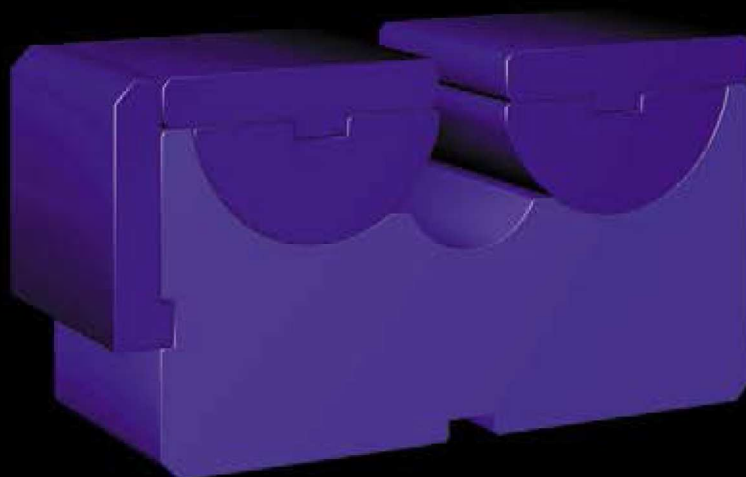
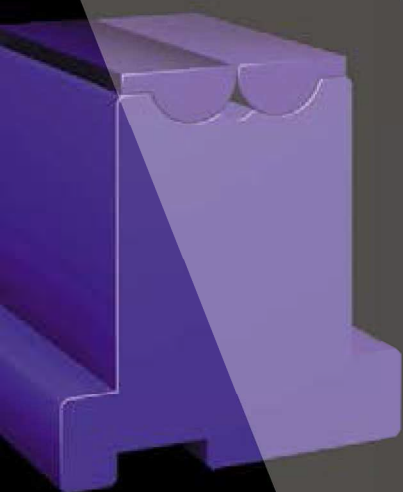
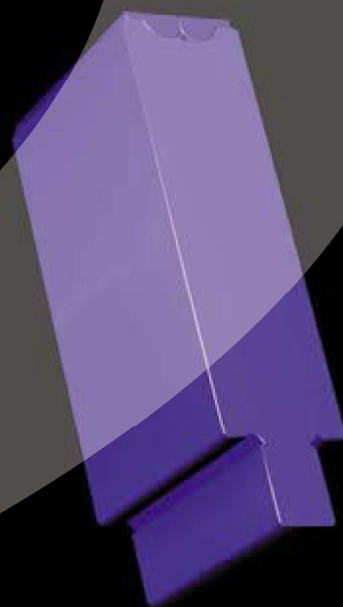
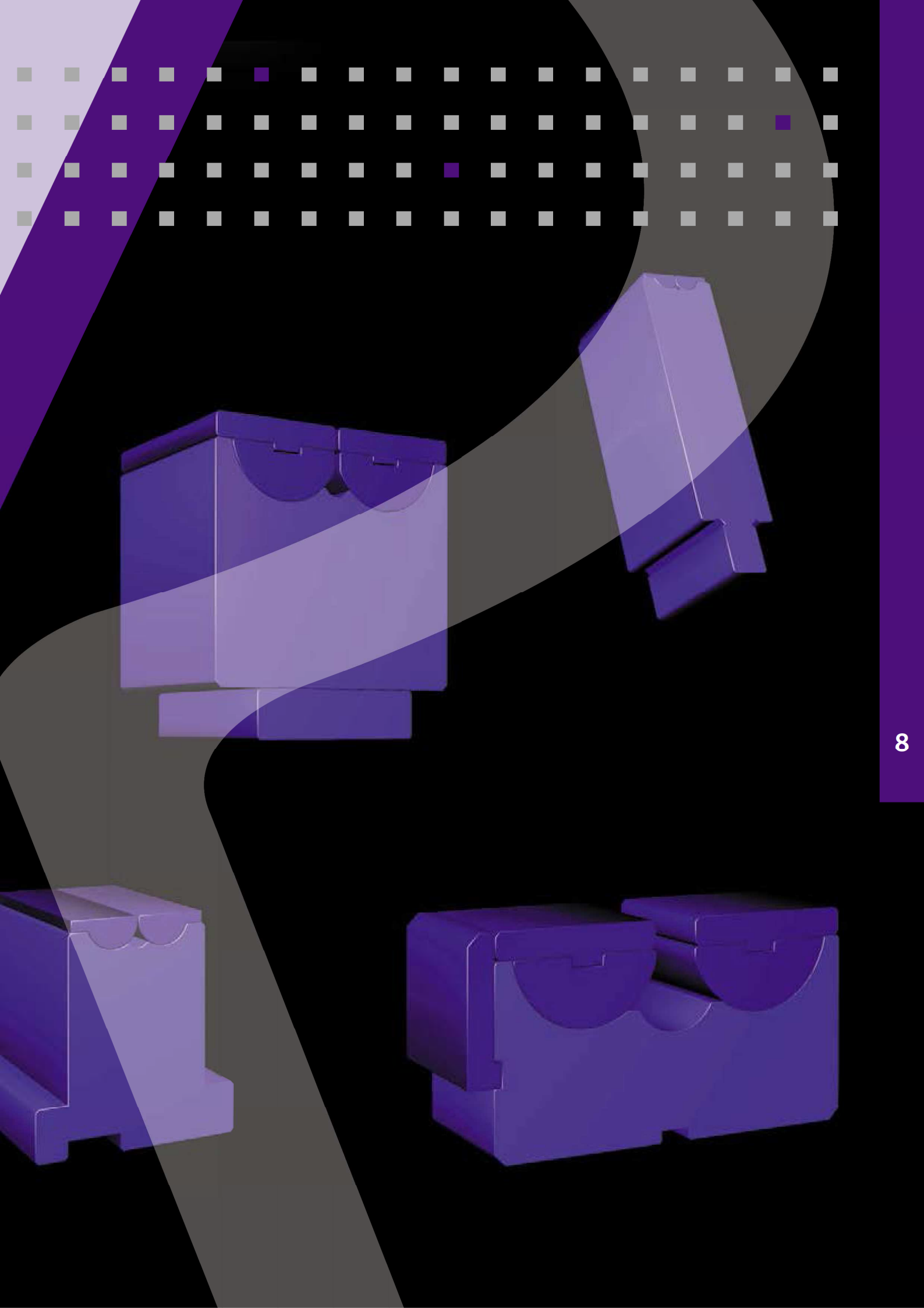


ROLLERI DIES ROLLA-V

Content Explanation	198 - 199
Model 1	200
Model 2	201
Model 2.5	201
Model 3	202
Model 4	202
Adjustable Dies	203
Hemming- and Joggle Tools	203



Content Explanation

Compatibility

- **RVP Dies (Models 1, 2, 3)** are **compatible** with press brake machines (60 mm / 2.36 in die holder) from: ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- **RVS Dies (Models 1, 2, 3)** are **compatible** with press brake machines (14 mm / 0.55 in pins) from: Amada Single V style
- **RVT Dies (Models 1, 2, 3)** are **compatible** with press brake machines (12.7 mm / 0.50 in / 13 mm / 0.51 in pins) from: Bystronic, Hämmerle, Beyeler, Edwards, Safan, SMD, Trumpf
- **RVT90 Dies (Models 1, 2, 3)** are **compatible** with press brakes machines (12.7 mm / 0.50 in pins) from: LVD
- **RVM Dies (Models 2.5, 3, 4)** are **compatible** with all press brake machines (various die holders)
- all dies are compatible on other press brakes machines with the means of adapter-systems or customized die holders.

Our Advantages – Your Convenience

- highly precision ground
- interchangeability guaranteed
- exact Parallelism
- reducing 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
- fewer tool exchange
- ideal for diagonal or tapered edges



Material

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

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4	1100-1200 N/mm ²	55 HRc
Inserts	1 / 2 / 2.5	Toolox 44	1450 N/mm ²	through hardened 44 HRc
Inserts	3 / 4	Toolox 33	1100 N/mm ²	55 HRc

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

	Equivalent V size mm (in)	max. tool load (kN/m)	Material Thickness mm (in)		min. bending angle	needed press force (kN)	min. outside flange mm (in)		max. outside radius mm (in)	
Model 1 Max. recommended thickness =1.5 mm (0.06 in) (2.0 mm / 0.08 in possible)	8 (0.31)	1000	0.70	(0.03)	40°	50	3.0	(0.12)	3.0	(0.12)
		1000	1.10	(0.04)	35°	130	3.9	(0.15)	2.6	(0.10)
		1000	1.50	(0.06)	35°	270	4.2	(0.17)	2.2	(0.09)
Model 2 Max. recommended thickness =3.0 mm (0.12 in) (4.0 mm / 0.15 in possible)	15 (0.59)	1500	2.00	(0.08)	59°	210	8.5	(0.33)	6.0	(0.24)
		1500	3.00	(0.12)	47°	550	9.3	(0.37)	5.0	(0.20)
		1500	3.20	(0.13)	47°	650	9.3	(0.37)	4.8	(0.19)
Model 2.5 Max. recommended thickness =5.0 mm (0.20 in) (6.35 mm / 0.24 in possible)	28 (1.10)	2500	2.00	(0.08)	46°	100	18.6	(0.73)	13.2	(0.52)
		2500	4.00	(0.16)	46°	470	18.6	(0.73)	12.0	(0.47)
		2500	6.00	(0.24)	55°	1270	18.6	(0.73)	9.8	(0.39)
Model 3 Max. recommended thickness =6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)	38 (1.50)	2500	2.00	(0.08)	68°	70	22.5	(0.89)	13.9	(0.55)
		2500	4.00	(0.16)	47°	340	22.5	(0.89)	11.9	(0.47)
		2500	6.00	(0.24)	50°	900	22.5	(0.89)	9.9	(0.39)
Model 4 Max. recommended thickness =16.0 mm (0.63 in)	85 (3.35)	3000	6.00	(0.24)	78°	260	56.6	(2.23)	36.4	(1.43)
		3000	8.00	(0.31)	76°	500	56.6	(2.23)	36.4	(1.43)
		3000	12.00	(0.47)	73°	1290	56.6	(2.23)	36.4	(1.43)

Content Explanation

Tool lengths and sectioning

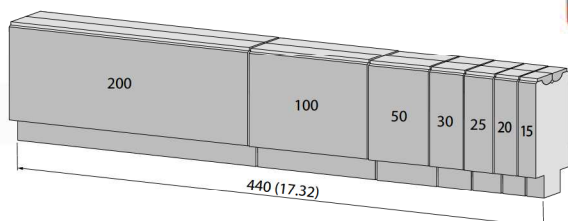
Standard

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

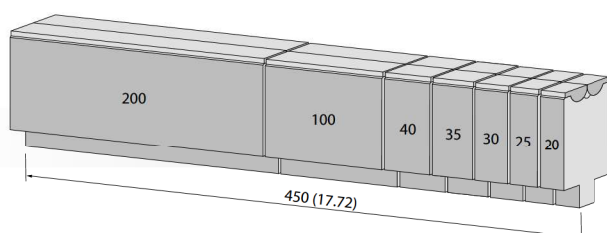
More lengths and sectionings are possible upon request.

500 mm (19.68 in)

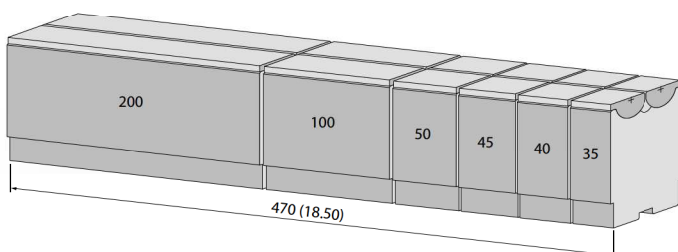
200 mm (7.87 in)



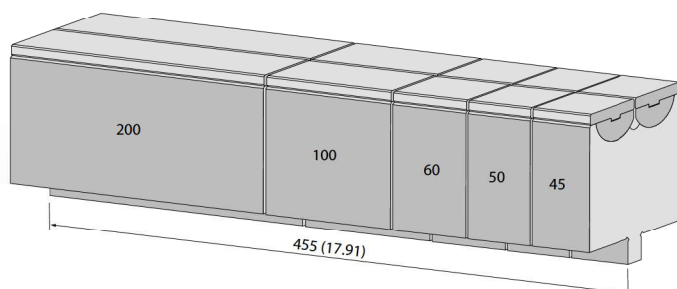
Model 1, 440 mm (17.32 in) segmented
(7 segments)



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)



Article
on stock



Please ask for
delivery time!

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



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

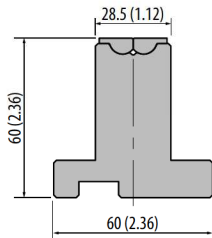
DIES ROLLA-V

Model 1

RVP60-1

1000 kN/m max.

NEW



500 mm	16.68 in	6.9 kg
440 mm segmented	17.32 in segmented	6.1 kg

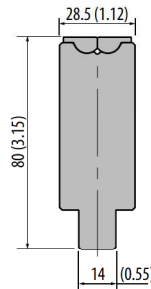
42Cr: 1100-1200 N/mm²



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

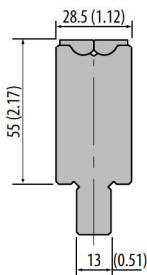
42Cr: 1100-1200 N/mm²



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

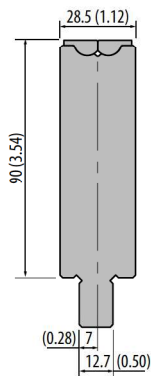
42Cr: 1100-1200 N/mm²



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

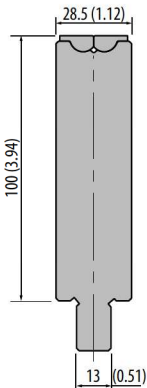
42Cr: 1100-1200 N/mm²



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



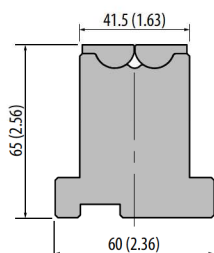
Ideal for thick material!
Making the impossible,
possible ...



Model 2

RVP65-2

1500 kN/m max.

NEW


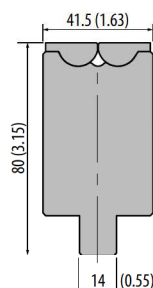
500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm²



RVS80-2

1500 kN/m max.

NEW


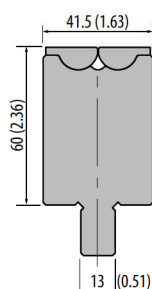
500 mm	16.68 in	8.3 kg
450 mm segmented	17.72 in segmented	7.8 kg

42Cr: 1100-1200 N/mm²



RVT60-2

1500 kN/m max.

NEW


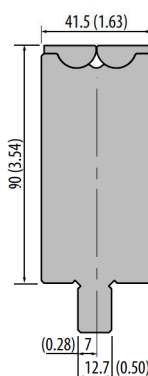
500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm²



RVT90-2

1500 kN/m max.

NEW


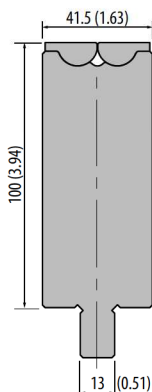
500 mm	16.68 in	11.3 kg
450 mm segmented	17.72 in segmented	10.6 kg

42Cr: 1100-1200 N/mm²



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

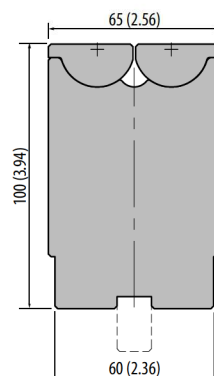
42Cr: 1100-1200 N/mm²



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


Rolleri Videos


Use and application of Rolla-V dies

www.rolleritools.com/videos/rolla-v

 Article
on stock

 Please ask for
delivery time!

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

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

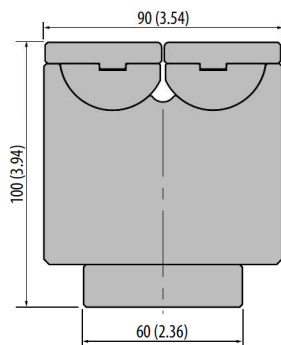
DIES ROLLA-V

Model 3

RVP100-3

2500 kN/m max.

NEW



500 mm	16.68 in	28.8 kg
455 mm segmented	17.91 in segmented	26.2 kg

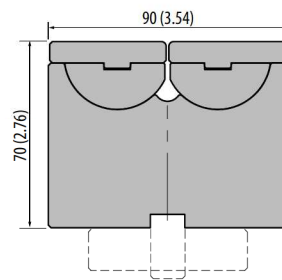
42Cr: 1100-1200 N/mm²



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



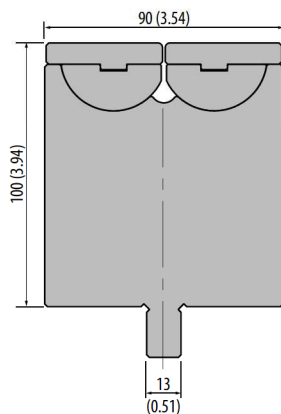
Possible Die Holders:

- 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

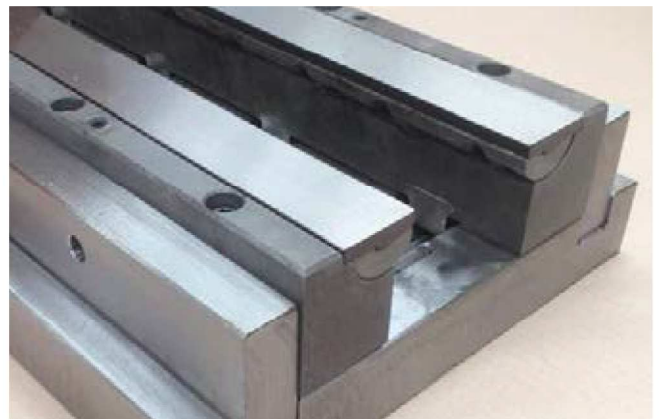
2500 kN/m max.

NEW



500 mm	16.68 in	30.9 kg
455 mm segmented	17.91 in segmented	28.5 kg

42Cr: 1100-1200 N/mm²



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.

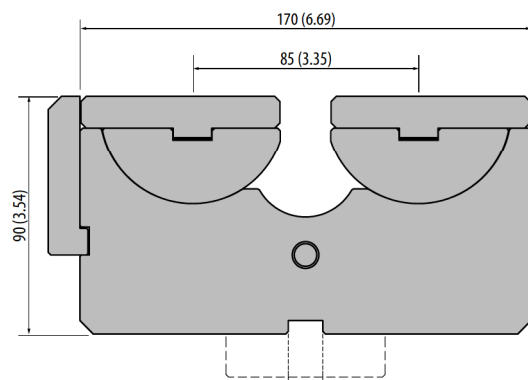
- Minimum borders are highly dependant on the squareness of the component.
- Enlargement and hole distortion will be greatly reduced, however will be influenced depending on the type of material
- Radius bending is strongly influenced by the elastic return of specific material and flange-size.

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



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

Our advantages – Your Convenience

- bending possible up to the thickness of 30 mm
- inserts hardened
- no traditional bending marks
- adjustable openings
 RVPV3 = 39-94 mm (1.54-3.70 in)
 RVHD3 = 39-118 mm (1.54-4.65 in)
 RVHD4 = 70-220 mm (2.76-8.66 in)
- bends laser-cut sheet metal without damaging the tool
- exact inner radius

RVPV3

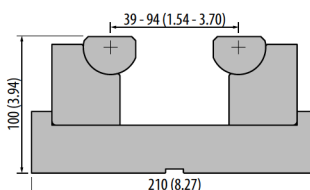
2500 kN/m max.

NEW

42Cr: 1100-1200 N/mm²



500 mm	16.68 in	50.0 kg
200 mm	7.87 in	20.0 kg



RVHD3

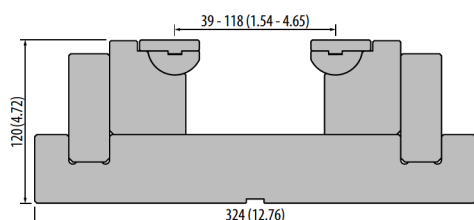
3500 kN/m max.

NEW

42Cr: 1100-1200 N/mm²



500 mm	16.68 in	98.0 kg
200 mm	7.87 in	38.1 kg



RVHD4

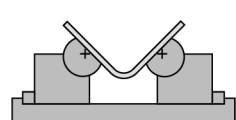
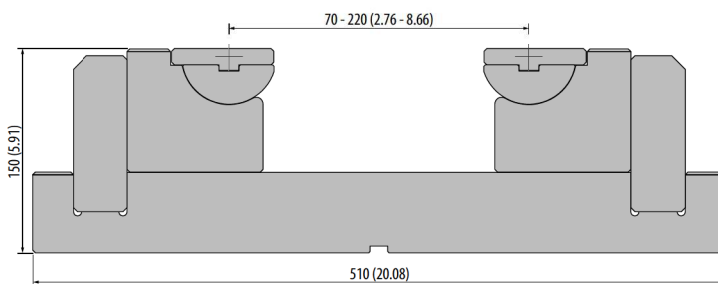
3500 kN/m max.

NEW

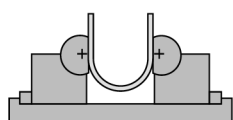
42Cr: 1100-1200 N/mm²



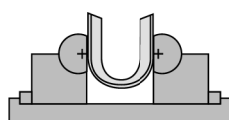
500 mm	16.68 in	200.0 kg
200 mm	7.87 in	80.0 kg



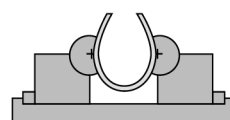
- V-Bending
- flat inserts



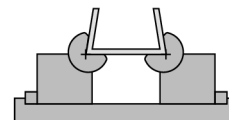
- Radius-Bending
- flat inserts



- Conical Bending
- flat inserts



- Radius-Overbending
- concave inserts

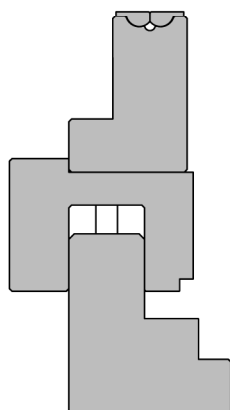


- U-Bending
- V-inserts

Hemming- and Z-Tools

Hemming Tool

NEW



per piece | Price upon request

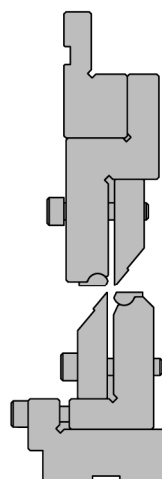
Production according to your specifications

42Cr: 1100-1200 N/mm²



Joggle Tool

NEW



per piece | Price upon request

Production according to your specifications

42Cr: 1100-1200 N/mm²

