max.

150 mm	5.91 in	3.0 kg



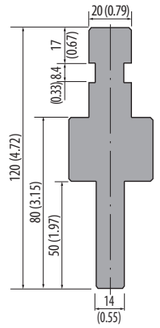
Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²

AD14

1000 kN/m max.

150 mm	5.91 in	3.2 kg



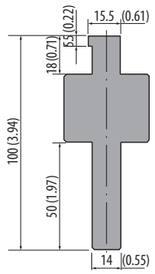
Rolleri Type RX Gas-
parini → Rolleri Type R1

C45: 560-710 N/mm²

AD15

1000 kN/m max.

150 mm	5.91 in	4.0 kg



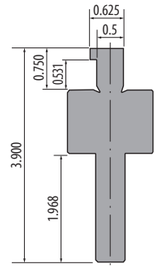
Rolleri Type RX Ajial-
Axial → Rolleri Type R1

C45: 560-710 N/mm²

AD16

1000 kN/m max.

5.9 inch	5.91 in	4.0 kg



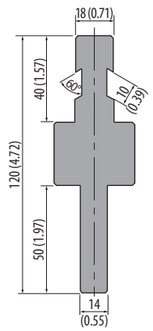
Rolleri Type American
→ Rolleri Type R1

C45: 560-710 N/mm²

AD12

1000 kN/m max.

150 mm	5.91 in	1.5 kg



Rolleri Type RX Colgar
→ Rolleri Type R1

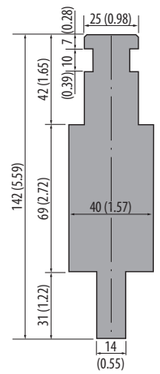
C45: 560-710 N/mm²

AD23

1000 kN/m max.

NEW

150 mm	5.91 in	5.0 kg



Rolleri Type RX
Weinbrenner
→ Rolleri Type R1

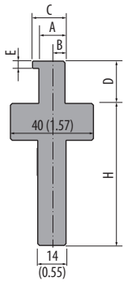
C45: 560-710 N/mm²

10

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

ADX

1000 kN/m max.



150 mm	5.91 in	3.5 kg

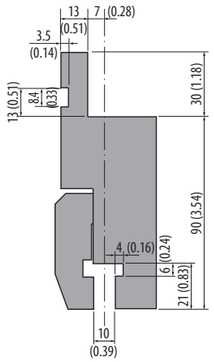
Type X
→ Rolleri Type R1

Producation according to your specifications

C45: 560-710 N/mm²

AD19-A

1000 kN/m max.



150 mm	5.91 in	6.0 kg

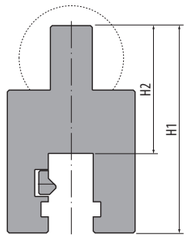
Rolleri Type R1
→ Rolleri Type RX LVD

C45: 560-710 N/mm²

on stock

ADX2

NEW



150 mm	5.91 in	4.0 kg

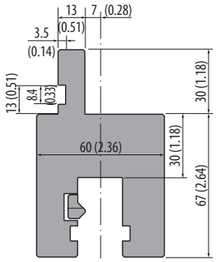
Type X
→ Rolleri Type R2

Producation 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

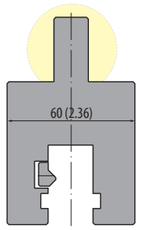
on stock

Pneumatic Adapters see page 206

AD20 LVD

1000 kN/m max.

NEW



Tang A: **AD20 LVD-A**		
150 mm	5.91 in	3.6 kg
Tang B: **AD20 LVD-B**		
150 mm	5.91 in	3.8 kg
Tang C: **AD20 LVD-C**		
150 mm	5.91 in	4.0 kg
Tang D: **AD20 LVD-D**		
150 mm	5.91 in	4.0 kg

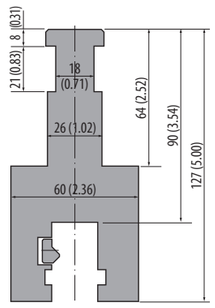
C45: 560-710 N/mm²

Rolleri Type RX LVD
→ Rolleri Type R2

AD28

1000 kN/m max.

NEW

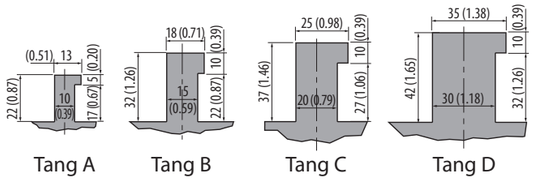


150 mm	5.91 in	5.0 kg

Rolleri Type RX EHT
→ Rolleri Type R2

C45: 560-710 N/mm²

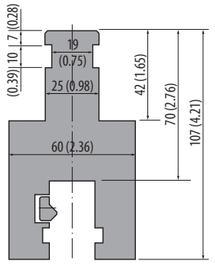
Tangs LVD



AD29

1000 kN/m max.

NEW



150 mm	5.91 in	4.5 kg

Rolleri Type RX
Weinbrenner
→ Rolleri R2

C45: 560-710 N/mm²

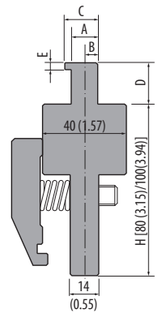
Rolleri Videos

Bolted Adapters AW, P. 216-217
www.rolleritools.com/videos/bolted-adapters

ROLLERI® PROFESSIONAL BENDING

INT80-100

1000 kN/m max.

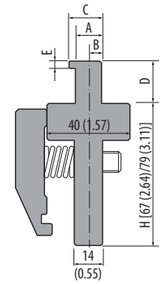


835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg

C45: 560-710 N/mm²

INT67-79

1000 kN/m max.

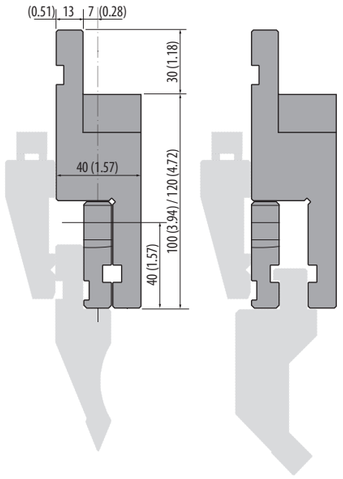


835 mm	32.87 in	20.5 kg
415 mm	16.34 in	10.0 kg

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

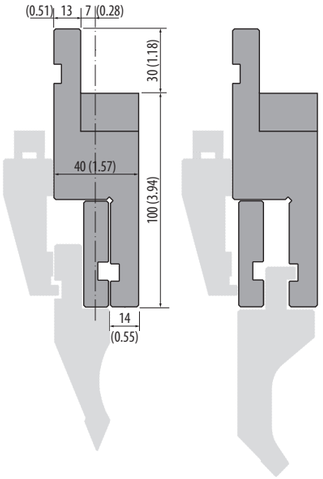
suitable Models:

- **Manual system** (ST60, STL60, STX60 etc.), see page 200
- **Fast Clamping** (ROL1 Clamp3), see page 201
- **Pneumatic system** only on **INT120-A** (ROL1 Clamp3 PN), see page 201
- **Hydraulic system** (ROL1 Clamp3 HYD), see page 201

horizontal

INT100-N (Newton)

1000 kN/m max.



150 mm	5.91 in	3.5 kg

C45: 560-710 N/mm²

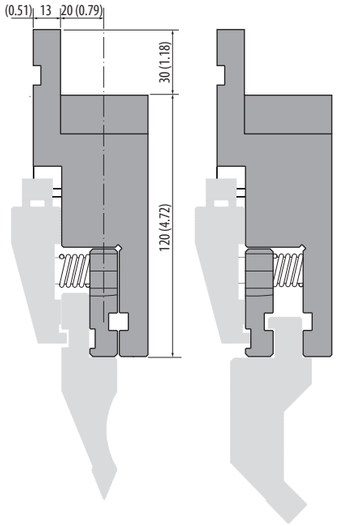
suitable Models:

- **Manual system** (ST60, STL60, STX60 etc.), see page 200
- **Fast Clamping** (ROL1 Clamp3), see page 201
- **Hydraulic system** (ROL1 Clamp3 HYD), see page 201

horizontal

INT120-40-A

1000 kN/m max.



150 mm	5.91 in	6.0 kg

C45: 560-710 N/mm²

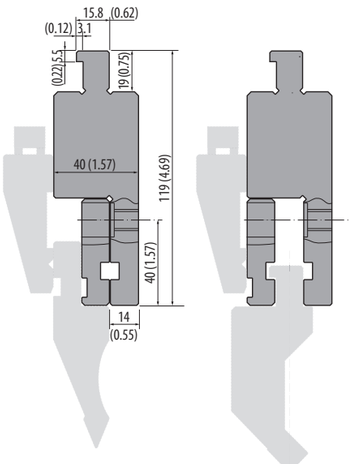
suitable Models:

- **Manual system** (ST60, STL60, STX60 etc.), see page 200
- **Fast Clamping** (ROL1 Clamp3), see page 201

horizontal

INT100-A (American)

1000 kN/m max.



150 mm	5.91 in	3.5 kg

C45: 560-710 N/mm²

suitable Models:

- **Manual system** (ST60, STL60, STX60 etc.), see page 200
- **Fast Clamping** (ROL1 Clamp3), see page 201
- **Hydraulic system** (ROL1 Clamp3 HYD), see page 201

horizontal

10

on stock Article on stock

Please ask for delivery time!

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

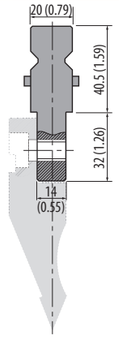
Articles on stock – Please note that delivery time depends on your location.

Bolted Adapters

AW11

1000 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	2.9 kg

Rolleri Type R2
→ Rolleri Type R1

C45: 560-710 N/mm²

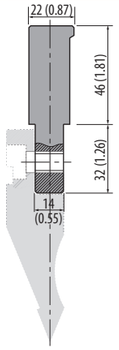
on stock

Do you prefer our QuickLock or ROL1-System? Contact us now!

AW3

1000 kN/m max.

NEW



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

Rolleri Type R3 Beyeler S
→ Rolleri Type R1

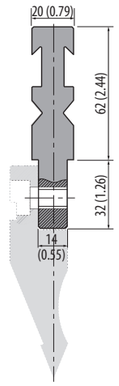
C45: 560-710 N/mm²

on stock

AW10

1000 kN/m max.

NEW



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

Rolleri Type R3 Beyeler RFA
→ Rolleri Type R1

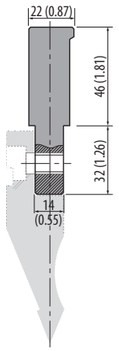
C45: 560-710 N/mm²

on stock

AW12

1000 kN/m max.

NEW



835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.5 kg
805 mm segmented	31.69 in segmented	6.7 kg

Rolleri Type RX Colgar
→ Rolleri Type R1

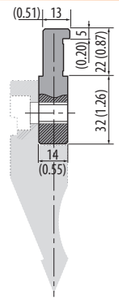
C45: 560-710 N/mm²

on stock

AW1-A

1000 kN/m max.

NEW



835 mm	32.87 in	4.5 kg
415 mm	16.34 in	2.2 kg
805 mm segmented	31.69 in segmented	4.3 kg

Rolleri Type RX LVD A
→ Rolleri Type R1

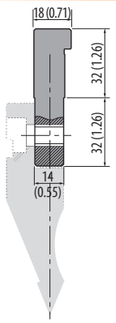
C45: 560-710 N/mm²

on stock

AW1-B

1000 kN/m max.

NEW



835 mm	32.87 in	6.3 kg
415 mm	16.34 in	3.1 kg
805 mm segmented	31.69 in segmented	6.0 kg

Rolleri Type RX LVD B
→ Rolleri Type R1

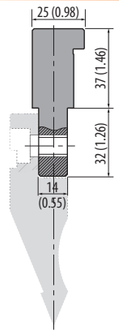
C45: 560-710 N/mm²

on stock

AW1-C

1000 kN/m max.

NEW



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

Rolleri Type RX LVD C
→ Rolleri Type R1

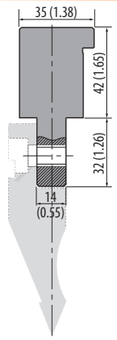
C45: 560-710 N/mm²

on stock

AW1-D

1000 kN/m max.

NEW



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

Rolleri Type RX LVD D
→ Rolleri Type R1

C45: 560-710 N/mm²

on stock

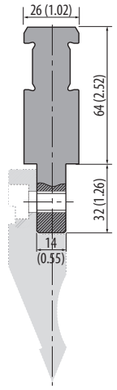
Bolted Adapters

ROLLERI® PROFESSIONAL BENDING

AW13

1000 kN/m max.

NEW



835 mm	32.87 in	12.6 kg
415 mm	16.34 in	6.3 kg
805 mm segmented	31.69 in segmented	12.1 kg

Rolleri Type RX EHT
→ Rolleri Type R1

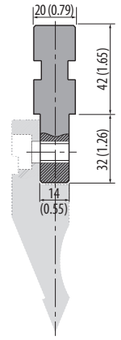
C45: 560-710 N/mm²

on stock

AW14

1000 kN/m max.

NEW



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

Rolleri Type RX Gas-parini → Rolleri Type R1

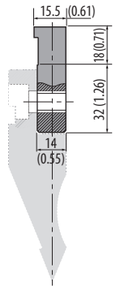
C45: 560-710 N/mm²

on stock

AW15

1000 kN/m max.

NEW



835 mm	32.87 in	4.6 kg
415 mm	16.34 in	2.3 kg
805 mm segmented	31.69 in segmented	4.4 kg

Rolleri Type RX Ajial-Axial → Rolleri Type R1

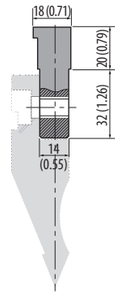
C45: 560-710 N/mm²

on stock

AWC16

1000 kN/m max.

NEW



835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

Rolleri Type RX Colly
→ Rolleri Type R1

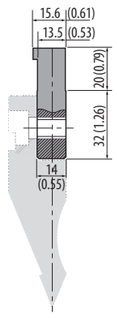
C45: 560-710 N/mm²

on stock

AWC13.5

1000 kN/m max.

NEW



835 mm	32.87 in	4.8 kg
415 mm	16.34 in	2.4 kg
805 mm segmented	31.69 in segmented	4.6 kg

Rolleri Type RX Colly
→ Rolleri Type R1

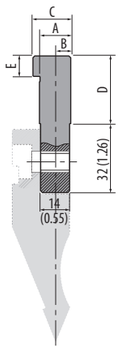
C45: 560-710 N/mm²

on stock

AWX

1000 kN/m max.

NEW



835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	3.0 kg

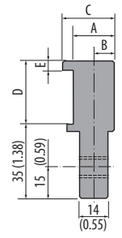
Individual
→ Rolleri Type R1

C45: 560-710 N/mm²

INT35

1000 kN/m max.

NEW



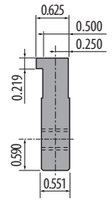
835 mm	32.87 in	4.0 kg
525 mm	20.67 in	2.5 kg
805 mm segmented	31.69 in segmented	3.9 kg

C45: 560-710 N/mm²

INT35-A

1000 kN/m max.

NEW



835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

C45: 560-710 N/mm²

10

on stock Article on stock

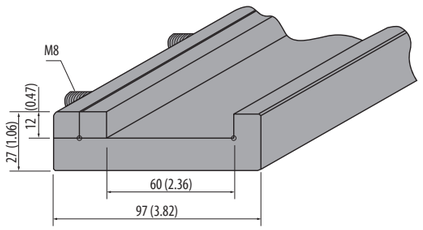
Please ask for delivery time!

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

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

Die Adapter Rails

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



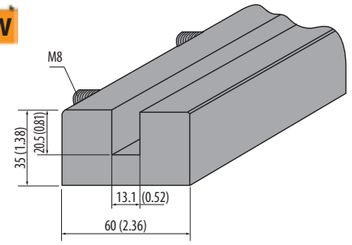
Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg

on stock

C45: 560-710 N/mm²

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

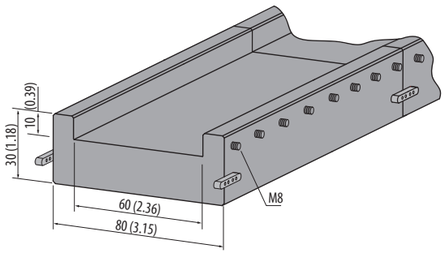
NEW



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

C45: 560-710 N/mm²

C 1050/R

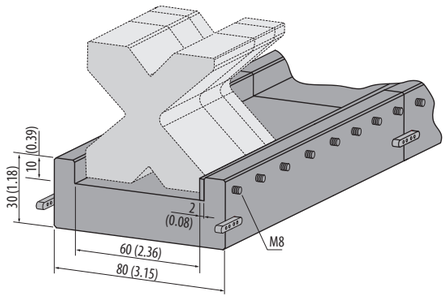


Model	Length (mm)	Length (in)	Weight
C 1050/R	1050	41.34	15.0 kg
C 1050/R/C	520	20.47	7.5 kg

on stock

C45: 560-710 N/mm²

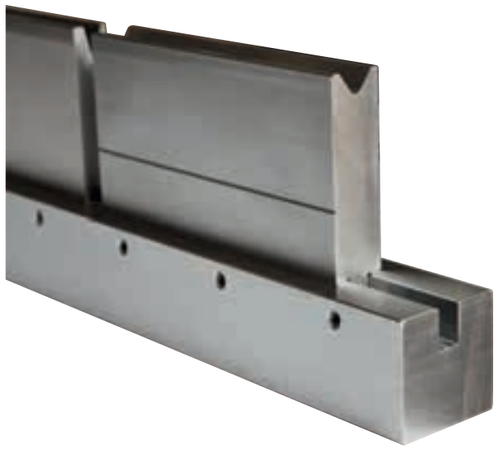
C 1050/RS



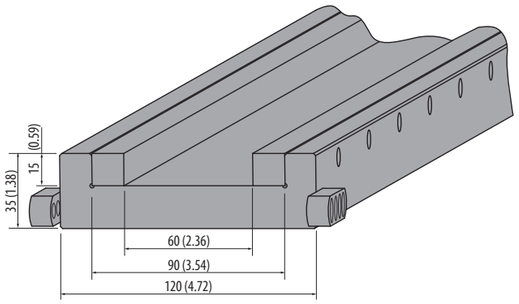
Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg

on stock

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

on stock

C45: 560-710 N/mm²

Die Adapters

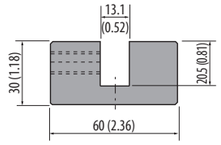
ROLLERI® PROFESSIONAL BENDING

AD6

1000 kN/m max.

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

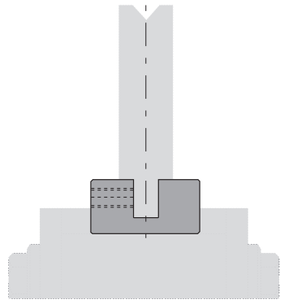
Rolleri Type R1
→ Rolleri Type R2/R3



C45: 560-710 N/mm²

on stock

AD6 Example of Application

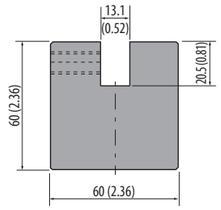


AD5

1000 kN/m max.

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

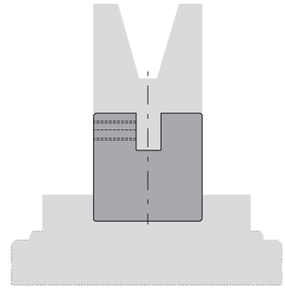
Rolleri Type R1
→ Rolleri Type R2/R3



C45: 560-710 N/mm²

on stock

AD5 Example of Application

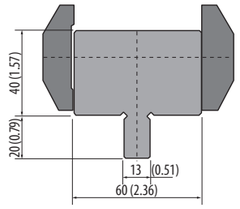


AD7

1000 kN/m max.

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

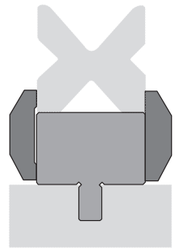
Rolleri Type R2/R3
→ Rolleri Type R1



C45: 560-710 N/mm²

on stock

AD7 Example of Application



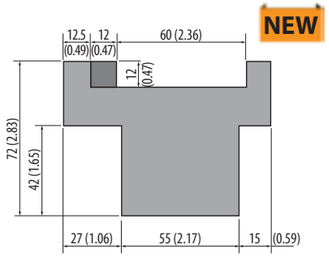
AD24

1000 kN/m max.

NEW

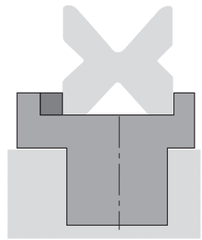
835 mm	32.87 in	28.5 kg
415 mm	16.34 in	14.2 kg

Rolleri Type RX EHT
→ Rolleri Type R1



C45: 560-710 N/mm²

AD24 Example of Application



10

on stock Article on stock

Please ask for delivery time!

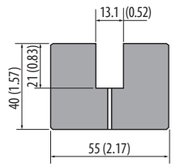
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

AD25

1000 kN/m max.

NEW

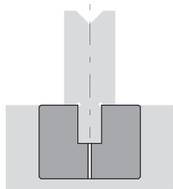


500 mm	19.68 in	7.5 kg

Rolleri Type RX EHT
→ Rolleri Type R2/R3

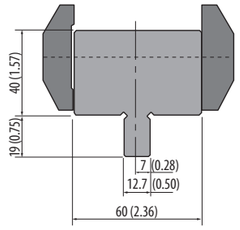
C45: 560-710 N/mm²

AD25 Example of Application



AD9-12.7

1000 kN/m max.



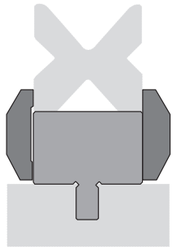
835 mm	32.87 in	17.0 kg
415 mm	16.34 in	8.5 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²

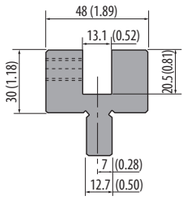
on stock

AD9-12.7 Example of Application



AD8-12.7

1000 kN/m max.



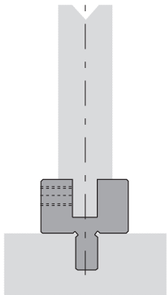
1000 mm	39.37 in	15.0 kg
500 mm	19.68 in	7.5 kg

Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

on stock

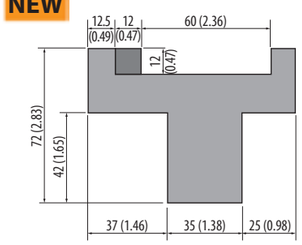
AD8-12.7 Example of Application



AD26

1000 kN/m max.

NEW

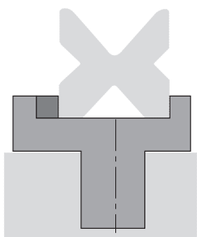


835 mm	32.87 in	23.0 kg
415 mm	16.34 in	11.4 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm²

AD26 Example of Application

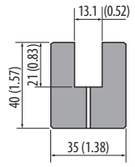


ROLLERI® PROFESSIONAL BENDING

AD27

1000 kN/m max.

NEW

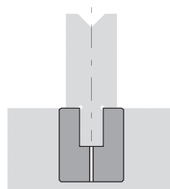


500 mm	19.68 in	4.5 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R2/R3

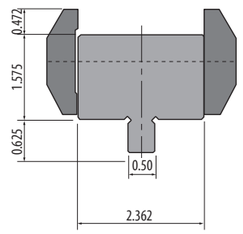
C45: 560-710 N/mm²

AD27 Example of Application



AD17

1000 kN/m max.



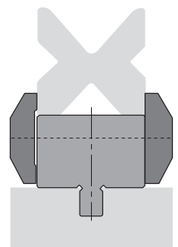
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Type American
→ Rolleri Type R1

C45: 560-710 N/mm²

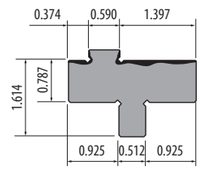
on stock

AD17 Example of Application



AD18

1000 kN/m max.



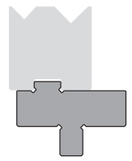
835 mm	32.87 in	18.0 kg
415 mm	16.34 in	9.0 kg

Type American
→ Rolleri Type R1

C45: 560-710 N/mm²

on stock

AD18 Example of Application



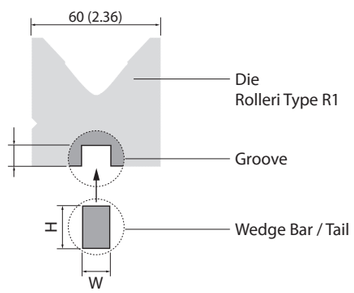
Modification: Wedge Bar / Tail

In order to use the dies Rolleri Type R1 on other press brake machines, a 10 mm (0.39 in) groove is milled to insert a ground wedge bar / tail into the die.

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

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

Mounting example

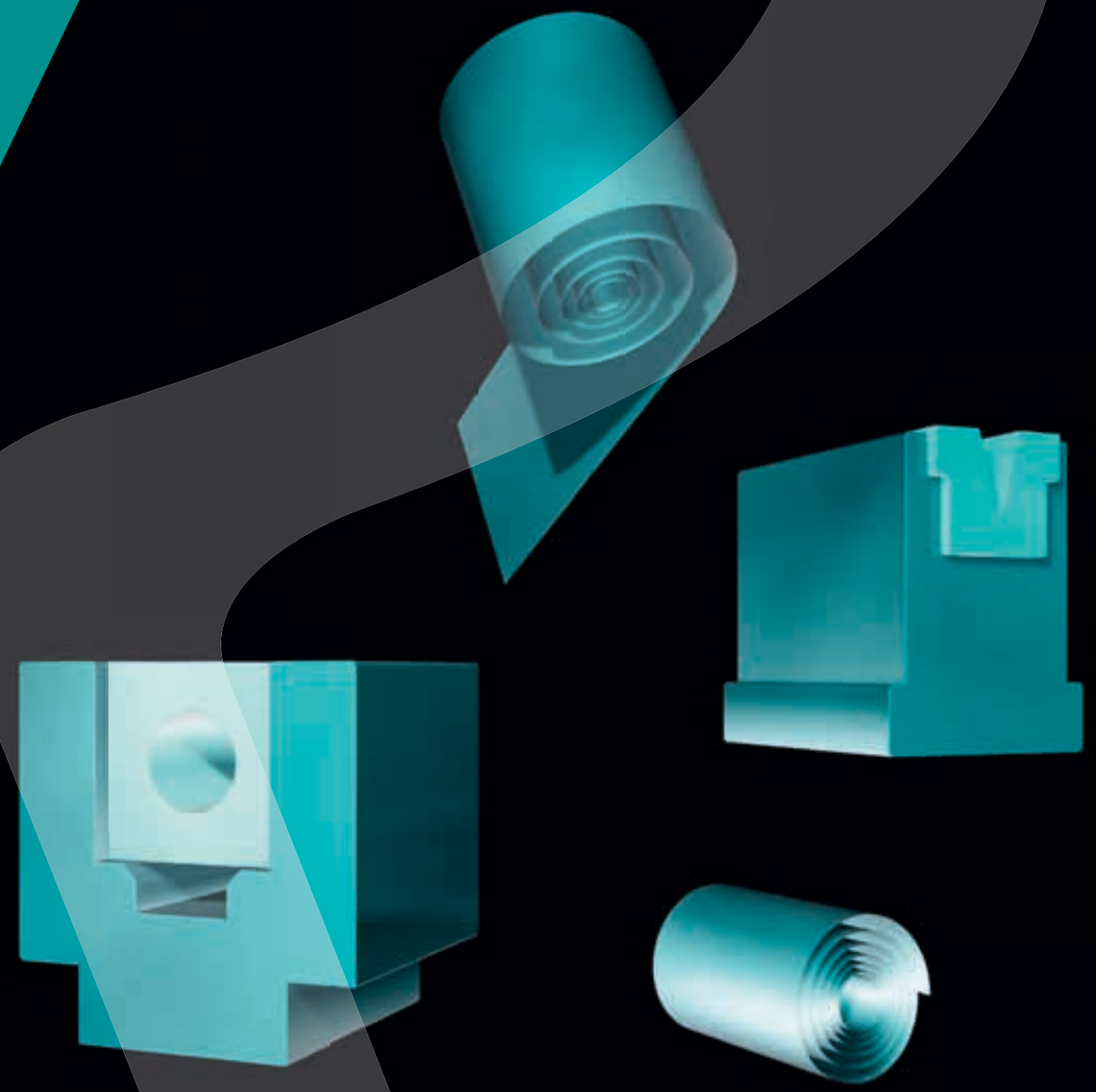


on stock Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

ROLLERI®

ROLLERI **MARK FREE BENDING**

Prevention of Bending Marks	224
Bending Foil Holder/Tensioner	224
Bending Foil	225
PU-Holder and PU-Upholstery	226 - 227
Synthetic Dies	228 - 229



Prevention of Bending Marks

One of the challenges of bending is to prevent the profile of having bending marks, such as; scratches and abrasions on the surface areas.

Especially of Profile made of:

- Stainless Steel
- Aluminium
- painted metal panels

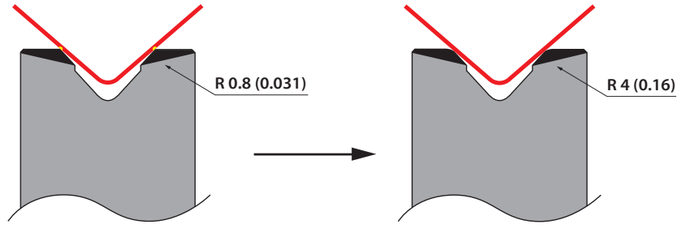
It is often the case of a line building from the contact of the sheet metal with the die. This is the cause of friction of sheet metal on small radius.

In order to prevent this markings, the following solutions are possible:

- **Bending Foil**
- **PU-Upholstery**
- **Plastic Dies**
- **enlarged opening radius on special T-Dies**

Our Advantages – Your Convenience

- Prevention of scratches and abrasions on bent sheet metals
- No post-processing necessary, therefore time and cost saving
- No contamination of bended pieces
- increases the product quality
- easy handling



Standard T-Die
with small opening radius
causes visible bending marks

T-Die TR
with an enlarged opening radius
reduces visibly the bending marks

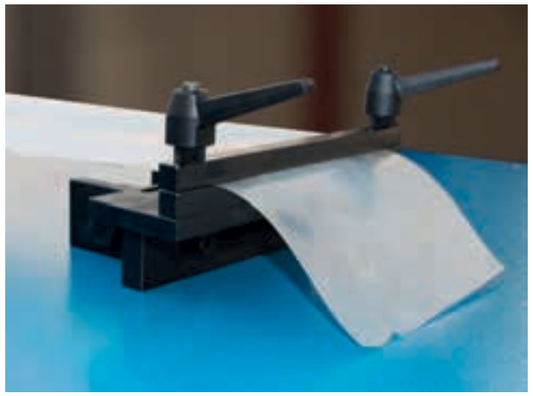
T-Dies (TR) with an enlarged opening radius for the prevention of bending marks
see pages 54-55, 60-61

Bending Foil - Holder / Tensioner

CT

per piece | 6.0 kg

on stock



ROLLERI MARK FREE BENDING

ROLLERI® PROFESSIONAL BENDING

Bending Foil

Our Advantages – Your Convenience

- easy handling
- can be used flexibly
- Prevention of Bending Marks
- decrease of post-processing of bent parts
- no contamination of the material
- increased product quality

Bending Foil: Practical, easy and economic!

ROLFILM

on stock

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

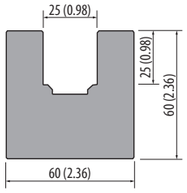
on stock Article on stock

Please ask for delivery time!

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

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

MPG25

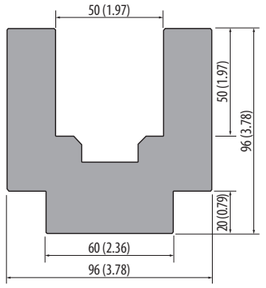


835 mm	32.87 in	18.5 kg
415 mm	16.34 in	9.2 kg

C45: 560-710 N/mm²

on stock

MPG50

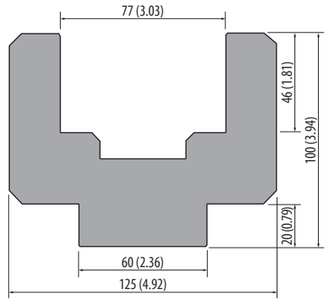


835 mm	32.87 in	44.0 kg
415 mm	16.34 in	22.0 kg

C45: 560-710 N/mm²

on stock

MPG75

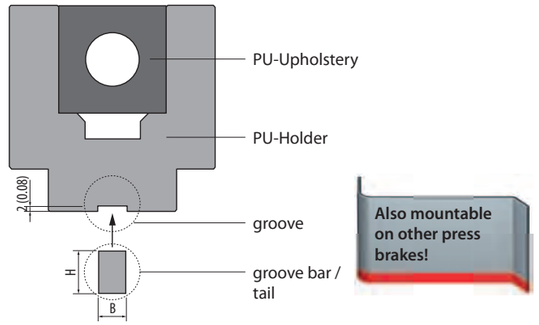


835 mm	32.87 in	46.0 kg
415 mm	16.34 in	22.5 kg

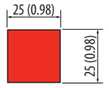
C45: 560-710 N/mm²

on stock

Mounting example



GM 25x25

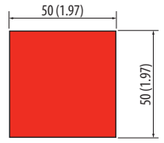


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane

on stock

GM 50x50

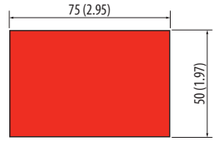


835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

polyurethane

on stock

GM 75x50

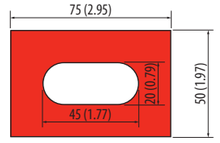


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane

on stock

GMF 75x50x20

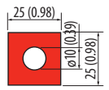


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

polyurethane

on stock

GMF 25x25x10

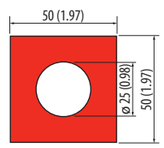


835 mm	32.87 in	0.6 kg
415 mm	16.34 in	0.3 kg

polyurethane

on stock

GMF 50x50x25

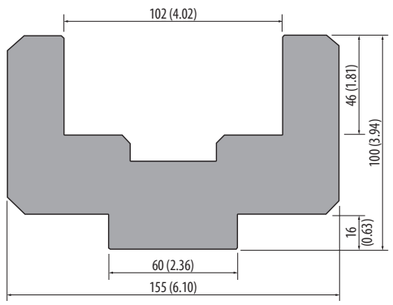


835 mm	32.87 in	2.5 kg
415 mm	16.34 in	1.2 kg

polyurethane

on stock

MPG100



835 mm	32.87 in	55.0 kg
415 mm	16.34 in	27.5 kg

C45: 560-710 N/mm²

on stock

PU-Upholstery are suitable for radius- and U-profile bendings, etc.

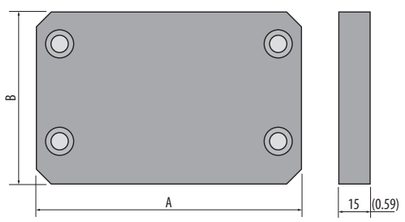
PSTCON

cover plate

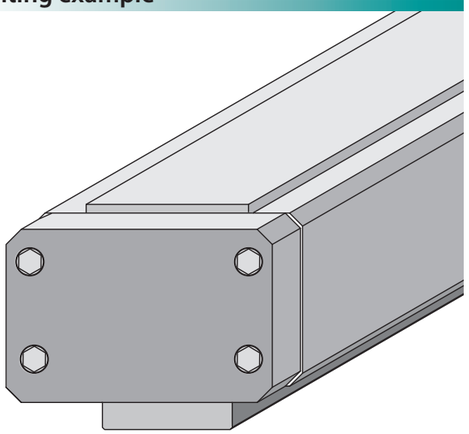
on stock

C45: 560-710 N/mm²

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

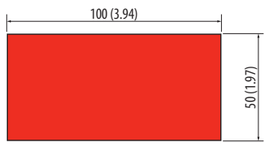


Mounting example



GM 100x50

835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg

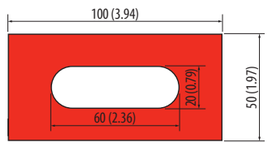


polyurethane

on stock

GMF 100x50x20

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	2.2 kg



polyurethane

on stock

11

on stock Article on stock

Please ask for delivery time!

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

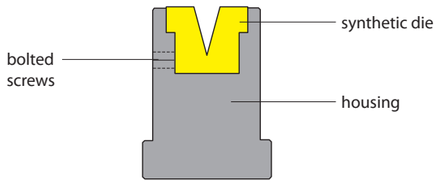
Articles on stock – Please note that delivery time depends on your location.

Our Advantages – Your Convenience

- easy handling
- faster and easier exchange of plastic dies
- prevention of bending marks
- decrease of post-processing of bent pieces
- no contamination of the materials
- increased product quality

Mounting example

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



TN80.14

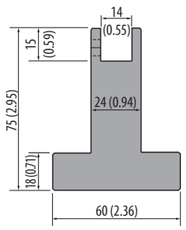
1000 kN/m max.

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

Rolleri Type R1

C45: 560-710 N/mm²

on stock

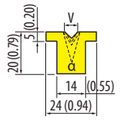


INS14...

200 kN/m max.

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

on stock



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

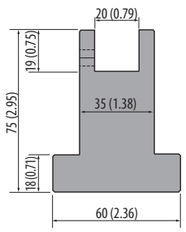
1000 kN/m max.

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

Rolleri Type R1

C45: 560-710 N/mm²

on stock

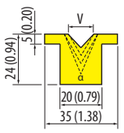


INS20...

200 kN/m max.

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

on stock



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

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

ROLLERI® PROFESSIONAL BENDING

TN80.30

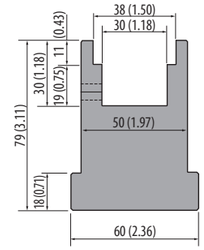
1000 kN/m max.

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

Rolleri Type R1

C45: 560-710 N/mm²

on stock

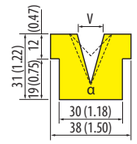


INS30...

200 kN/m max.

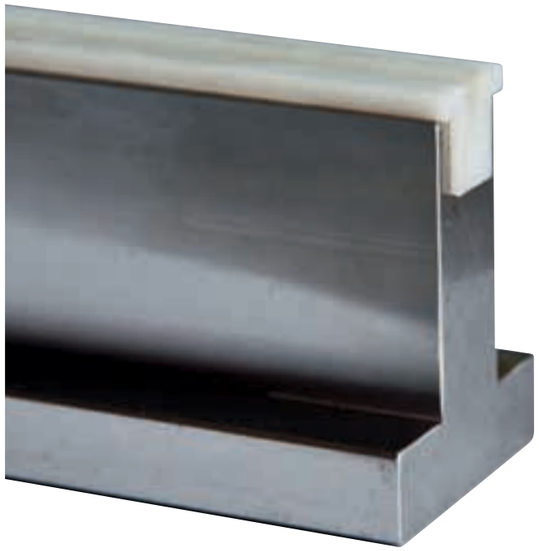
835 mm	32.87 in	0.50 kg
415 mm	16.34 in	0.25 kg

on stock



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



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

TMN95.20

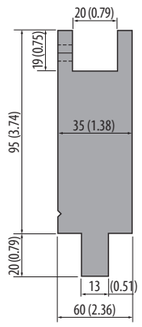
1000 kN/m max.

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

Rolleri Type R2/R3

C45: 560-710 N/mm²

on stock

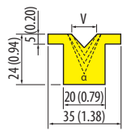


INS20...

200 kN/m max.

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

on stock



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

on stock Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

ROLLERI®

ROLLERI **SPECIAL** AND **HEAVY DUTY TOOLS**

Explanation of Special Tools	232
Explanation of Heavy Duty Tools	233
Heavy Duty Tools	234 - 235
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Dies with Rollers	239 - 241
ROL6-System	242
Panelling Tools	242
BLACKFIRE	243

Special Solutions

Our Advantages – Your Convenience

- in-house construction and production (no reseller or dealer)
- competent consulting
- client specific developments
- tracking of every tool possible, with a unique serial number on every article after the quality control check
- precision grinding (tolerance of +/-0.01mm)
- guaranteed tool reproduction
- exact parallelism
- bending tests upon request

Special Tooling for:

- Z-Profiles
- Hat-Profiles
- Trapezoidal Profiles
- Pressed contours
- Foldings
- Hinges
- Radii
- Beads
- Special Profiles
- etc.

Material

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

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC
1.2767	830 N/mm²	22 - 25 HRC	54 - 60 HRC

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

Solutions for heavy tasks

Our Advantages – Your Convenience

The bending of materials with extreme high resistance, (Hardox, Weldox, etc.), has developed into an important task.

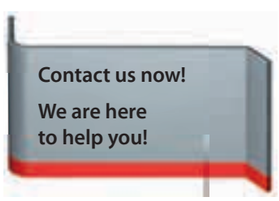
The Heavy Duty tools of Rolleri are built and finished for these challenges.

Tools that have a press force up to 4000 kN/m, offer you many production possibility.

Our many years of experience in the area of special and heavy duty tooling, along with our own developing department, guarantee you functional and economic solutions in the bending sector.

From the compatible tang to the punch onto the compatible die; we manufacture everything in our own production facilities.

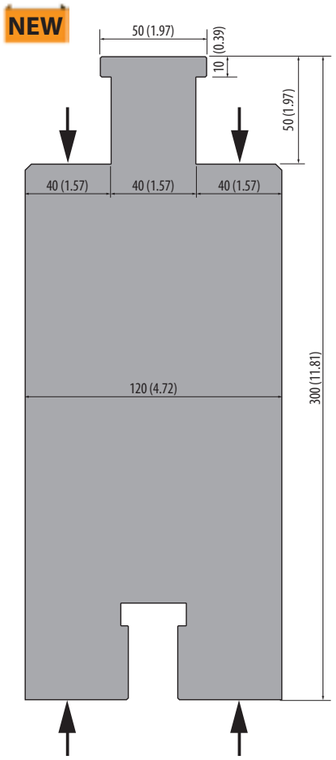
Take advantage of the direct contact to the manufacturer and the benefits which come along with it.



Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

RHD.300

NEW



RHD.300-250		
500 mm	19.68 in	122.0 kg

2500 kN/m max.

42Cr: 900-1150 N/mm²

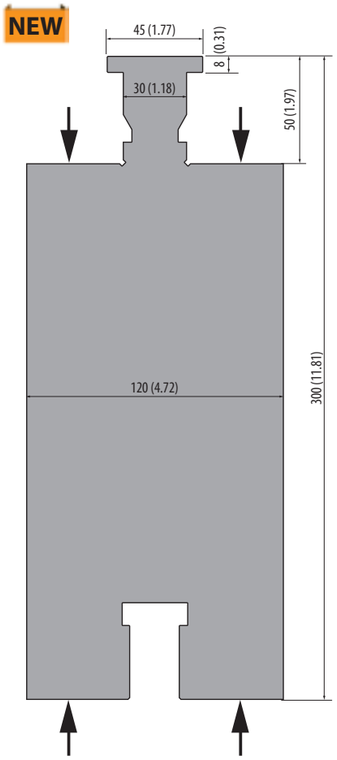
RHD.300-400		
500 mm	19.68 in	122.0 kg

4000 kN/m max.

1.2767: 830 N/mm²

RHD.300 HYD

NEW



RHD.300-250 HYD		
500 mm	19.68 in	120.0 kg

2500 kN/m max.

42Cr: 900-1150 N/mm²

RHD.300-400 HYD		
500 mm	19.68 in	120.0 kg

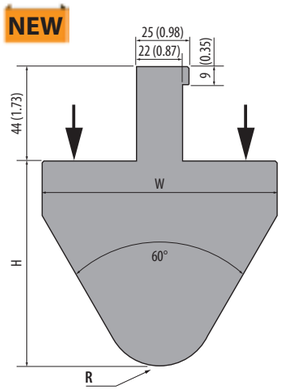
4000 kN/m max.

1.2767: 830 N/mm²

RHDP.60

NEW

500 mm	19.68 in



2500 kN/m max.

Model	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-250	96	3.78	110	4.33	20	0.79
RHDP.60.25-250	96	3.78	110	4.33	25	0.98
RHDP.60.30-250	96	3.78	110	4.33	30	1.18
RHDP.60.40-250	96	3.78	110	4.33	40	1.57
RHDP.60.50-250	96	3.78	110	4.33	50	1.97
RHDP.60.60-250	96	3.78	110	4.33	60	2.36
RHDP.60.70-250	86	3.39	140	5.51	70	2.76
RHDP.60.80-250	86	3.39	150	5.91	80	3.15
RHDP.60.90-250	86	3.39	165	6.50	90	3.54
RHDP.60.100-250	86	3.39	185	7.28	100	3.94

42Cr: 900-1150 N/mm²

4000 kN/m max.

Model	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-400	96	3.78	110	4.33	20	0.79
RHDP.60.25-400	96	3.78	110	4.33	25	0.98
RHDP.60.30-400	96	3.78	110	4.33	30	1.18
RHDP.60.40-400	96	3.78	110	4.33	40	1.57
RHDP.60.50-400	96	3.78	110	4.33	50	1.97
RHDP.60.60-400	96	3.78	110	4.33	60	2.36
RHDP.60.70-400	86	3.39	140	5.51	70	2.76
RHDP.60.80-400	86	3.39	150	5.91	80	3.15
RHDP.60.90-400	86	3.39	165	6.50	90	3.54
RHDP.60.100-400	86	3.39	185	7.28	100	3.94

1.2767: 830 N/mm²

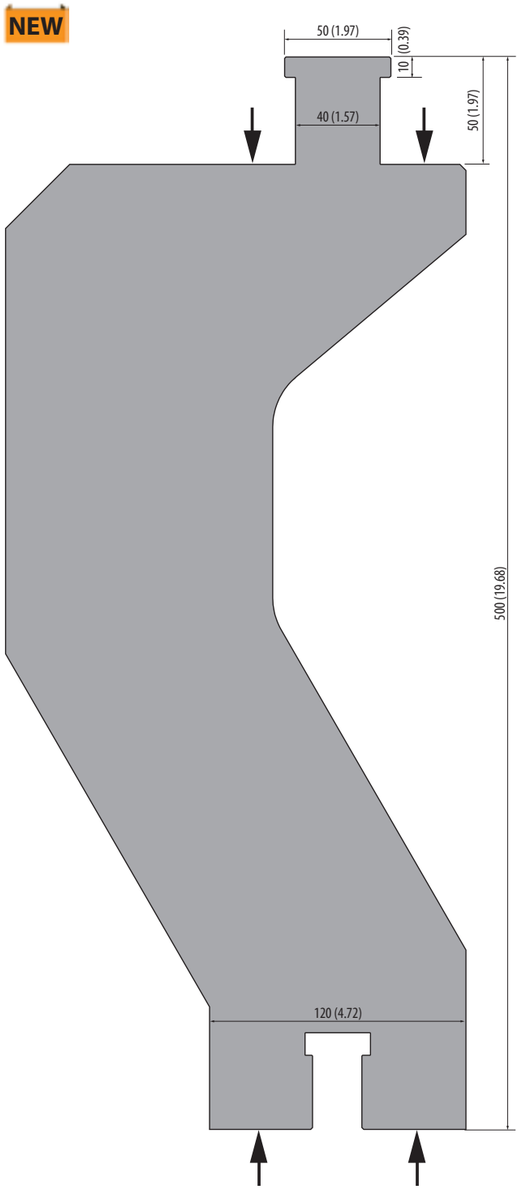
ROLLERI® PROFESSIONAL BENDING

RHD.500-200

2000 kN/m max.

150 mm	19.68 in	253.0 kg

NEW



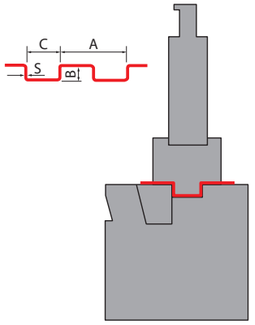
42Cr: 900-1150 N/mm²

More Tools for Heavy Duty operations can be found on pages 156-158

Tool examples

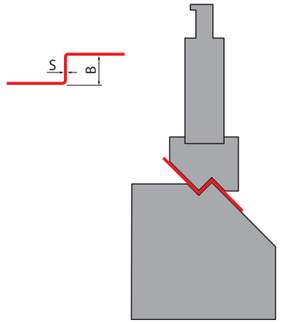
SPE1

Hat-Profiles



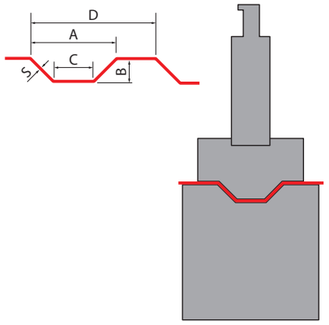
SPE2

Z-Profiles

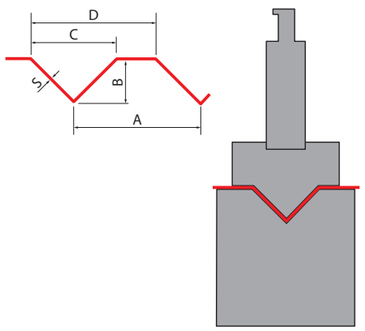


SPE3

Trapezoidal Profiles

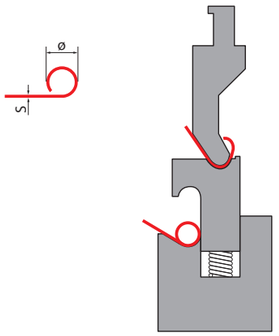


SPE4

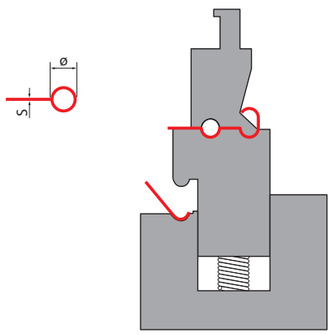


SPE5

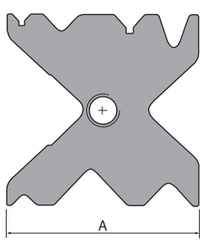
Hinges



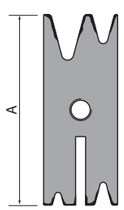
SPE6



SPE7

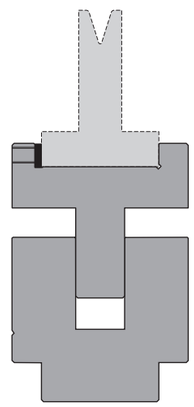


SPE-X

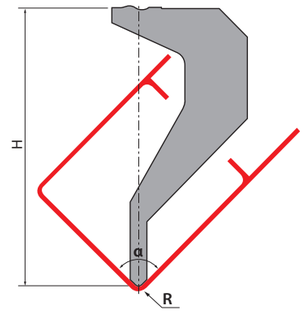


ROLLERI® PROFESSIONAL BENDING

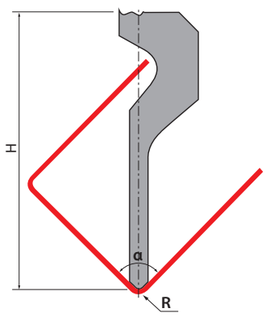
SPE9



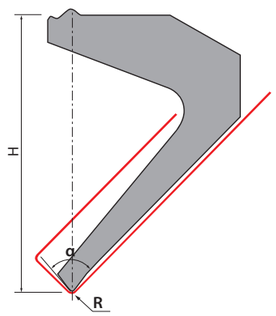
SPE-P1



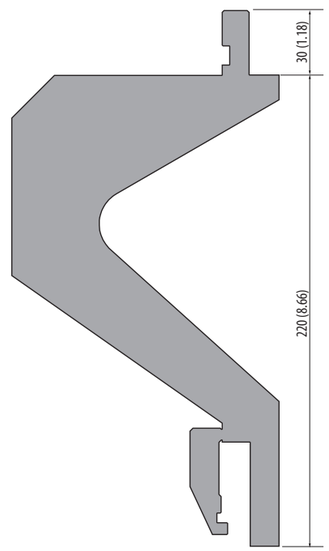
SPE-P2



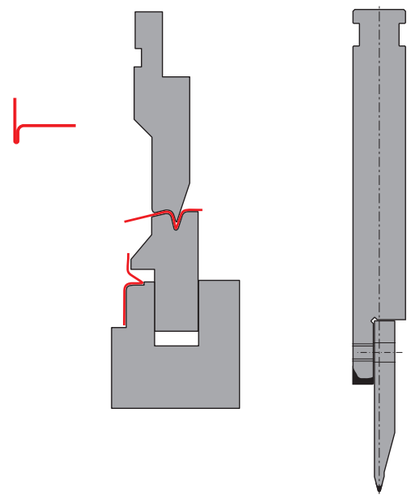
SPE-P3



SPE-P4



Front- and Hemming Tool (Foldings)



12

Article on stock

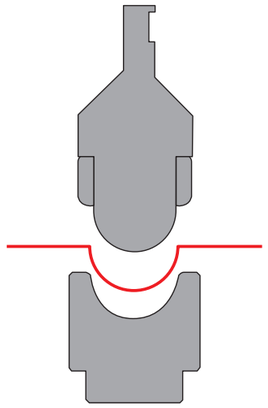
Please ask for delivery time!

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

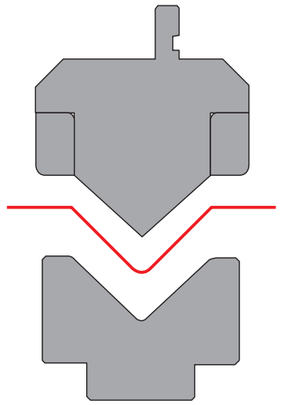
Articles on stock – Please note that delivery time depends on your location.

Tool examples

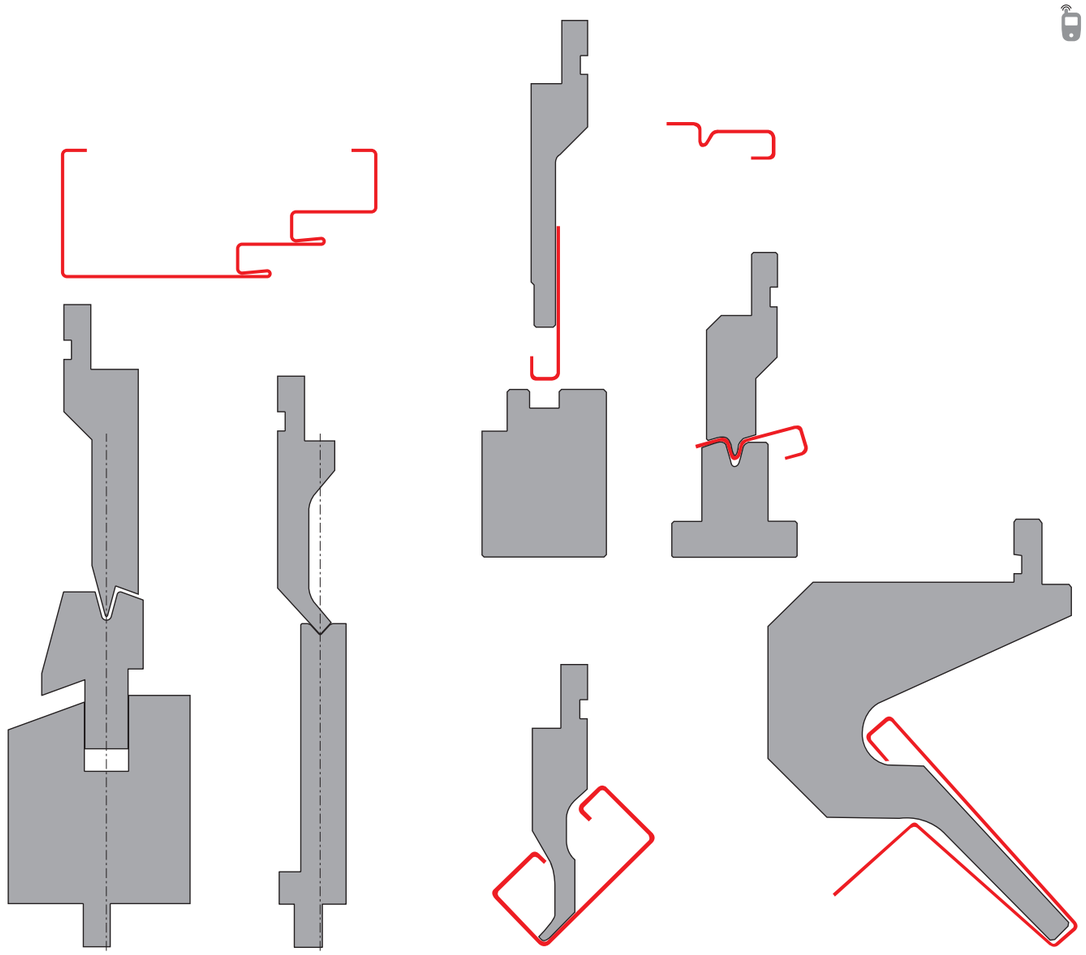
Radii



Pressing

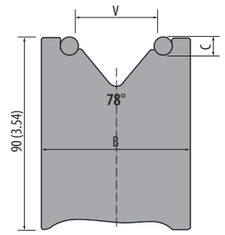


Special Profiles



Dies with Rollers

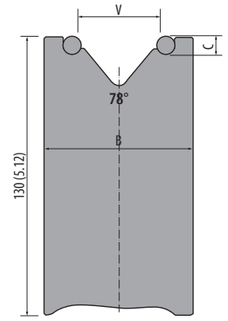
MR90



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

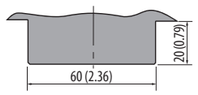
MR130



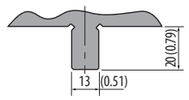
Rollen: C53.60-62 HRC
42Cr: 900-1150 N/mm²

Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
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

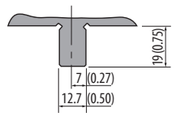
A10



A11



A13



12

Article on stock

Please ask for delivery time!

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

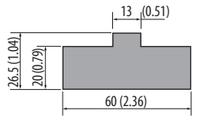
Articles on stock – Please note that delivery time depends on your location.

Our Advantages – Your Convenience

- increase in wear resistance through rollers
- induction hardened rollers (approx. 60 HRc)
- decrease in bending marks
- decrease in press force
- easy and economic exchange of rollers

AD MR60

NEW



98 mm	3.86 in

Adapter for Rolleri Type R1

C45: 560-710 N/mm²

AD MR13

NEW

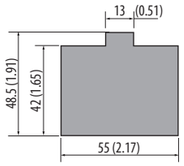
98 mm	3.86 in

Adapter for Rolleri Type R2/R3

C45: 560-710 N/mm²

AD MR55

NEW



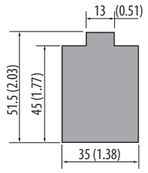
98 mm	3.86 in

Adapter for Rolleri Type RX EHT

C45: 560-710 N/mm²

AD MR35

NEW



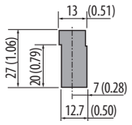
98 mm	3.86 in

Adapter for Rolleri Type RX Weinbrenner

C45: 560-710 N/mm²

AD MR12.7

NEW



98 mm	3.86 in

Adapter for Rolleri Type RX LVD

C45: 560-710 N/mm²

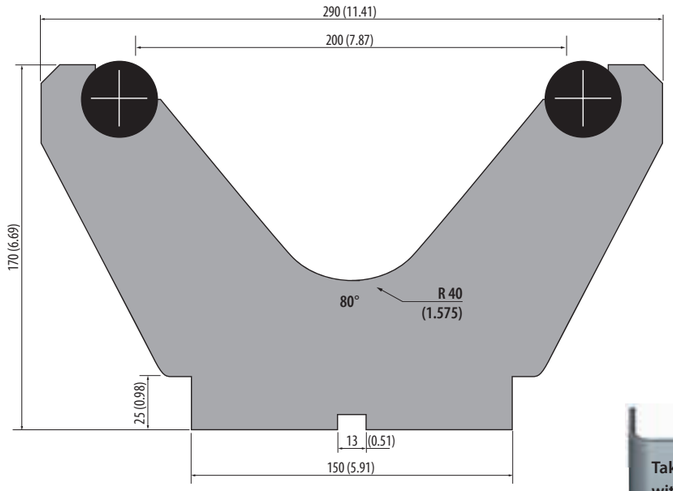
MR170.200.80

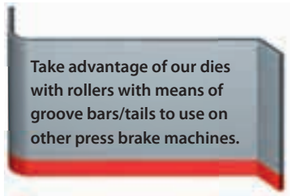
2000 kN/m max.

NEW

100 mm	3.94 in	19.0 kg

42Cr: 900-1150 N/mm²





ROLLERI® PROFESSIONAL BENDING

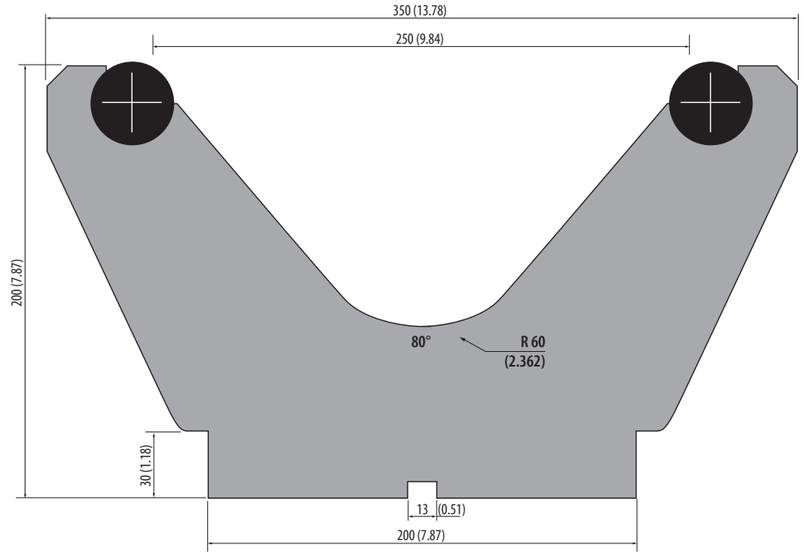
MR200.250.80

2000 kN/m max.

NEW

100 mm	3.94 in	28.0 kg

42Cr: 900-1150 N/mm²



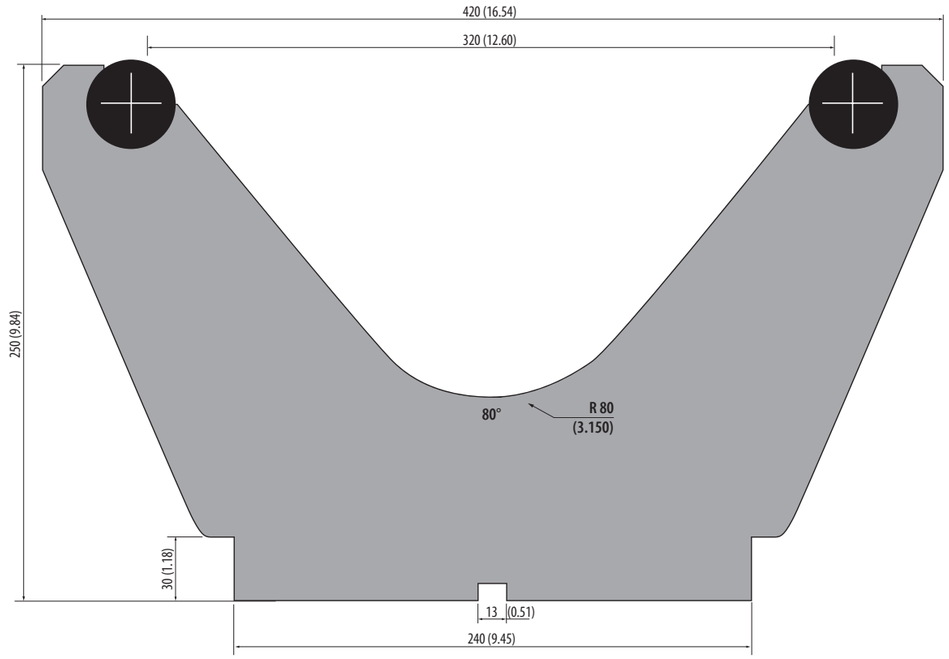
MR250.320.80

2000 kN/m max.

NEW

100 mm	3.94 in	42.0 kg

42Cr: 900-1150 N/mm²



12

Article on stock — Please ask for delivery time! — 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) — Articles on stock – Please note that delivery time depends on your location.

ROL6-System

Our Advantages – Your Convenience

- various V-Openings: 40-360 mm (1.57-14.17 in)
- Instructions:
  - secured manually with steering wheel
  - driven by gear motor or
  - CNC-system

While using the manual version, the opening is set in place by a turn of the stearing wheel, or with a gear reduction which is attached to the die.

The automatic version, on the other hand, is operated by a control panel. The standard system does not come with the CNC-Connection for the press brake. It is available upon request at an additional cost.

The base of the ROL6-system is 720 mm (28.35 in) wide, but can also be fitted onto narrow designed tables. There is a adapter available in order to secure the system onto a table with a width of 400 mm (15.75 in). The inserts in the opening radius are exchangeable. The standard version comes with an opening radius of R=10 mm (0.39 in).

Die weight: approx. 1 ton/m

ROL6

42Cr: 900-1150 N/mm²

bending angle	kN/m max.
0°	6000
90°	6000
60°	4000

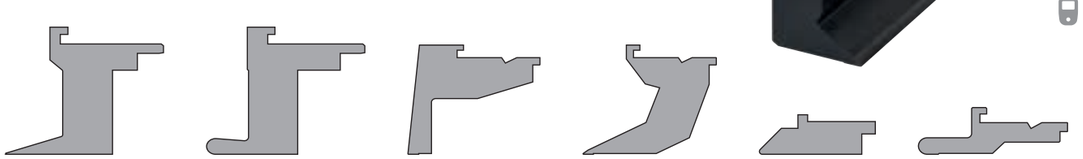
Rolleri Videos

Application of various dies ROL6:
www.rolleritools.com/videos/rol6

Panelling Tools

Our Advantages – Your Convenience

- in-house construction (no reseller or dealer)
- production according to your specifications
- tracking of every tool possible, with a unique serial number on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- exact parallelism
- use of the best materials, guaranteed high resistance and tensile strength



BLACKFIRE

The Unique Coating

Rolleri BLACKFIRE is a particular coating of your tools which defines itself by its increased corrosion resistance and special design.

The chemical treatment permanently solves the problem of oxidation.

The top surface of the metals changes through the phosphate process. It builds phosphate-like crystals, that attach themselves chemically on the substance. This improves the durability of the surface against corrosion.

Your equipment will have a long-term lifecycle left unchanged. The glossy black color of BLACKFIRE is compatible with the new technology and that allows a unique and esthetic look which connects well with the advantages of it.

You can have the BLACKFIRE treatment on all standard tools with a surcharge of 30%.

Please note that the delivery times vary by a BLACKFIRE Treatment.

Our Advantages – Your Convenience

- no corrosion
- better gliding by the exchange of tools
- appealing design
- long-life cycle

Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

ROLLERI®

ROLLERI **SERVICES / MODIFICATIONS**

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Horn Pieces	250
Modifying the V-Opening	250
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Grooves and Groove Bars/Tails for Dies	252
Gaps and Windows	253

Our Machine Park

Our comprehensive machinery with state-of-the-art technology ensures you the highest quality in tools.

In addition to the manufactured standard and special tools, we perform all modifications individually according to your requirements.

Take advantage the modifications to reduce costs and increase the productivity of your existing tools!

CNC-Milling

With our state-of-the-art milling centers we can do your modification requests fast, precise and with high-quality.

Swivel milling heads with high swivel range allows flexible and universal production.

This is where, grooves, gaps, and openings are created.

CNC-Profile Grinding

Our CNC-Professional grinding machines guarantee, highest precision ground (tolerance of +/-0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tool pieces. Radius and angle modifications are precisely grounded after your measurements.

ROLLERI SERVICES
Our Production Department

Hardening

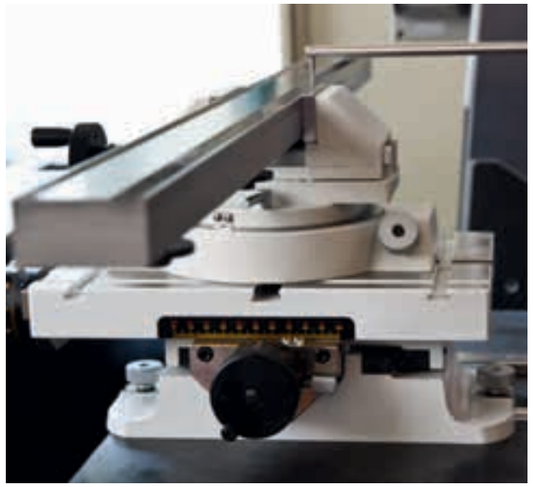
The surface areas of the tools are exposed to the highest mechanical stress. Due to the fact that, the whole press force of the press brake machine is focused on small surface of the sheet metal. Therefore the stress is very high on these surfaces. During the bending process of the sheet metal, friction occurs.

For more resistance strength the hardening of the surfaces can be increased. The depth of the hardening must be at least 3 mm to avoid deformations. We use the electromagnetic technique also known as induction hardening to the best quality for your money's worth.

Quality Control and Laser Marking

After the laser marking, tracking of every tool is possible with a unique serial number on every article. Therefore the tracking of your tools is guaranteed and a new productions with the exact same measurements (angle, radius, hardening, etc.) is possible. This step is happens after quality control.

Individual markings are upon request possible.



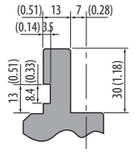
EDM Wire

By using EDM wire, hardened and very tough material can be retrofitted. The process is operated based on a CAD-system which can also process high dimensions such as special shapes.

Modified Tangs

- Rolleri Punches Type R1, R2, and R3 can be used on other press brake machines by modifying the tang.
- Precision ground (Tolerance of +/-0.01 mm)
- exact parallelism
- fast, economic, precise

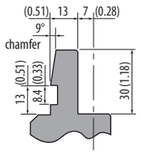
Standard Rolleri Type R1



Fast delivery on these items guaranteed. Please note that delivery terms vary according to your location.

OT

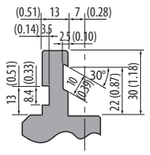
Modification for:
- for Amada fast clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A1

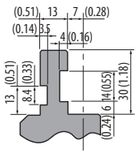
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- pneumatic clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A6

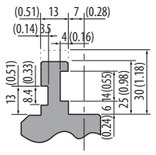
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A7

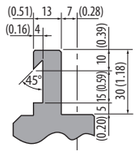
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
- Rolleri Type R3
- Bystronic-Beyeler Euro
- Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A8

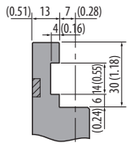
Groove Bar/Tail for:
- hydraulic clamping system Gasparini



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A41

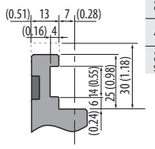
older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A42

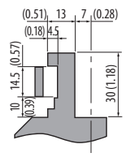
older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A43

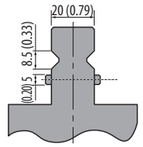
Groove with steel bar for:
- segmented punches



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

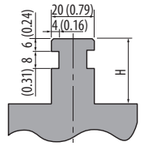
ROLLERI® PROFESSIONAL BENDING

Standard Rolleri Type R2

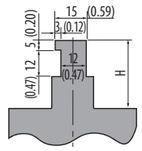


Modification examples Type R2

production according to your specifications

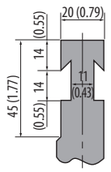


production according to your specifications



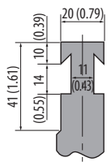
Take advantage of your existing tools with means of modifications.

Standard Rolleri Type R3

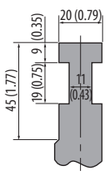


Modification examples Type R3

production according to your specifications



production according to your specifications



13

Article on stock
Please ask for delivery time!
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)
Articles on stock – Please note that delivery time depends on your location.

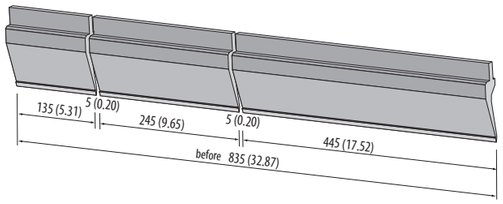
Special Sectioning

- Individual sectioning of your punches and dies
- fast, economic, precise

Pro separation cutting causes a decrease in length of approx. 5 mm

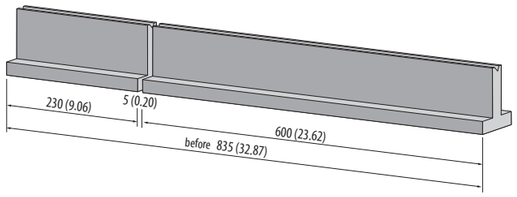
Special Sectioning of Punches

Example of punches
production according to your specifications



Special Sectioning of Dies

Example of Dies
production according to your specifications

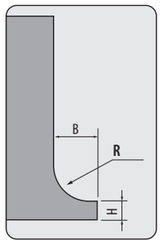


Horn Pieces

- individual horn pieces on punches and dies
- on one or both sides
- fast, economic, precise

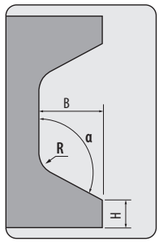
Horn Pieces for Punches

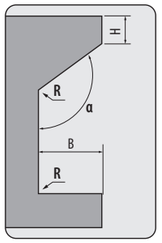
Punch example
production according to your specifications



Horn Pieces for Dies

Die example
production according to your specifications



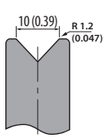


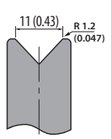
Modifying the V-Opening

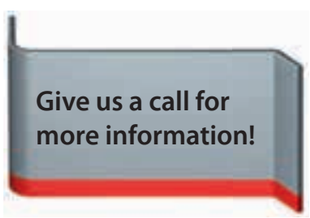
- individual modification for dies
- fast, economic, precise

Modifying the V-Opening

Example
production according to your specifications







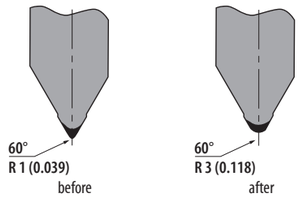
ROLLERI® PROFESSIONAL BENDING

Radius and Angle Modifications

- Individual modifications of your punches and dies
- fast, economic, precise

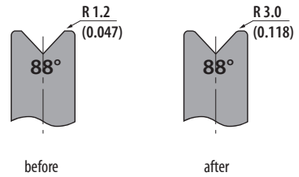
Radius Modifications for Punches

Radii modification Punch example
production according to your specifications



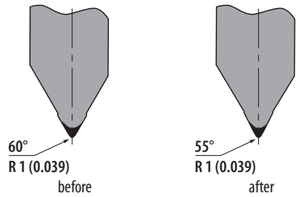
Radius Modifications for Dies

Opening Radius modification die example
production according to your specifications



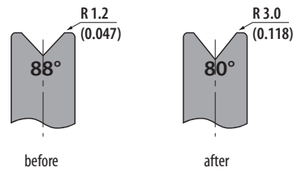
Angle Modification Punches

Angle modification punch example
production according to your specifications



Angle Modification Dies

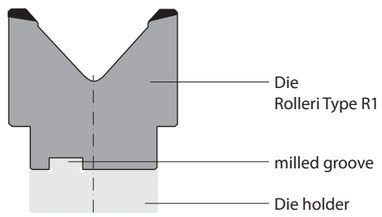
Angle modification die example
production according to your specifications



Grooves for Dies

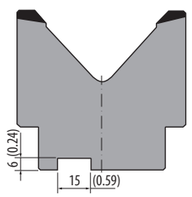
- Milling of grooves for use on other press brake systems
- fast, economic, precise

Mounting example



A28

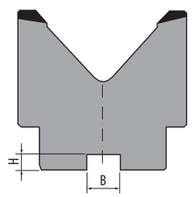
Groove for die holder



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A29

groove production according to your specifications



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

13

Article on stock

Please ask for delivery time!

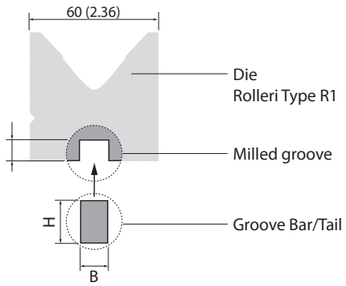
1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

Grooves und Groove Bars/Tails for Dies

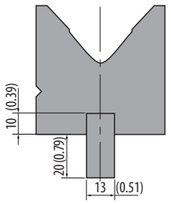
- For milling of the groove and the insert of a ground groove bar/tail the exact measurement is needed to use on other press brake systems
- fast, economic, precise

Mounting example



A30

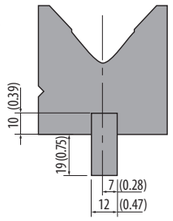
Groove Bars/Tails:
13 x 30 mm (0.51 x 1.18 in) for
- Rolleri Type R2
- Rolleri Type R3



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A31

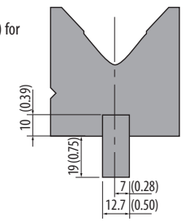
Groove Bars/Tails:
12 x 29 mm (0.47 x 1.14 in) for
- Rolleri Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A32

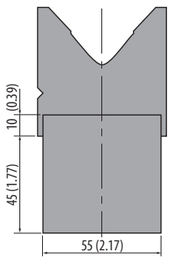
Groove Bars/Tails:
12.7 x 29 mm (0.50 x 1.14 in) for
- Rolleri Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A44

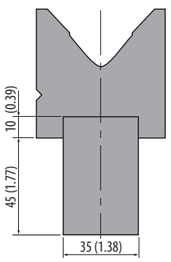
Groove Bars/Tails:
55 x 55 mm (2.17 x 2.17 in) for
- Rolleri Type RX EHT



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A45

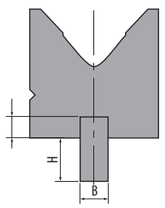
Groove Bars/Tails:
35 x 55 mm (1.38 x 2.17 in) for
- Rolleri Type RX Weinbrenner



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

AX

individual Groove Bars/Tails
for other systems



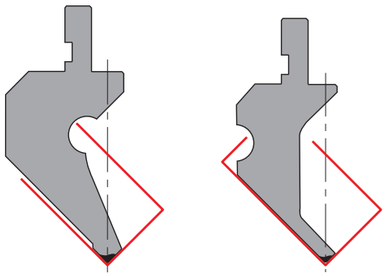
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

Gaps and Windows

- The retrofitting of the tool edges of long parts, short U-profiles and similar
- fast, economic, precise

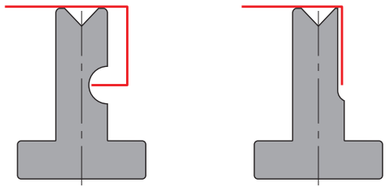
Gaps on Punches

Example Punches
production according to your specifications



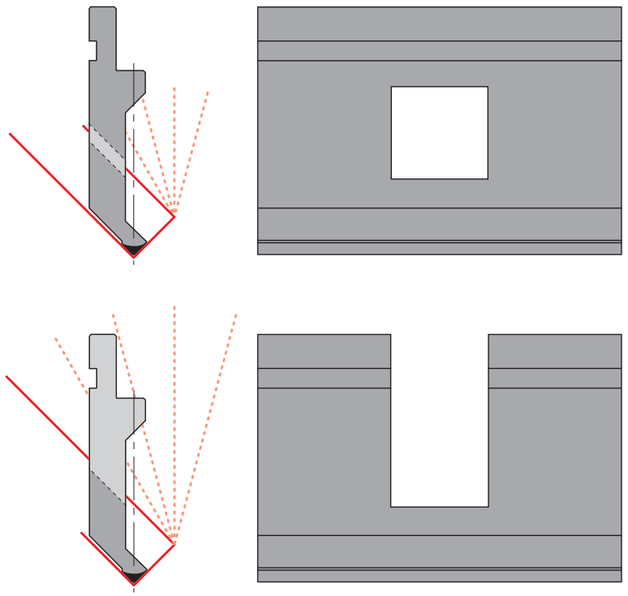
Gaps on Dies

Example Dies
production according to your specifications



Windows for Punches

Example Punches
production according to your specifications



Article on stock

Please ask for delivery time!

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

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

ROLLERI®

ROLLERI **SHEAR BLADES** AND **ACCESSORIES**

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Shear Blades	260 - 261

Tooling Cabinets

Our Advantages – Your Convenience

- Protection against contamination and damage
- Faster access
- Robust construction
- Clear and tidy storage
- Cabinet doors specially designed for lift trucks and truck
- Adjustable height, zinc-plated shelves

Rolleri Videos

Tool storage demonstration at:
www.rolleritools.com/videos/tooling-cabinets

ARM 835-4

for max. tool length = 835 mm (32.87 in)

850 x 1240 x 1050 (W x H x D)
33.46 x 48.82 x 41.34 (W x H x D)

for Tools Rolleri 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 Rolleri 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 Rolleri Type R2/R3
approx. 26 m / 39 m (1023.62 in / 1535.43 in) Storage capacity

Equipment **ARM 1060-4**	
4 Drawers	vertical, on wheels (see CS-2)
16 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
4 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	340.0 kg

Equipment **ARM 1060-4-CV**	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	351.0 kg

ARM 1060-5 / -CV

for max. tool length = 1060 mm (41.73 in)

1040 x 1240 x 1360 (W x H x D)
40.94 x 48.82 x 53.54 (W x H x D)

for Tools Rolleri Type R2/R3
approx. 32.5 m / 52 m (1279.52 in / 2047.24 in) Storage capacity

Equipment **ARM 1060-5**	
5 Drawers	vertical, on wheels (see CS-2)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
5 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	400.0 kg

Equipment **ARM 1060-5-CV**	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
30 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	490.0 kg

Tool Cabinets

ROLLERI® PROFESSIONAL BENDING

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 Rolleri Type R2/R3
approx. 20.8 m / 31.2 m (818.89 in / 1228.34 in) Storage capacity

Equipment **ARM 1060-4-T**	
4 Drawers	vertical, on wheels (see CS-2)
8 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	383.0 kg

Equipment **ARM 1060-4-T-CV**	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
16 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	360.0 kg

ARM 1060-5-T / -CV

for max. tool length = 1060 mm (41.73 in)

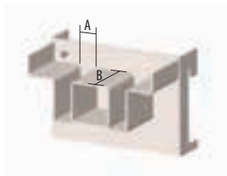
1040 x 1240 x 1360 (W x H x D)
40.94 x 48.82 x 53.54 (W x H x D)

for tools Rolleri Type R2/R3
approx. 26 m / 41.6 m (1023.62 in / 1637.79 in) Storage capacity

Equipment **ARM 1060-5-T**	
5 Drawers	vertical, on wheels (see CS-2)
10 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
10 Shelves	for type R2/R3 (see shelves UT-4)
Weight	447.0 kg

Equipment **ARM 1060-5-T-CV**	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
24 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	500.0 kg

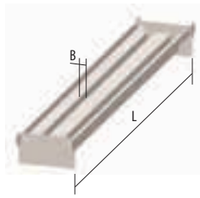
UC-Shelves



Model	L mm (in)	A mm (in)	B mm (in)	Weight
UC-13-1	125 (4.92)	13 (0.51)	76 (2.99)	0.5 kg
UC-13-2	250 (9.84)	13 (0.51)	232 (9.13)	1.0 kg
UC-20-1	125 (4.92)	20 (0.79)	76 (2.99)	0.5 kg
UC-20-2	250 (9.84)	20 (0.79)	232 (9.13)	1.0 kg

2 pieces

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

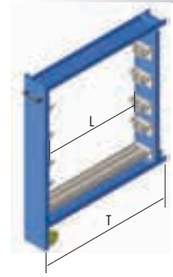
Model	L (mm)	L (in)	Weight
UT-1	270	10.63	1.4 kg
UT-2	580	22.83	3.2 kg
UT-3	1050	41.34	5.8 kg
UT-4	1360	53.54	7.5 kg

enough room for punches with safety pins

UV-Shelves

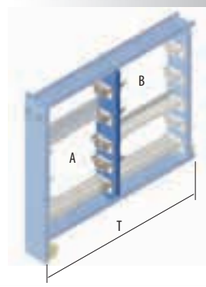
Model	L (mm)	L (in)	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg

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

on stock Article on stock

Please ask for delivery time!

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

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

Tool Trolley

Our Advantages – Your Convenience

- faster access
- robust construction
- clear and tidy storage
- visibility of tools

Tool Trolleys

Model	Content	Tool System	Weight
A Trolley	30 Shelves	**for R1 tools**	108.0 kg
T Trolley	21 Shelves	**for R2 tools**	175.0 kg
B Trolley	21 Shelves	**for R3 tools**	135.0 kg

Rolleri Videos

Secure storage and mobility:
www.rolleritools.com/videos/tool-trolley

Bending Box

Bending Box

per piece | 1.6 kg

ROLLERI® PROFESSIONAL BENDING

Squaring Arms

Our Advantages – Your Convenience

- easy and fast securing
- percise and flexible adjustability
- adjustable angle stop
- mountable on all dies
- ideal for long, and thin sheet metals

Rolleri Videos

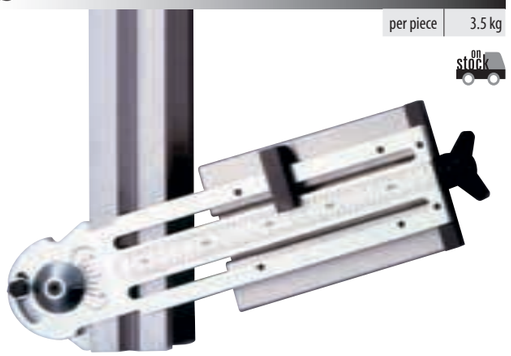
Magnetic Squaring Arms :
www.rolleritools.com/videos/squaring-arms

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 Ounzes (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)

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

Supporting Arms and Back Gauge

RIF-Supporting Arm

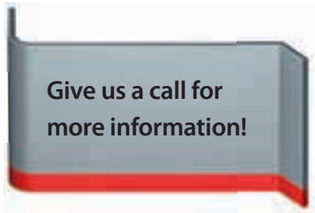
Model	Length mm (in)		Weight
RIF500	500	(19.68)	7.0 kg
RIF1000	1000	(39.37)	12.0 kg
RIF1500	1500	(59.05)	17.0 kg

- for secure support for high volume sheet metals
- greater surface guarantees a trouble-free support for sheet metals
- easy handling

RP-Back Gauge

Model	Weight
RP500A	8.0 kg
RP500B	8.0 kg

- ensures for the correct posistioning of tools on the press brake and secures herewith the exact border distance.
- fast and exact repeatability
- easy handling



Shear Blades

We manufacture in our company over more than 20 years shear blades.

High-quality steels are finished according to your specifications.

Please provide us with the following information:

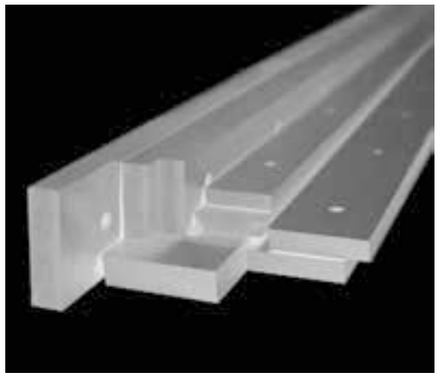
- What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.
- How thick is the material in diameter?
- How often do you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

Shear Blades

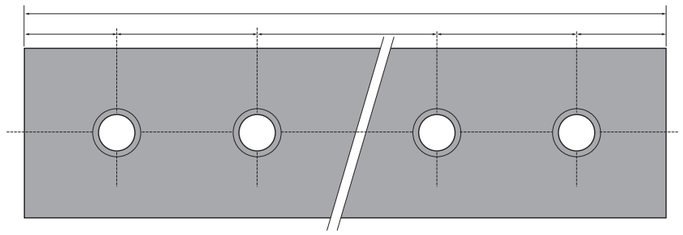
Our Advantages – Your Convenience

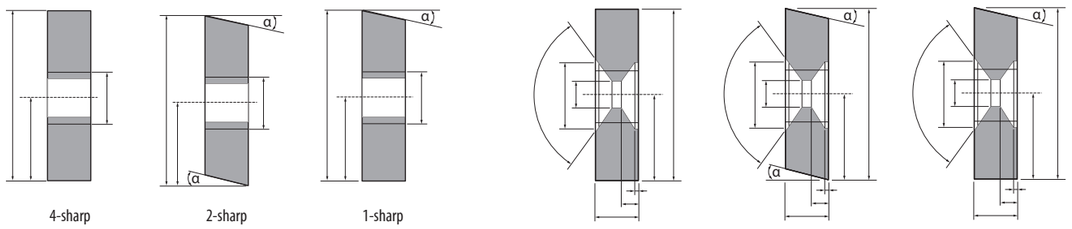
- own production
- custom production
- depending on the cutting material
- high quality Materials
- 4-, 2- or 1-sharp
- with threaded holes or bilateral reduction
- hardened according to your specifications and request

available sizes mm (in)				
50 x 10 (1.97 x 0.39)	55 x 12 (2.17 x 0.47)	60 x 12 (2.36 x 0.47)	65 x 13 (2.56 x 0.51)	70 x 13 (2.76 x 0.51)
50 x 11 (1.97 x 0.43)	55 x 13 (2.17 x 0.51)	60 x 13 (2.36 x 0.51)	65 x 14 (2.56 x 0.55)	70 x 14 (2.76 x 0.55)
50 x 12 (1.97 x 0.47)	55 x 14 (2.17 x 0.55)	60 x 14 (2.36 x 0.55)	65 x 15 (2.56 x 0.59)	70 x 15 (2.76 x 0.59)
50 x 13 (1.97 x 0.51)	55 x 15 (2.17 x 0.59)	60 x 15 (2.36 x 0.59)	65 x 16 (2.56 x 0.63)	70 x 16 (2.76 x 0.63)
50 x 14 (1.97 x 0.55)	55 x 16 (2.17 x 0.63)	60 x 16 (2.36 x 0.63)	65 x 17 (2.56 x 0.67)	70 x 17 (2.76 x 0.67)
50 x 15 (1.97 x 0.59)	55 x 17 (2.17 x 0.67)	60 x 17 (2.36 x 0.67)	65 x 18 (2.56 x 0.71)	70 x 18 (2.76 x 0.71)
	55 x 18 (2.17 x 0.71)	60 x 18 (2.36 x 0.71)	65 x 19 (2.56 x 0.75)	70 x 19 (2.76 x 0.75)
	55 x 19 (2.17 x 0.75)	60 x 19 (2.36 x 0.75)	65 x 20 (2.56 x 0.79)	70 x 20 (2.76 x 0.79)
	55 x 20 (2.17 x 0.79)	60 x 20 (2.36 x 0.79)		



available sizes mm (in)				
75 x 15 (2.95 x 0.59)	80 x 16 (3.15 x 0.63)	85 x 18 (3.35 x 0.71)	90 x 20 (3.54 x 0.79)	100 x 20 (3.94 x 0.79)
75 x 16 (2.95 x 0.63)	80 x 18 (3.15 x 0.71)	85 x 19 (3.35 x 0.75)	90 x 21 (3.54 x 0.83)	100 x 22 (3.94 x 0.87)
75 x 17 (2.95 x 0.67)	80 x 19 (3.15 x 0.75)	85 x 20 (3.35 x 0.79)	90 x 22 (3.54 x 0.87)	100 x 25 (3.94 x 0.98)
75 x 18 (2.95 x 0.71)	80 x 20 (3.15 x 0.79)	85 x 21 (3.35 x 0.83)	90 x 23 (3.54 x 0.91)	100 x 26 (3.94 x 1.02)
75 x 19 (2.95 x 0.75)	80 x 21 (3.15 x 0.83)	85 x 22 (3.35 x 0.87)	90 x 24 (3.54 x 0.94)	100 x 27 (3.94 x 1.06)
75 x 20 (2.95 x 0.79)	80 x 22 (3.15 x 0.87)	85 x 23 (3.35 x 0.91)	90 x 25 (3.54 x 0.98)	100 x 28 (3.94 x 1.10)
75 x 21 (2.95 x 0.83)	80 x 23 (3.15 x 0.91)	85 x 24 (3.35 x 0.94)		100 x 29 (3.94 x 1.14)
75 x 22 (2.95 x 0.87)	80 x 24 (3.15 x 0.94)	85 x 25 (3.35 x 0.98)		100 x 30 (3.94 x 1.18)
75 x 23 (2.95 x 0.91)	80 x 25 (3.15 x 0.98)			
75 x 24 (2.95 x 0.94)				
75 x 25 (2.95 x 0.98)				





4-sharp 2-sharp 1-sharp

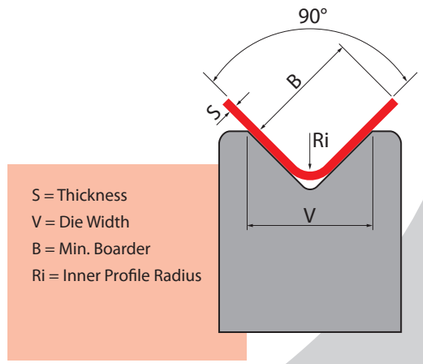
Article on stock | Please ask for delivery time! | 1 kg = 2.20 Pounds (lb) = 35.27 Ounzes (oz) 100 mm = 3.94 Inch (in) = 0.33 Feet (ft) | Articles on stock – Please note that delivery time depends on your location.

Press Force Table

The press force table is based on the press force caliper and is very useful to those who deal with sheet metal profiles. It can assist you from the projection of profiles, to technical construction, to the buying of tools, and to the finished profile from the press brake machine.

In the first left column the thickness of the sheet metal is noted as (S). In the three first lines you can find the die width (V), the minimum boarder (B), and the ideal inner profile radius (Ri).

By crossing the thickness with the die width, you will find the necessary press force per meter. Furthermore, depicted are the span of 5 different die widths. The correction factors are found below in the table.



420 N/mm²																				
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								F kN/m
5.0									760	540	390	290	220							
6.0										850	620	450	330	250						
8.0											1210	880	700	460	350					
10.0												1510	1090	790	580	440				
12.0													1730	1240	910	660	500			
15.0														2130	1550	1130	810	620		
20.0															3020	2200	1580	1150	890	
25.0																3780	2690	1970	1440	

INOX – stainless steel R 700 N/mm² Ton x 1.7
AL – aluminium R 200 N/mm² Ton x 0.5
(R = tensile strength)

30°	B x 1.6	R=200 N/mm²	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm²	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm²	r x 1.4	INOX

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