



**ROLLERI®**

**PROFESSIONAL  
BENDING**

**DIRECTLY  
FROM THE  
MANUFACTURER!**



**PRESS BRAKE TOOLS**

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

## ROLLERI

### WELCOME ...

... to the new Rolleri catalogue!

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

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

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



### THE COMPANY

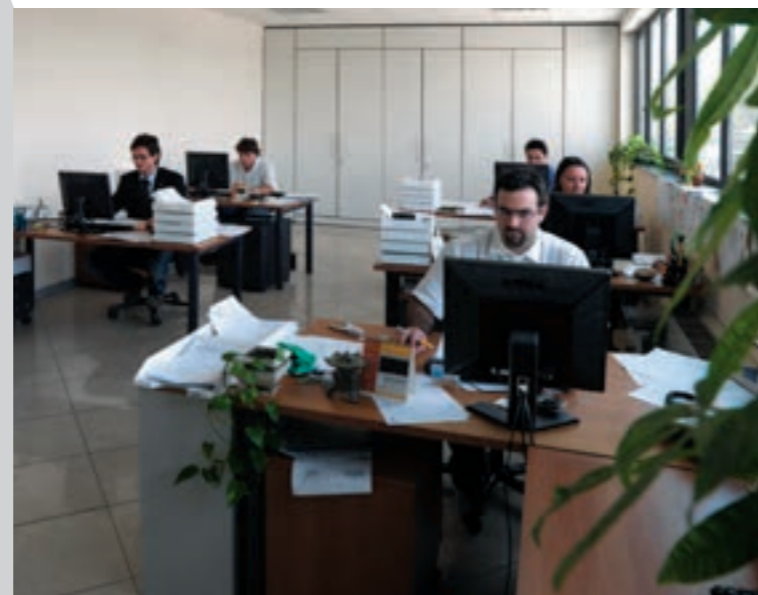
Since 1987 we have been producing standard and special tooling. The family owned company (Francesco and Marco Rolleri) can nowadays be considered one of the largest press brake tooling manufacturers in Europe. We are internationally available with our branches Rolleri Brasil, Rolleri USA, Rolleri India,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

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

### THE TEAM

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

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



### Rolleri Videos

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



### THE PRODUCTION

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

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

This is what we call accurate repetition.



### THE WAREHOUSE

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



Look for this symbol in the catalogue!



### THE SERVICE

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

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

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



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

# ROLLERI

## Professional Bending

### THE CONSTRUCTION

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

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

Inquire with us today!



### THE RAW MATERIAL

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



### THE QUALITY

Rolleri ISO 9001:2008 certified.

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

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

### THE PRESS BRAKE TOOLS

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

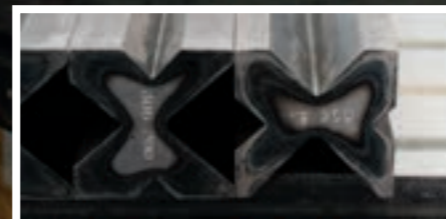
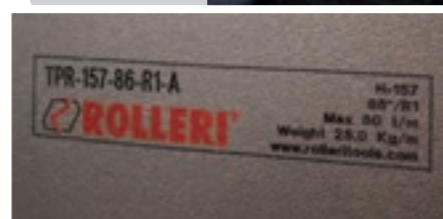


### THE QUALITY CONTROL

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

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

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



### INNOVATIONS

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

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



## Compatibility

### ■ Tools Roller Type R1

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

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

### ■ Tools Roller Type R2

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

### ■ Tools Roller Type R3

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

### ■ Tools Roller Type RX

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

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

PUNCHES ROLLERI TYPE R1

DIES ROLLERI TYPE R1

PUNCHES ROLLERI TYPE R2

DIES ROLLERI TYPE R2

PUNCHES ROLLERI TYPE R3

DIES ROLLERI TYPE R3

TOOLS ROLLERI TYPE RX

ROLLERI DIES ROLLA-V

ROLLERI CLAMPING SYSTEMS

ROLLERI ADAPTERS

ROLLERI MARK FREE BENDING

ROLLERI SPECIAL AND HEAVY DUTY TOOLS

ROLLERI SERVICE / MODIFICATIONS

ROLLERI SHEAR BLADES / ACCESSORIES

## PUNCHES ROLLERI TYPE R1

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| 88° Segmented Punches with Mobile Horns | 18      |
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### Compatibility

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

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



### Compatibility

Punches Roller Type R1 are:

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

### Material

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

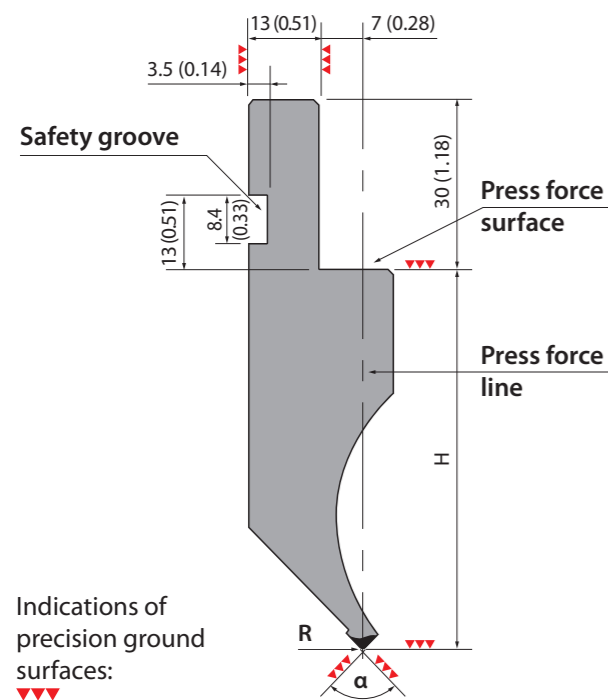
| Material Type | Mechanical resistance of the material and the tool body | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------------|---|--|--|
| 42CrMo4       | 900-1150 N/mm <sup>2</sup>                              | 29.1 - 36.9 HRC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

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

### Tang

All punches Roller Type R1:

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



Indications of precision ground surfaces: ▼▼▼

### Our Advantages – Your Convenience

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

### Modifications from Safety Grooves

**A1**  
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:  
• Pneumatic clamping

**A6**  
Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:  
• Roller 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:  
• Roller Type R3  
• Bystronic-Beyeler Euro  
• Safan

**A8**  
Groove for:  
• hydraulic clamping  
Gasparini

**A9**  
Modified groove for:  
• Roller Type R3

**A41**  
Modified groove for:  
• Roller Type R3

**A42**  
Modified groove for:  
• Roller Type R3

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

# R1 ROLLERI TYPE R1

## Content Explanation Punches

### Tool lengths and sectioning

Standard

- 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

- 495 mm (19.49 in) segmented (8 segments)
- 500 mm (19.68 in) segmented (3 segments)
- 525 mm (20.67 in)

### Horn Types

| Horn Type       | Dimensions                                   | Application                               | Part Numbers               |
|-----------------|--|---|----------------------------|
| Horn 1 Standard | R 25 (0.98), 20 (0.79), 9 (0.35)             | for all segm. Punches Roller Type R1      | 00402, 00430, 04702        |
| Horn 2 TOP      | 30 (1.18), R 20 (0.79), 120°, 13 (0.51)      | for all segm. TOP Punches Roller Type R1  | 11700, 10900, 10906        |
| Horn 3          | 35 (1.38), R 5 (0.197), 10 (0.39), 35 (1.38) | for punches:                              | 00402, 00430, 04702        |
| Horn 4          | 25 (0.98), R 10 (0.39), 10 (0.39), 20 (0.79) | for punches:                              | 20000, 20200, 10900, 10906 |
| Horn 5          | 20 (0.79), R 8 (0.31), 12 (0.47), 18 (0.71)  | for punches:                              | 10300                      |
| Horn 6          | 30 (1.18), R 5 (0.197), 12 (0.47), 35 (1.38) | for punches:                              | 00300                      |
| Horn individual | B, R   | produced according to your specifications |                            |

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www.rolleritools.com

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.

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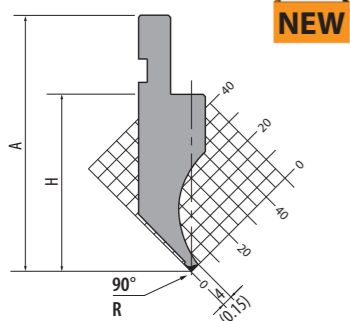
1 R1

# R1 ROLLERI TYPE R1

## 90° Punches

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

350 kN/m max.

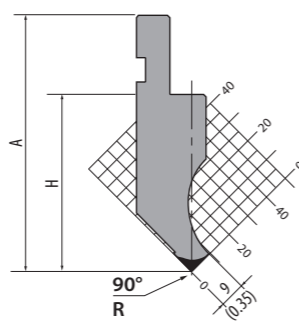


|   |                    |         |
|---|--------------------|---------|
| <b>PK.97.90.R06</b>                                       |                    |         |
| H=66.80 / A=96.80 / R=0.6<br>(H=2.63 / A=3.81 / R=0.024)  |                    |         |
| 835 mm  | 32.87 in           | 10.5 kg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

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

### PK.97.90.R08 / R025

1000 kN/m max.

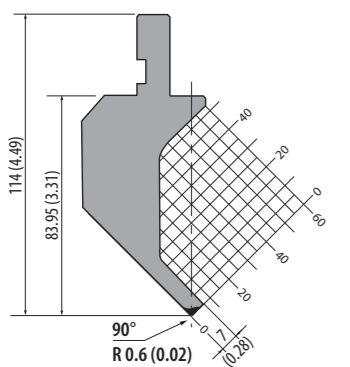


|   |                    |         |
|---|--------------------|---------|
| <b>PK.97.90.R08</b>                                       |                    |         |
| H=66.35 / A=96.35 / R=0.8<br>(H=2.61 / A=3.79 / R=0.031)  |                    |         |
| 835 mm  | 32.87 in           | 11.0 kg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

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

### PK.114.90.R06

200 kN/m max.

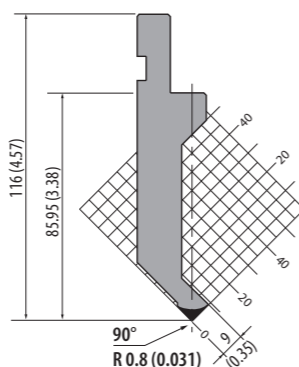


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 14.0 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 13.3 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### PK.116.90.R08

400 kN/m max.

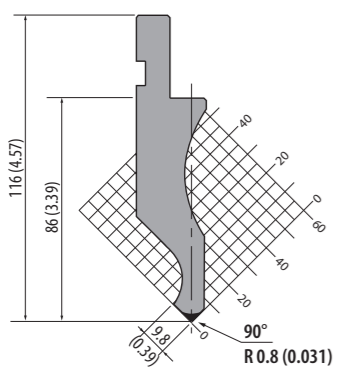


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### DK.116.90.R08

500 kN/m max.

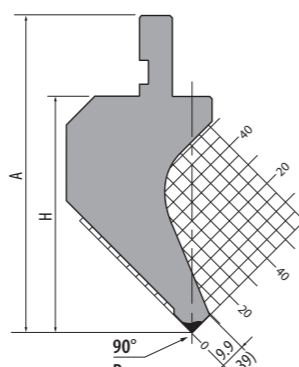


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### PK.120.90.R08 / R025

600 kN/m max.



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

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

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

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

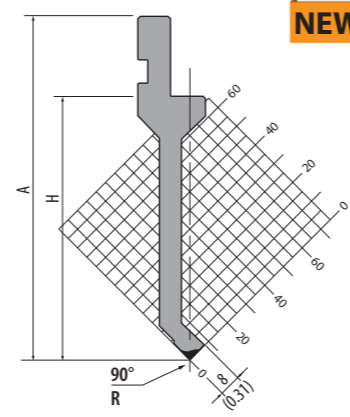
# R1 ROLLERI TYPE R1

## 90° Punches



### P.130.90.R06 / R025

350 kN/m max.

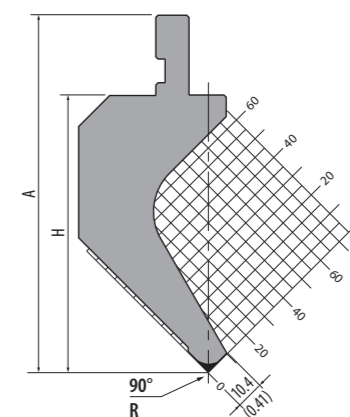


|   |                    |         |
|---|--------------------|---------|
| <b>P.130.90.R06</b>   |                    |         |
| H=100.00 / A=130.00 / R=0.6<br>(H=3.94 / A=5.12 / R=0.024)  |                    |         |
| 835 mm  | 32.87 in           | 11.5 kg |
| 415 mm  | 16.34 in           |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

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

### PK.135.90.R08 / R025

500 kN/m max.



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

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

## 90° Segmented Punches with Mobile Horns



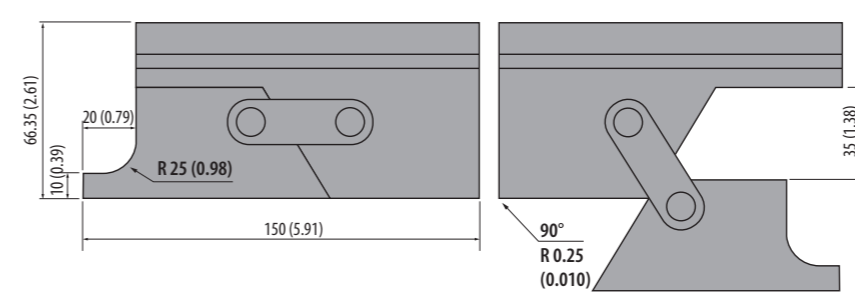
### Area of Application

- for easy bending of special box profiles

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

### SCA.M.90.R08

150 kN/m max.

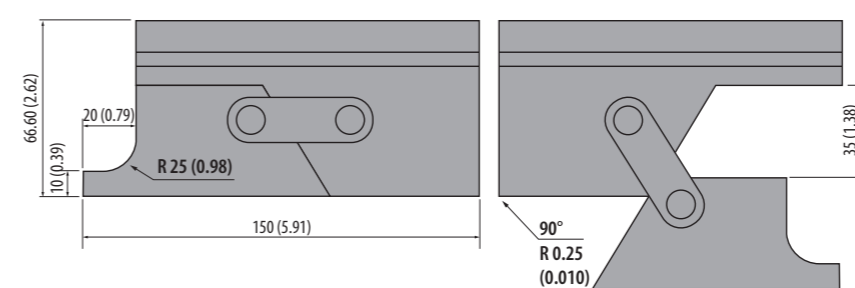


**NEW** per pair 3.5 kg  
1 Pair left/right compatible with PK.97.90.R08

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

### SCA.M.90.R025

150 kN/m max.



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

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

# R1 ROLLERI TYPE R1

## 88° Punches

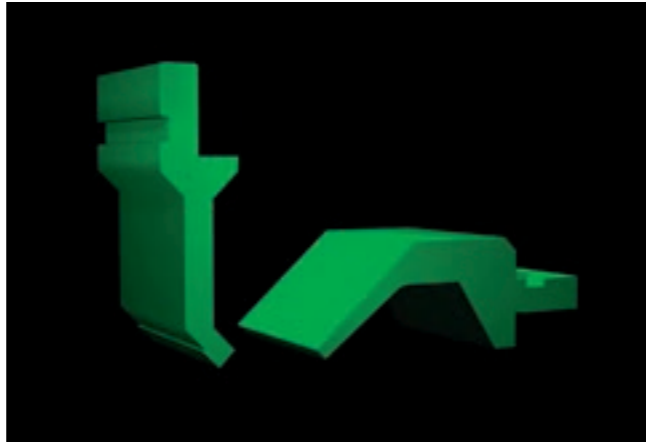
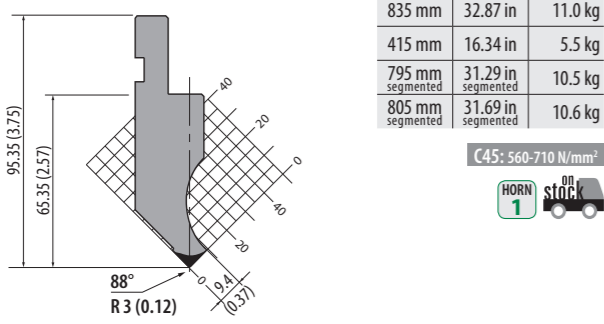
# R1 ROLLERI TYPE R1

## 88° Punches

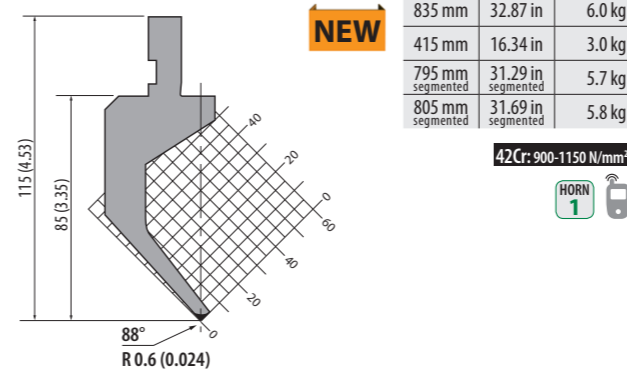


1  
R1

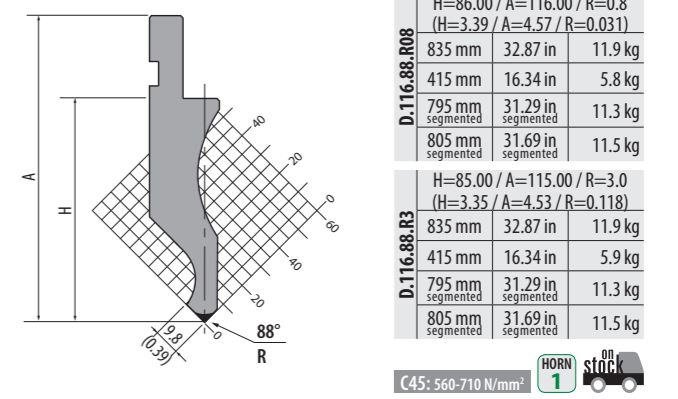
**P.95.88.R3** 1000 kN/m max.



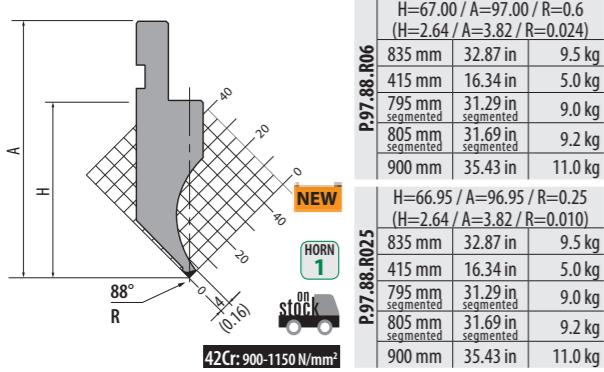
**P.115.88.R06** 130 kN/m max.



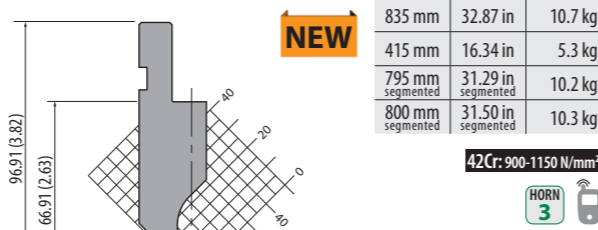
**D.116.88.R08 / R3** 500 kN/m max.



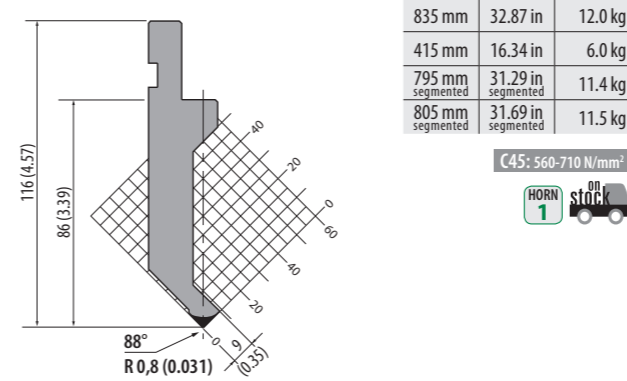
**P.97.88.R06 / R025** 350 kN/m max.



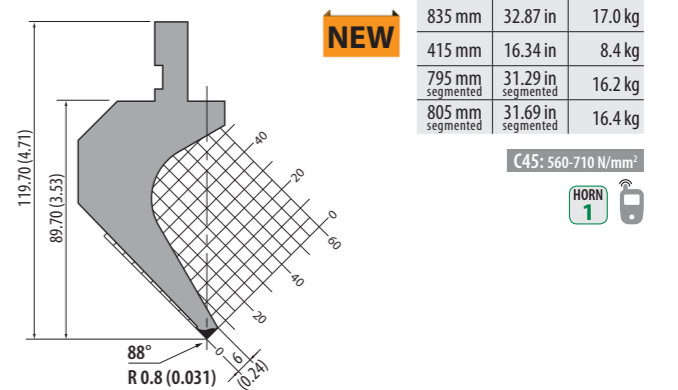
**11700** 200 kN/m max.



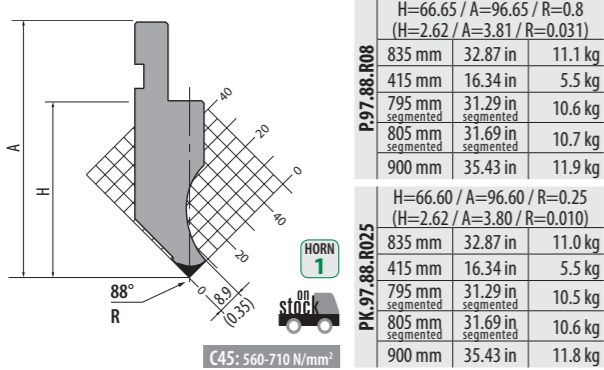
**P.116.88.R08** 400 kN/m max.



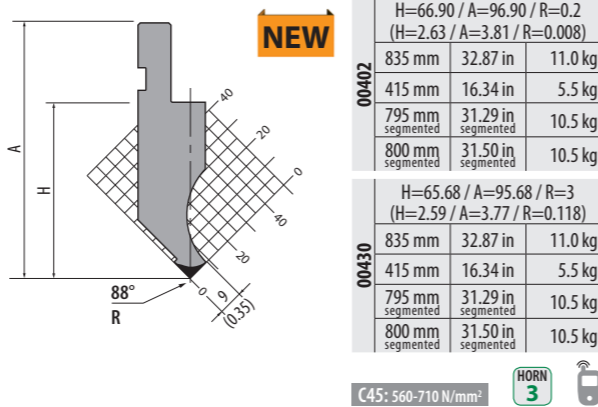
**PS.120.88.R08** 450 kN/m max.



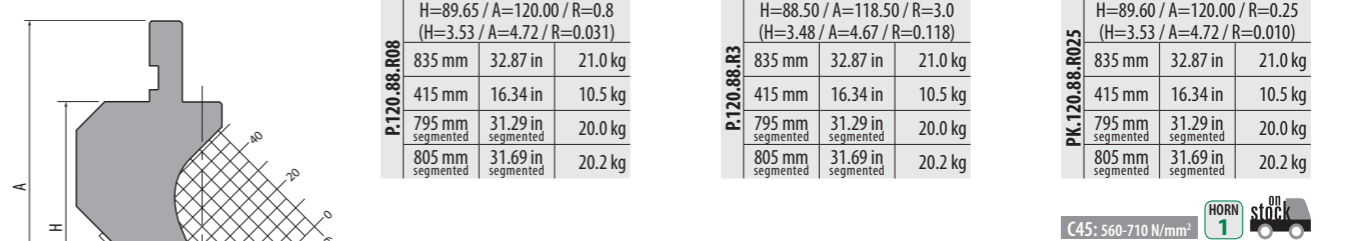
**P.97.88.R08 / PK.97.88.R025** 1000 kN/m max.



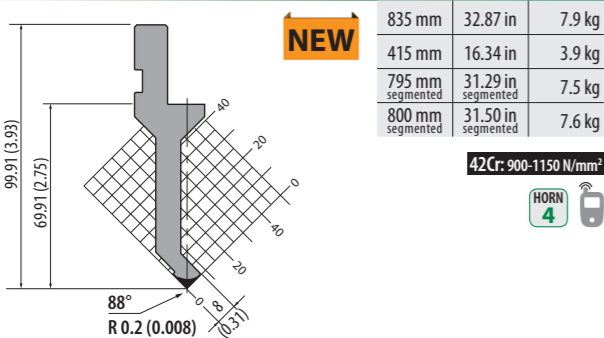
**00402 / 00430** 1000 kN/m max.



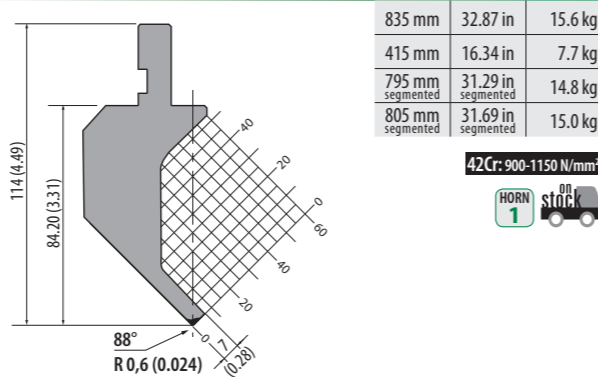
**P.120.88.R08 / P.120.88. R3 / PK.120.88.R025** 600 kN/m max.



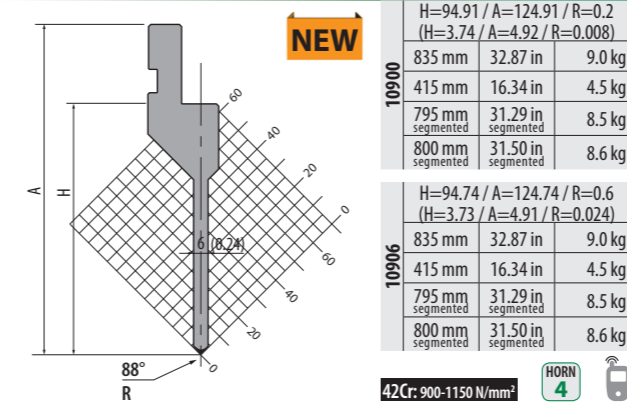
**20000** 300 kN/m max.



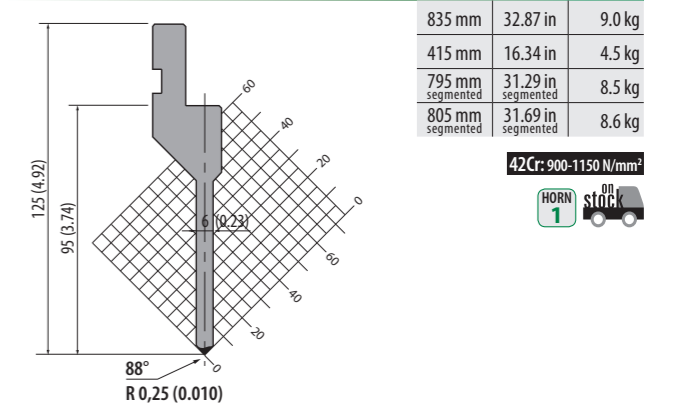
**P.114.88.R06** 200 kN/m max.



**10900 / 10906** 500 kN/m max.



**P.125.88.R025** 500 kN/m max.





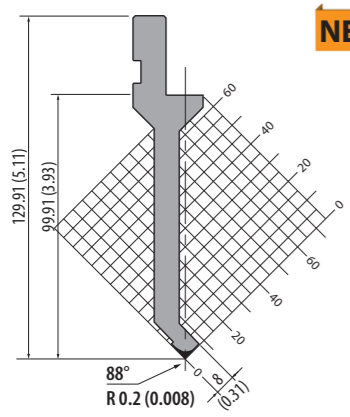
# R1 ROLLERI TYPE R1

88° Punches



1  
R1

## 20200 300 kN/m max.



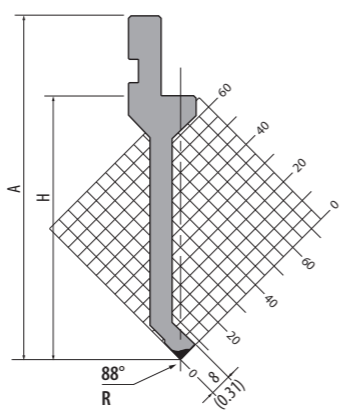
**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 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/mm<sup>2</sup>



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

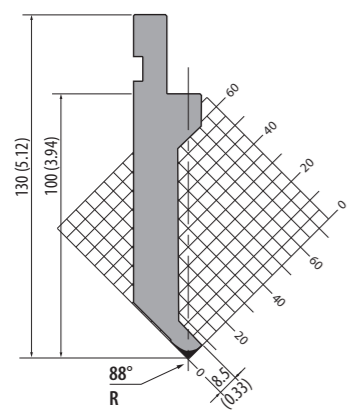


|   |                    |         |
|---|--------------------|---------|
| P.130.88.R06  |                    |         |
| H=100.00 / A=130.00 / R=0.6 (H=3.94 / A=5.12 / R=0.024) |                    |         |
| 835 mm  | 32.87 in           | 9.8 kg  |
| 415 mm  | 16.34 in           | 4.9 kg  |
| 795 mm segmented  | 31.29 in segmented | 9.3 kg  |
| 805 mm segmented  | 31.69 in segmented | 9.4 kg  |
| 900 mm  | 35.43 in           | 10.5 kg |

|   |                    |         |
|---|--------------------|---------|
| PK.130.88.R025  |                    |         |
| H=99.95 / A=129.95 / R=0.25 (H=3.94 / A=5.12 / R=0.010) |                    |         |
| 835 mm  | 32.87 in           | 9.7 kg  |
| 415 mm  | 16.34 in           | 4.8 kg  |
| 795 mm segmented  | 31.29 in segmented | 9.2 kg  |
| 805 mm segmented  | 31.69 in segmented | 9.3 kg  |
| 900 mm  | 35.43 in           | 10.4 kg |

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

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

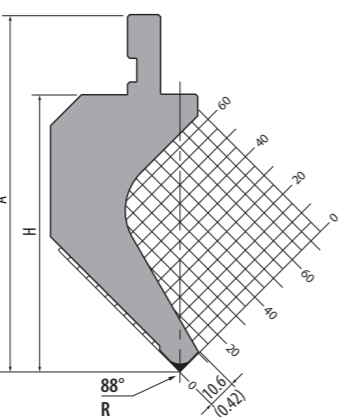


|   |                    |         |
|---|--------------------|---------|
| P.130.88.R08  |                    |         |
| H=100.00 / A=130.00 / R=0.8 (H=3.94 / A=5.12 / R=0.031) |                    |         |
| 835 mm  | 32.87 in           | 14.0 kg |
| 415 mm  | 16.34 in           | 7.0 kg  |
|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

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

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

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



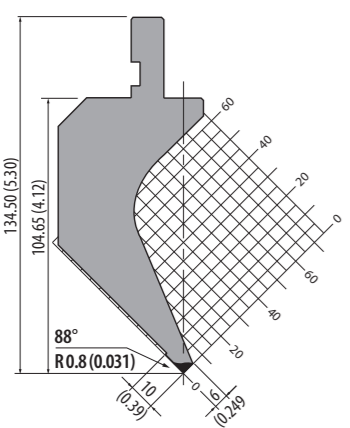
|   |                    |         |
|---|--------------------|---------|
| P.135.88.R08  |                    |         |
| H=104.65 / A=134.50 / R=0.8 (H=4.12 / A=5.30 / R=0.031) |                    |         |
| 835 mm  | 32.87 in           | 22.5 kg |
| 415 mm  | 16.34 in           | 11.2 kg |
| 795 mm segmented  | 31.29 in segmented | 21.4 kg |
| 805 mm segmented  | 31.69 in segmented | 21.7 kg |

|   |                    |         |
|---|--------------------|---------|
| P.135.88.R3   |                    |         |
| H=103.40 / A=133.40 / R=3.0 (H=4.07 / A=5.25 / R=0.118) |                    |         |
| 835 mm  | 32.87 in           | 22.5 kg |
| 415 mm  | 16.34 in           | 11.2 kg |
| 795 mm segmented  | 31.29 in segmented | 21.4 kg |
| 805 mm segmented  | 31.69 in segmented | 21.7 kg |

|  |                    |         |
|--|--------------------|---------|
| PK.135.88.R025   |                    |         |
| H=104.60 / A=134.50 / R=0.25 (H=4.12 / A=5.30 / R=0.010) |                    |         |
| 835 mm   | 32.87 in           | 22.7 kg |
| 415 mm   | 16.34 in           | 11.5 kg |
| 795 mm segmented   | 31.29 in segmented | 21.6 kg |
| 805 mm segmented   | 31.69 in segmented | 21.8 kg |

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

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

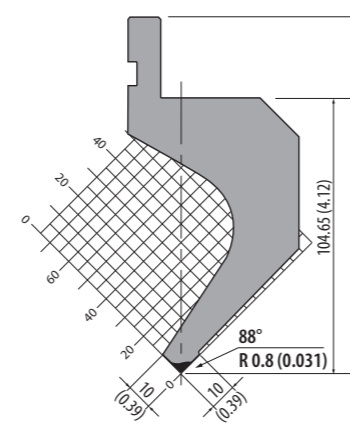


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.0 kg |
| 415 mm           | 16.34 in           | 12.5 kg |
| 795 mm segmented | 31.29 in segmented | 20.9 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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



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

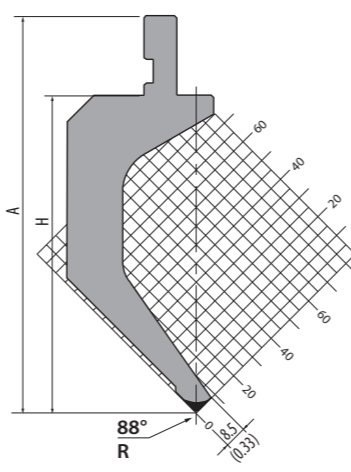
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

88° Punches

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

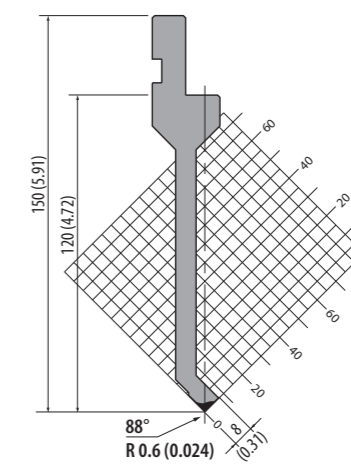


|   |                    |         |
|---|--------------------|---------|
| P.150.88.R08  |                    |         |
| H=120.00 / A=150.00 / R=0.8 (H=4.72 / A=5.91 / R=0.031) |                    |         |
| 835 mm  | 32.87 in           | 21.5 kg |
| 415 mm  | 16.34 in           | 10.5 kg |
|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

|   |                    |         |
|---|--------------------|---------|
| P.150.88.R3   |                    |         |
| H=119.00 / A=149.00 / R=3.0 (H=4.69 / A=5.87 / R=0.118) |                    |         |
| 835 mm  | 32.87 in           | 21.0 kg |
| 415 mm  | 16.34 in           | 10.5 kg |
| 795 mm segmented  | 31.29 in segmented | 19.9 kg |
| 805 mm segmented  | 31.69 in segmented | 20.2 kg |
| 900 mm  | 35.43 in           | 22.6 kg |

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

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

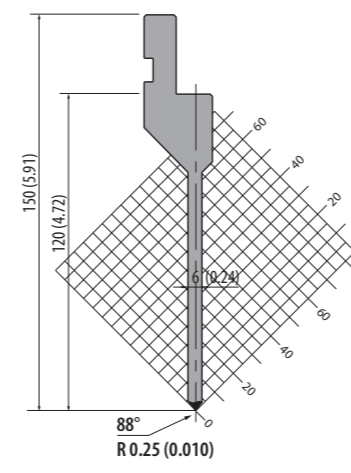


|                  |                    |         |
|------------------|--------------------|---------|
| 900 mm           | 35.43 in           | 12.9 kg |
| 415 mm           | 16.34 in           | 5.9 kg  |
| 795 mm segmented | 31.29 in segmented | 12.2 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

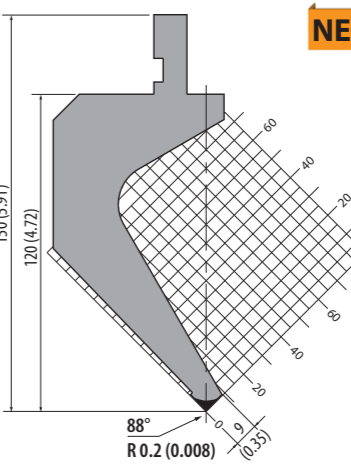


|                  |                    |         |
|------------------|--------------------|---------|
| 900 mm           | 32.87 in           | 10.0 kg |
| 415 mm           | 16.34 in           | 4.6 kg  |
| 795 mm segmented | 31.29 in segmented | 9.5 kg  |
| 805 mm segmented | 31.69 in segmented |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

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



## 04702 500 kN/m max.



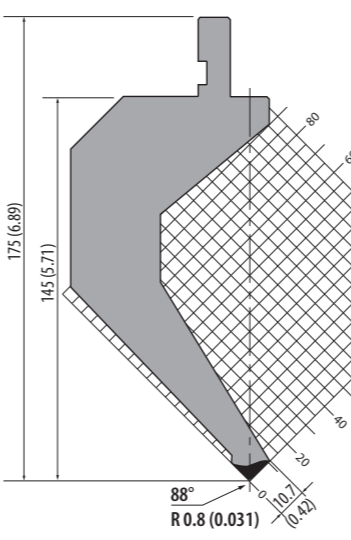
**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 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/mm<sup>2</sup>



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



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

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

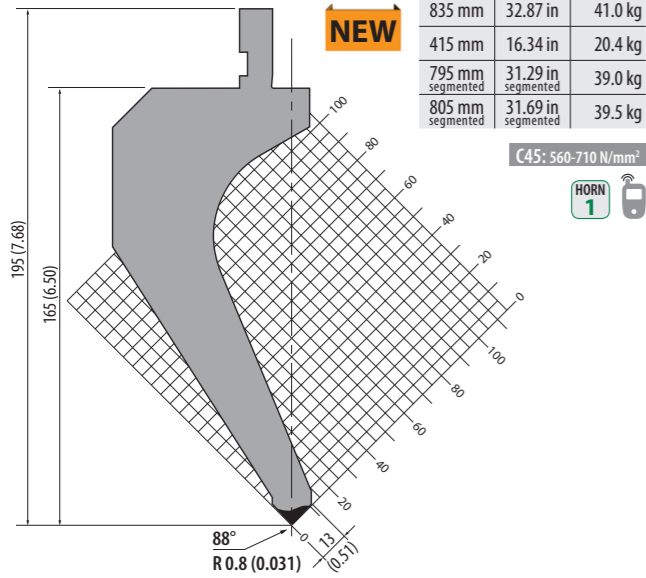


# R1 ROLLERI TYPE R1

88° Punches

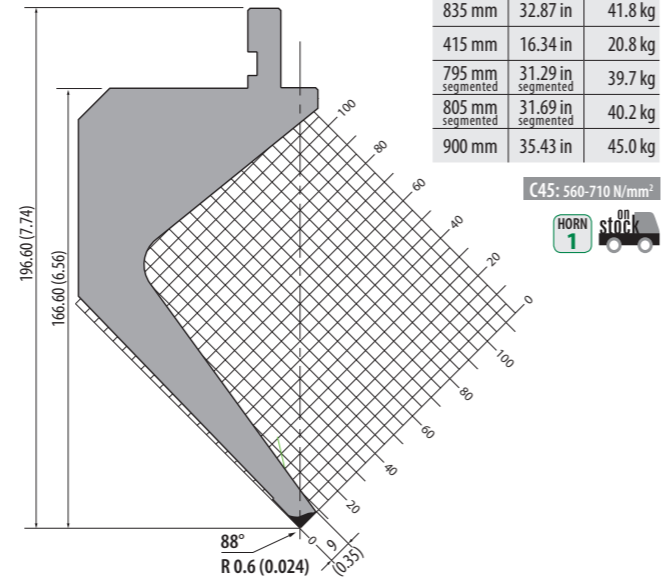
P.195.88.R08

600 kN/m max.

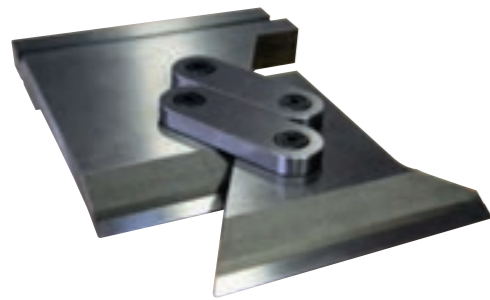


P.196.88.R06

300 kN/m max.



## 88° Segmented Punches with Mobile Horns



### Area of Application

- for easy bending of special box profiles

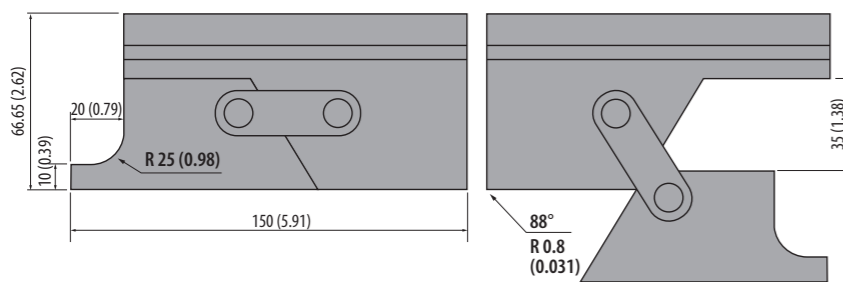


### Rolleri Videos

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

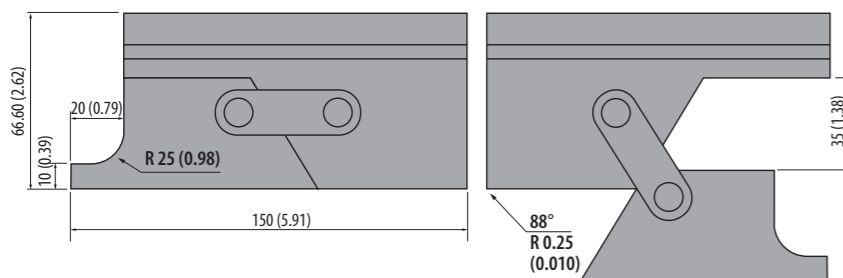
SCA.M.88.R08

150 kN/m max.



SCA.M.88.R025

150 kN/m max.



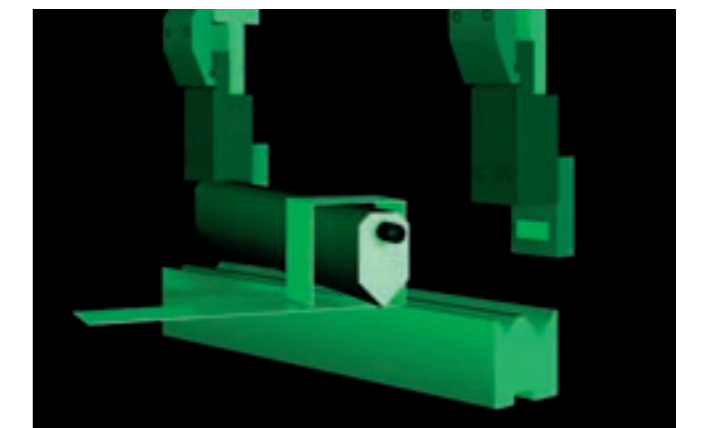
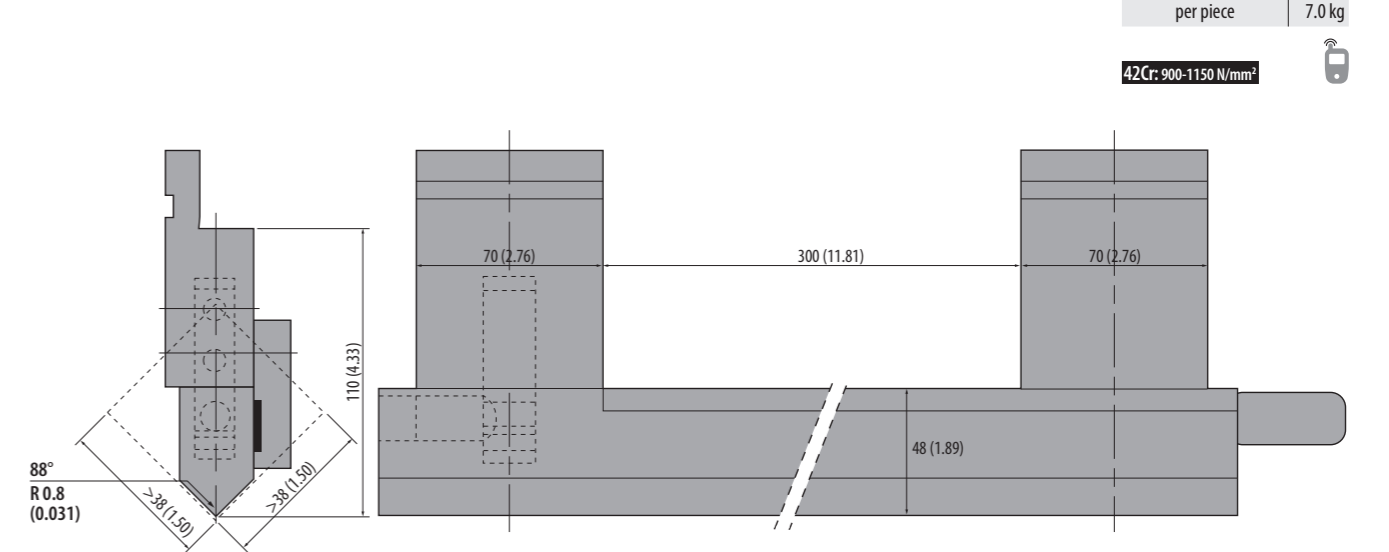
# R1 ROLLERI TYPE R1

88° Punches for closed profiles

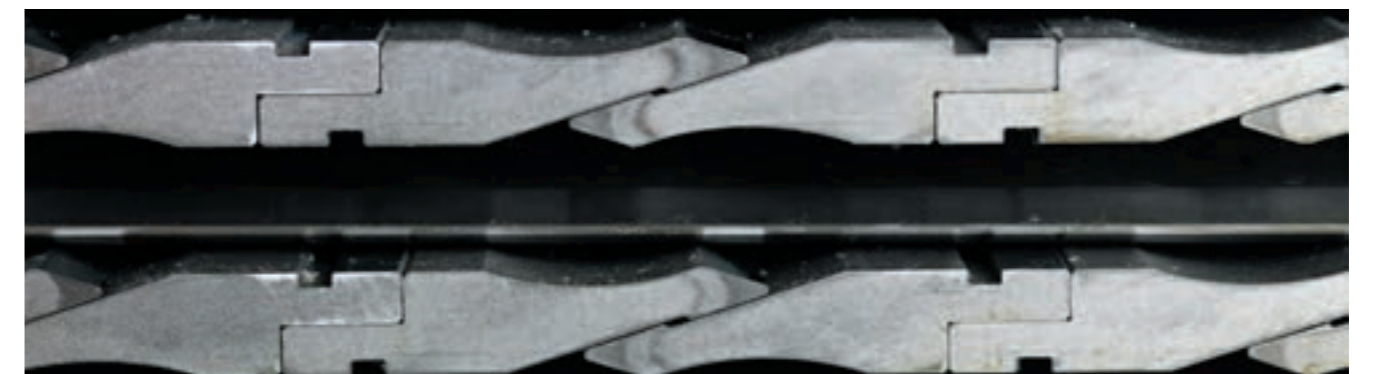


SPE.11

150 kN/m max.



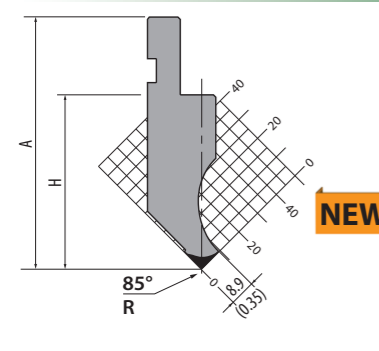
Articles on stock – Please note that delivery time varies according to your location



# R1 ROLLERI TYPE R1

## 85° Punches

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



1000 kN/m max.

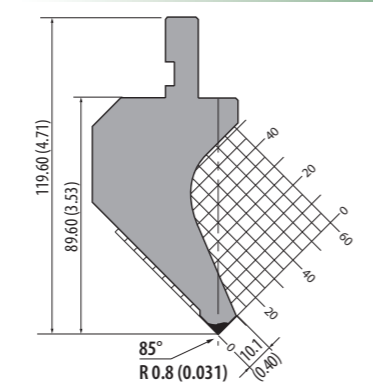
|  |                    |         |
|--|--------------------|---------|
| H=66.60 / A=96.50 / R=0.8<br>(H=2.62 / A=3.80 / R=0.031) |                    |         |
| 835 mm   | 32.87 in           | 11.0 kg |
| 415 mm   | 16.34 in           | 5.5 kg  |
| 795 mm segmented   | 31.29 in segmented | 10.4 kg |
| 805 mm segmented   | 31.69 in segmented | 10.6 kg |
| H=65.45 / A=95.45 / R=3.0<br>(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 |

**NEW**

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



### PK.120.85.R08

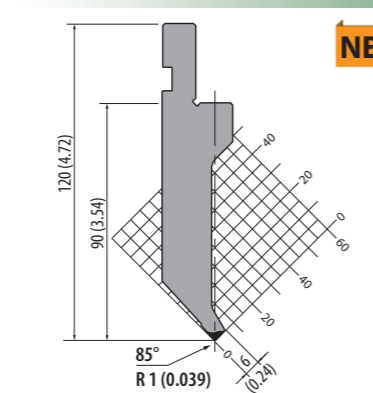


600 kN/m max.

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

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

### P.120.85.R1

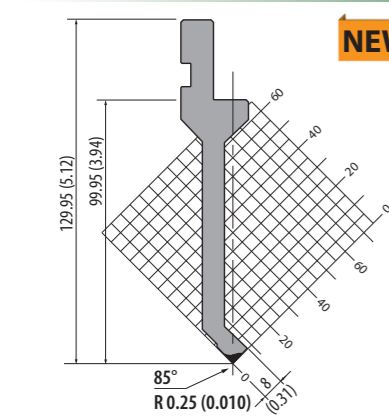


800 kN/m max.

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

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

### P.130.85.R025

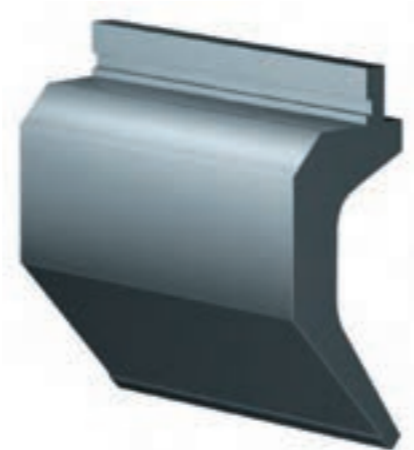


350 kN/m max.

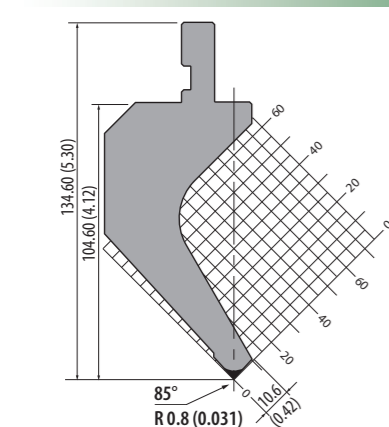
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.5 kg |
| 415 mm           | 16.34 in           | 5.7 kg  |
| 795 mm segmented | 31.29 in segmented | 10.9 kg |
| 805 mm segmented | 31.69 in segmented |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

**NEW**

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



### PK.135.85.R08

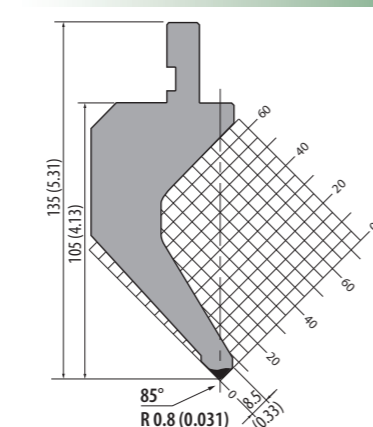


500 kN/m max.

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

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

### P.135.85.R08



800 kN/m max.

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

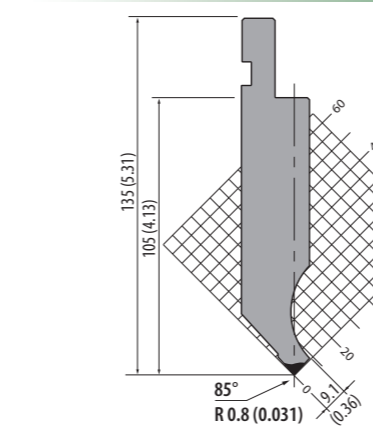
42Cr: 900-1150 N/mm<sup>2</sup> **HORN 1**

# R1 ROLLERI TYPE R1

## 85° Punches



### PS.135.85.R08

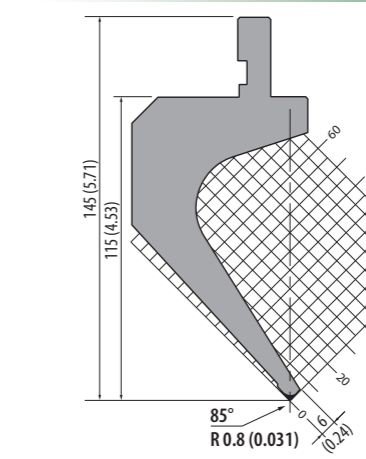


1000 kN/m max.

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

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

### P.145.85.R08

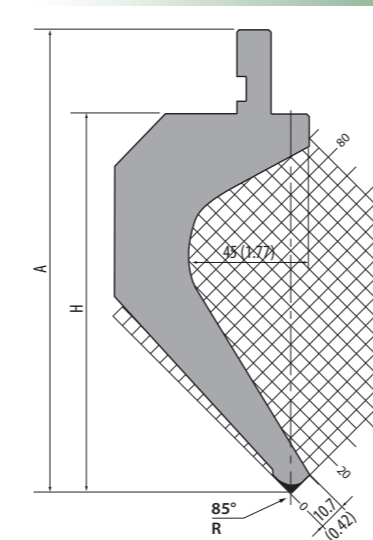


600 kN/m max.

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

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

### TOP.175.85.R08 / R2

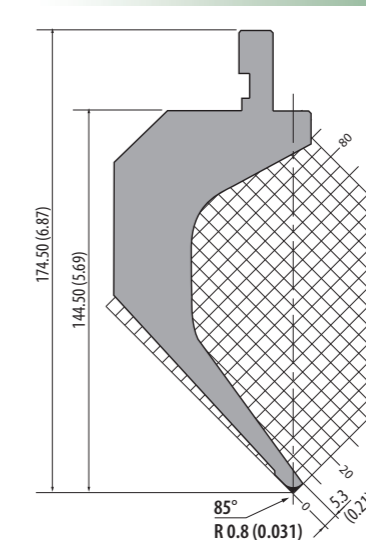


900 kN/m max.

|  |                    |         |
|--|--------------------|---------|
| H=145.00 / A=175.00 / R=0.8<br>(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 |
| H=144.30 / A=174.30 / R=2.0<br>(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/mm<sup>2</sup> **HORN 2**

### TOP.175.85.R08.S

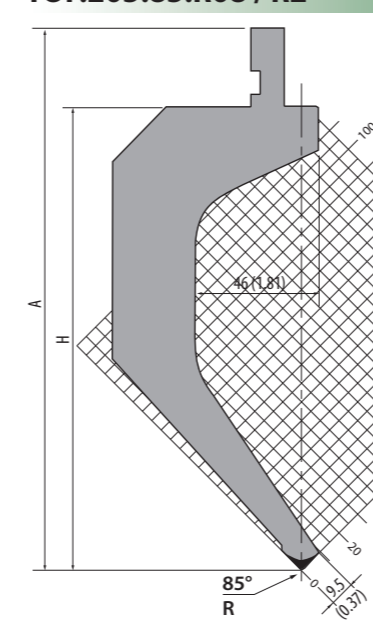


200 kN/m max.

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

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

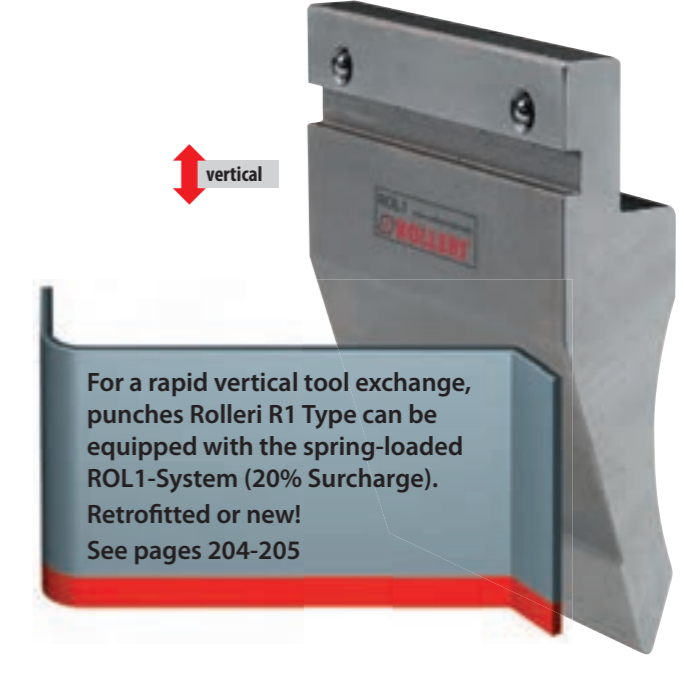
### TOP.205.85.R08 / R2



700 kN/m max.

|  |                    |         |
|--|--------------------|---------|
| H=175.00 / A=205.00 / R=0.8<br>(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 |
| H=174.30 / A=204.30 / R=2.0<br>(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/mm<sup>2</sup> **HORN 2**



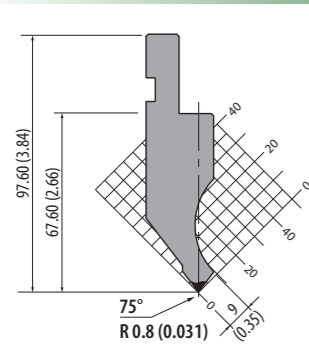
For a rapid vertical tool exchange, punches Rolleri R1 Type can be equipped with the spring-loaded ROL1-System (20% Surcharge). Retrofitted or new! See pages 204-205

# R1 ROLLERI TYPE R1

## 75° Punches

### P.97.75.R08

1000 kN/m max.

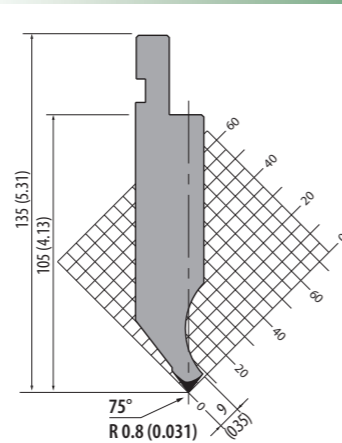


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.0 kg |
| 415 mm           | 16.34 in           | 5.5 kg  |
| 795 mm segmented | 31.29 in segmented | 10.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### P.135.75.R08

1000 kN/m max.

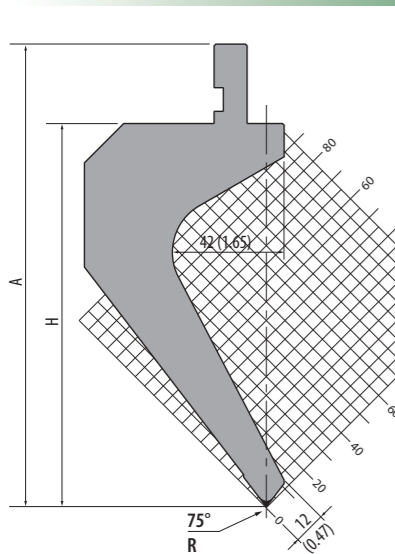


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 17.5 kg |
| 415 mm           | 16.34 in           | 8.5 kg  |
| 795 mm segmented | 31.29 in segmented | 16.7 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### TOP.175.75.R08 / R2

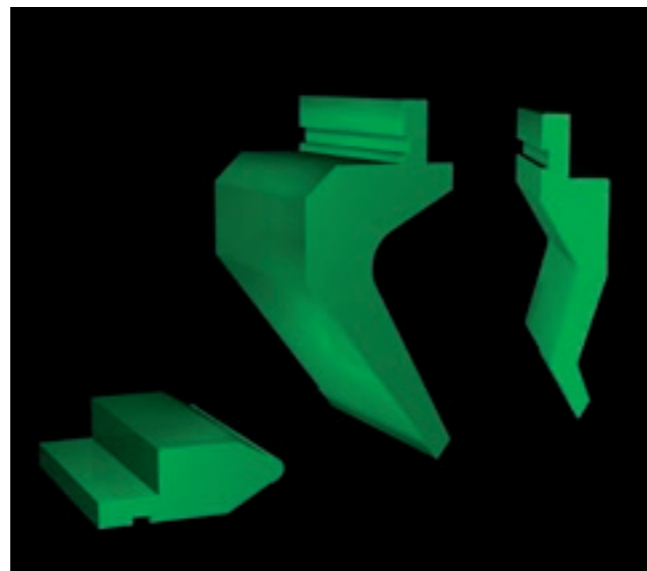
750 kN/m max.



|  |                    |         |
|--|--------------------|---------|
| TOP.175.75.R08   |                    |         |
| H=145.00 / A=175.00 / R=0.8<br>(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<br>(H=5.68 / A=6.86 / R=0.079) |                    |         |
| 525 mm   | 20.67 in           | 21.5 kg |
| 495 mm segmented   | 19.49 in segmented | 20.3 kg |
| 500 mm segmented   | 19.68 in segmented | 20.5 kg |

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



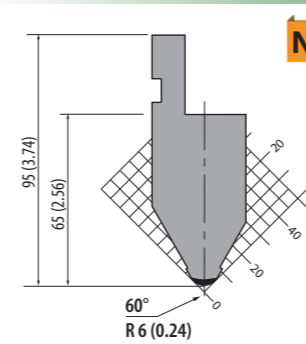
# R1 ROLLERI TYPE R1

## 60° Punches



### 00300

1000 kN/m max.

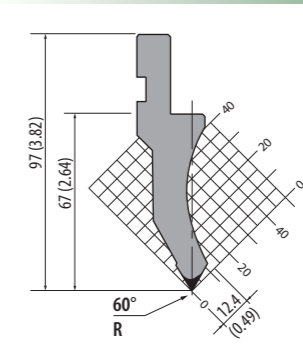


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 15.0 kg |
| 415 mm           | 16.34 in           | 7.5 kg  |
| 795 mm segmented | 31.29 in segmented | 14.2 kg |
| 800 mm segmented | 31.50 in segmented |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

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

### P.97.60.R08 / R2

600 kN/m max.



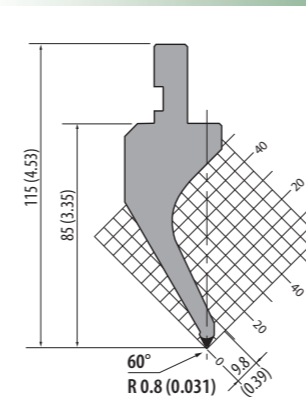
|                  |                    |        |
|------------------|--------------------|--------|
| R=0.8 (0.031)    |                    |        |
| 835 mm           | 32.87 in           | 9.0 kg |
| 415 mm           | 16.34 in           | 4.5 kg |
| 795 mm segmented | 31.29 in segmented | 8.5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

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

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

### P.115.60.R08

400 kN/m max.

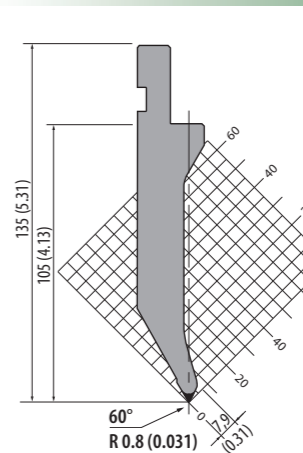


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.9 kg |
| 415 mm           | 16.34 in           | 6.0 kg  |
| 795 mm segmented | 31.29 in segmented | 11.3 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### P.135.60.R08

800 kN/m max.

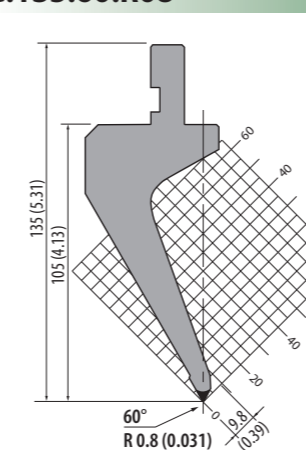


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 14.0 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 13.3 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### PG.135.60.R08

700 kN/m max.

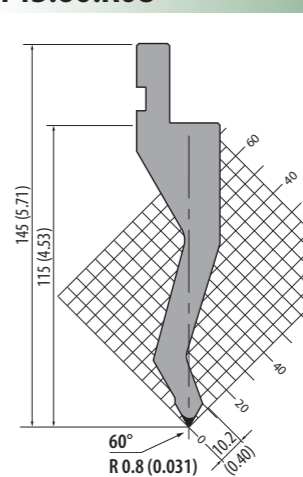


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.5 kg |
| 415 mm           | 16.34 in           | 8.5 kg  |
| 795 mm segmented | 31.29 in segmented | 15.7 kg |
| 805 mm segmented | 31.69 in segmented |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

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

### P.145.60.R08

700 kN/m max.



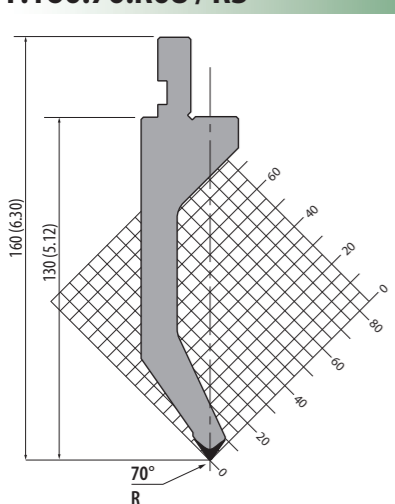
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 15.0 kg |
| 415 mm           | 16.34 in           | 7.5 kg  |
| 795 mm segmented | 31.29 in segmented | 14.3 kg |
| 805 mm segmented | 31.69 in segmented |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

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

## 70° Punches

### P.160.70.R08 / R3

450 kN/m max.



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

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

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

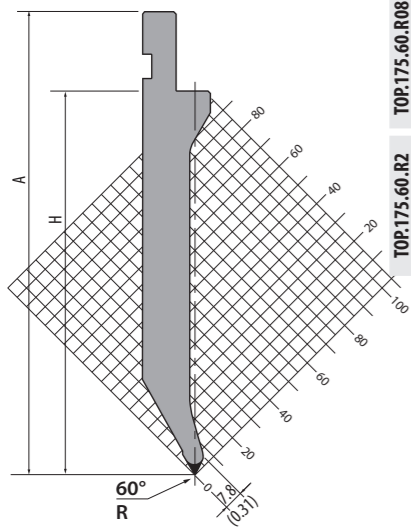
**Modifications of Standard Tools: rapid and precise, directly from the manufacturer!**  
See pages 248-253

# R1 ROLLERI TYPE R1

60° Punches

## TOP.175.60.R08 / R2

800 kN/m max.



| TOP.175.60.R08   |                    |         |
|--|--------------------|---------|
| H=145.00 / A=175.00 / R=0.8<br>(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 |

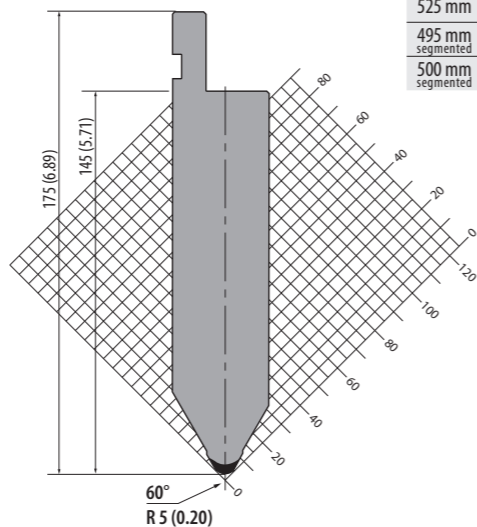
| TOP.175.60.R2  |                    |         |
|--|--------------------|---------|
| H=143.80 / A=173.80 / R=2.0<br>(H=5.66 / A=6.84 / R=0.079) |                    |         |
| 525 mm   | 20.67 in           | 12.0 kg |
| 495 mm segmented   | 19.49 in segmented | 11.3 kg |
| 500 mm segmented   | 19.68 in segmented | 11.4 kg |

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



## TOP.175.60.R5

1600 kN/m max.



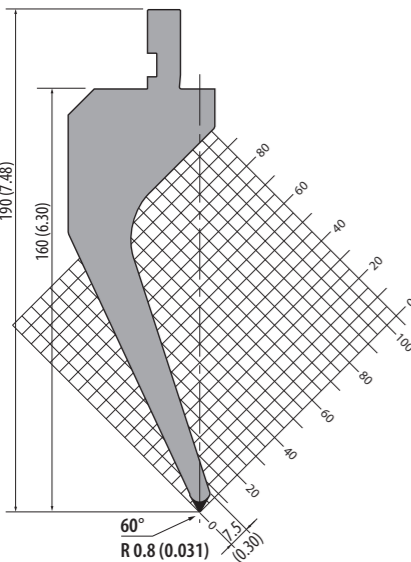
|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 22.0 kg |
| 495 mm segmented | 19.49 in segmented | 20.7 kg |
| 500 mm segmented | 19.68 in segmented | 20.9 kg |

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



## P.190.60.R08

400 kN/m max.



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

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



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



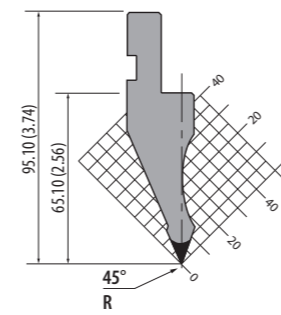
# R1 ROLLERI TYPE R1

45° Punches



## P.95.45.R08 / R15

800 kN/m max.



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

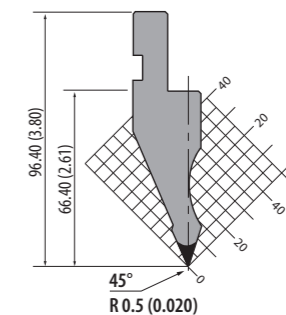
| R=1.5 (0.059)    |                    |        |
|------------------|--------------------|--------|
| P.95.45.R15      |                    |        |
| 835 mm           | 32.87 in           | 9.5 kg |
| 415 mm           | 16.34 in           | 4.2 kg |
| 795 mm segmented | 31.29 in segmented | 9.5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

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



## P.97.45.R05

800 kN/m max.



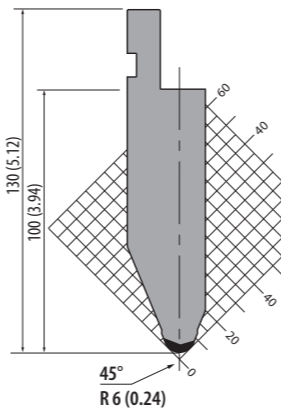
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 10.2 kg |
| 415 mm           | 16.34 in           | 5.1 kg  |
| 795 mm segmented | 31.29 in segmented | 9.7 kg  |
| 805 mm segmented | 31.69 in segmented |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

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



## P.130.45.R6

1000 kN/m max.



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

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



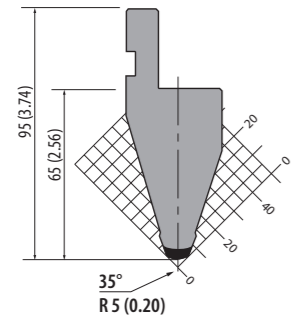
Faster vertical tool exchange with ROL100  
See pages 202-203



# R1 ROLLERI TYPE R1

## 35° Punches

### P.95.35.R5



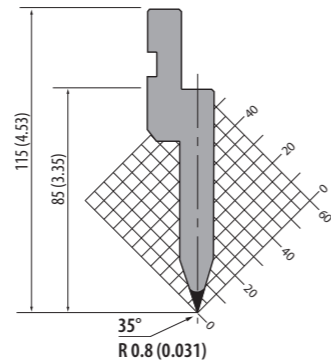
1000 kN/m max.

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

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

**HORN 1**

### PU.85.35.R08



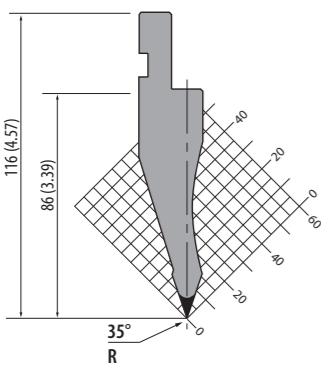
1000 kN/m max.

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

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

**HORN 1**

### P.116.35.R08 / R15



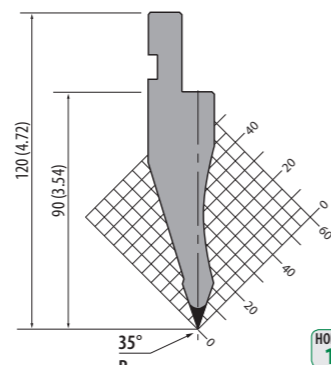
700 kN/m max.

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

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

**HORN 1**

### P.120.35.R08 / R15 / R3



700 kN/m max.

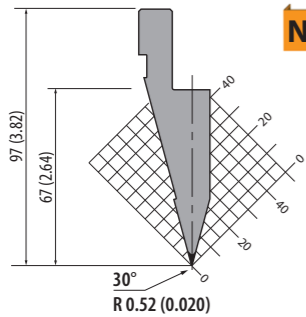
| R=0.8 (0.031) |                  |                    |         |
|---------------|------------------|--------------------|---------|
| P.120.35.R08  | 835 mm           | 32.87 in           | 12.3 kg |
|               | 415 mm           | 16.34 in           | 6.0 kg  |
|               | 795 mm segmented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

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

**HORN 1**

## 30° Punches

### 10300



1000 kN/m max.

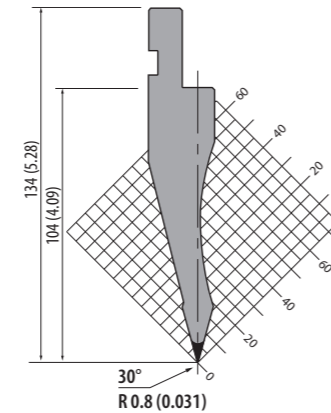
**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 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/mm<sup>2</sup>

**HORN 5**

### PS.134.30.R08



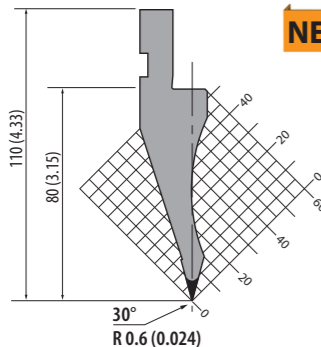
700 kN/m max.

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

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

**HORN 1**

### P.110.30.R06



500 kN/m max.

**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 |

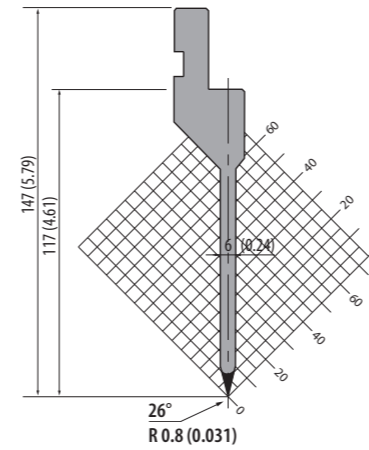
C45: 560-710 N/mm<sup>2</sup>

**HORN 1**

# R1 ROLLERI TYPE R1

## 26° Punches

### P.147.26.R08



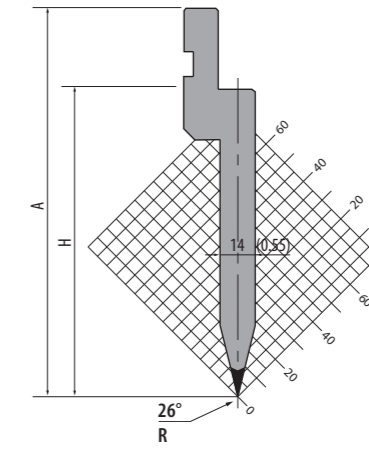
500 kN/m max.

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

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

**HORN 1**

### PU.117.26.R08 / R3



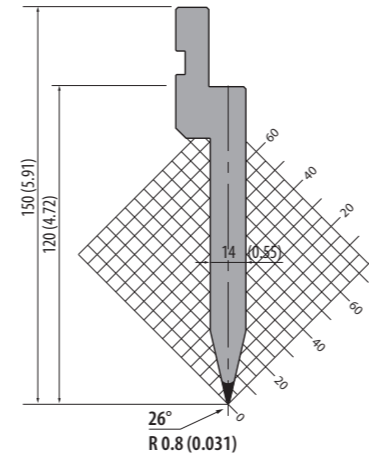
1000 kN/m max.

| PU.117.26.R08   |                  |                    |         |
|---|------------------|--------------------|---------|
| 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/mm<sup>2</sup>

**HORN 1**

### PU.150.26.R08.L



1000 kN/m max.

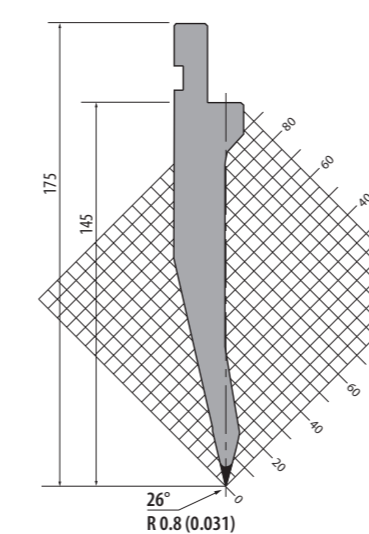
|                  |                    |         |
|------------------|--------------------|---------|
| 900 mm           | 35.43 in           | 15.0 kg |
| 415 mm           | 16.34 in           | 6.2 kg  |
| 795 mm segmented | 31.29 in segmented | 14.3 kg |
| 805 mm segmented | 31.69 in segmented |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

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

**HORN 1**



### TOP.175.26.R08



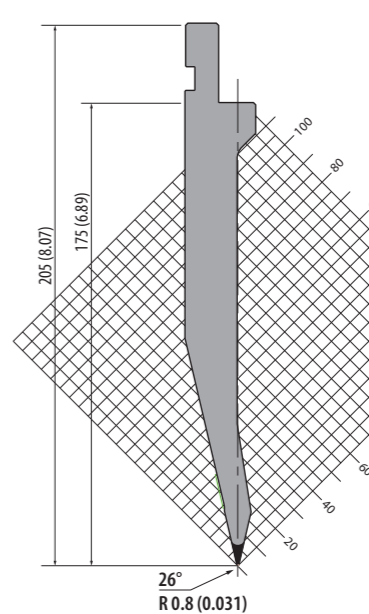
950 kN/m max.

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

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

**HORN 2**

### TOP.205.26.R08



950 kN/m max.

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

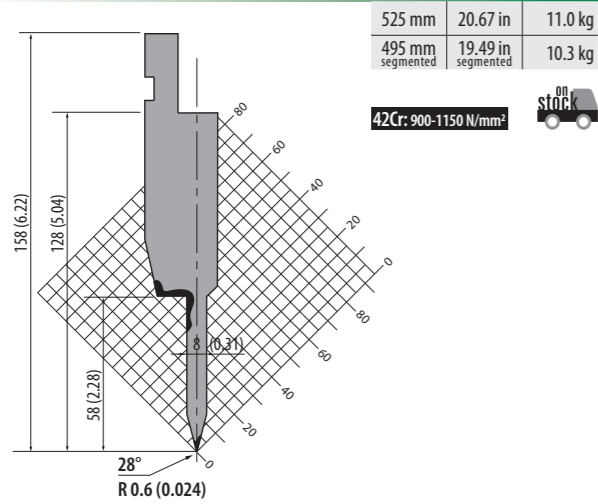
42Cr: 900-1150 N/mm<sup>2</sup>

**HORN 2**

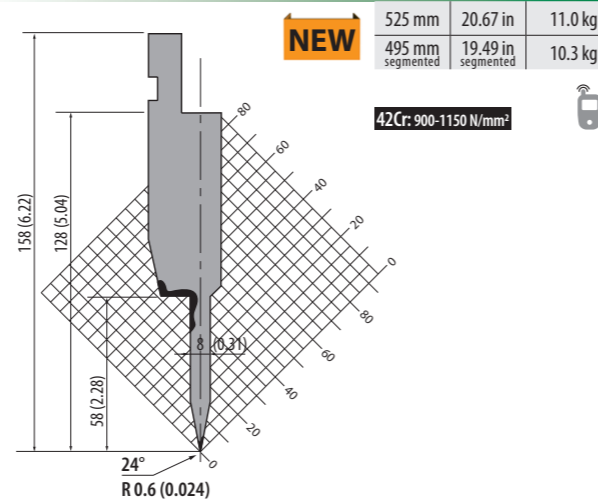
# R1 ROLLERI TYPE R1

28°/24° Hemming tools

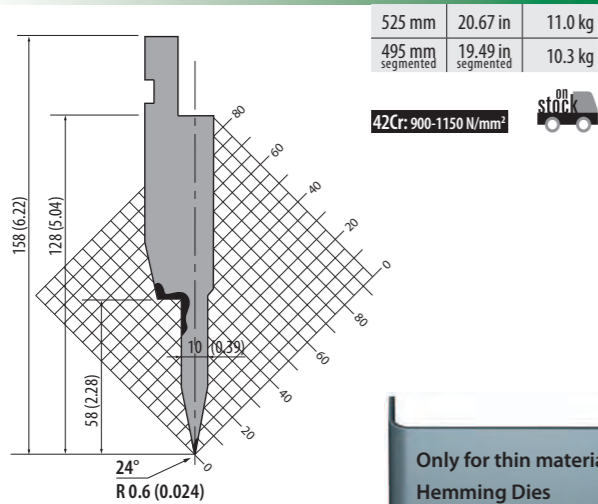
## TOP.SP.134.28.8



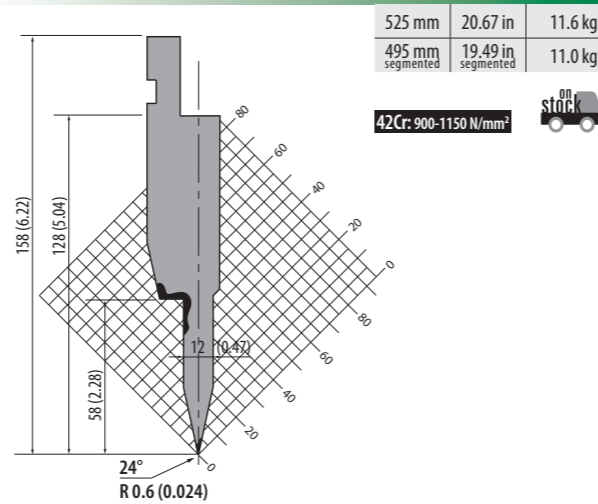
## TOP.SP.134.24.8



## TOP.SP.134.24.10

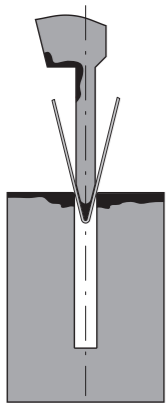


## TOP.SP.134.24.12

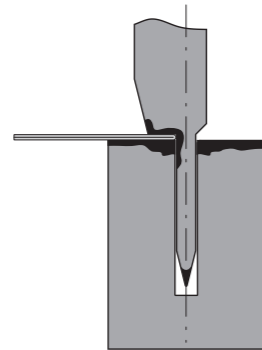


Only for thin material!  
Hemming Dies  
See page 75

## Example of application



800 kN/m max.



1000 kN/m max.

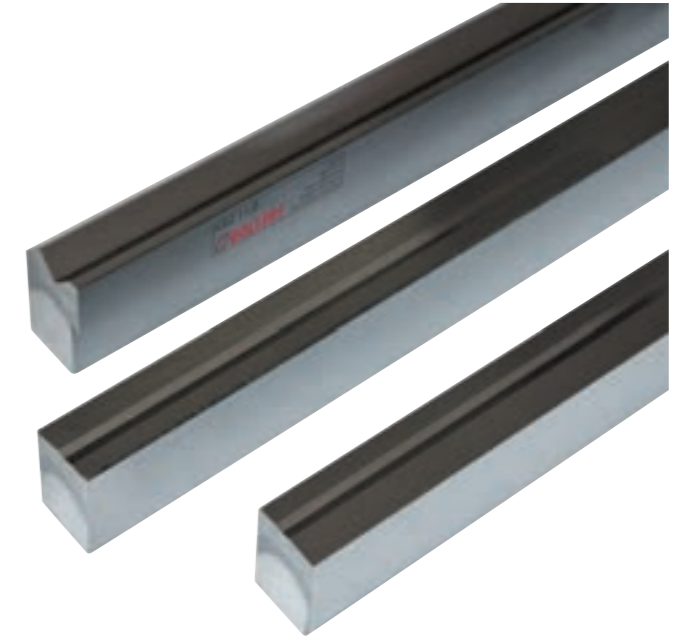
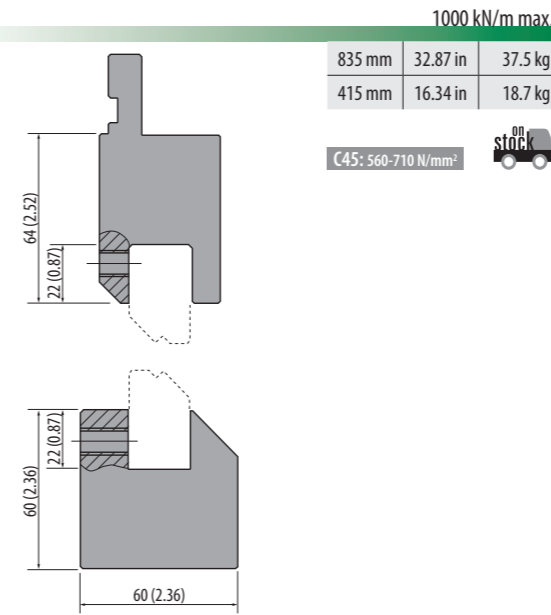
| S mm | S in | A mm | A in | R.45 Kg/mm <sup>2</sup><br>t/m | R.70 Kg/mm <sup>2</sup><br>t/m | S mm | S in | A mm | A in | R.45 Kg/mm <sup>2</sup><br>t/m | R.70 Kg/mm <sup>2</sup><br>t/m |
|------|------|------|------|--------------------------------|--------------------------------|------|------|------|------|--------------------------------|------------------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

# R1 ROLLERI TYPE R1

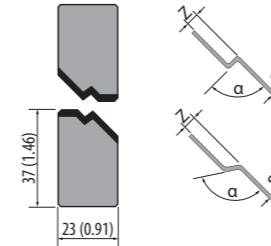
Z-Profile Tools



## CPZ



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

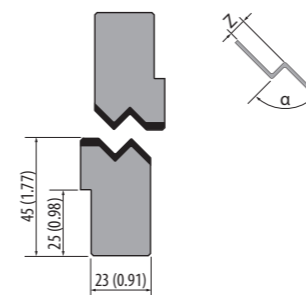


| Model      | Z mm | Z in | α    | S* mm | S* inch | Weight  | Weight |
|------------|------|------|------|-------|---------|---------|--------|
| CEZ 1.0    | 1.0  | 0.04 | 160° | 1.2   | 0.05    | 11.0 kg | 5.5 kg |
| CEZ 1.5    | 1.5  | 0.06 | 160° | 1.5   | 0.06    | 11.0 kg | 5.5 kg |
| CEZ 2.0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

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

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

## Z-Tool Inserts 90°



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

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

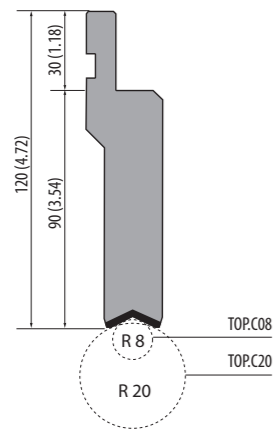
\* Fe Rmax = 42 Kg/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

## Radius Tools

### TOP.PC.120-08

1000 kN/m max.



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

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

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

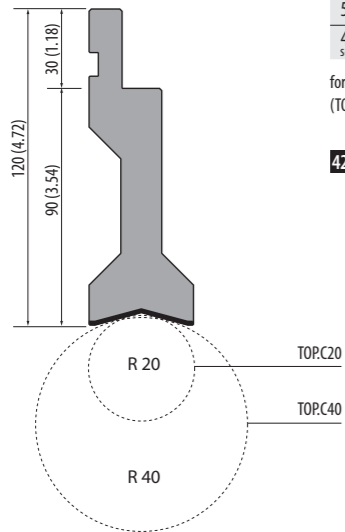


Radius Punches by  
Rolleri also sectioned  
on stock! Take advantage  
of this flexibility!



### TOP.PC.120-20

1000 kN/m max.



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

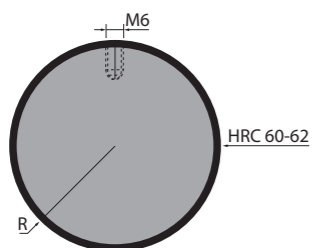
for Radius tools with R20-R40  
(TOP.C20-TOP.C40) see below

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



### TOP-Radius Tools: R8-40

1000 kN/m max.



Material: C53  
induction hard-  
ened 60-62 HRC

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



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

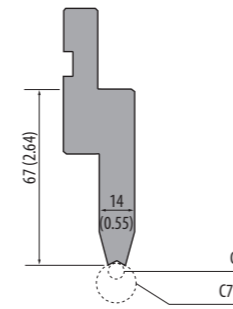
# R1 ROLLERI TYPE R1

## Radius Tools



### PU.67.14-S

400 kN/m max.



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

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

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



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

### C3 - C7.5

400 kN/m max.



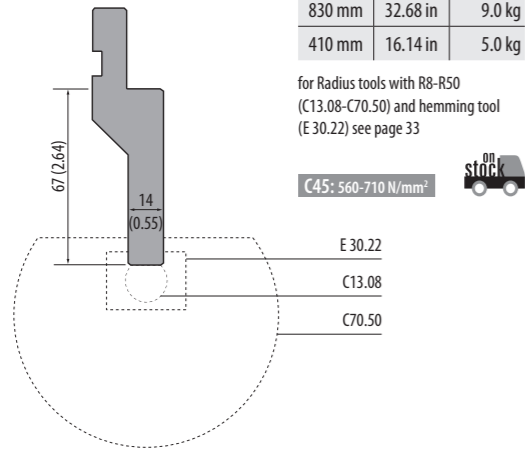
C45: 560-710 N/mm<sup>2</sup>



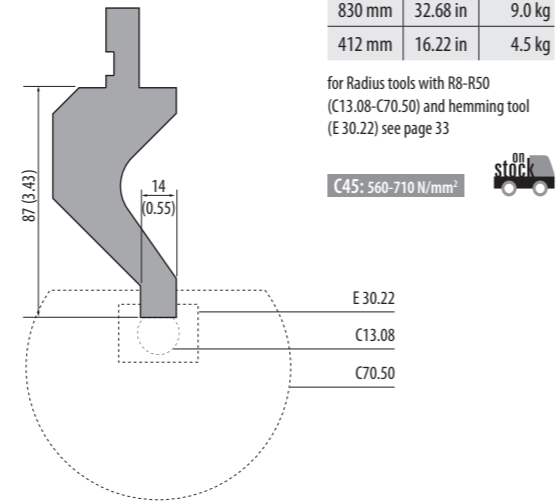
| Model | R mm | R in | Weight  | Weight  |
|-------|------|------|---------|---------|
| C3    | 3.0  | 0.12 | 0.20 kg | 0.10 kg |
| C3.5  | 3.5  | 0.14 | 0.20 kg | 0.10 kg |
| C4    | 4.0  | 0.16 | 0.35 kg | 0.17 kg |
| C4.5  | 4.5  | 0.18 | 0.50 kg | 0.25 kg |
| C5    | 5.0  | 0.20 | 0.60 kg | 0.30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



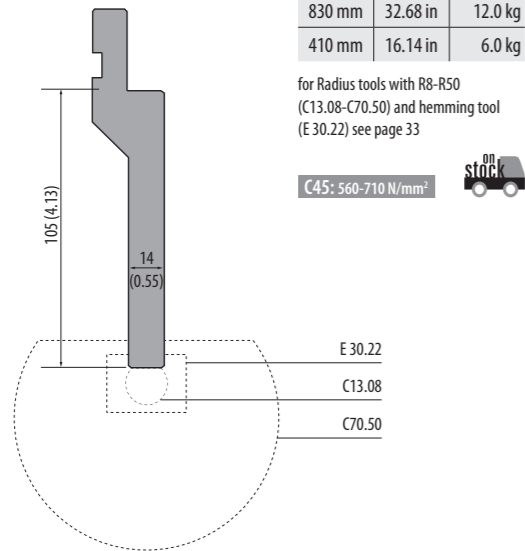
### PU.67.14 800 kN/m max.



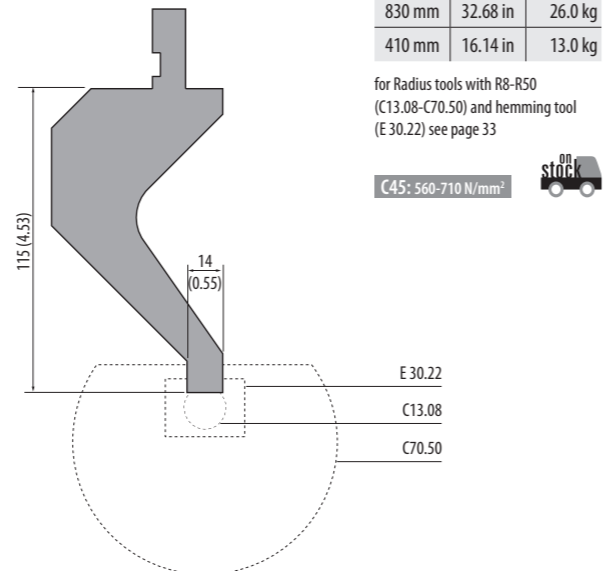
### PU.87.14 500 kN/m max.



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



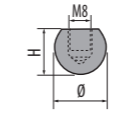
### PU.115.14 500 kN/m max.



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

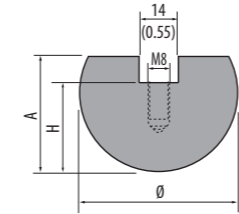


### Radius Tool: Ø 16-20 mm (0.63-0.79 in) 800 kN/m max.



| Model  | Ø mm | Ø in | H mm | H in | Weight  | 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 |

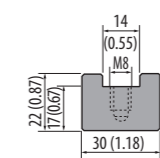
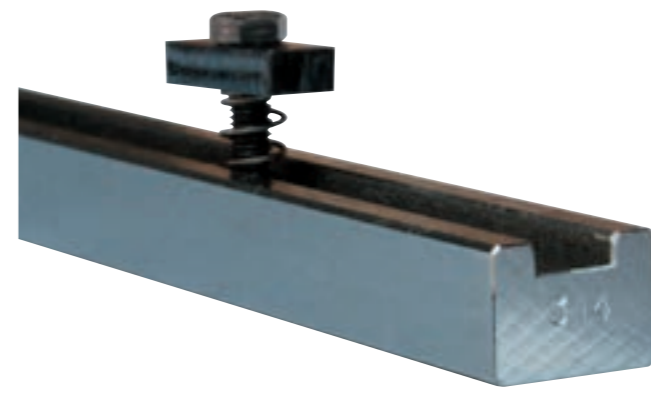
### Radius Tool: Ø 25-100 mm (0.98-3.94) 800 kN/m max.



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

## Hemming Tool

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



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

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

# R1 ROLLERI TYPE R1

## Punch extensions / Intermediates

### Our Advantages – Your Convenience

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

**AD4** 1000 kN/m max.

per piece 1.8 kg

L=150 mm (5.91 in)

Punch extension without wedge crowning

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

Compatible tensioner see page 196

# R1 ROLLERI TYPE R1

## Intermediates



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

**NEW**

per piece 8.0 kg

L=150 mm (5.91 in)

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

Wedge crown

Rolleri Clamping Systems  
See pages 198-205

**INT150** 1000 kN/m max.

per piece 5.9 kg

L=150 mm (5.91 in)

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

Wedge crown

**INT100** 1000 kN/m max.

per piece 3.5 kg

L=150 mm (5.91 in)

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

Wedge crown

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

per piece 4.0 kg

L=150 mm (5.91 in)

Punch extension without wedge crowning

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

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

**NEW**

per piece 5.2 kg

L=150 mm (5.91 in)

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

Wedge crown

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

**NEW**

per piece 4.5 kg

L=150 mm (5.91 in)

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

Wedge crown

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

per piece 5.2 kg

L=150 mm (5.91 in)

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

Wedge crown

**INT120** 1000 kN/m max.

per piece 4.5 kg

L=150 mm (5.91 in)

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

Wedge crown

Intermediates also available in L=70 mm upon request.

## Punch Adapters

**AD20** 1000 kN/m max.

per piece 4.0 kg

L=150 mm (5.91 in)

head-bearing

Rolleri Type R1 → Roller Type R2

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

Punches Roller Type R2 see pages 85-90

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

per piece 6.0 kg

L=150 mm (5.91 in)

Rolleri Type R1 → Roller Type RX LVD

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

Punches Roller Type RX LVD see page 162

## DIES ROLLERI TYPE R1

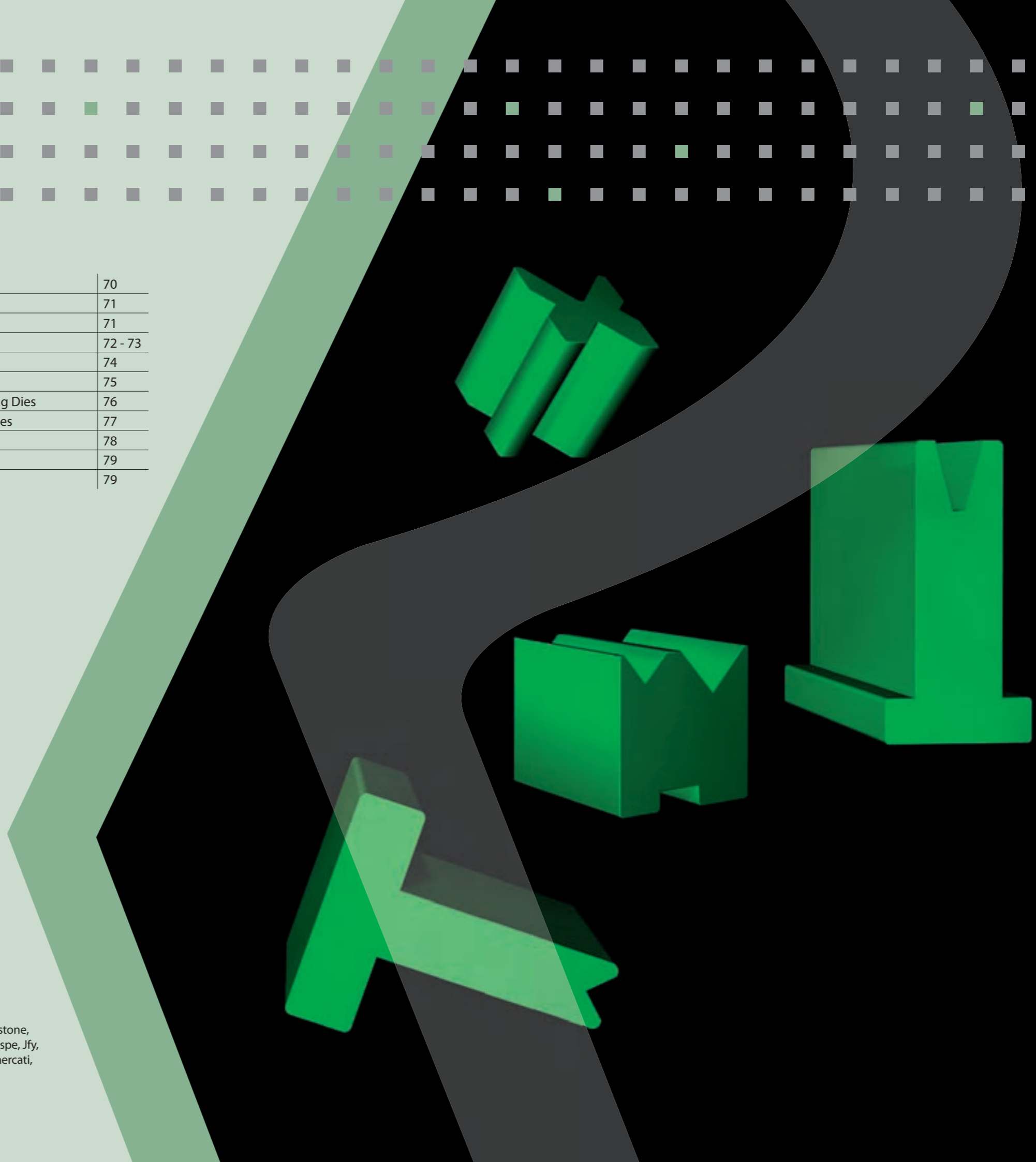
|  |         |                            |         |
|--|---------|----------------------------|---------|
| Content Explanation                        | 38 - 39 | 1-V Dies, 70°              | 70      |
| 2-V Dies 90°                               | 40      | 1-V Dies, 60°              | 71      |
|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

### Compatibility

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

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

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



### Compatibility

Dies Rolleri Type R1 are:

- compatible with press brake machines (60 mm clamping-width) from: ACL, Accurpress, Amada, Atlantic, Adira, Baykal, BL, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Dener, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, 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.

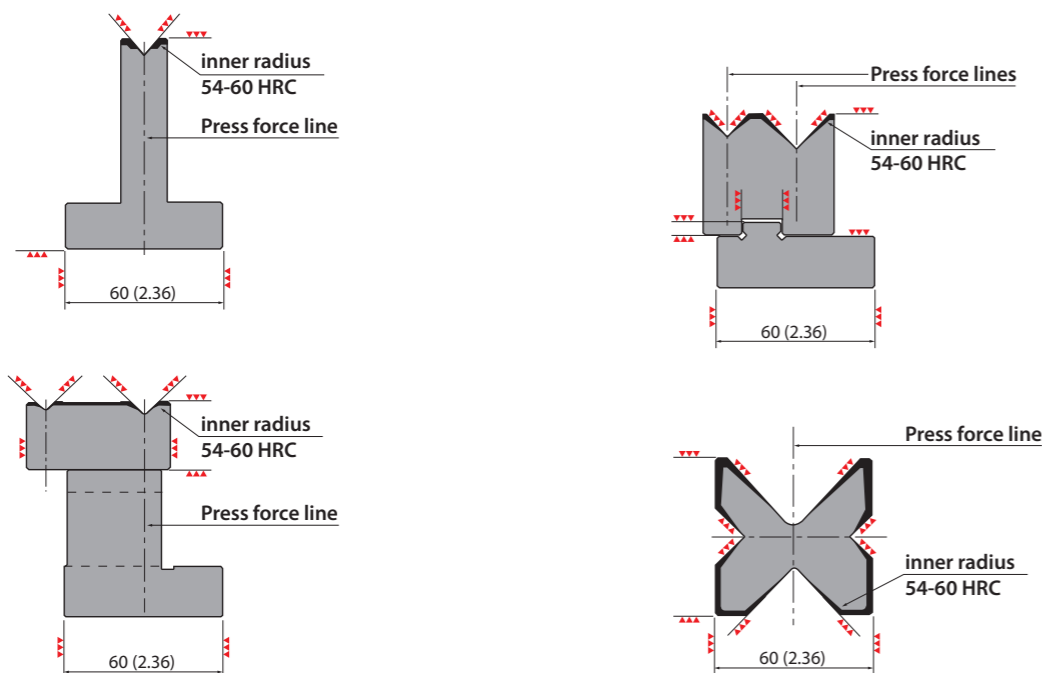
| Material Type | Mechanical resistance of the material and the tool body | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------------|---|--|--|
| 42CrMo4       | 900-1150 N/mm <sup>2</sup>                              | 29.1 - 36.9 HRC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

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

### Tang

All dies 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

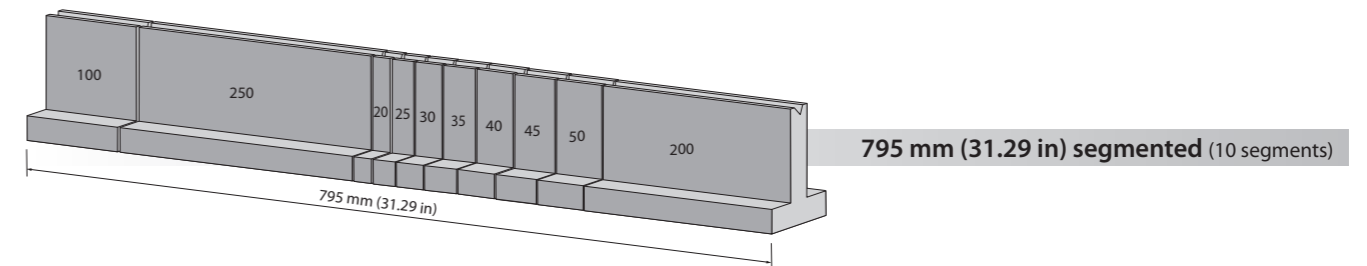
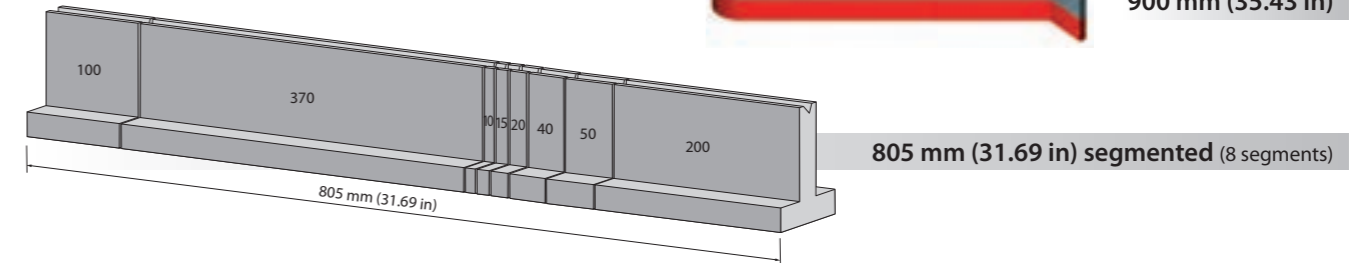
Standard

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)



Rolleri TOP-System

525 mm (20.67 in)

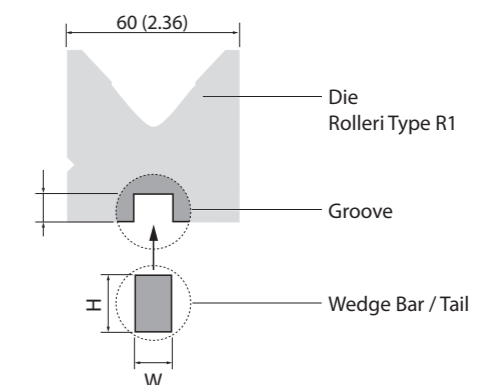


### Modification: Wedge Bar / Tail

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                                  |

### Mounting example



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

# R1 ROLLERI TYPE R1

## 2-V Dies 90°

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

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

**NEW**

**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 |

**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 |

Die Holders for 2-V Dies see page 43

**12300** 700 kN/m max.

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

**NEW**

**12400** 800 kN/m max.

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

**NEW**

# R1 ROLLERI TYPE R1

## 2-V Dies 88°



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

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

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

**12306** 700 kN/m max.

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

**NEW**

**12406** 800 kN/m max.

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

**NEW**

**12500** 1000 kN/m max.

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

**NEW**

**12600** 1000 kN/m max.

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

**NEW**

## 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 |

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

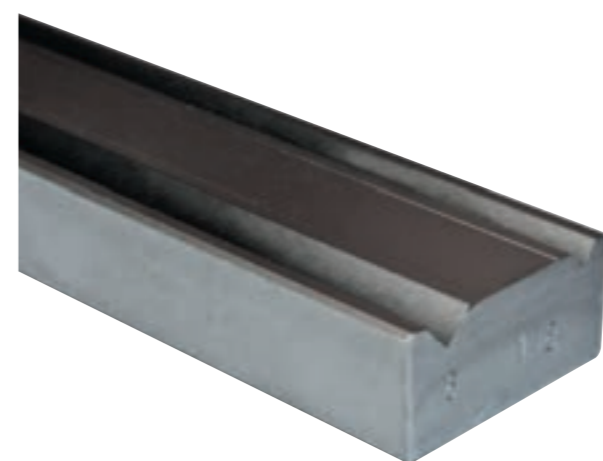
|        |          |        |
|--------|----------|--------|
| 835 mm | 32.87 in | 9.0 kg |
| 415 mm | 16.34 in | 4.5 kg |

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

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

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

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



**12700** 700 kN/m max.

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

**NEW**

**31400** 1000 kN/m max.

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

**NEW**

# R1 ROLLERI TYPE R1

## 2-V Dies 60°

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

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

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

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

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

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

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

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

## 2-V Dies 35°

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

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

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

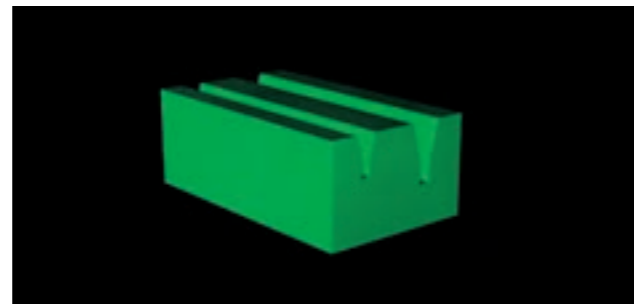
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 10.0 kg |
| 415 mm | 16.34 in | 5.0 kg  |

## 2-V Dies 30°

**33700** 300 kN/m max.

**NEW**

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



# R1 ROLLERI TYPE R1

## Die Holders for 2-V Dies



**SU034**

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

for all 2-V Dies pages 40-42

**SU055**

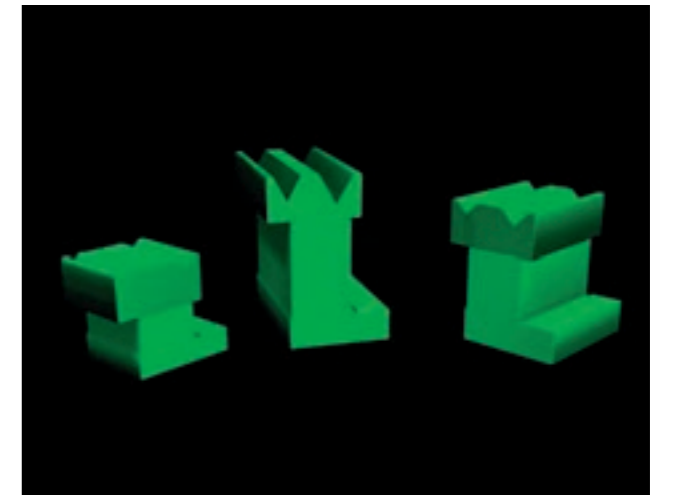
|        |          |         |
|--------|----------|---------|
| 830 mm | 32.68 in | 14.5 kg |
| 410 mm | 16.14 in | 7.2 kg  |

for all 2-V Dies pages 40-42

**SU075**

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

for all 2-V Dies pages 40-42



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

**Rolleri Videos**

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



# R1 ROLLERI TYPE R1

## Self Centering 2-V Dies 90°

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

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

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

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

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

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

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

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

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

**50190** 600 kN/m max.

**NEW**

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

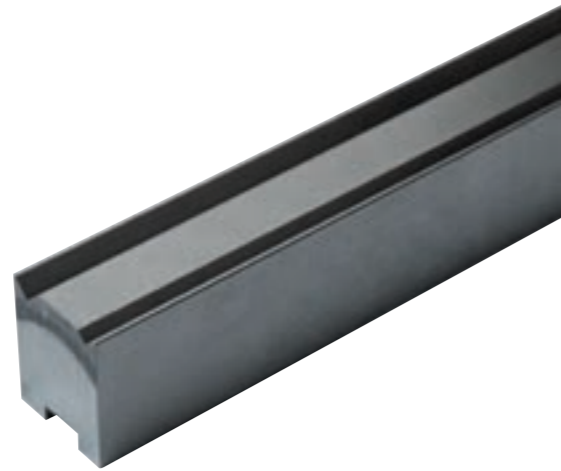
C45: 800-850 N/mm<sup>2</sup>

**50290** 700 kN/m max.

**NEW**

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

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



## Self Centering 2-V Dies 88°

**46.11.88** 800 kN/m max.

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

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

**46.13** 800 kN/m max.

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

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

# R1 ROLLERI TYPE R1

## Self Centering 2-V Dies 88°



**46.14** 800 kN/m max.

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

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

**46.15** 800 kN/m max.

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

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

**46.16** 800 kN/m max.

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

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

**30246** 700 kN/m max.

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

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

## Self Centering 2-V Dies 85°

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

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

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

Die Adapters  
see pages 218-221

## 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/mm<sup>2</sup>

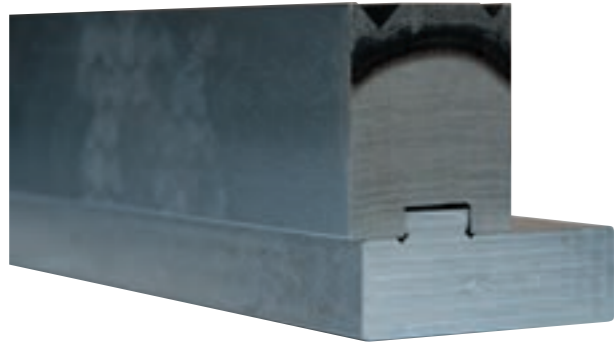
**46.18** 400 kN/m max.

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

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

# R1 ROLLERI TYPE R1

## Die Holders for Self Centering 2-V Dies



**PM60** 1000 kN/m max.

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

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

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

**PM50** 1000 kN/m max.

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

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

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

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

**NEW**

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

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

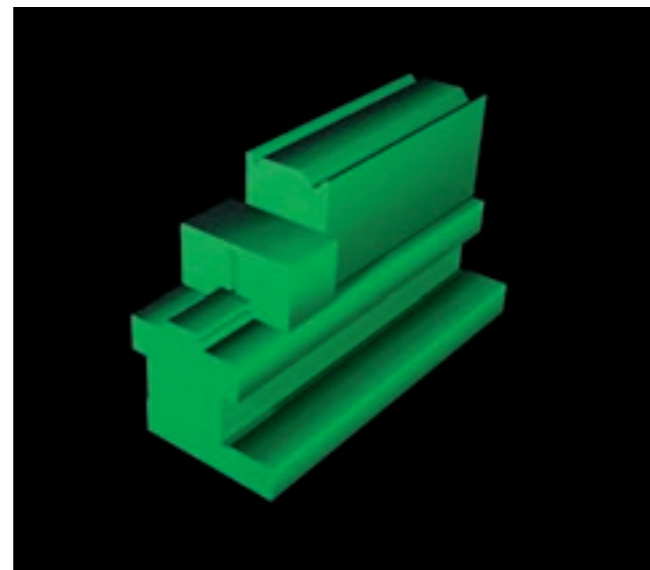
C45: 800-850 N/mm<sup>2</sup>

## Clamping Piece for Self Centering 2-V Dies

**PB60**

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

Fe37



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

# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 90°



**32000** 950 kN/m max.

**NEW**

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

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

**32100** 950 kN/m max.

**NEW**

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

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

**32300** 950 kN/m max.

**NEW**

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

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

**07000** 950 kN/m max.

**NEW**

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

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

**07100** 950 kN/m max.

**NEW**

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

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

**07300** 950 kN/m max.

**NEW**

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

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

## Self Centering 1-V Dies 88°

**32006** 950 kN/m max.

**NEW**

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

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

**32106** 950 kN/m max.

**NEW**

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

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

**32200** 950 kN/m max.

**NEW**

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

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

**32400** 1000 kN/m max.

**NEW**

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

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

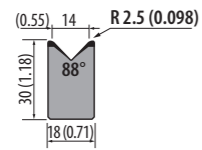


# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 88°

**32500**

**NEW**



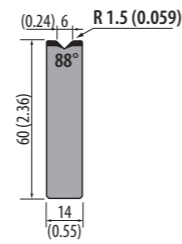
| 1000 kN/m max. |          |        |
|----------------|----------|--------|
| 835 mm         | 32.87 in | 3.3 kg |
| 415 mm         | 16.34 in | 1.6 kg |

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



**07006**

**NEW**



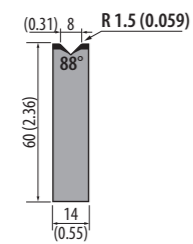
| 950 kN/m max. |          |        |
|---------------|----------|--------|
| 835 mm        | 32.87 in | 5.5 kg |
| 415 mm        | 16.34 in | 2.7 kg |

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



**07106**

**NEW**



| 950 kN/m max. |          |        |
|---------------|----------|--------|
| 835 mm        | 32.87 in | 5.5 kg |
| 415 mm        | 16.34 in | 2.7 kg |

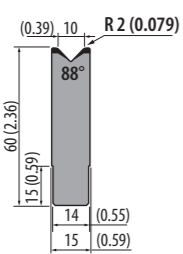
C45: 560-710 N/mm<sup>2</sup>



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

**07200**

**NEW**



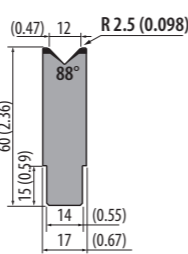
| 950 kN/m max. |          |        |
|---------------|----------|--------|
| 835 mm        | 32.87 in | 6.0 kg |
| 415 mm        | 16.34 in | 3.0 kg |

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



**07400**

**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/mm<sup>2</sup>



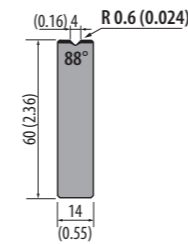
# R1 ROLLERI TYPE R1

## Self Centering 1-V Dies 88°



**AMR60.04.88**

**NEW**



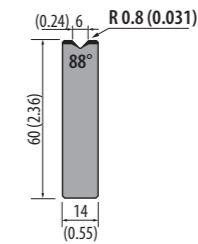
| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 5.4 kg |
| 415 mm           | 16.34 in           | 2.7 kg |
| 795 mm segmented | 31.29 in segmented | 5.1 kg |
| 805 mm segmented | 31.69 in segmented | 5.2 kg |

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



**AMR60.06.88**

**NEW**



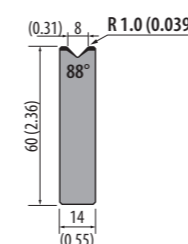
| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 5.4 kg |
| 415 mm           | 16.34 in           | 2.7 kg |
| 795 mm segmented | 31.29 in segmented | 5.1 kg |
| 805 mm segmented | 31.69 in segmented | 5.2 kg |

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



**AMR60.08.88**

**NEW**



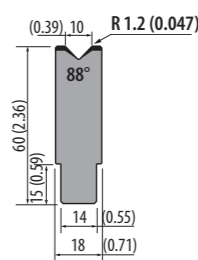
| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 5.4 kg |
| 415 mm           | 16.34 in           | 2.7 kg |
| 795 mm segmented | 31.29 in segmented | 5.1 kg |
| 805 mm segmented | 31.69 in segmented | 5.2 kg |

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



**AMR60.10.88**

**NEW**



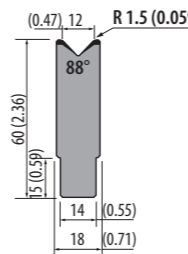
| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 5.6 kg |
| 415 mm           | 16.34 in           | 2.8 kg |
| 795 mm segmented | 31.29 in segmented | 5.3 kg |
| 805 mm segmented | 31.69 in segmented | 5.4 kg |

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



**AMR60.12.88**

**NEW**



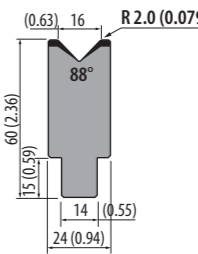
| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 6.1 kg |
| 415 mm           | 16.34 in           | 3.0 kg |
| 795 mm segmented | 31.29 in segmented | 5.8 kg |
| 805 mm segmented | 31.69 in segmented | 5.9 kg |

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



**AMR60.16.88**

**NEW**



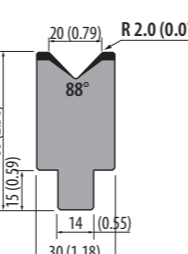
| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 7.1 kg |
| 415 mm           | 16.34 in           | 3.5 kg |
| 795 mm segmented | 31.29 in segmented | 6.8 kg |
| 805 mm segmented | 31.69 in segmented | 6.9 kg |

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



**AMR60.20.88**

**NEW**



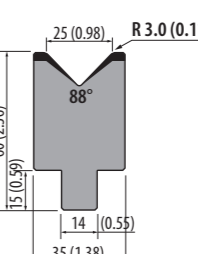
| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 8.0 kg |
| 415 mm           | 16.34 in           | 4.0 kg |
| 795 mm segmented | 31.29 in segmented | 7.6 kg |
| 805 mm segmented | 31.69 in segmented | 7.7 kg |

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



**AMR60.25.88**

**NEW**



| 1000 kN/m max.   |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 9.2 kg |
| 415 mm           | 16.34 in           | 4.6 kg |
| 795 mm segmented | 31.29 in segmented | 8.8 kg |
| 805 mm segmented | 31.69 in segmented | 8.9 kg |

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



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

# R1 ROLLER TYPE R1

## Self Centering 1-V Dies 85°

# R1 ROLLER TYPE R1

## Self Centering 1-V Dies 30°



**AMR60.04.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.06.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.06.30** 350 kN/m max.

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

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

**AMR60.08.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.10.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.08.30** 350 kN/m max.

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

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

**AMR60.10.30** 500 kN/m max.

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

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

**AMR60.12.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.16.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.12.30** 400 kN/m max.

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

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

**AMR60.16.30** 450 kN/m max.

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

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

**AMR60.20.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.25.85** 1000 kN/m max.

**NEW**

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

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

**AMR60.20.30** 500 kN/m max.

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

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

**AMR65.25.30** 500 kN/m max.

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

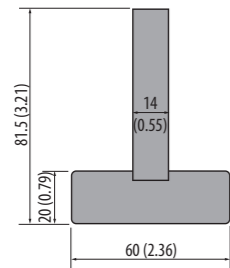
C45: 560-710 N/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

## Die Holders for Self Centering 1-V Dies

33000

NEW



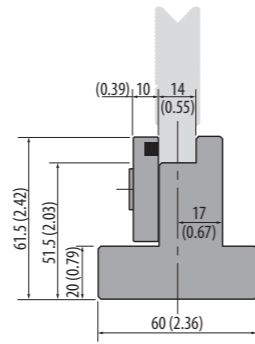
|                |          |         |
|----------------|----------|---------|
| 1000 kN/m max. |          |         |
| 835 mm         | 32.87 in | 12.7 kg |
| 415 mm         | 16.34 in | 6.3 kg  |

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

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



SU61F



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

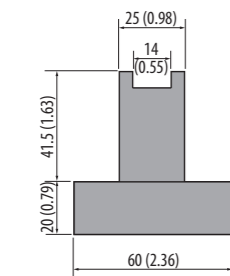
for self centering 1-V Dies, pages 49-51

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



08000

NEW



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

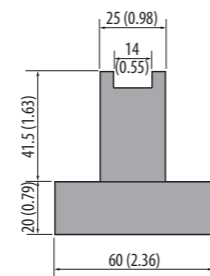
for self centering 1-V Dies, pages 47-51

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



08100

NEW



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

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

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



# R1 ROLLERI TYPE R1

## Prevention of Bending Marks



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

- Protective Sheets
- PU-Upholstery
- Synthetic Dies

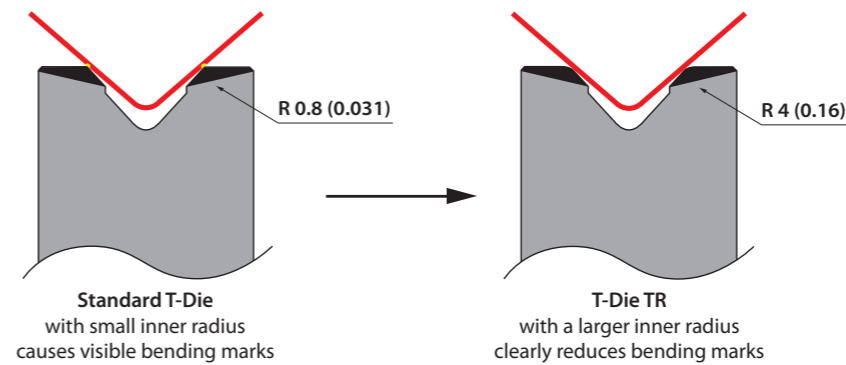
The alternative to these options mentioned above, is a modification of the dies:

- 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

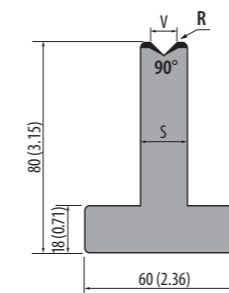
- Prevention of streaks and markings on the bended sheet metals
- No post processing necessary and therefore, time- and cost efficient.
- No contact of bending pieces
- increases product quality
- easy handling



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

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

### T-Dies 90°, H=80 mm (3.15 in)

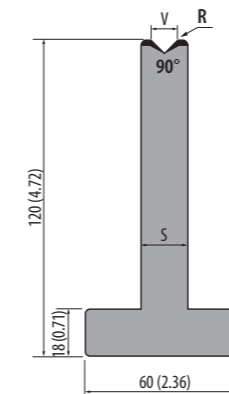


| Model     | V (mm) | V (in) | R (mm) | R (in) | S (mm) | S (in) | 1000 kN/m max. |        |         |         |         |
|-----------|--------|--------|--------|--------|--------|--------|----------------|--------|---------|---------|---------|
|           |        |        |        |        |   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

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



### T-Dies 90°, H=120 mm (4.72 in)



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

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

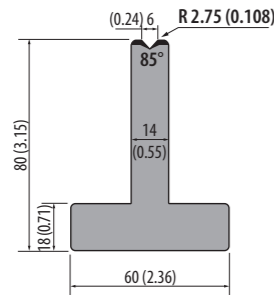




# R1 ROLLERI TYPE R1

T-Dies 85°, H=80 (3.15)

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

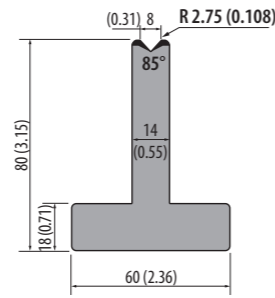


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

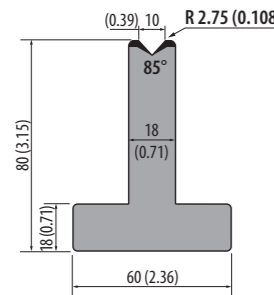


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 12.6 kg |
| 415 mm           | 16.34 in           | 6.2 kg  |
| 795 mm segmented | 31.29 in segmented | 12.0 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

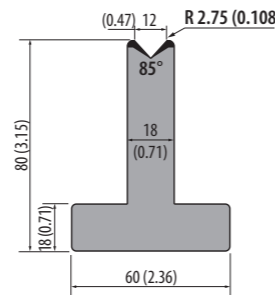


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 14.2 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 13.5 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

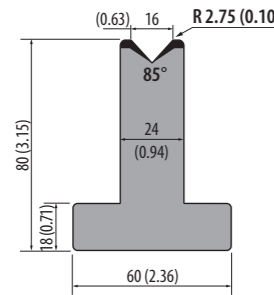


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 14.1 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 13.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

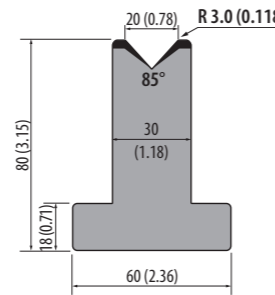


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.4 kg |
| 415 mm           | 16.34 in           | 8.2 kg  |
| 795 mm segmented | 31.29 in segmented | 15.6 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

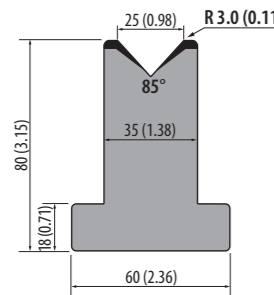


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 19.0 kg |
| 415 mm           | 16.34 in           | 9.5 kg  |
| 795 mm segmented | 31.29 in segmented | 18.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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



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

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



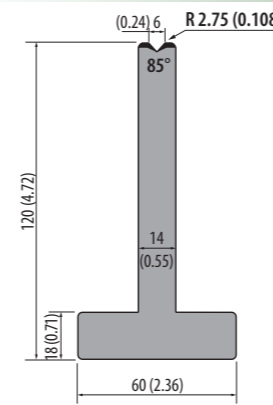
Do you have queries about delivery times, operational areas, and other possibilities? Give us a call!

# R1 ROLLERI TYPE R1

T-Dies 85°, H=120 (4.72)



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

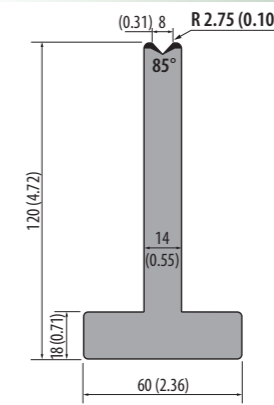


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.3 kg |
| 415 mm           | 16.34 in           | 8.1 kg  |
| 795 mm segmented | 31.29 in segmented | 15.5 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

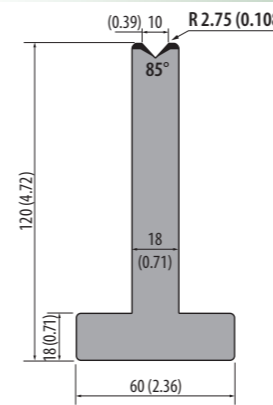


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.3 kg |
| 415 mm           | 16.34 in           | 8.1 kg  |
| 795 mm segmented | 31.29 in segmented | 15.5 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

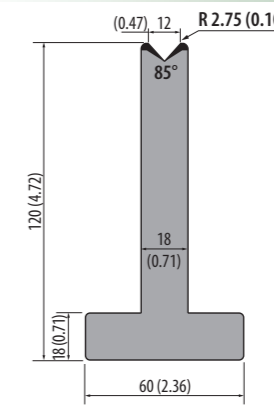


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 19.0 kg |
| 415 mm           | 16.34 in           | 8.0 kg  |
| 795 mm segmented | 31.29 in segmented | 18.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

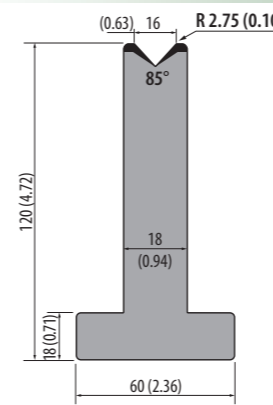


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.9 kg |
| 415 mm           | 16.34 in           | 9.4 kg  |
| 795 mm segmented | 31.29 in segmented | 18.0 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

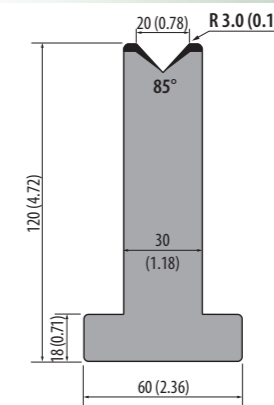


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.7 kg |
| 415 mm           | 16.34 in           | 11.3 kg |
| 795 mm segmented | 31.29 in segmented | 21.7 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

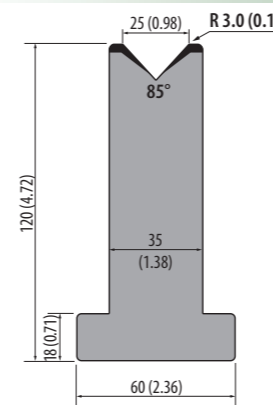


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 30.0 kg |
| 415 mm           | 16.34 in           | 15.0 kg |
| 795 mm segmented | 31.29 in segmented | 28.6 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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



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

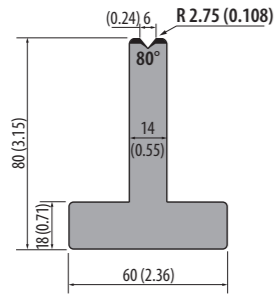
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

T-Dies 80°, H=80 (3.15)

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

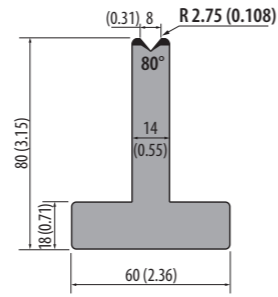


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

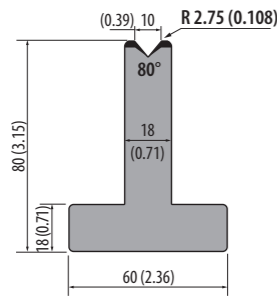


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

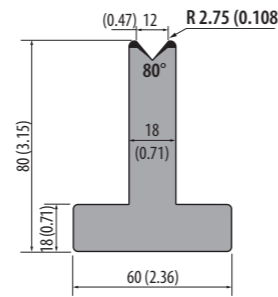


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

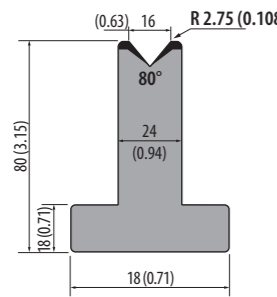


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

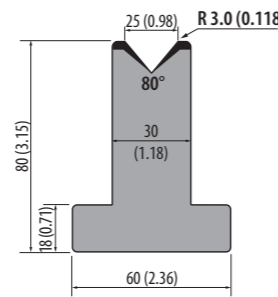


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

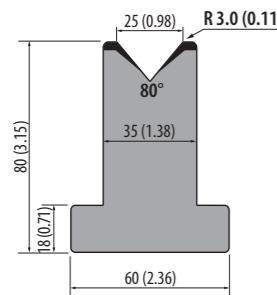


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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



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

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



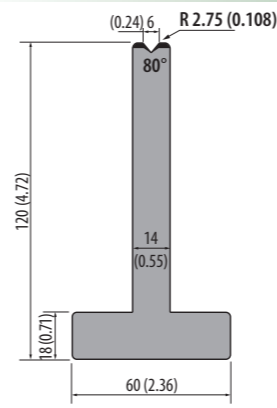
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# R1 ROLLERI TYPE R1

T-Dies 80°, H=120 (4.72)



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

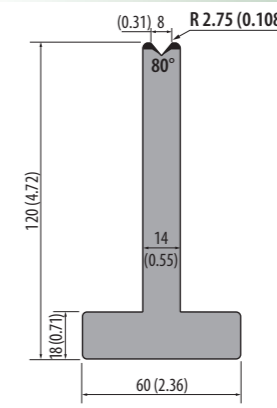


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.0 kg |
| 415 mm           | 16.34 in           | 9.0 kg  |
| 795 mm segmented | 31.29 in segmented | 17.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

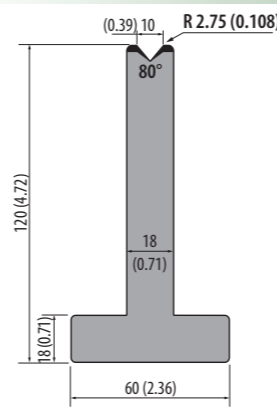


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.0 kg |
| 415 mm           | 16.34 in           | 9.0 kg  |
| 795 mm segmented | 31.29 in segmented | 17.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

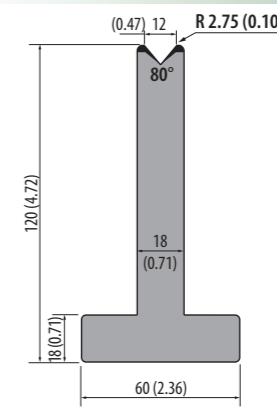


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.0 kg |
| 415 mm           | 16.34 in           | 9.0 kg  |
| 795 mm segmented | 31.29 in segmented | 17.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

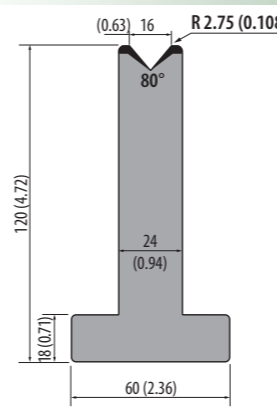


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.0 kg |
| 415 mm           | 16.34 in           | 9.0 kg  |
| 795 mm segmented | 31.29 in segmented | 17.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

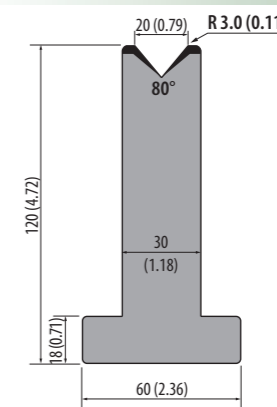


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.8 kg |
| 415 mm           | 16.34 in           | 9.3 kg  |
| 795 mm segmented | 31.29 in segmented | 17.9 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

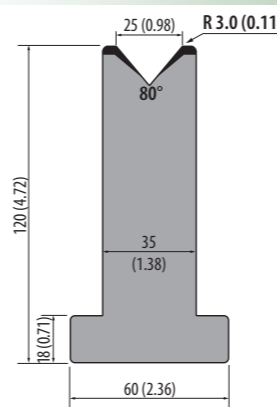


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 26.3 kg |
| 415 mm           | 16.34 in           | 13.0 kg |
| 795 mm segmented | 31.29 in segmented | 25.0 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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



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

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



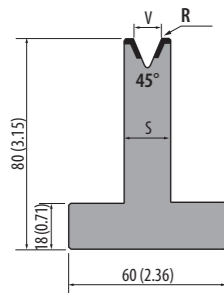


# R1 ROLLERI TYPE R1

T-Dies 45°, H=80 (3.15), H=120 (4.72)

## T-Dies 45°, H=80 mm (3.15 in)

500 kN/m max.



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

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



# R1 ROLLERI TYPE R1

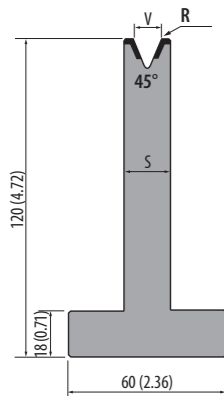
T-Dies 35°, H=80 (3.15), H=120 (4.72)



2  
R1

## T-Dies 45°, H=120 mm (4.72 in)

500 kN/m max.

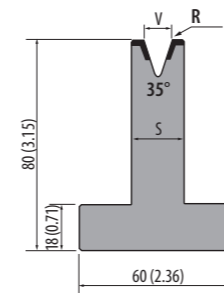


| Model      | V (mm) | V (in) | R (mm) | R (in) | S (mm) | S (in) | Weight  | Weight  | Weight  | Weight  |
|------------|--------|--------|--------|--------|--------|--------|---------|---------|---------|---------|
| T120.06.45 | 6      | 0.24   | 0.8    | 0.03   | 14     | 0.55   | 16.0 kg | 8.0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

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

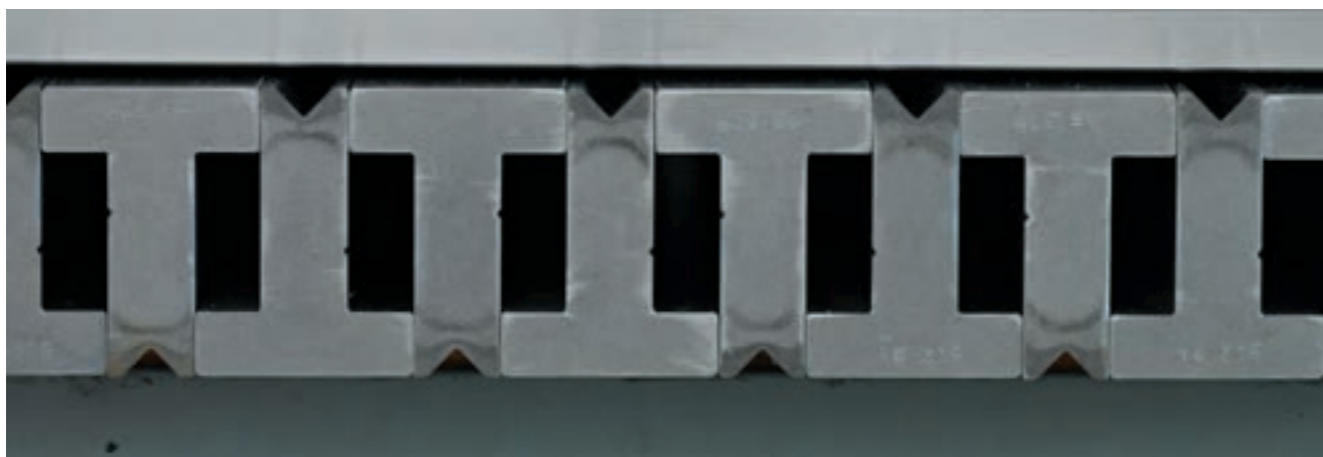


## T-Dies 35°, H=80 mm (3.15 in)

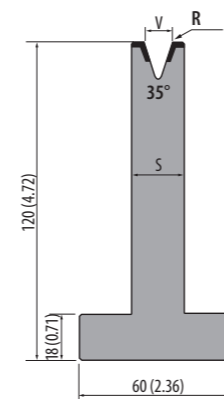


| Model     | V (mm) | V (in) | R (mm) | R (in) | S (mm) | S (in) | kN/m max. | Weight  | Weight | Weight  | Weight  |
|-----------|--------|--------|--------|--------|--------|--------|-----------|---------|--------|---------|---------|
| T80.06.35 | 6      | 0.24   | 0.8    | 0.03   | 14     | 0.55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

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



## T-Dies 35°, H=120 mm (4.72 in)



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

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



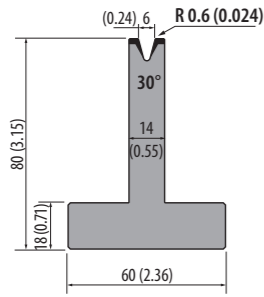


# R1 ROLLERI TYPE R1

T-Dies 30°, H=80 (3.15)



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

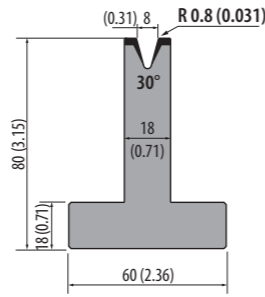


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 12.4 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 11.8 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

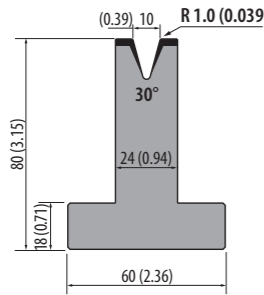


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 13.0 kg |
| 415 mm           | 16.34 in           | 6.5 kg  |
| 795 mm segmented | 31.29 in segmented | 12.4 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

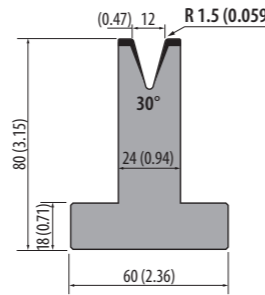


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.0 kg |
| 415 mm           | 16.34 in           | 8.0 kg  |
| 795 mm segmented | 31.29 in segmented | 15.2 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

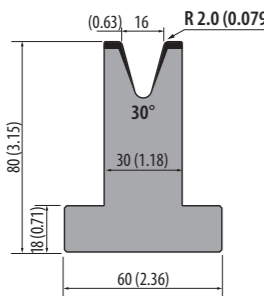


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.0 kg |
| 415 mm           | 16.34 in           | 8.0 kg  |
| 795 mm segmented | 31.29 in segmented | 15.2 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

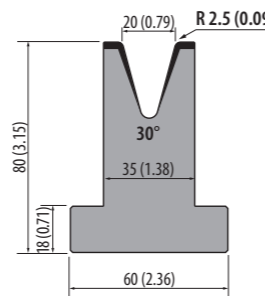


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.0 kg |
| 415 mm           | 16.34 in           | 8.9 kg  |
| 795 mm segmented | 31.29 in segmented | 17.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

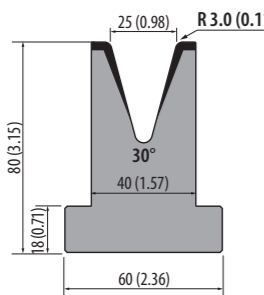


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.0 kg |
| 415 mm           | 16.34 in           | 8.9 kg  |
| 795 mm segmented | 31.29 in segmented | 17.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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



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

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

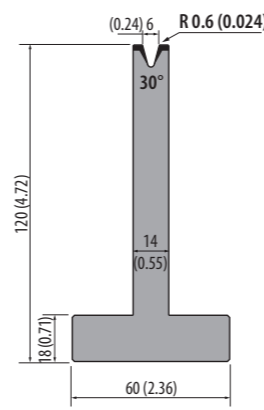


Articles on stock – Please note that delivery time varies according to your location.

# R1 ROLLERI TYPE R1

T-Dies 30°, H=120 (4.72)

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

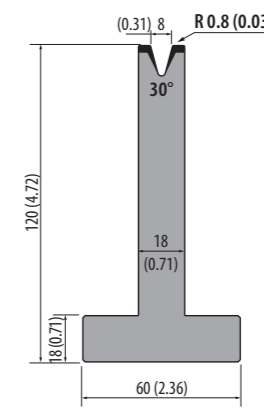


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 16.0 kg |
| 415 mm           | 16.34 in           | 8.0 kg  |
| 795 mm segmented | 31.29 in segmented | 15.2 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

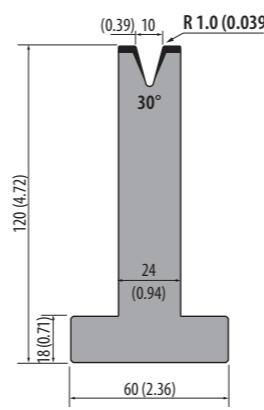


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 19.0 kg |
| 415 mm           | 16.34 in           | 9.5 kg  |
| 795 mm segmented | 31.29 in segmented | 18.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

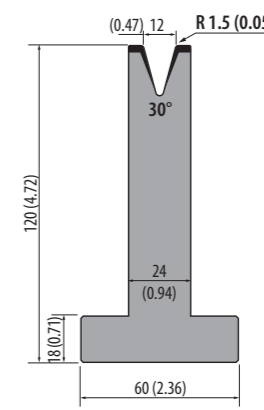


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.0 kg |
| 415 mm           | 16.34 in           | 10.9 kg |
| 795 mm segmented | 31.29 in segmented | 20.9 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

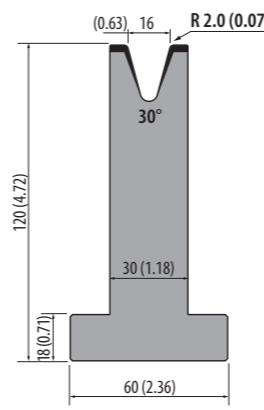


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.0 kg |
| 415 mm           | 16.34 in           | 10.0 kg |
| 795 mm segmented | 31.29 in segmented | 20.9 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

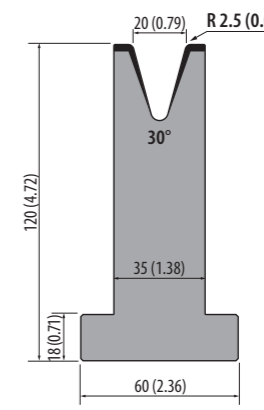


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 25.8 kg |
| 415 mm           | 16.34 in           | 12.8 kg |
| 795 mm segmented | 31.29 in segmented | 24.6 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

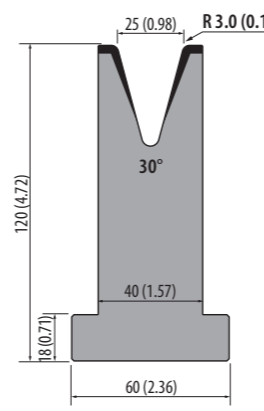


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 28.0 kg |
| 415 mm           | 16.34 in           | 14.0 kg |
| 795 mm segmented | 31.29 in segmented | 26.7 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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



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

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



# R1 ROLLERI TYPE R1

T-Dies 26°, H=80 (3.15)



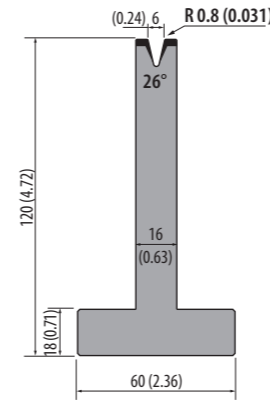
# R1 ROLLERI TYPE R1

T-Dies 26°, H=120 (4.72)



T120.06.26

200 kN/m max.



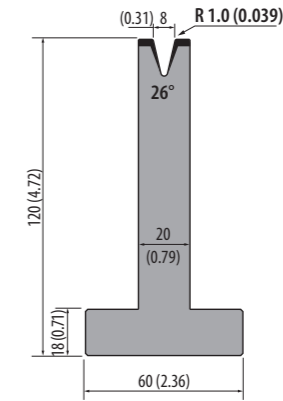
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 18.0 kg |
| 415 mm           | 16.34 in           | 9.0 kg  |
| 795 mm segmented | 31.29 in segmented | 17.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



T120.08.26

200 kN/m max.



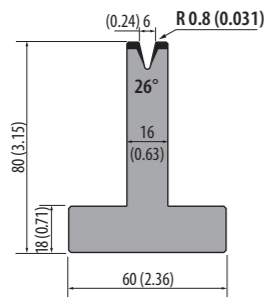
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 19.0 kg |
| 415 mm           | 16.34 in           | 9.5 kg  |
| 795 mm segmented | 31.29 in segmented | 18.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



T80.06.26

200 kN/m max.



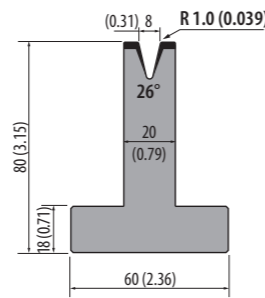
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 14.0 kg |
| 415 mm           | 16.34 in           | 7.0 kg  |
| 795 mm segmented | 31.29 in segmented | 13.3 kg |
| 805 mm segmented | 31.69 in segmented |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

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



T80.08.26

200 kN/m max.



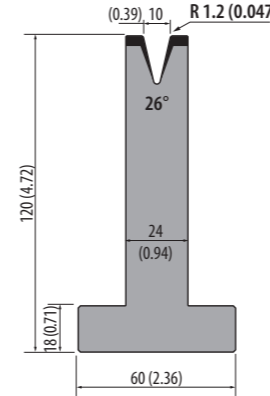
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 15.0 kg |
| 415 mm           | 16.34 in           | 7.5 kg  |
| 795 mm segmented | 31.29 in segmented | 14.3 kg |
| 805 mm segmented | 31.69 in segmented |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

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



T120.10.26

200 kN/m max.



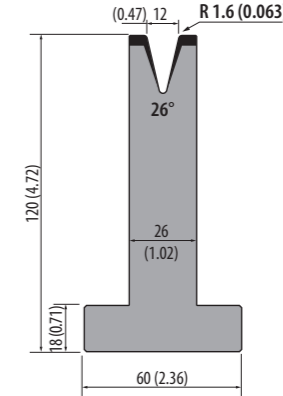
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.0 kg |
| 415 mm           | 16.34 in           | 11.0 kg |
| 795 mm segmented | 31.29 in segmented | 20.9 kg |
| 805 mm segmented | 31.69 in segmented |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

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



T120.12.26

200 kN/m max.



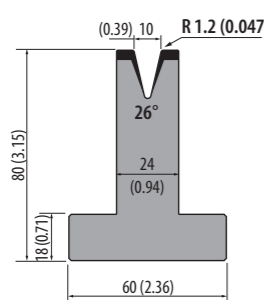
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 22.0 kg |
| 415 mm           | 16.34 in           | 11.0 kg |
| 795 mm segmented | 31.29 in segmented | 20.9 kg |
| 805 mm segmented | 31.69 in segmented |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

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



T80.10.26

200 kN/m max.



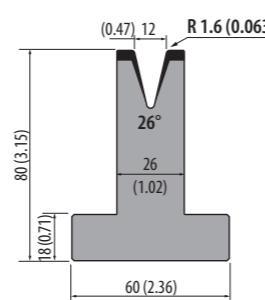
|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 15.5 kg |
| 415 mm           | 16.34 in           | 8.0 kg  |
| 795 mm segmented | 31.29 in segmented | 14.8 kg |
| 805 mm segmented | 31.69 in segmented |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

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



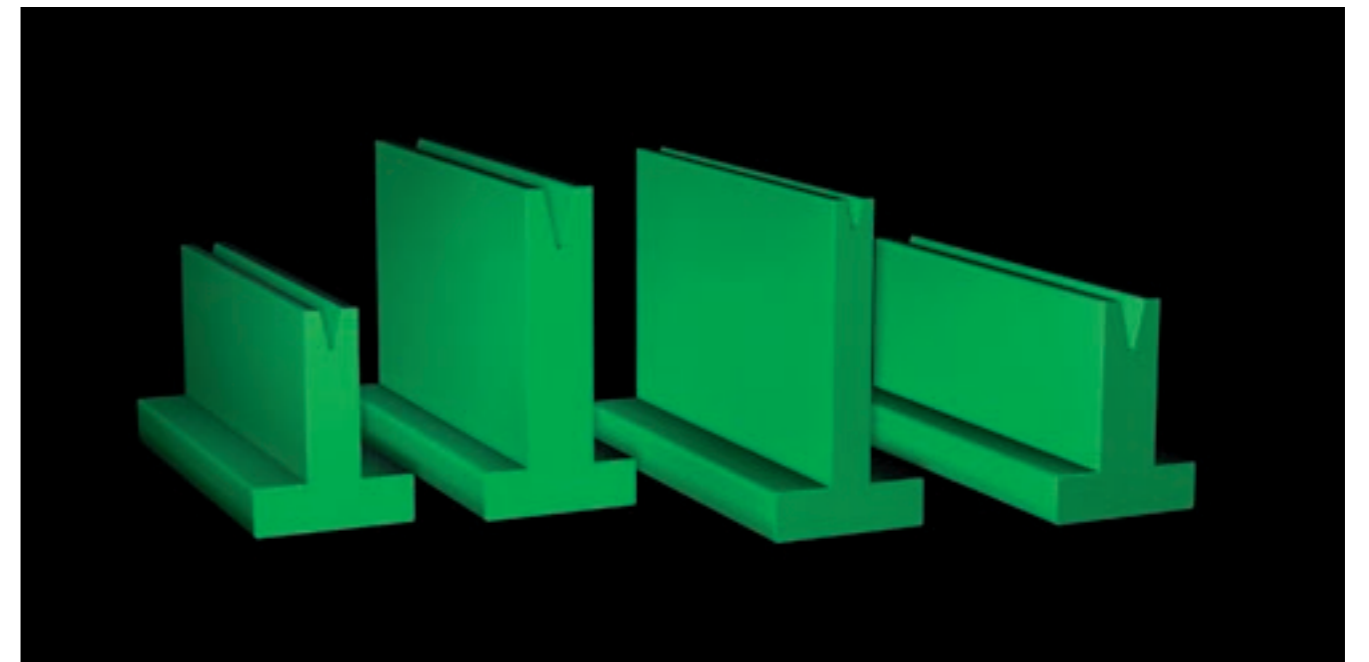
T80.12.26

200 kN/m max.



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

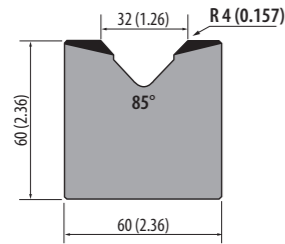
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

1-V Dies, 85°

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

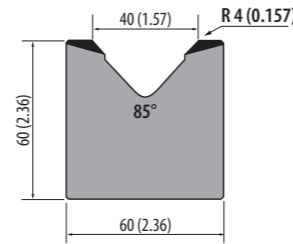


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 21.6 kg |
| 415 mm           | 16.34 in           | 10.7 kg |
| 795 mm segmented | 31.29 in segmented | 20.6 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

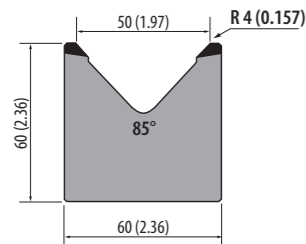


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 20.0 kg |
| 415 mm           | 16.34 in           | 10.5 kg |
| 795 mm segmented | 31.29 in segmented | 19.0 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

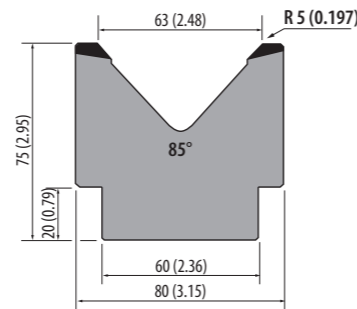


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 19.0 kg |
| 415 mm           | 16.34 in           | 9.5 kg  |
| 795 mm segmented | 31.29 in segmented | 18.1 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

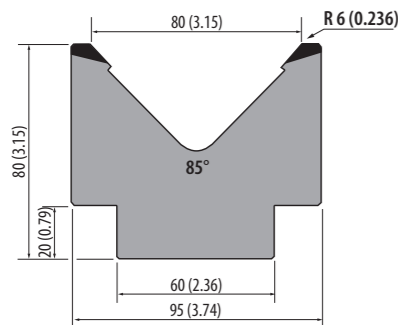


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 29.2 kg |
| 415 mm           | 16.34 in           | 14.5 kg |
| 795 mm segmented | 31.29 in segmented | 27.8 kg |
| 805 mm segmented | 31.69 in segmented |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

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

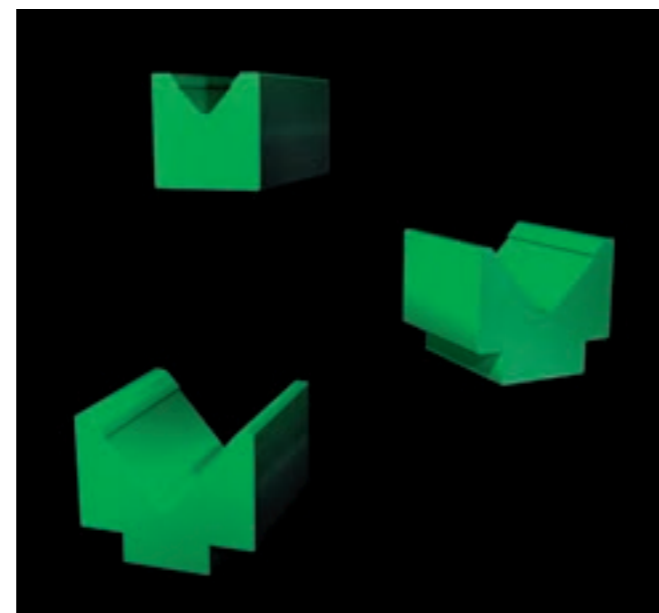


**M80.85.80** 1000 kN/m max.



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

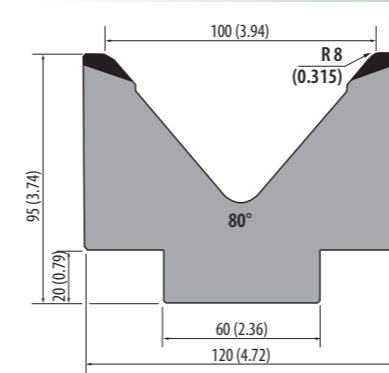
C45: 560-710 N/mm<sup>2</sup>



# R1 ROLLERI TYPE R1

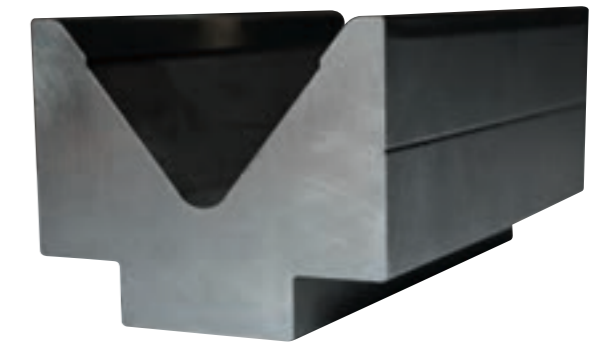
1-V Dies, 80°

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

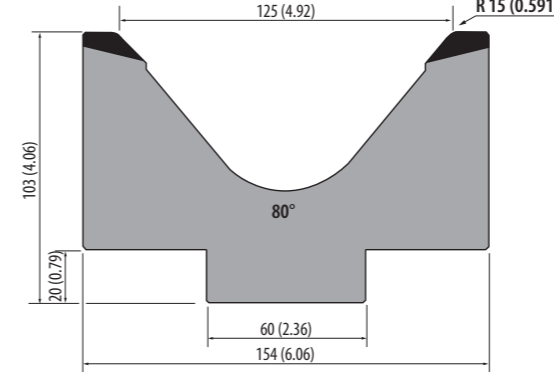


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 46.2 kg |
| 415 mm           | 16.34 in           | 22.9 kg |
| 795 mm segmented | 31.29 in segmented | 44.0 kg |
| 805 mm segmented | 31.69 in segmented |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

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



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

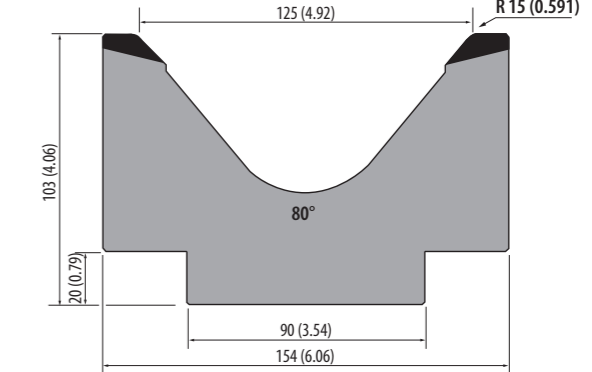


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 62.0 kg |
| 415 mm           | 16.34 in           | 31.0 kg |
| 795 mm segmented | 31.29 in segmented | 59.0 kg |
| 805 mm segmented | 31.69 in segmented |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



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

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

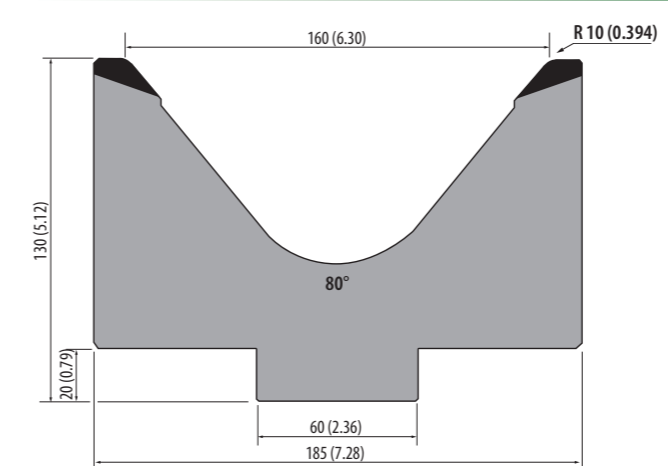


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 64.9 kg |
| 415 mm           | 16.34 in           | 32.2 kg |
| 795 mm segmented | 31.29 in segmented | 61.4 kg |
| 805 mm segmented | 31.69 in segmented |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



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

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

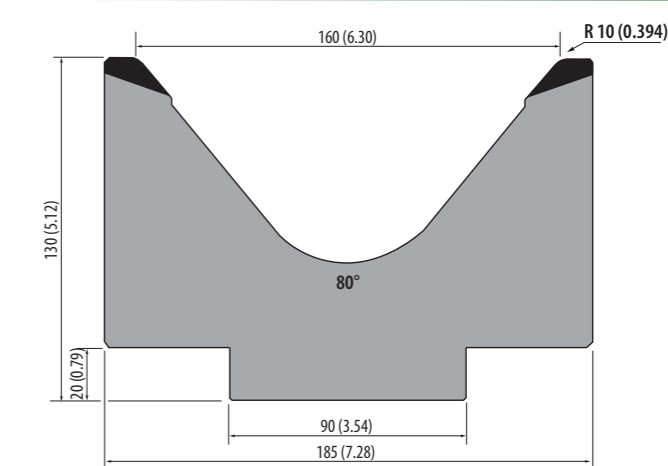


|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 93.0 kg |
| 415 mm           | 16.34 in           | 46.5 kg |
| 795 mm segmented | 31.29 in segmented | 88.5 kg |
| 805 mm segmented | 31.69 in segmented |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



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

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



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

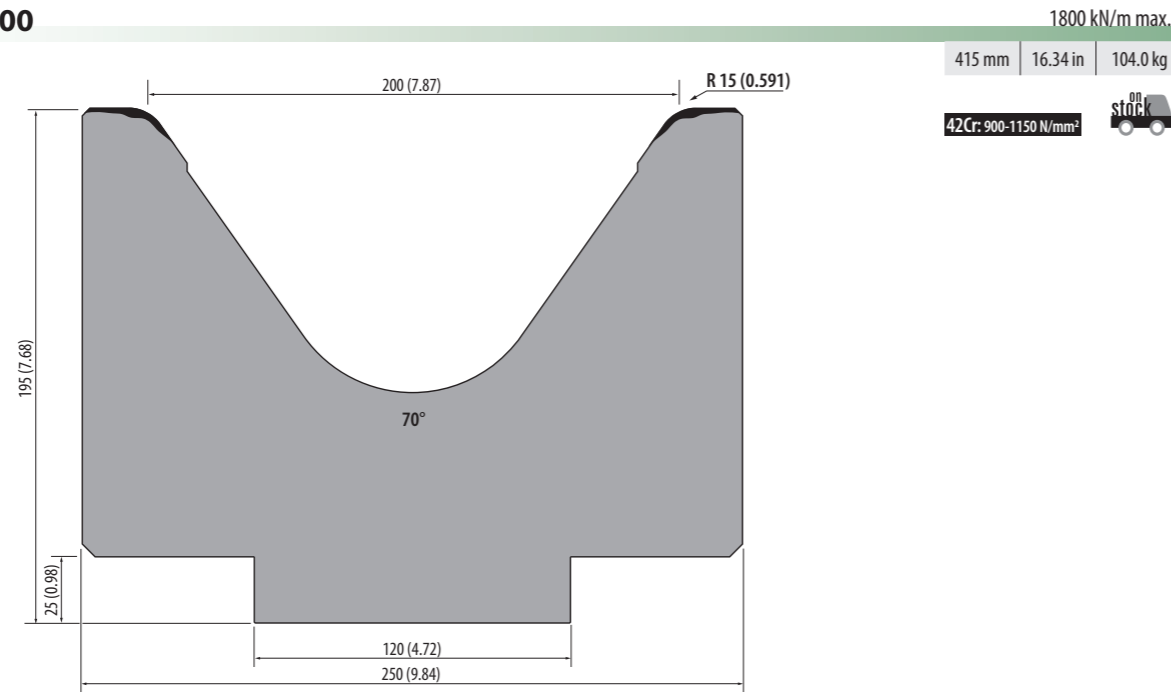


C45: 560-710 N/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

1-V Dies, 70°

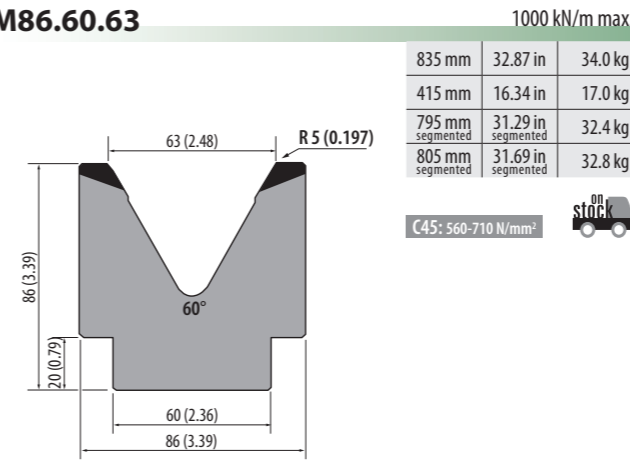
M195.70.200



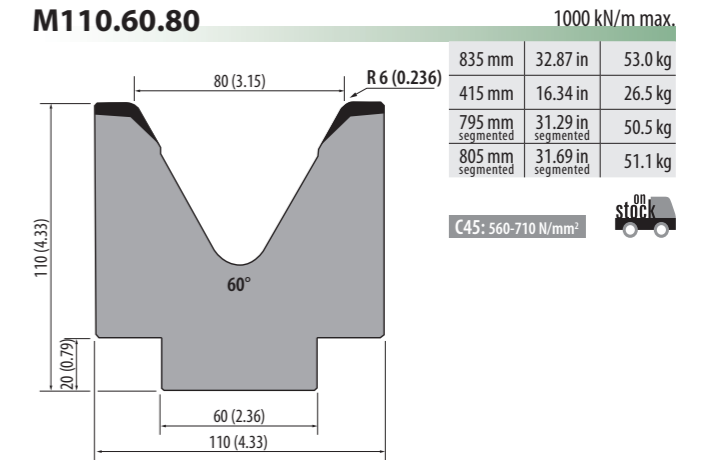
# R1 ROLLERI TYPE R1

1-V Dies, 60°

M86.60.63

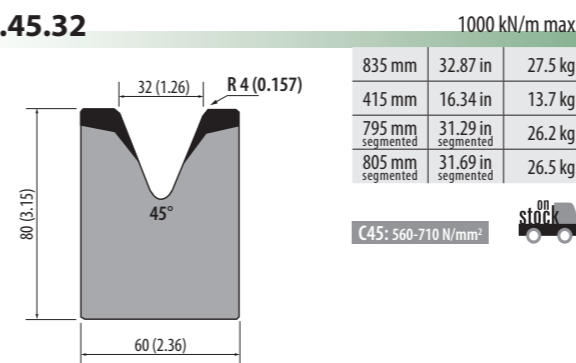


M110.60.80

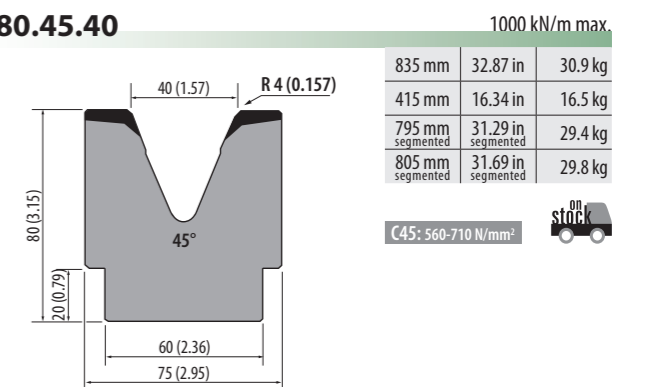


# 1-V Dies, 45°

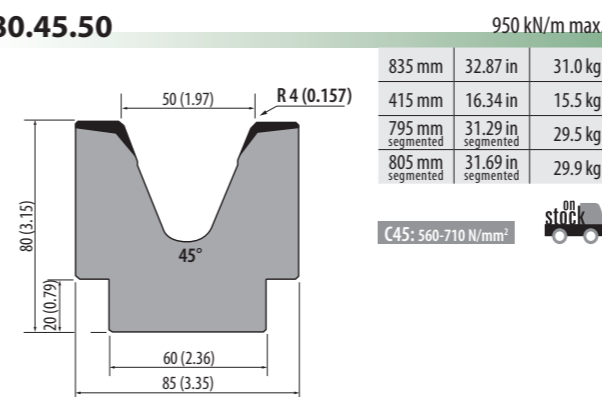
M80.45.32



M80.45.40



M80.45.50



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

# R1 ROLLERI TYPE R1

## Multi-V Dies

**M60.90.01** 1000 kN/m max.

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

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

**M60.90.02** 800 kN/m max.

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

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

**M.360.R** 1000 kN/m max.

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

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

**M.460.R** 800 kN/m max.

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

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

**M.460** 800 kN/m max.

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

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

**M.460.60** 600 kN/m max.

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

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

**M.490** 1000 kN/m max.

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

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

**M.490.70** 600 kN/m max.

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

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

# R1 ROLLERI TYPE R1

## Multi-V Dies



**T70-88** 1000 kN/m max.

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

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

**T70-60**

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

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

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

**T70-45**

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

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

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

**T70-35**

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

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

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

**SU-T70**

|        |          |         |
|--------|----------|---------|
| 525 mm | 20.67 in | 12.4 kg |
|--------|----------|---------|

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

**PB-T70**

|       |         |        |
|-------|---------|--------|
| 20 mm | 0.79 in | 0.2 kg |
|-------|---------|--------|

per pair

Fe37

Special Punches and Dies see pages 236-241

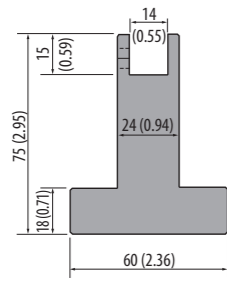
# R1 ROLLERI TYPE R1

## Synthetic Dies

### TN80.14 1000 kN/m max.

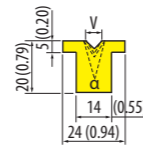
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 15.0 kg |
| 415 mm | 16.34 in | 7.5 kg  |

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



### INS14... 200 kN/m max.

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



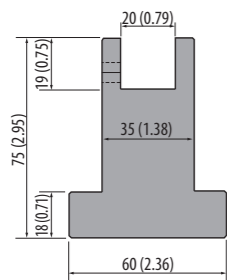
| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS14.06.88 | 88° | 6      | 0.24   |
| INS14.08.88 | 88° | 8      | 0.31   |
| INS14.10.88 | 88° | 10     | 0.39   |
| INS14.06.60 | 60° | 6      | 0.24   |
| INS14.08.60 | 60° | 8      | 0.31   |
| INS14.10.60 | 60° |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

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

### TN80.20 1000 kN/m max.

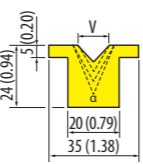
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 19.0 kg |
| 415 mm | 16.34 in | 9.5 kg  |

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



### INS20... 200 kN/m max.

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



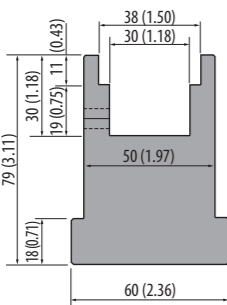
| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS20.06.88 | 88° | 6      | 0.24   |
| INS20.08.88 | 88° | 8      | 0.31   |
| INS20.10.88 | 88° | 10     | 0.39   |
| INS20.12.88 | 88° | 12     | 0.47   |
| INS20.16.88 | 88° | 16     | 0.63   |
| INS20.06.60 | 60° |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

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

### TN80.30 1000 kN/m max.

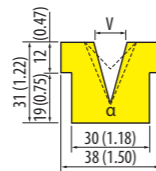
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 25.0 kg |
| 415 mm | 16.34 in | 12.5 kg |

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



### INS30... 200 kN/m max.

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



| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS30.06.88 | 88° | 6      | 0.24   |
| INS30.08.88 | 88° | 8      | 0.31   |
| INS30.10.88 | 88° | 10     | 0.39   |
| INS30.12.88 | 88° | 12     | 0.47   |
| INS30.16.88 | 88° | 16     | 0.63   |
| INS30.20.88 | 88° | 20     | 0.79   |
| INS30.25.88 | 88° | 25     | 0.99   |
| INS30.06.60 | 60° | 6      | 0.24   |
| INS30.08.60 | 60° | 8      | 0.31   |
| INS30.10.60 | 60° | 10     | 0.39   |
| INS30.12.60 | 60° | 12     | 0.47   |
| INS30.16.60 | 60° | 16     | 0.63   |
| INS30.20.60 | 60° | 20     | 0.79   |

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

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

# R1 ROLLERI TYPE R1

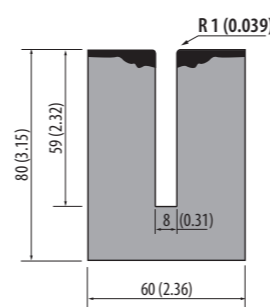
## Hemming Dies



### TOP.SM-134.28.8 / TOP.SM-134.24.8

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

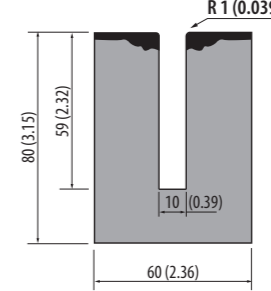
42Cr: 900-1150 N/mm<sup>2</sup>



### TOP.SM-134.24.10

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

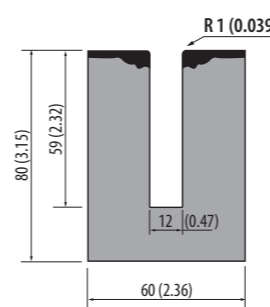
42Cr: 900-1150 N/mm<sup>2</sup>



### TOP.SM-134.24.12

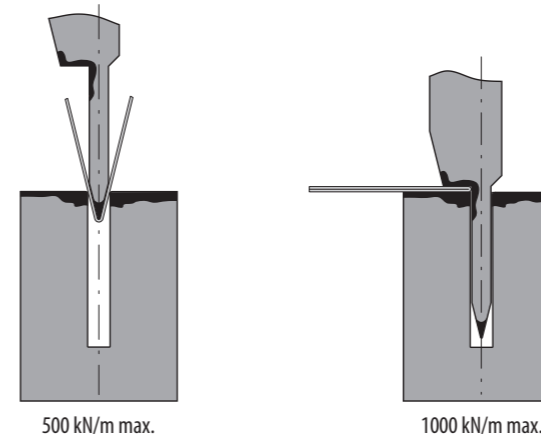
|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 16.8 kg |
| 495 mm segmented | 19.49 in segmented | 15.9 kg |

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



Compatible Hemming Punches see page 28

### Example of application



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

# R1 ROLLERI TYPE R1

## Spring-loaded Hemming Dies

**S101.35.06** 600 kN/m max.

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

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

**S101.35.08** 600 kN/m max.

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

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

**S101.35.10** 600 kN/m max.

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

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

**S110.30.08** 800 kN/m max.

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

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

**S135.26.08** 400 kN/m max.

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

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

**S135.26.10** 1000 kN/m max.

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

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

**SA135.26.12** 1000 kN/m max.

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

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

### Our Advantage – Your Convenience

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



### Rolleri Videos

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



# R1 ROLLERI TYPE R1

## Pneumatic Hemming Dies



**KPN**

per piece 1.0 kg

Accessories for pneumatic hemming dies

| S (mm) | A (mm) | R.45 Kgf/mm <sup>2</sup> t/m | R.70 Kgf/mm <sup>2</sup> t/m | S (mm) | A (mm) | R.45 Kgf/mm <sup>2</sup> t/m | R.70 Kgf/mm <sup>2</sup> t/m |
|--------|--------|------------------------------|------------------------------|--------|--------|------------------------------|------------------------------|
| 0.6    | 3.0    | 9                            | 15                           | 0.6    | 1.2    | 23                           | 35                           |
| 0.8    | 3.0    | 12                           | 20                           | 0.8    | 1.6    | 32                           | 50                           |
| 1.0    | 3.5    | 15                           | 25                           | 1.0    | 1.0    | 40                           | 60                           |
| 1.25   | 3.5    | 17                           | 26                           | 1.25   | 2.5    | 50                           | 80                           |
| 1.5    | 4.6    | 22                           | 38                           | 1.5    | 3.0    | 63                           | 95                           |
| 2.0    | 5.5    | 30                           | 50                           | 2.0    | 4.0    | 80                           | 130                          |
| 2.5    | 6.5    | 55                           | -                            | 2.5    | 5.0    | 90                           | -                            |
| 3.0    | 8.0    | 70                           | -                            | 3.0    | 6.0    | 100                          | -                            |

**S101PN.35.06** 600 kN/m max.

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

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

**S101PN.35.08** 600 kN/m max.

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

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

**S101PN.35.10** 600 kN/m max.

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

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

**S135PN.26.08** 400 kN/m max.

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

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

**S135PN.26.10** 1000 kN/m max.

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

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

**SA135PN.26.12** 1000 kN/m max.

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

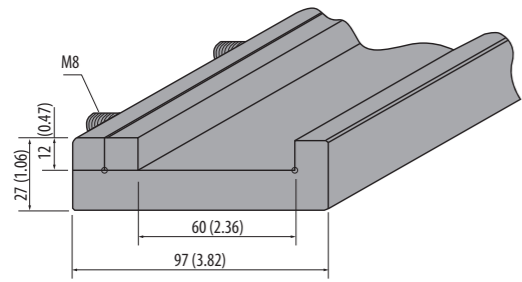
C45: 560-710 N/mm<sup>2</sup>

The complete pneumatic system is located within the die.

# R1 ROLLERI TYPE R1

Adpater Rails for Dies

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



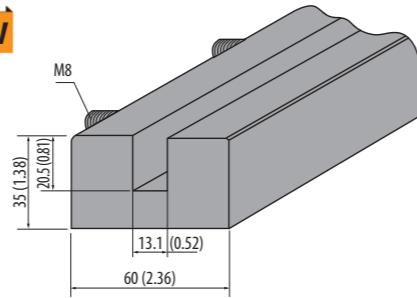
| Model    | Length (mm) | Length (in) | Weight  |
|----------|-------------|-------------|---------|
| C 2000/S | 2100        | 82.68       | 27.0 kg |
| C 2500/S | 2600        | 102.36      | 34.0 kg |
| C 3000/S | 3100        | 122.05      | 40.0 kg |
| C 4000/S | 4100        | 161.42      | 53.0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



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

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

**NEW**

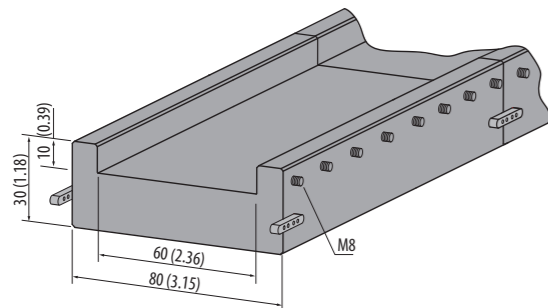


| Model     | Length (mm) | Length (in) | Weight  |
|-----------|-------------|-------------|---------|
| TC 2000/S | 2100 mm     | 82.68       | 30.0 kg |
| TC 2500/S | 2600 mm     | 102.36      | 37.0 kg |
| TC 3000/S | 3100 mm     | 122.05      | 44.0 kg |
| TC 4000/S | 4100 mm     | 161.42      |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



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

## C 1050/R

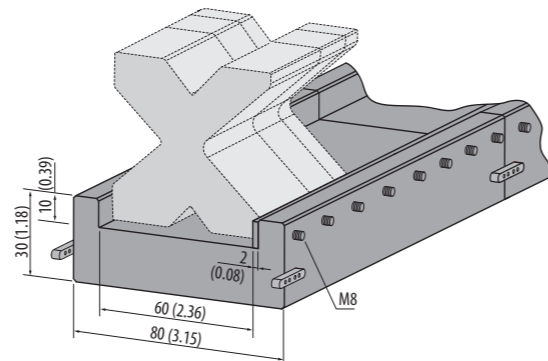


| Model      | Length (mm) | Length (in) | Weight  |
|------------|-------------|-------------|---------|
| C 1050/R   | 1050        | 41.34       | 15.0 kg |
| C 1050/R/C | 520         | 20.47       | 7.5 kg  |



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

## C 1050/RS

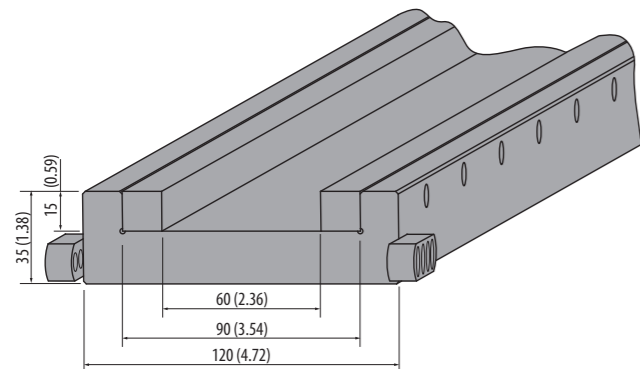


| Model       | Length (mm) | Length (in) | Weight  |
|-------------|-------------|-------------|---------|
| C 1050/RS   | 1050 mm     | 41.34       | 15.0 kg |
| C 1050/RS/C | 520 mm      | 20.47       | 7.5 kg  |



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

## C 1050-90



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



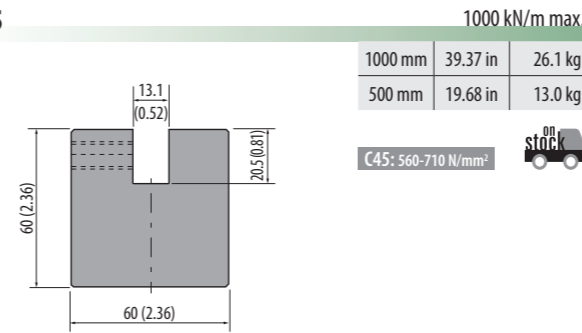
C45: 560-710 N/mm<sup>2</sup>

# R1 ROLLERI TYPE R1

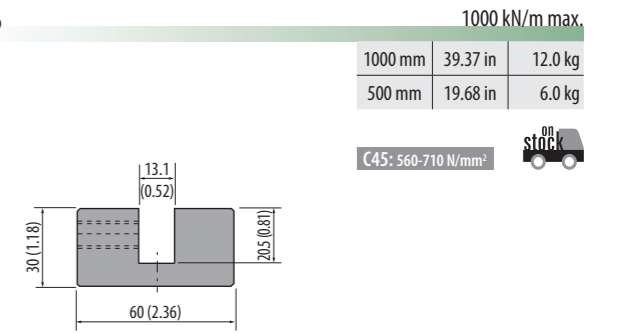
Die Adapters



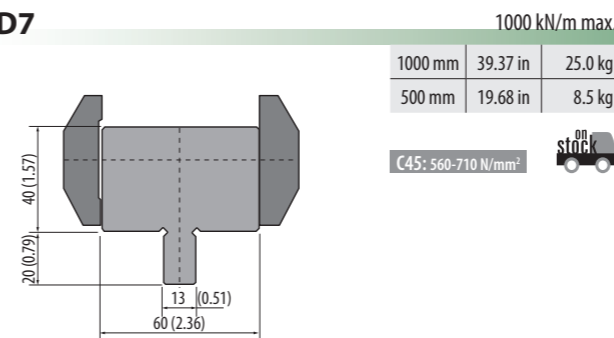
## AD5



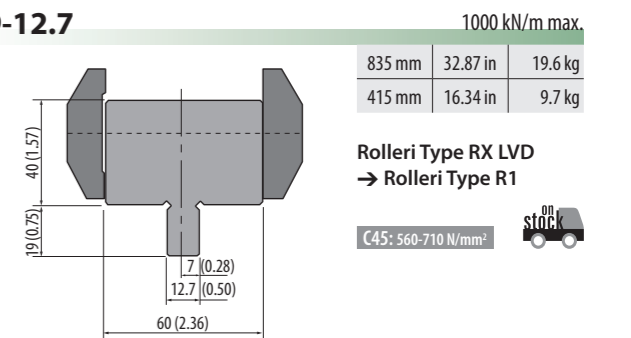
## AD6



## AD7



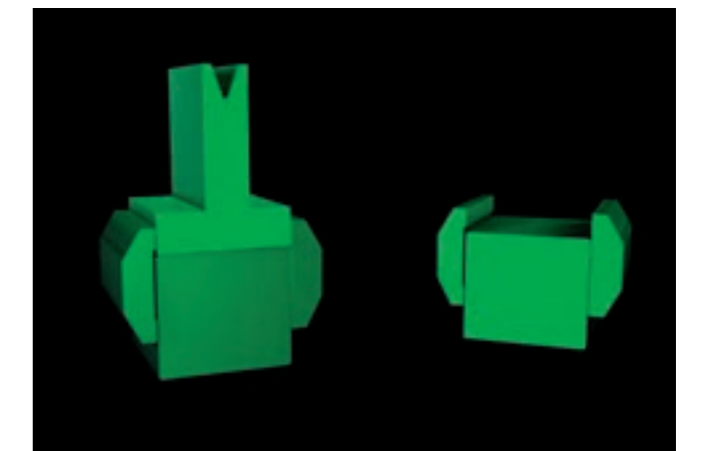
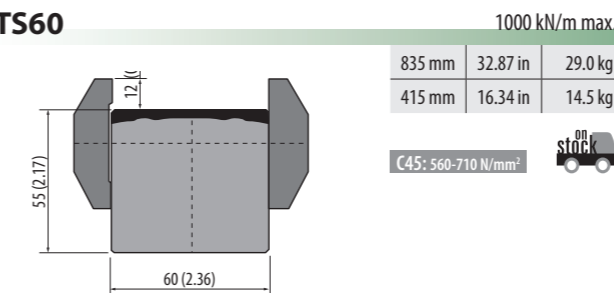
## AD9-12.7



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

## Die Extensions

### CTS60





## PUNCHES ROLLERI TYPE R2

|                       |         |
|-----------------------|---------|
| Content Explanation   | 82 - 84 |
| 90° Punches           | 85      |
| 86° Punches           | 85 - 86 |
| 80° Punches           | 87      |
| 60° Punches           | 88      |
| 28° Punches           | 89 - 90 |
| 28°/24° Hemming Tools | 91      |
| Z-Profile Tools       | 92      |
| Radius Tools          | 93 - 94 |
| Punch Extensions      | 95      |
| Punch Adapters        | 95      |

### Compatibility

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

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



### Compatibility

Punches Roller Type R2 are:

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

### Material

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

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

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

### Tang

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

- QuickLock ↓
- Safety Pins ↔
- ROL-System ↑

#### ATTENTION:

#### QuickLock

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

#### Safety Pins

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

#### ROL1-System

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

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

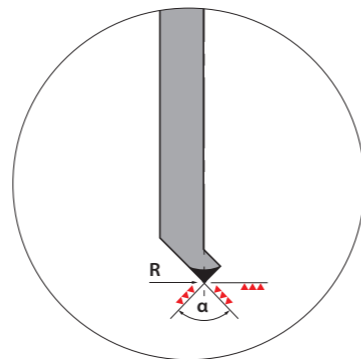
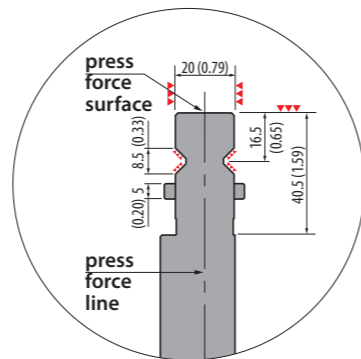
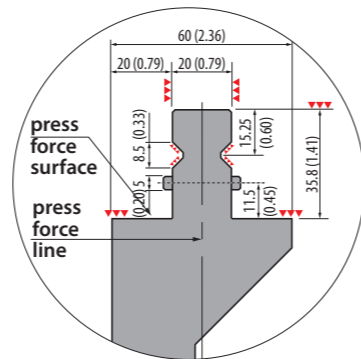
Depending on each type, the punches are either head-bearing or shoulder-bearing.

Indications of precision ground surfaces:



### Our Advantages – Your Convenience

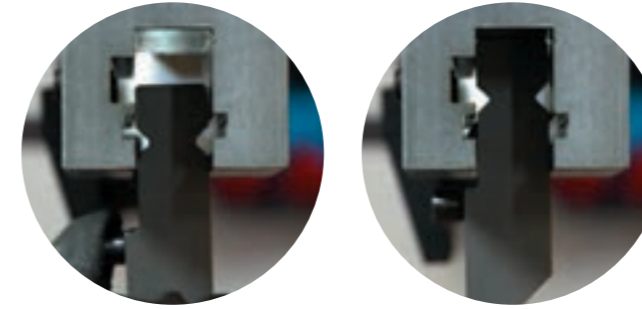
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height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



### Clamping Systems

#### QuickLock (Standard)

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



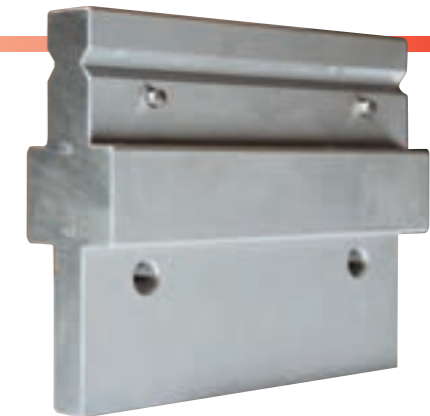
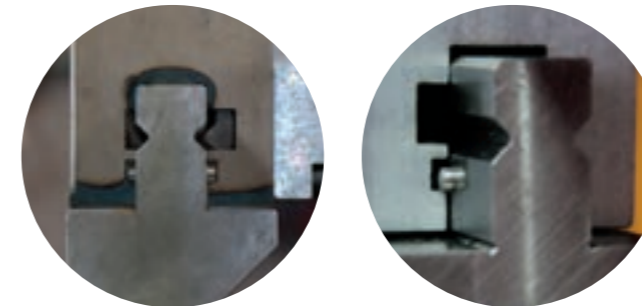
#### Rolleri Videos

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



#### Safety Pins (Standard)

- horizontal tool exchange



#### ROL1-System

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



### Tool Lengths and Sectioning

Standard

More lengths and sectionings are possible upon request.

500 mm (19.68 in)

515 mm (20.28 in)

525 mm (20.67 in)

#### Sectioning FA

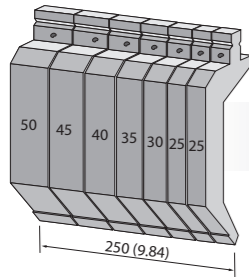
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

| Length in mm (in) | 25 (0.98) | 30 (1.18) | 35 (1.38) | 40 (1.57) | 45 (1.77) | 50 (1.97) | 100 (3.94) Horn L. | 100 (3.94) Horn I. | 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

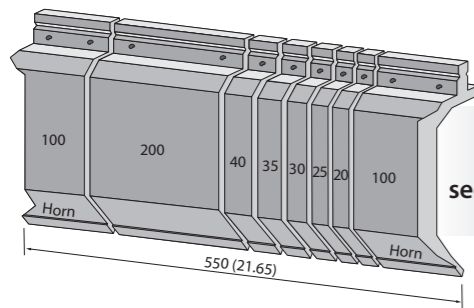
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

| 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 I. | 100 (3.94) | 200 (7.87) | 300 (11.81) |
|-------------------|-----------|-----------|-----------|-----------|-----------|-----------|--------------------|--------------------|------------|------------|-------------|
| 1250 (49.21)      | 2         | 1         | 1         | 1         | 1         | 1         | 1                  | 1                  | 1          | 2          | 1           |
| 2050 (80.71)      | 2         | 1         | 1         | 1         | 1         | 1         | 1                  | 1                  | 1          | 3          | 3           |
| 2550 (100.39)     | 2         | 1         | 1         | 1         | 1         | 1         | 1                  | 1                  | 1          | 4          | 4           |
| 3050 (120.08)     | 2         | 1         | 1         | 1         | 1         | 1         | 1                  | 1                  | 1          | 5          | 5           |
| 4050 (159.45)     | 2         | 1         | 1         | 1         | 1         | 1         | 1                  | 1                  | 1          | 7          | 7           |

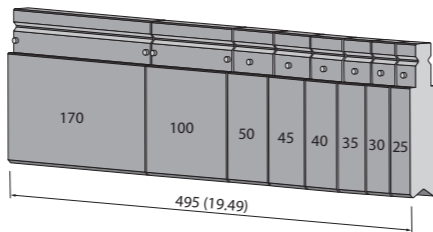


250 mm (9.84 in) segmented / FC (7 segments)

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

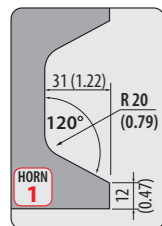


550 mm (21.65 in) segmented / FW (8 segments)

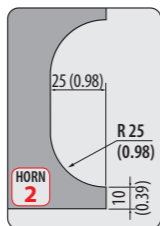


495 mm (19.49 in) segmented / F (8 segments)

### Horn Types



**Horn 1**  
Standard for all segmented Punches Rolleri Type R2

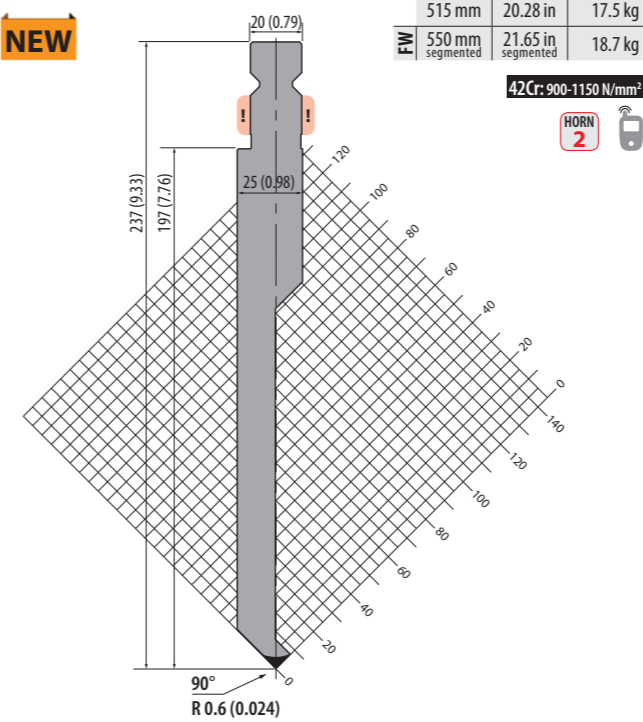


**Horn 2**  
for all segmented Punches Rolleri Type R2 of Length 550 mm (21.65 in)

### TPR237.90.R06

600 kN/m max.

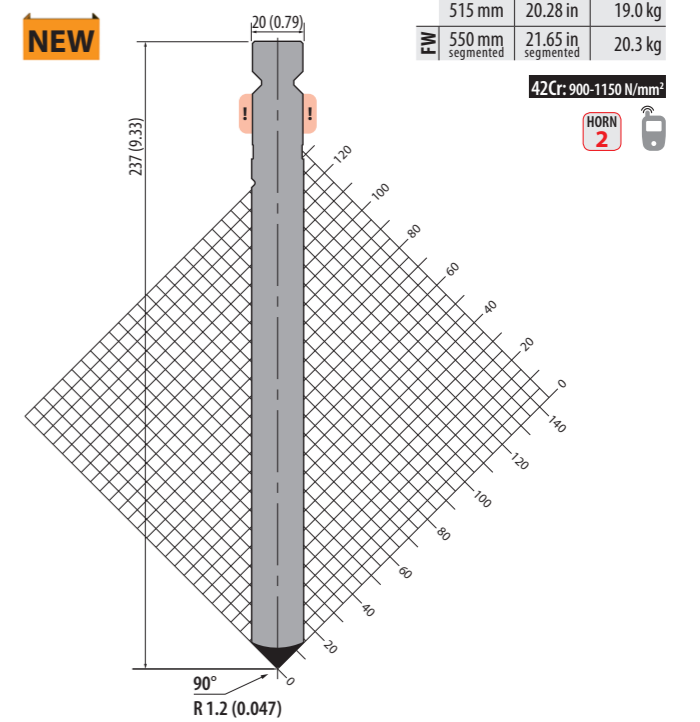
NEW



### TPR237.90.R12

1000 kN/m max.

NEW

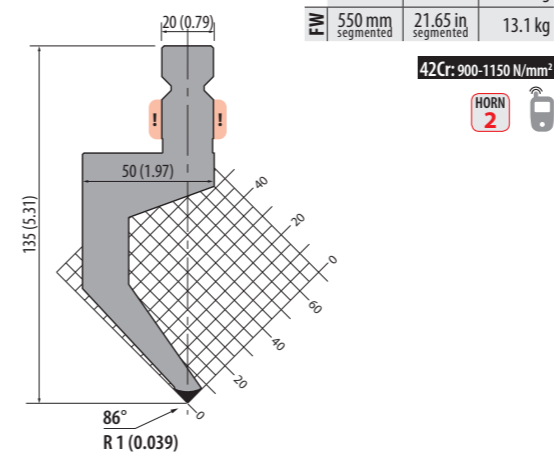


### 86° Punches

### TPR135.86.R1

650 kN/m max.

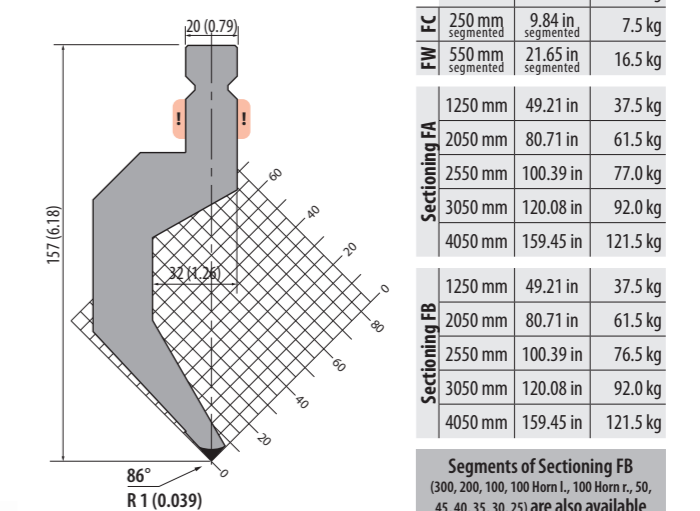
NEW



### TPR157.86.R1

800 kN/m max.

NEW



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

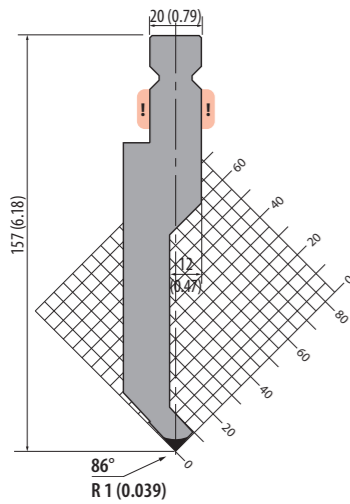
42Cr: 900-1150 N/mm<sup>2</sup>  
HORN 1  
HORN 2 only for 550 mm (21.65 in) segm.

# R2 ROLLERI TYPE R2

## 86° Punches

TPR157.86.R1-A

800 kN/m max.



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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

# R2 ROLLERI TYPE R2

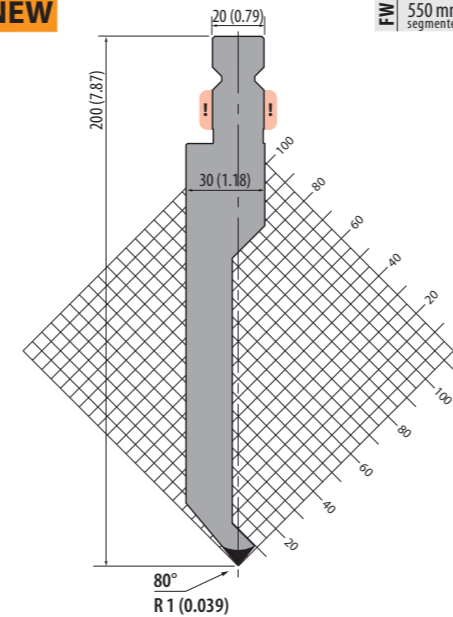
## 80° Punches



TPR200.80.R1

800 kN/m max.

**NEW**



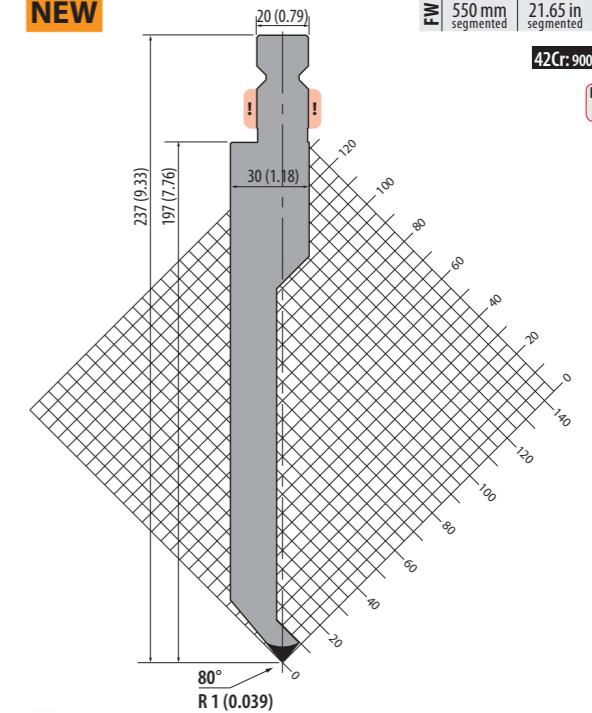
|           | 515 mm           | 20.28 in           | 19.0 kg |
|-----------|------------------|--------------------|---------|
| <b>FC</b> | 250 mm segmented | 9.84 in segmented  | 6.3 kg  |
| <b>FW</b> | 550 mm segmented | 21.65 in segmented | 20.3 kg |

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

TPR237.80.R1

800 kN/m max.

**NEW**



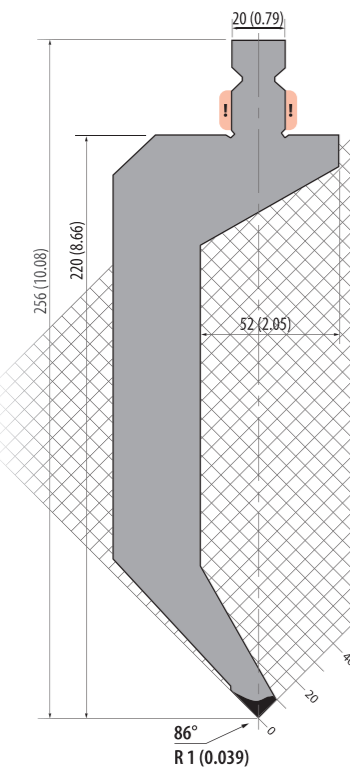
|           | 515 mm           | 20.28 in           | 19.7 kg |
|-----------|------------------|--------------------|---------|
| <b>FC</b> | 250 mm segmented | 9.84 in segmented  | 6.3 kg  |
| <b>FW</b> | 550 mm segmented | 21.65 in segmented | 21.0 kg |

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

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

TPR256.86.R1

800 kN/m max.



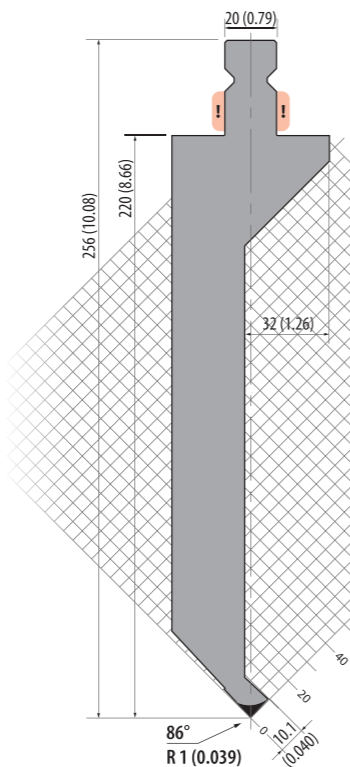
|                      | 500 mm           | 19.68 in           | 33.0 kg  |
|----------------------|------------------|--------------------|----------|
| <b>FC</b>            | 250 mm segmented | 9.84 in segmented  | 16.5 kg  |
| <b>FW</b>            | 550 mm segmented | 21.65 in segmented | 36.3 kg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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.

TPR256.86.R1-A

800 kN/m max.



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

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

42Cr: 900-1150 N/mm<sup>2</sup>  
**HORN 1**   
**HORN 2** only for 550 mm (21.65 in) segm.



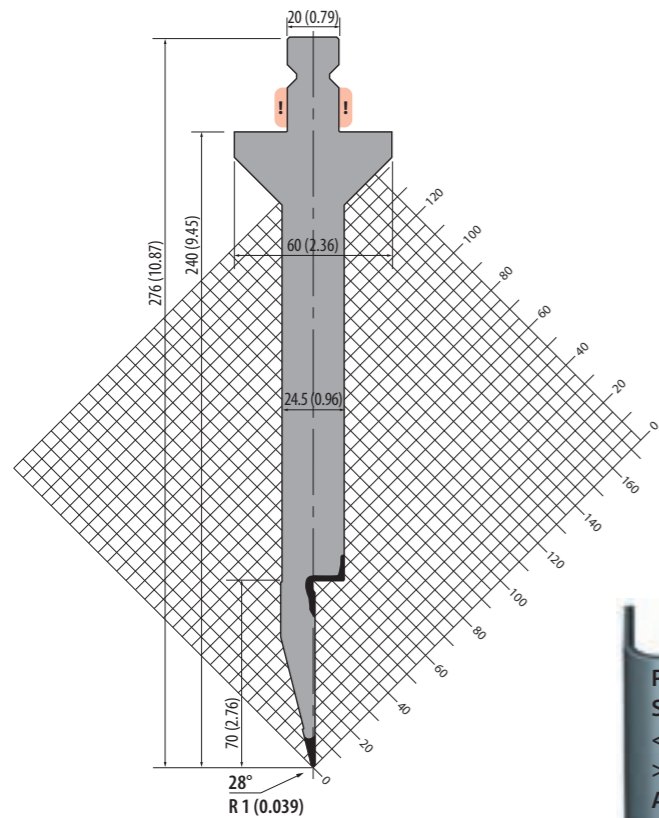


# R2 ROLLERI TYPE R2

## 28° Punches

TPR276.28.R1

400 kN/m max.



|               |                  |                    |          |
|---------------|------------------|--------------------|----------|
| FW   FC       | 500 mm           | 19.68 in           | 24.0 kg  |
|               | 250 mm segmented | 9.84 in segmented  | 12.0 kg  |
|               | 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/mm<sup>2</sup>

HORN 1

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

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



### Rolleri Videos

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



# R2 ROLLERI TYPE R2

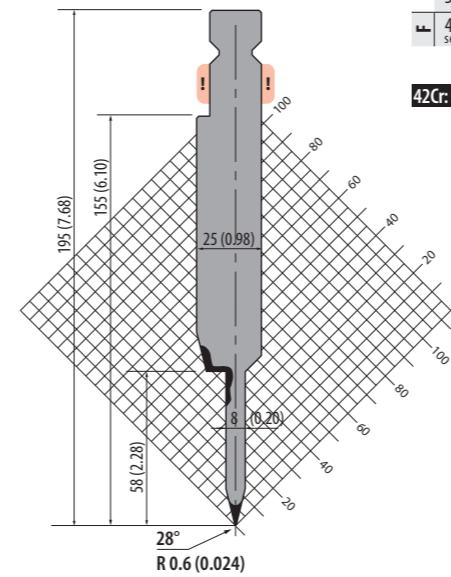
## 28°/24° Hemming Punches



TPR.SP.195.28.8

|                  |                    |        |
|------------------|--------------------|--------|
| 525 mm           | 20.67 in           | 9.4 kg |
| 495 mm segmented | 19.49 in segmented | 8.9 kg |

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

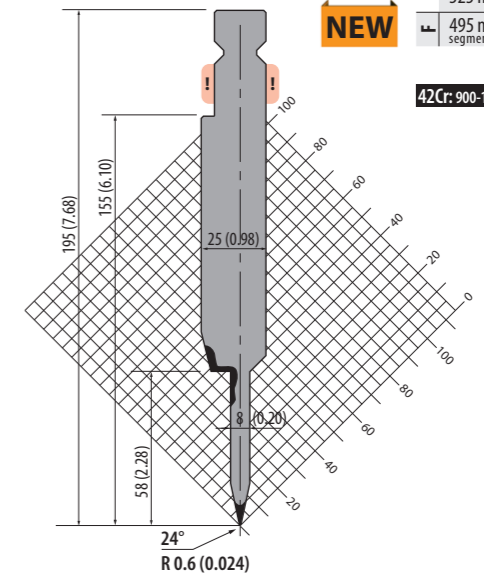


TPR.SP.195.24.8

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 525 mm           | 20.67 in           | 9.4 kg |
| 495 mm segmented | 19.49 in segmented | 8.9 kg |

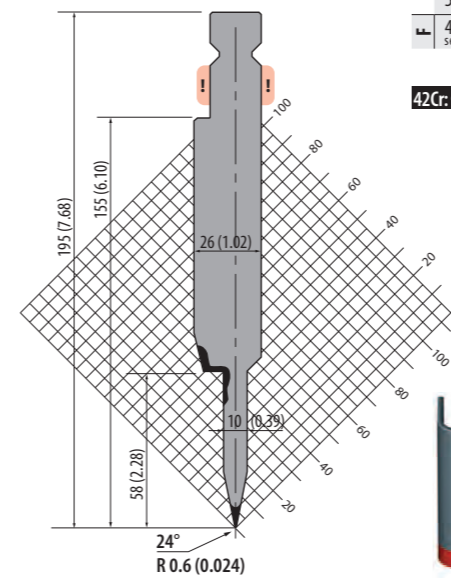
42Cr: 900-1150 N/mm<sup>2</sup>



TPR.SP.195.24.10

|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 15.5 kg |
| 495 mm segmented | 19.49 in segmented | 9.3 kg  |

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

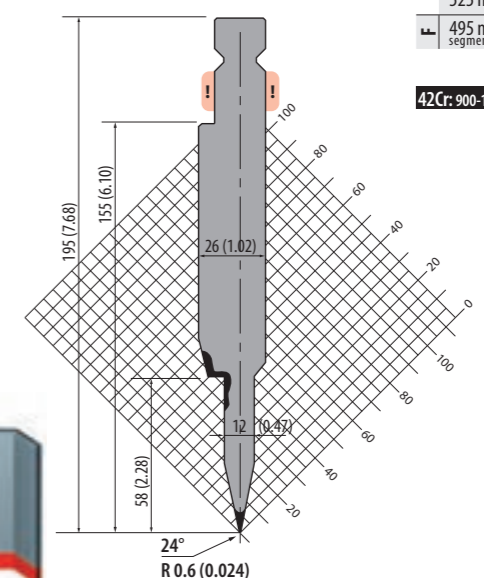


Only for thin material!  
Hemming Dies  
see page 118

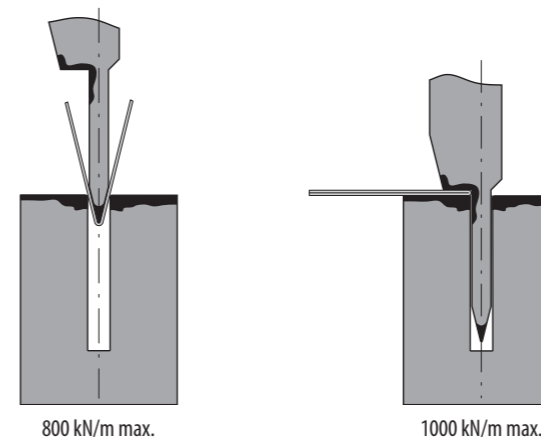
TPR.SP.195.24.12

|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 15.5 kg |
| 495 mm segmented | 19.49 in segmented | 9.5 kg  |

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

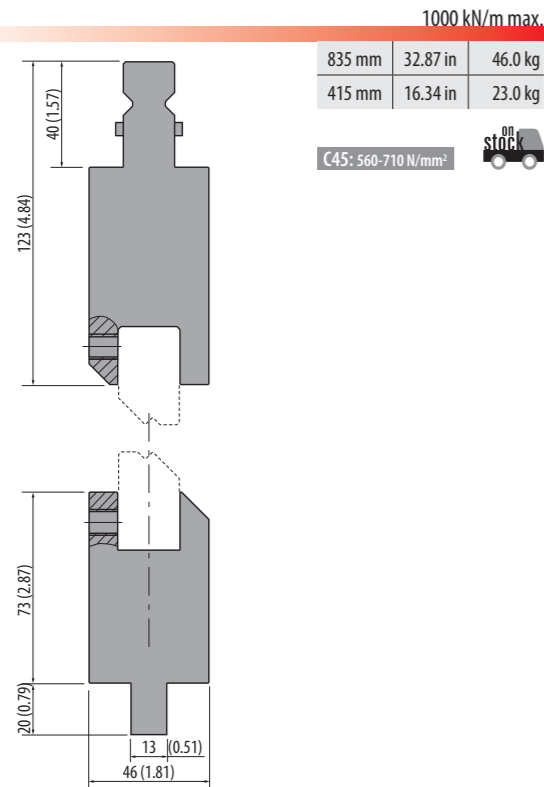


### Example of application



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

### TPZ

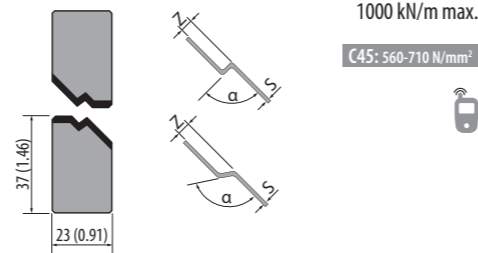


1000 kN/m max.

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

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

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



1000 kN/m max.

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

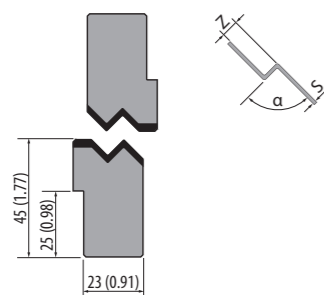
| Model      | Z mm | Z in | α    | S* mm | S* inch | Weight  | Weight |
|------------|------|------|------|-------|---------|---------|--------|
| CEZ 1.0    | 1.0  | 0.04 | 160° | 1.2   | 0.05    | 11.0 kg | 5.5 kg |
| CEZ 1.5    | 1.5  | 0.06 | 160° | 1.5   | 0.06    | 11.0 kg | 5.5 kg |
| CEZ 2.0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

835 mm / 32.87 in      415 mm / 16.34 in

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

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

### Z-Profile Tool Inserts 90°



1000 kN/m max.

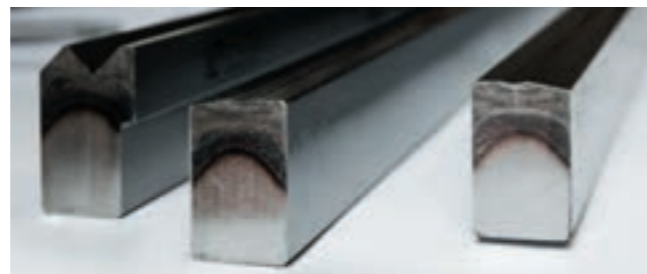
C45: 560-710 N/mm<sup>2</sup>

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

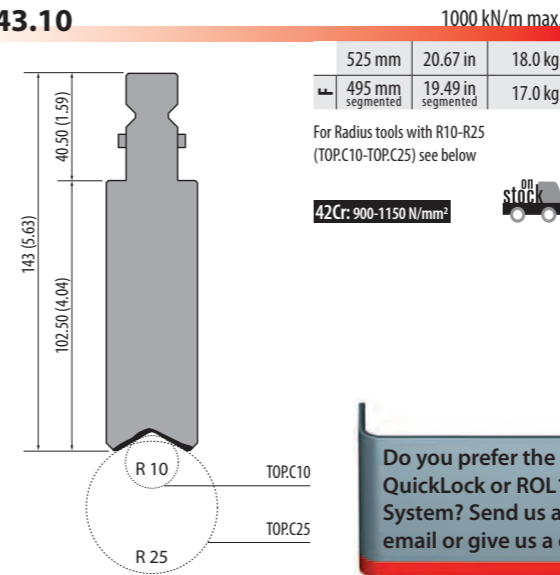
| Model    | Z mm | Z in | α   | S* mm | S* inch | Weight  | Weight |
|----------|------|------|-----|-------|---------|---------|--------|
| CEZ 9.0  | 9    | 0.35 | 90° | 1.8   | 0.07    | 13.5 kg | 6.5 kg |
| CEZ 10.0 | 10   | 0.39 | 90° | 1.8   | 0.07    | 13.5 kg | 6.5 kg |
| CEZ 11.0 | 11   | 0.43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

835 mm / 32.87 in      415 mm / 16.34 in

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



### TPR143.10



1000 kN/m max.

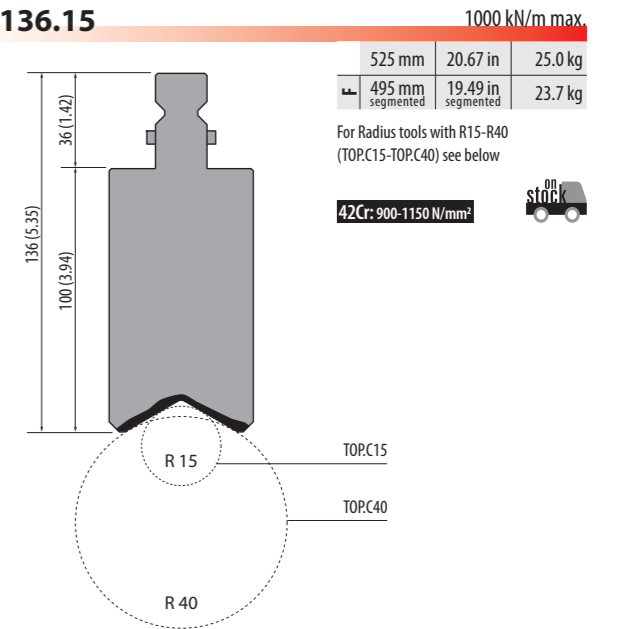
|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 18.0 kg |
| 495 mm segmented | 19.49 in segmented | 17.0 kg |

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

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

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

### TPR136.15



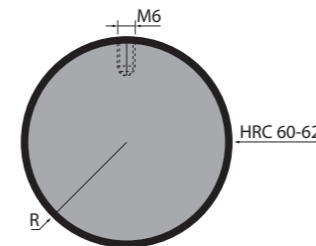
1000 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 25.0 kg |
| 495 mm segmented | 19.49 in segmented | 23.7 kg |

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

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

### Radius punches: R10-40



Material C53 induction hardened 60-62HRC

1000 kN/m max.

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

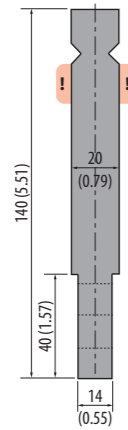
525 mm / 20.67 in      495 mm / 16.34 in segmented

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

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



### TPR140-14 800 kN/m max.

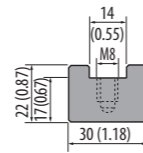


|        |          |         |
|--------|----------|---------|
| 830 mm | 32.68 in | 17.0 kg |
| 412 mm | 16.22 in | 9.0 kg  |

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

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

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

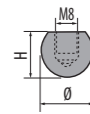


|        |          |        |
|--------|----------|--------|
| 835 mm | 32.87 in | 3.5 kg |
| 415 mm | 16.34 in | 1.7 kg |

Hemming tool

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

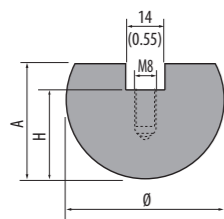
### Radius Tool: Ø 16-20 mm (0.63-0.79 in)



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

| Model  | Ø mm | Ø in | H mm | H in | Weight  | Weight  |
|--------|------|------|------|------|---------|---------|
| C13.08 | 16   | 0.63 | 13   | 0.51 | 2.00 kg | 1.00 kg |
| C13.09 | 18   | 0.71 | 16   | 0.63 | 2.00 kg | 1.00 kg |
| C16.10 | 20   | 0.79 | 16   | 0.63 | 2.00 kg | 1.00 kg |

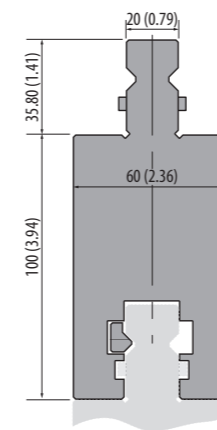
### Radius Tool: Ø 25-100 mm (0.98-3.94)



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

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

### AD21 1500 kN/m max.

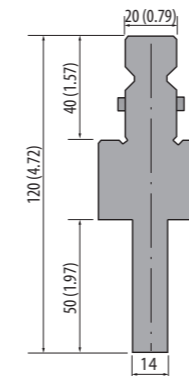


|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 7.0 kg |
|--------|---------|--------|

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

### Punch Adapters

### AD11 1000 kN/m max.

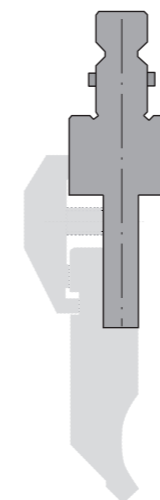


|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 3.0 kg |
|--------|---------|--------|

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



### Example of application



For more Adapters see pages 212-217



## DIES ROLLERI TYPE R2

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

### Compatibility

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

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

### Compatibility

Dies Roller Type R2 are:

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

### Our Advantages – Your Convenience

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

### Material

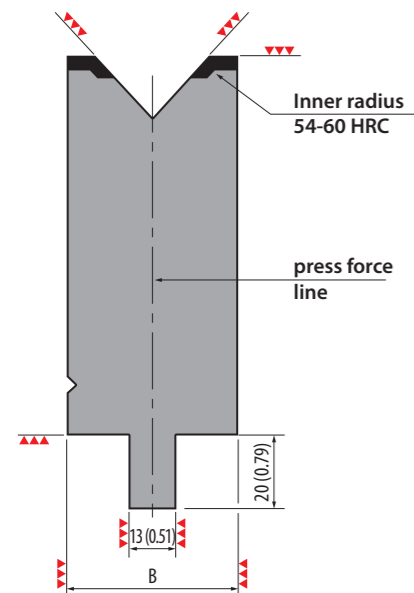
The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

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

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

### Tang

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



Indications of precision ground surfaces:

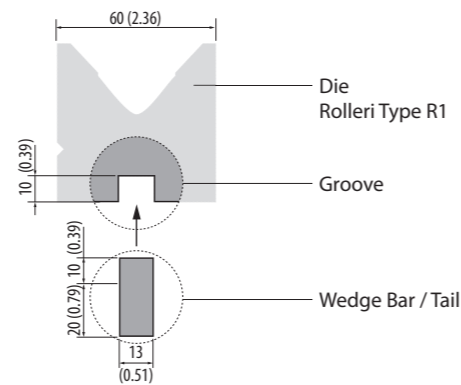


### Modification: Wedge Bar / Tail

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

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

### A30 (Mounting example)



### Tool lengths and sectioning

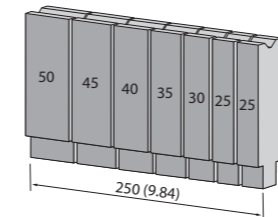
Standard

More lengths and sectionings are possible upon request.

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

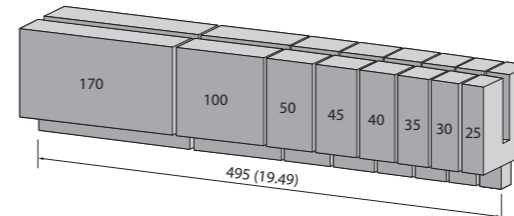
| Length in mm (in) | Sectioning FA |           |           |           |           |           |            |
|-------------------|---------------|-----------|-----------|-----------|-----------|-----------|------------|
|                   | 25 (0.98)     | 30 (1.18) | 35 (1.38) | 40 (1.57) | 45 (1.77) | 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         |

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

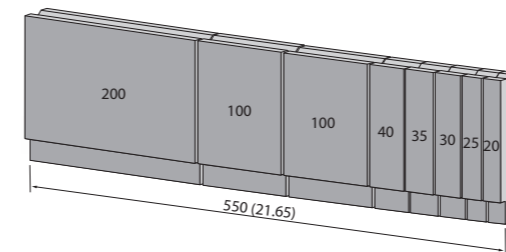


250 mm (9.84 in) segmented / FC (7 segments)

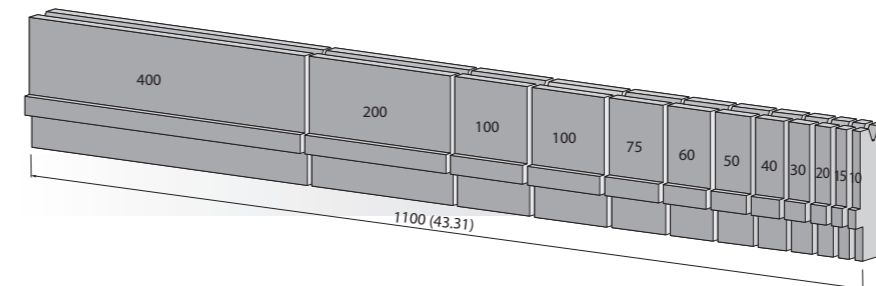
Segmented tools are delivered in complete sets. Single pieces are also available!



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



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



1100 mm (43.31 in) segmented (12 segments)













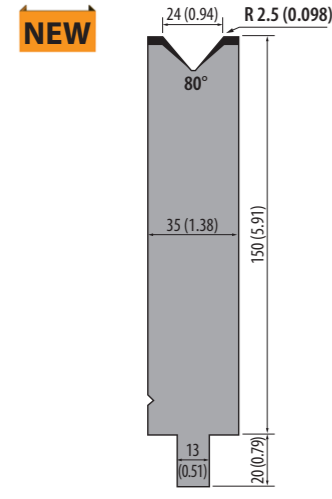


# R2 ROLLERI TYPE R2

Dies 80°, H=150 (5.91)

### TMR150.24.80

700 kN/m max.



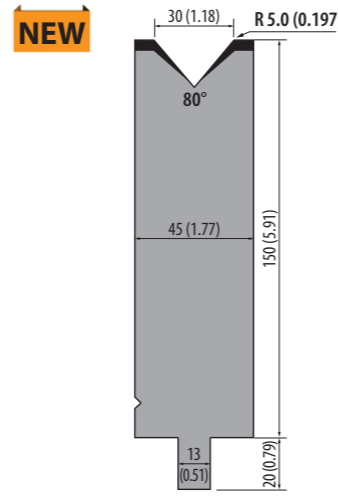
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 20.8 kg  |
| 250 mm segmented | 9.84 in segmented  | 10.4 kg  |
| 550 mm segmented | 21.65 in segmented | 22.9 kg  |
| 1250 mm          | 49.21 in           | 52.0 kg  |
| 2050 mm          | 80.71 in           | 85.3 kg  |
| 2550 mm          | 100.39 in          | 106.0 kg |
| 3050 mm          | 120.08 in          | 129.9 kg |
| 4050 mm          | 159.45 in          | 168.5 kg |

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

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

### TMR150.30.80

900 kN/m max.



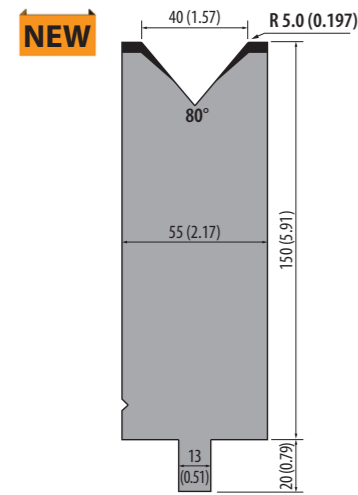
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 26.0 kg  |
| 250 mm segmented | 9.84 in segmented  | 13.0 kg  |
| 550 mm segmented | 21.65 in segmented | 28.6 kg  |
| 1250 mm          | 49.21 in      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

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

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

### TMR150.40.80

1200 kN/m max.



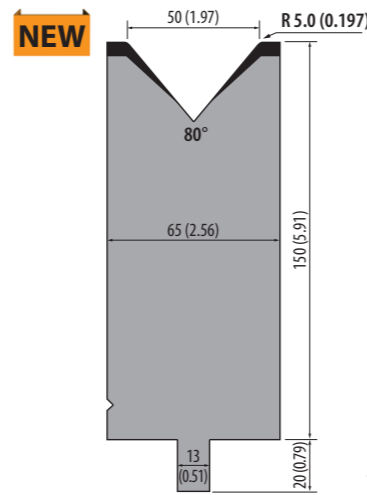
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 31.0 kg  |
| 250 mm segmented | 9.84 in segmented  | 15.5 kg  |
| 550 mm segmented | 21.65 in segmented | 34.1 kg  |
| 1250 mm          | 49.21 in      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

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

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

### TMR150.50.80

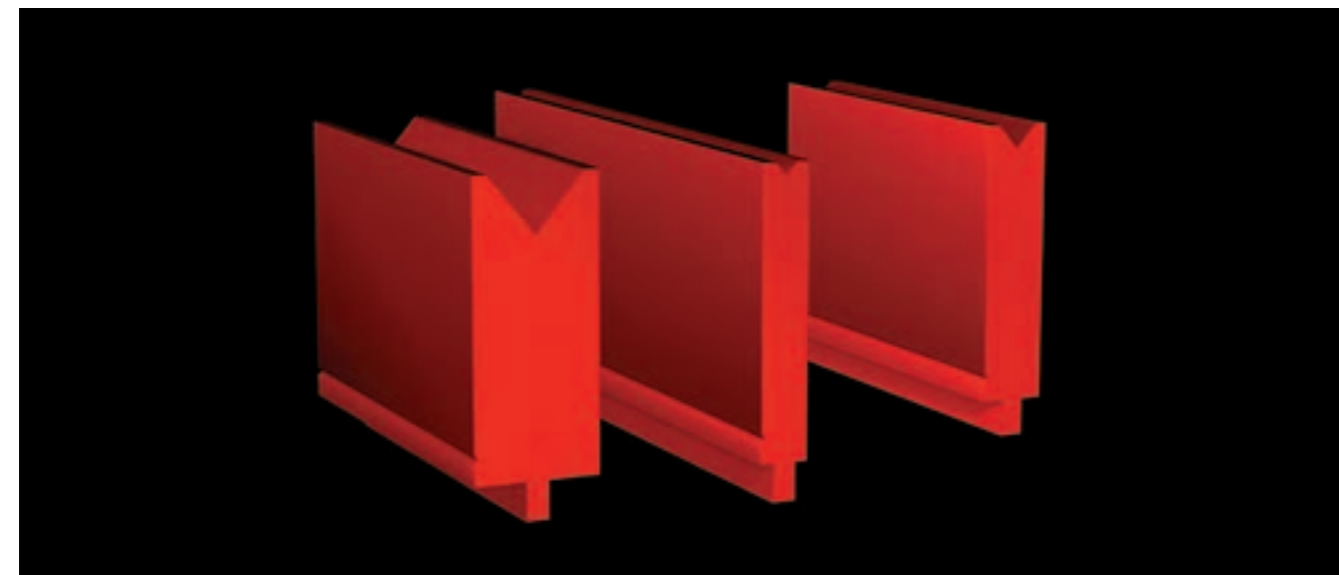
1500 kN/m max.



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

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

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



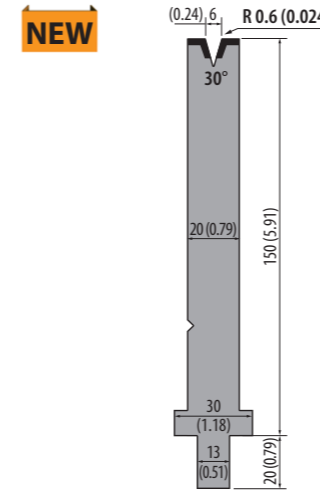
# R2 ROLLERI TYPE R2

Dies 30°, H=150 (5.91)



### TMR150.06.30

400 kN/m max.



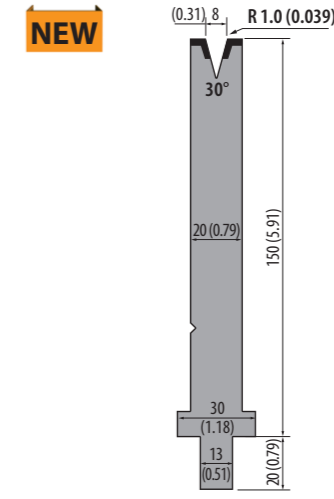
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 12.8 kg  |
| 250 mm segmented | 9.84 in segmented  | 6.4 kg   |
| 550 mm segmented | 21.65 in segmented | 14.0 kg  |
| 1250 mm          | 49.21 in      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

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

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

### TMR150.08.30

400 kN/m max.



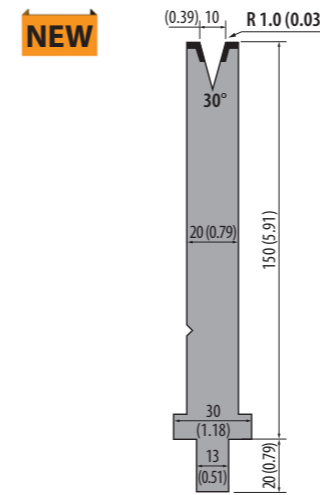
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 12.7 kg  |
| 250 mm segmented | 9.84 in segmented  | 6.4 kg   |
| 550 mm segmented | 21.65 in segmented | 13.9 kg  |
| 1250 mm          | 49.21 in      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

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

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

### TMR150.10.30

400 kN/m max.



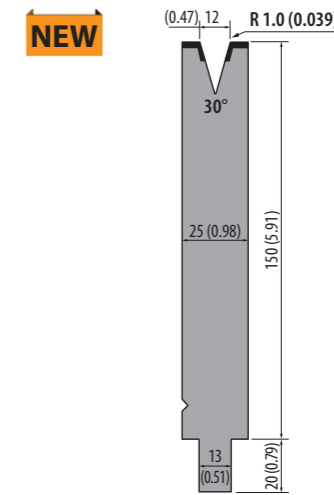
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 12.6 kg  |
| 250 mm segmented | 9.84 in segmented  | 6.3 kg   |
| 550 mm segmented | 21.65 in segmented | 13.9 kg  |
| 1250 mm          | 49.21 in      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

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

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

### TMR150.12.30

400 kN/m max.



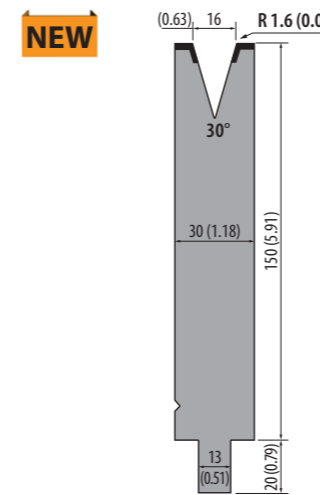
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 15.2 kg  |
| 250 mm segmented | 9.84 in segmented  | 7.6 kg   |
| 550 mm segmented | 21.65 in segmented | 16.7 kg  |
| 1250 mm          | 49.21 in      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

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

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

### TMR150.16.30

500 kN/m max.



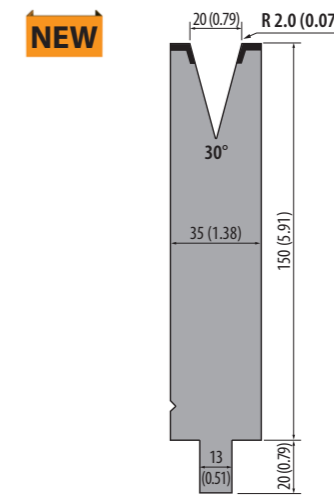
|                  |                    |          |
|------------------|--------------------|----------|
| 500 mm           | 19.68 in           | 17.7 kg  |
| 250 mm segmented | 9.84 in segmented  | 8.9 kg   |
| 550 mm segmented | 21.65 in segmented | 19.5 kg  |
| 1250 mm          | 49.21 in      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

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

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

### TMR150.20.30

600 kN/m max.



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

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

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

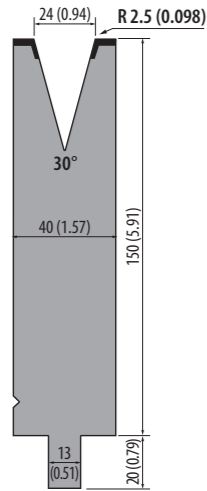
# R2 ROLLERI TYPE R2

Dies 30°, H=150 (5.91)

## TMR150.24.30

650 kN/m max.

**NEW**



| FW / FC              | mm     | in   | kg    |
|----------------------|--------|------|-------|
| 250 mm segmented     | 9.84   | 0.39 | 12.3  |
| 550 mm segmented     | 21.65  | 0.85 | 27.0  |
| <b>Sectioning FA</b> |        |      |       |
| 1250 mm              | 49.21  | 1.94 | 61.5  |
| 2050 mm              | 80.71  | 3.18 | 100.9 |
| 2550 mm              | 100.39 | 3.95 | 125.5 |
| 3050 mm              | 120.08 | 4.73 | 150.1 |
| 4050 mm              | 159.45 | 6.27 | 199.3 |
| <b>Sectioning FB</b> |        |      |       |
| 1250 mm              | 49.21  | 1.94 | 61.5  |
| 2050 mm              | 80.71  | 3.18 | 100.9 |
| 2550 mm              | 100.39 | 3.95 | 125.5 |
| 3050 mm              | 120.08 | 4.73 | 150.1 |
| 4050 mm              | 159.45 | 6.27 | 199.3 |

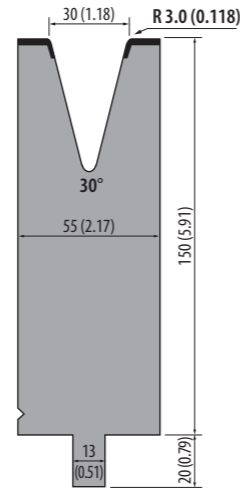
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR150.30.30

900 kN/m max.

**NEW**



| FW / FC              | mm     | in   | kg    |
|----------------------|--------|------|-------|
| 250 mm segmented     | 9.84   | 0.39 | 12.3  |
| 550 mm segmented     | 21.65  | 0.85 | 27.0  |
| <b>Sectioning FA</b> |        |      |       |
| 1250 mm              | 49.21  | 1.94 | 61.5  |
| 2050 mm              | 80.71  | 3.18 | 100.9 |
| 2550 mm              | 100.39 | 3.95 | 125.5 |
| 3050 mm              | 120.08 | 4.73 | 150.1 |
| 4050 mm              | 159.45 | 6.27 | 199.3 |
| <b>Sectioning FB</b> |        |      |       |
| 1250 mm              | 49.21  | 1.94 | 61.5  |
| 2050 mm              | 80.71  | 3.18 | 100.9 |
| 2550 mm              | 100.39 | 3.95 | 125.5 |
| 3050 mm              | 120.08 | 4.73 | 150.1 |
| 4050 mm              | 159.45 | 6.27 | 199.3 |

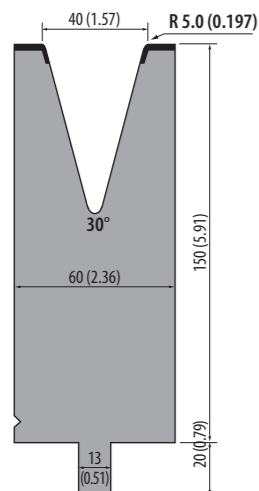
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

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

## TMR150.40.30

900 kN/m max.

**NEW**



| FW / FC              | mm     | in   | kg    |
|----------------------|--------|------|-------|
| 250 mm segmented     | 9.84   | 0.39 | 12.7  |
| 550 mm segmented     | 21.65  | 0.85 | 27.8  |
| <b>Sectioning FA</b> |        |      |       |
| 1250 mm              | 49.21  | 1.94 | 63.3  |
| 2050 mm              | 80.71  | 3.18 | 103.7 |
| 2550 mm              | 100.39 | 3.95 | 129.0 |
| 3050 mm              | 120.08 | 4.73 | 154.3 |
| 4050 mm              | 159.45 | 6.27 | 204.9 |
| <b>Sectioning FB</b> |        |      |       |
| 1250 mm              | 49.21  | 1.94 | 63.3  |
| 2050 mm              | 80.71  | 3.18 | 103.7 |
| 2550 mm              | 100.39 | 3.95 | 129.0 |
| 3050 mm              | 120.08 | 4.73 | 154.3 |
| 4050 mm              | 159.45 | 6.27 | 204.9 |

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

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

Please ask for delivery times.  
It is usually faster than you think!

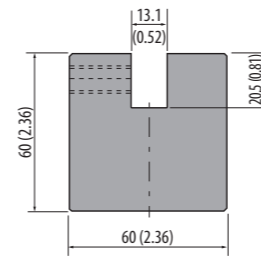
# R2 ROLLERI TYPE R2

Die adapters



## AD5

1000 kN/m max.



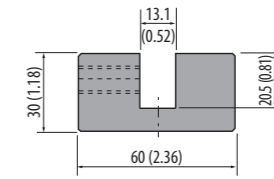
Rolleri Type R1  
→ Rolleri Type R2/R3

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



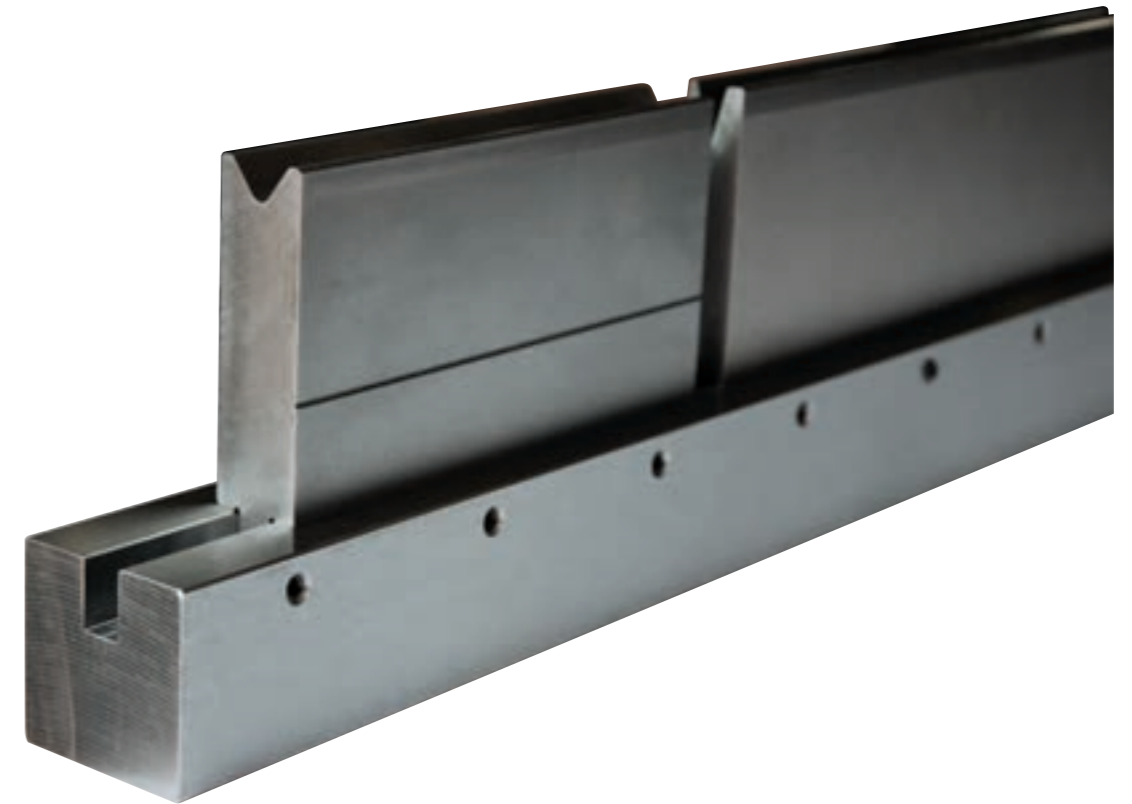
## AD6

1000 kN/m max.



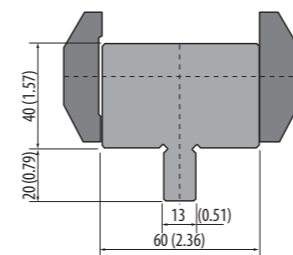
Rolleri Type R1  
→ Rolleri Type R2/R3

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



## AD7

1000 kN/m max.



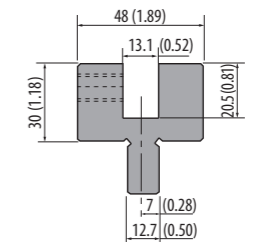
Rolleri Type R2/R3  
→ Rolleri Type R1

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



## AD8-12.7

1000 kN/m max.



Rolleri Type RX LVD  
→ Rolleri Type R2/R3

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



# R2 ROLLERI TYPE R2

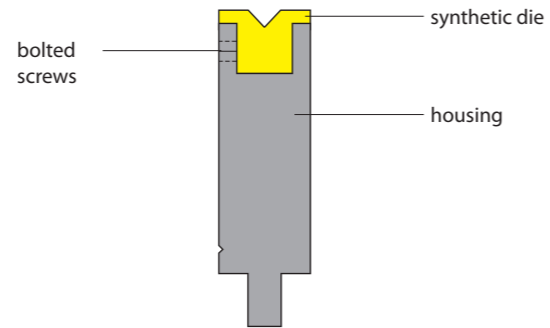
Synthetic dies, H=100 (3.94)

## Our Advantages – Your Convenience

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

## Mounting example

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

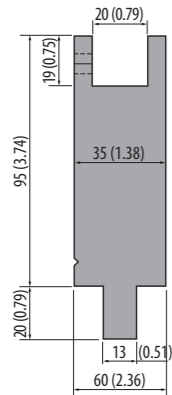


### TMN95.20

1000 kN/m max.

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

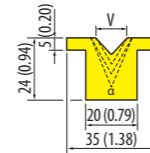
C45: 560-710 N/mm<sup>2</sup>



### INS20...

200 kN/m max.

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



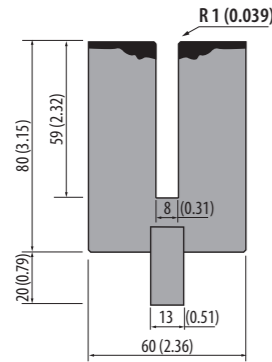
| Model       | $\alpha$ | V (mm) | V (in) |
|-------------|----------|--------|--------|
| INS20.06.88 | 88°      | 6      | 0.24   |
| INS20.08.88 | 88°      | 8      | 0.31   |
| INS20.10.88 | 88°      | 10     | 0.39   |
| INS20.12.88 | 88°      | 12     | 0.47   |
| INS20.16.88 | 88°      | 16 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

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

More mark-free bending available see pages 222-229



### TPR.SM.195.28.8 / TPR.SM.195.24.8

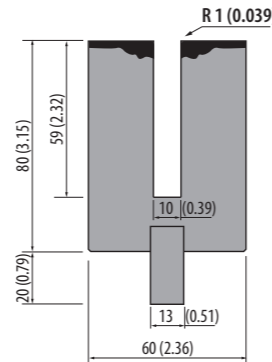


|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 12.0 kg |
| 495 mm segmented | 19.49 in segmented | 11.4 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



### TPR.SM.195.24.10

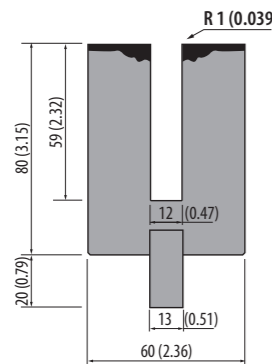


|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 11.8 kg |
| 495 mm segmented | 19.49 in segmented | 11.2 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



### TPR.SM.195.24.12



|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 11.5 kg |
| 495 mm segmented | 19.49 in segmented | 11.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

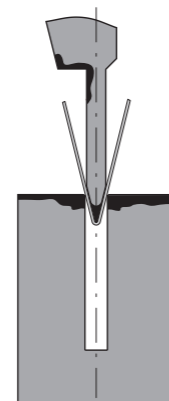


Only for thin material!  
Hemming punches  
see page 91

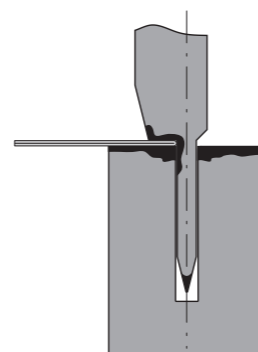
### Example of application



| S mm | S in | A mm | A in | R.45 Kg/mm <sup>2</sup><br>t/m | R.70 Kg/mm <sup>2</sup><br>t/m | S mm | S in | A mm | A in | R.45 Kg/mm <sup>2</sup><br>t/m | R.70 Kg/mm <sup>2</sup><br>t/m |
|------|------|------|------|--------------------------------|--------------------------------|------|------|------|------|--------------------------------|--------------------------------|
| 0.6  | 0.02 | 3.0  | 0.12 | 9                              | 15                             | 0.6  | 0.02 | 1.2  | 0.05 | 23                             | 35                             |
| 0.8  | 0.03 | 3.0  | 0.12 | 12                             | 20                             | 0.8  | 0.03 | 1.6  | 0.06 | 32                             | 50                             |
| 1.0  | 0.04 | 3.5  | 0.14 | 15                             | 25                             | 1.0  | 0.04 | 1.0  | 0.04 | 40                             | 60                             |
| 1.25 | 0.05 | 3.5  | 0.14 | 17                             | 26                             | 1.25 | 0.05 | 2.5  | 0.10 | 50                             | 80                             |



500 kN/m max.



1000 kN/m max.

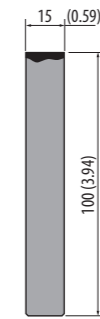
### Application

- movable table necessary
- used flexibly
- easy mounting

Hemming punches  
see page 91

### TMI100

1300 kN/m max.



|               |                  |                    |         |
|---------------|------------------|--------------------|---------|
| FW FC         | 500 mm           | 19.68 in           | 5.0 kg  |
|               | 250 mm segmented | 9.84 in segmented  | 2.5 kg  |
|               | 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 |
| Sectioning FB | 1250 mm          | 49.21 in           | 12.5 kg |
|               | 2050 mm          | 80.71 in           | 20.5 kg |
|               | 2550 mm          | 100.39 in          | 25.5 kg |
|               | 3050 mm          | 120.08 in          | 30.5 kg |
| 4050 mm       | 159.45 in        | 40.5 kg            |         |

Segments of Sectioning FB  
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)  
are also available separately (FD).  
Prices upon request!



C45: 560-710 N/mm<sup>2</sup>

### TML100

1200 kN/m max.



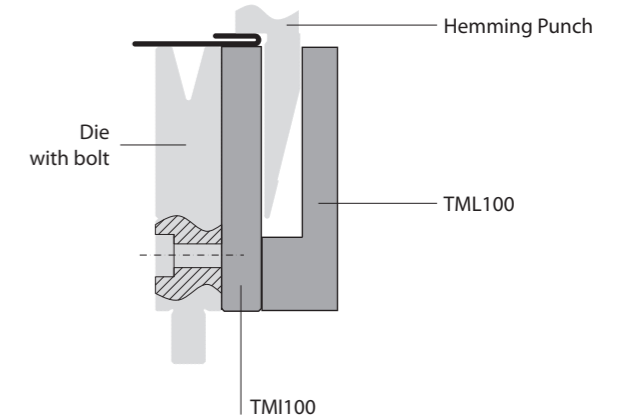
|               |                  |                    |         |
|---------------|------------------|--------------------|---------|
| FW FC         | 500 mm           | 19.68 in           | 5.0 kg  |
|               | 250 mm segmented | 9.84 in segmented  | 2.5 kg  |
|               | 550 mm segmented | 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 |
| Sectioning FB | 1250 mm          | 49.21 in           | 12.5 kg |
|               | 2050 mm          | 80.71 in           | 20.5 kg |
|               | 2550 mm          | 100.39 in          | 25.5 kg |
|               | 3050 mm          | 120.08 in          | 30.5 kg |
| 4050 mm       | 159.45 in        | 40.5 kg            |         |

Segments of Sectioning FB  
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)  
are also available separately (FD).  
Prices upon request!



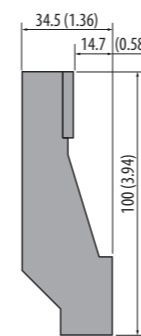
C45: 560-710 N/mm<sup>2</sup>

### Example of application TMI100 + TML100



### TMS100

1300 kN/m max.



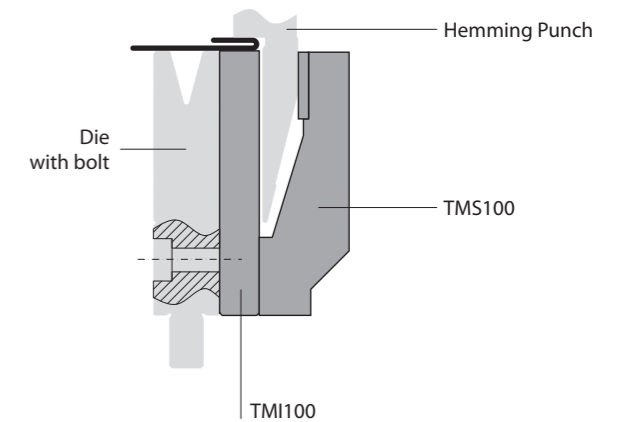
|               |                  |                    |         |
|---------------|------------------|--------------------|---------|
| FW FC         | 500 mm           | 19.68 in           | 5.0 kg  |
|               | 250 mm segmented | 9.84 in segmented  | 2.5 kg  |
|               | 550 mm segmented | 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 |
| Sectioning FB | 1250 mm          | 49.21 in           | 12.5 kg |
|               | 2050 mm          | 80.71 in           | 20.5 kg |
|               | 2550 mm          | 100.39 in          | 25.5 kg |
|               | 3050 mm          | 120.08 in          | 30.5 kg |
| 4050 mm       | 159.45 in        | 40.5 kg            |         |

Segments of Sectioning FB  
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)  
are also available separately (FD).  
Prices upon request!



C45: 560-710 N/mm<sup>2</sup>

### Example of application TMI100 + TMS100



## PUNCHES ROLLERI TYPE R3

|                                       |           |
|---------------------------------------|-----------|
| Content Explanation                   | 122 - 123 |
| Punches Bystronic-Beyeler RFA         | 124 - 125 |
| Punches Bystronic-Beyeler RF          | 125       |
| Hemming Punches Bystronic-Beyeler RFA | 126       |
| Punches Bystronic-Beyeler R           | 127       |
| Punches Bystronic-Beyeler S           | 128       |
| Punch adapters                        | 129       |
| Z-Profile Tools                       | 130 - 131 |
| Radius Tools                          | 132 - 133 |

### Compatibility

Punches Roller Type R3 are compatible with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

With Adapter-Systems the punches Roller Type R3 are also applicable on all other press brake machines.

### Compatibility

Punches Rolleri Type R3 are:

- compatible with press brake machines from:
  - Bystronic-Beyeler RFA
  - Bystronic-Beyeler RF
  - Bystronic-Beyeler R
  - Bystronic-Beyeler S

### Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

| Material Type | Mechanical resistance of the material and the tool body | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------------|---|--|--|
| 42CrMo4       | 900-1150 N/mm <sup>2</sup>                              | 29.1 - 36.9 HRC                            | 54 - 60 HRC  |
| C45           | 560-710 N/mm <sup>2</sup>                               | 12 - 15.5 HRC                              | 54 - 60 HRC  |

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

### Tang

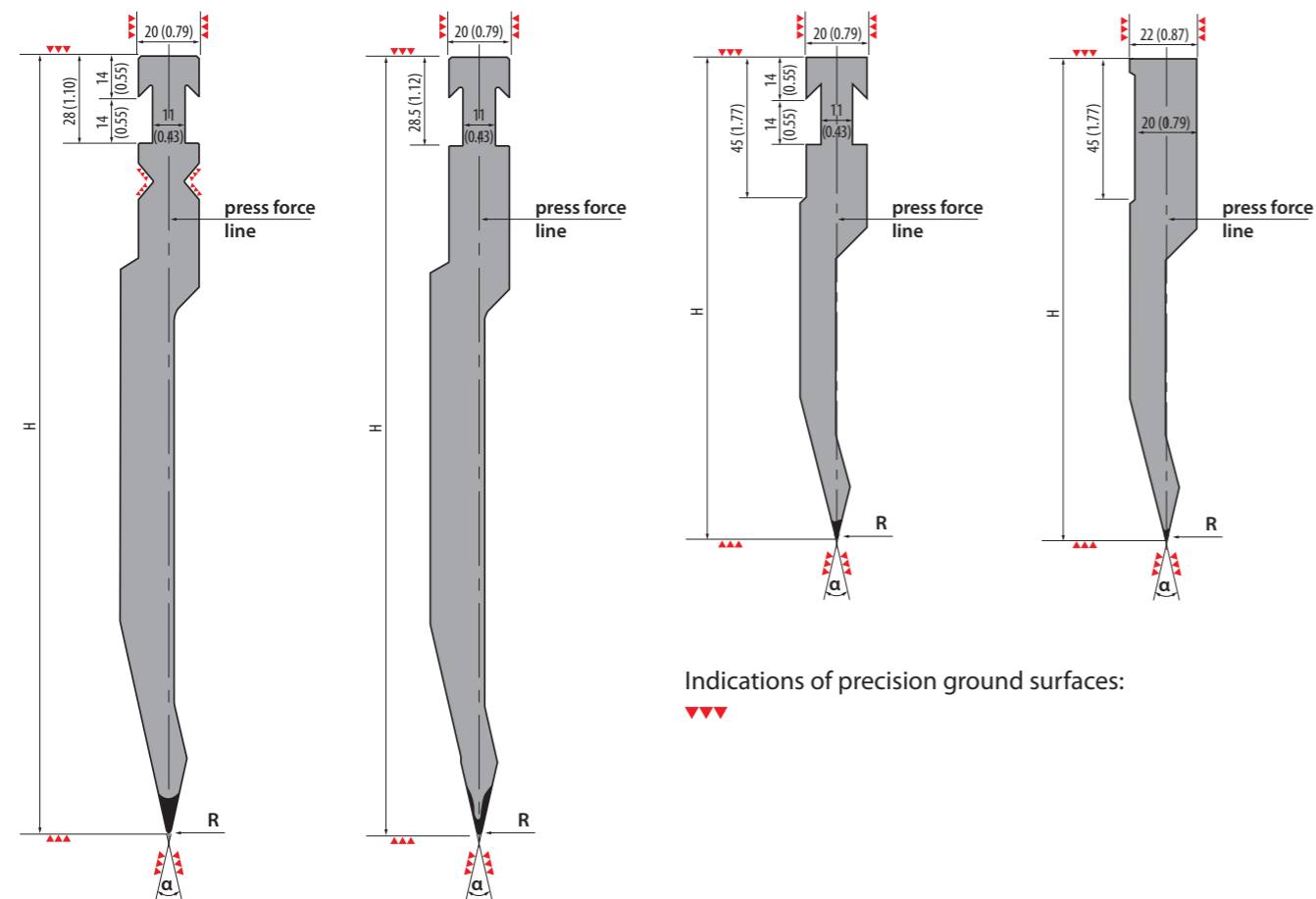
Punches Rolleri Type R3 have the following tangs:

Bystronic-Beyeler RFA

Bystronic-Beyeler RF

Bystronic-Beyeler R

Bystronic-Beyeler S



### Our Advantages – Your Convenience

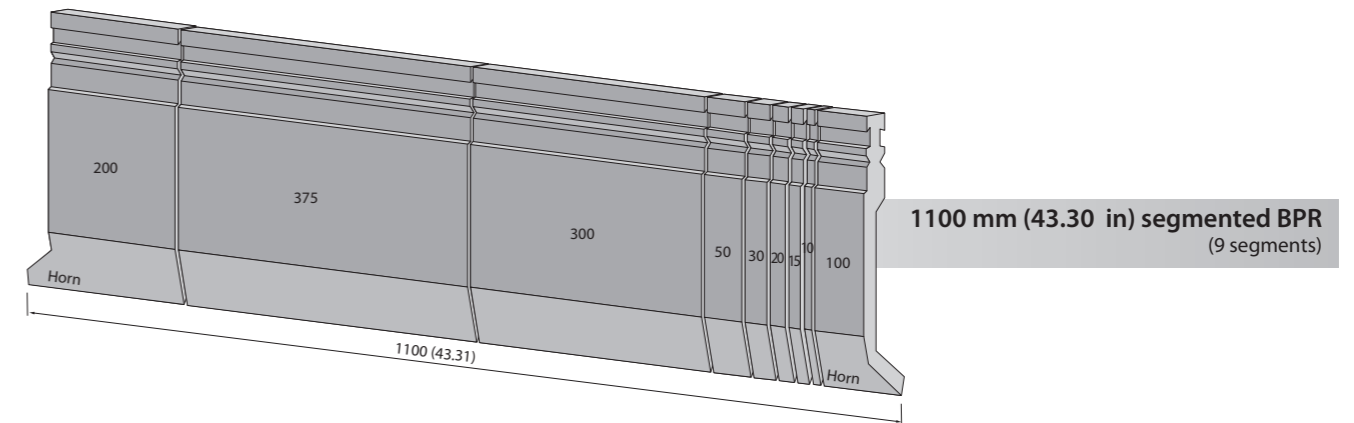
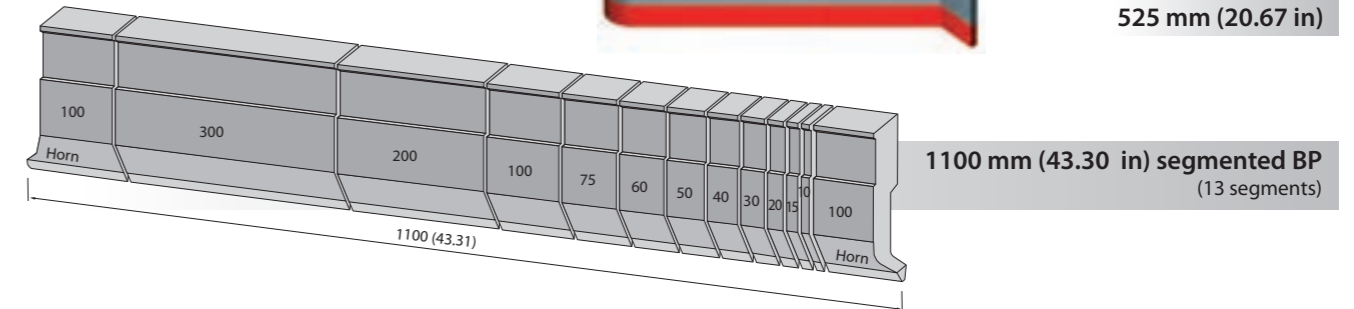
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 248-249)
- very large stock availability

### Tool lengths and sectioning

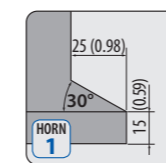
Standard

Segmented tools are delivered in complete sets. Single pieces are also available!  
More lengths and sectionings are possible upon request.

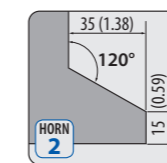
- 1000 mm (39.36 in)
- 500 mm (19.68 in)
- 508 mm (20.00 in)
- 525 mm (20.67 in)



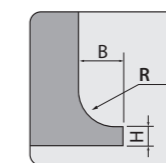
### Horn Types



**Horn 1**  
Standard BP  
for all segm.  
Punches BP  
Rolleri Type R3



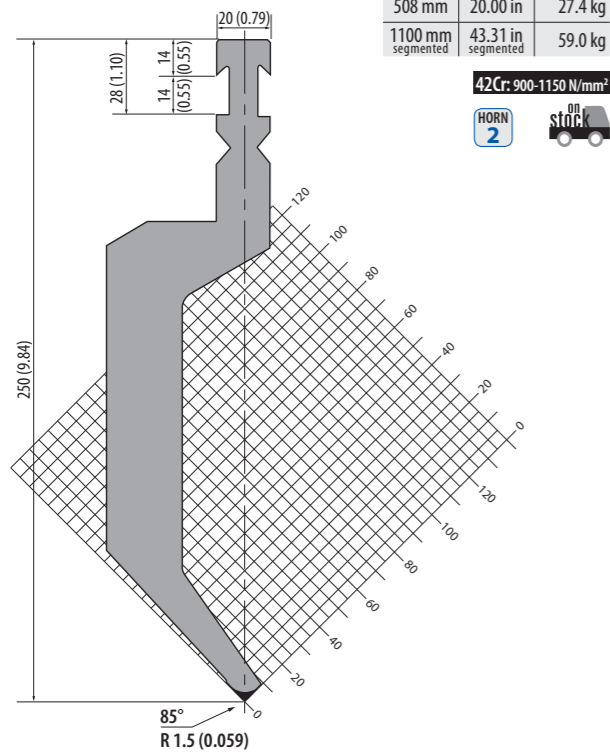
**Horn 2**  
Standard BPR  
for all segm.  
Punches BPR  
Rolleri Type R3



**Individual Horn**  
production  
according  
to your  
specifications

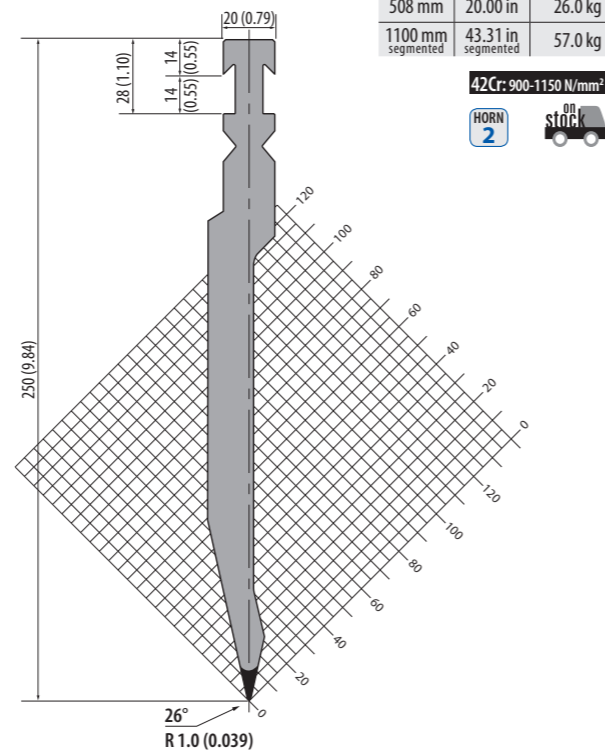
**BPR250.P4-RFA**

900 kN/m max.



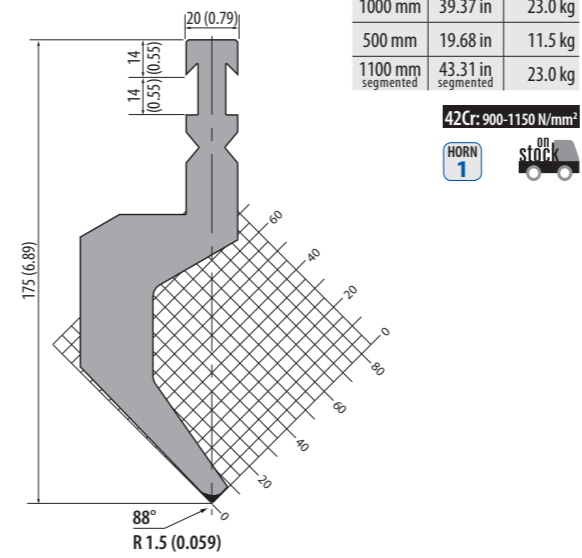
**BPR250.P5-RFA**

1000 kN/m max.



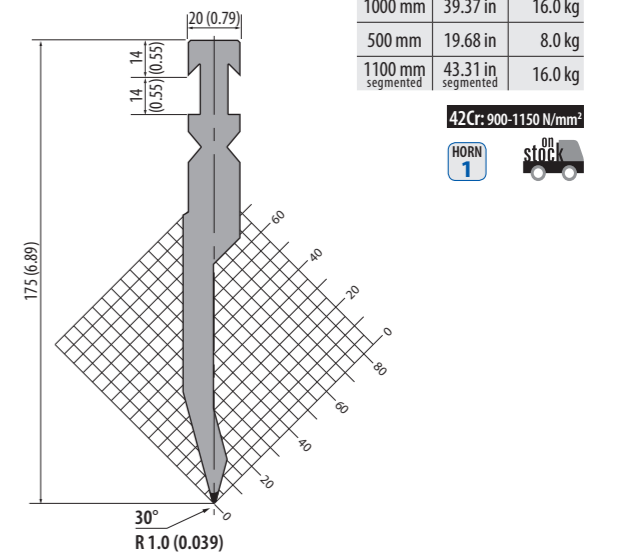
**BP175.88.R15-RFA**

500 kN/m max.



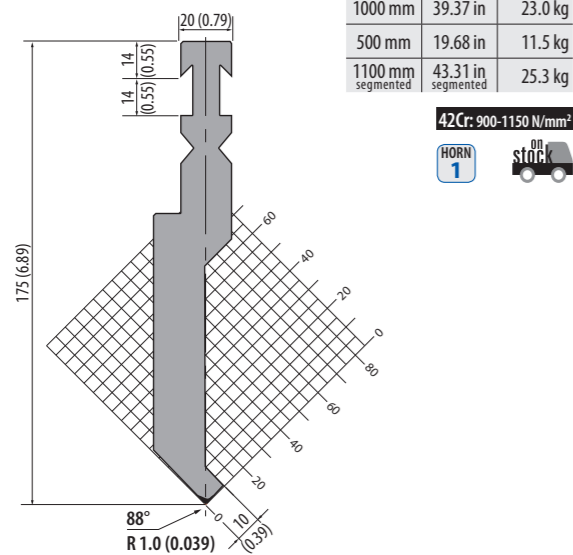
**BP175.30.R1-RFA**

800 kN/m max.



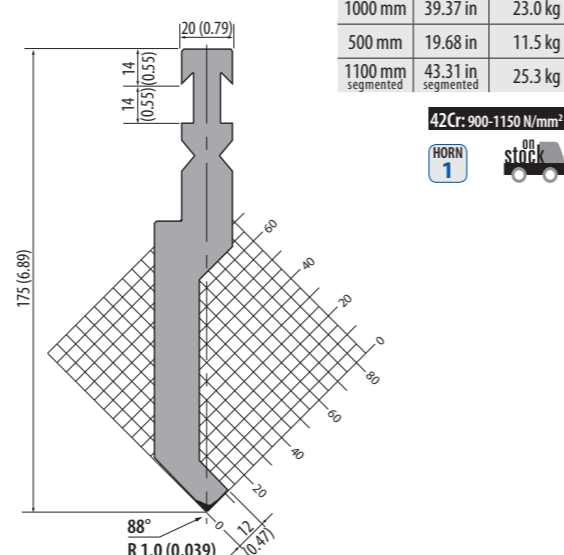
**BP175.88.R1-A-RFA**

1000 kN/m max.



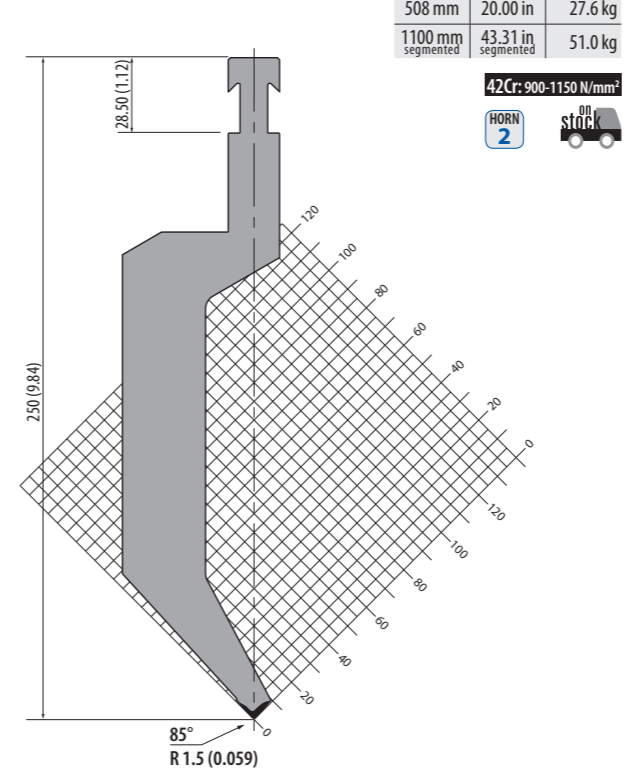
**BP175.88.R1-B-RFA**

1000 kN/m max.



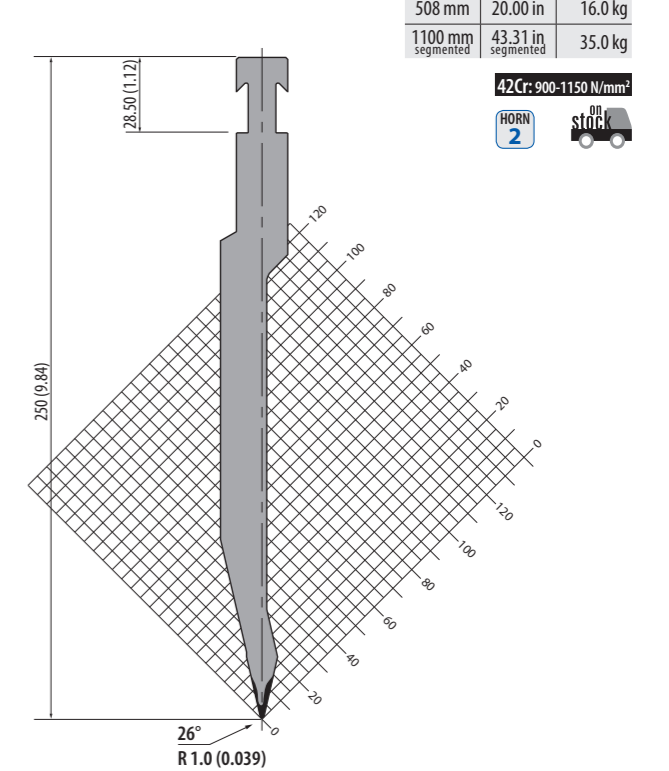
**BPR250.P4-RF**

1000 kN/m max.



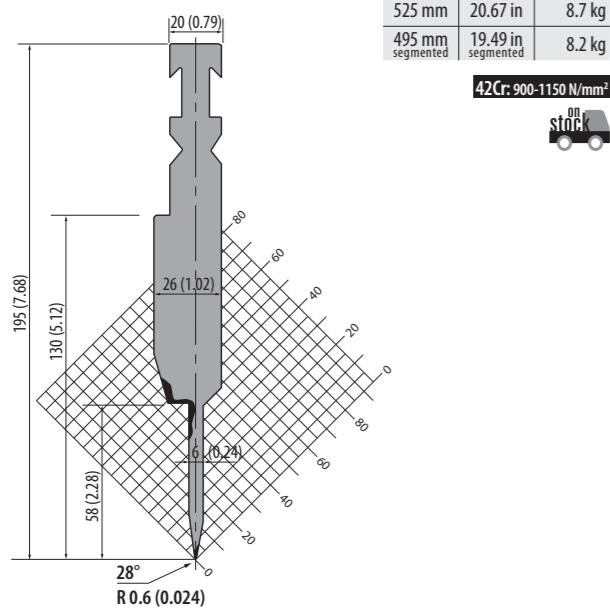
**BPR250.P5-RF**

900 kN/m max.

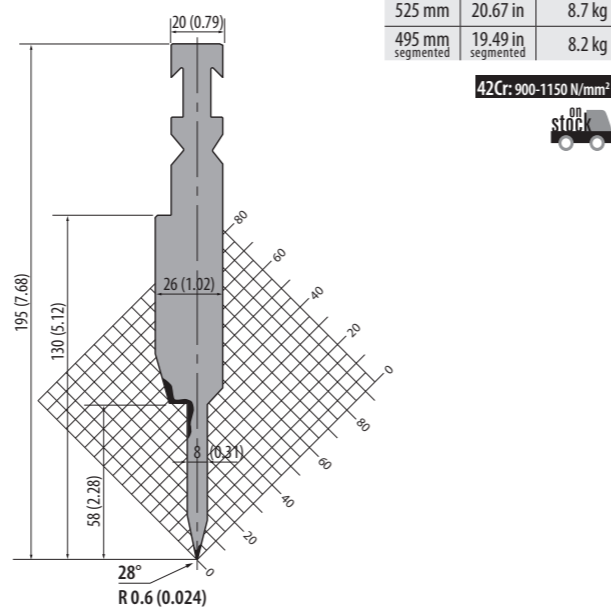


Punches Bystronic-Beyeler RF

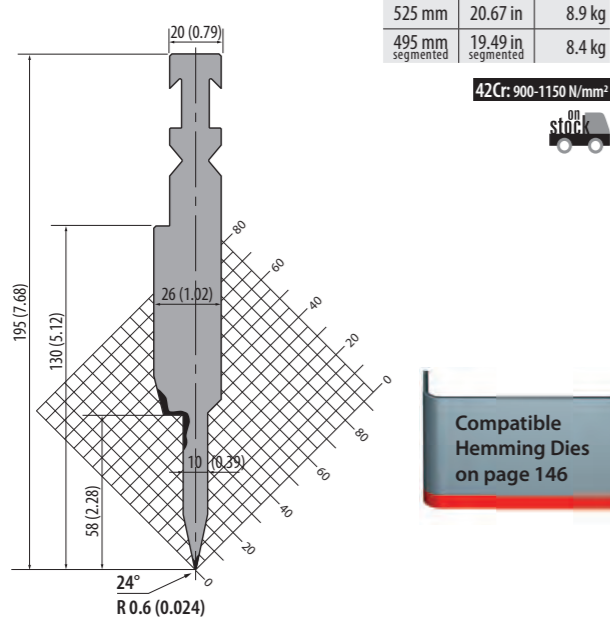
**BPR.SP-195.28.6** 500 kN/m max.



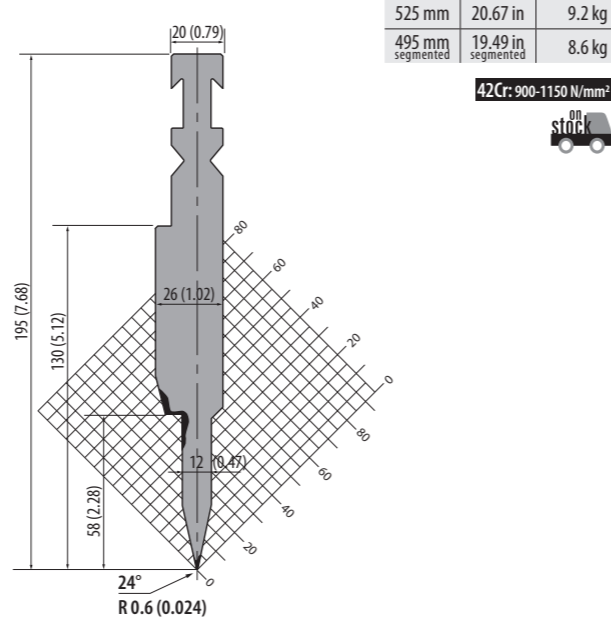
**BPR.SP-195.28.8** 500 kN/m max.



**BPR.SP-195.24.10** 500 kN/m max.

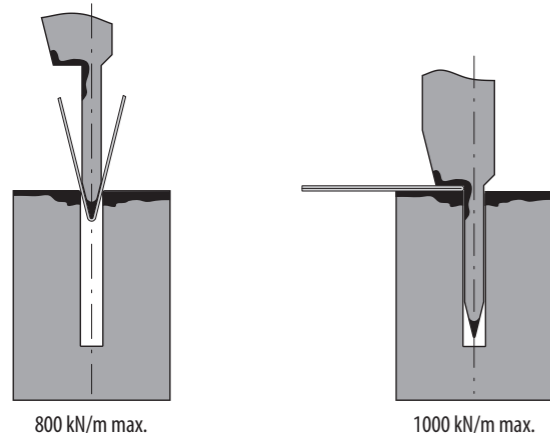


**BPR.SP-195.24.12** 500 kN/m max.



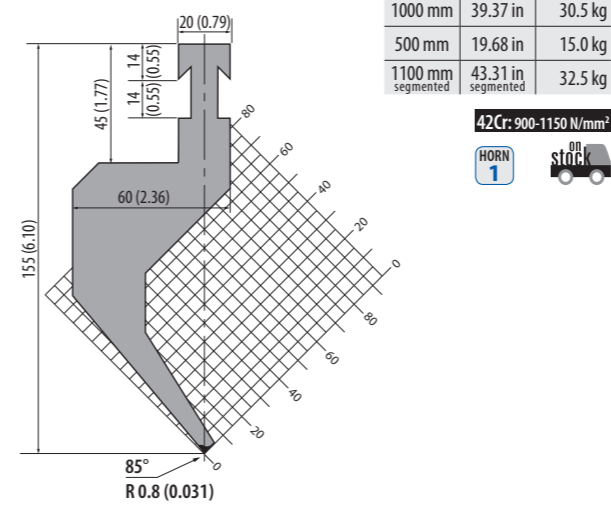
Compatible Hemming Dies on page 146

**Example of Application**

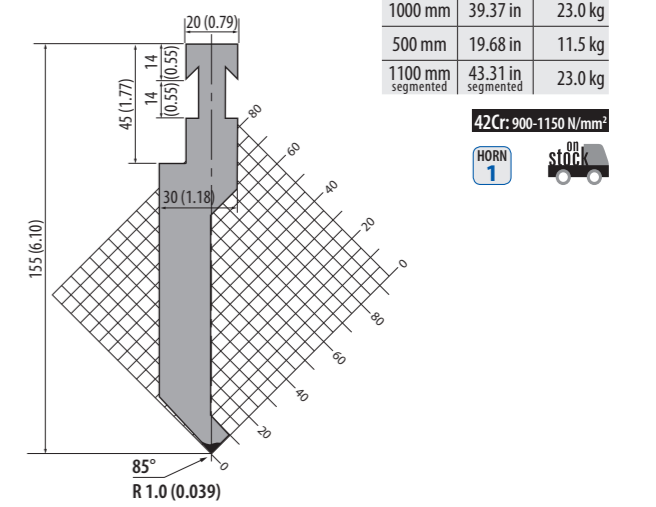


| S    | S    | A   | A    | R.45                | R.70                | S    | S    | A   | A    | R.45                | R.70                |
|------|------|-----|------|---------------------|---------------------|------|------|-----|------|---------------------|---------------------|
| mm   | in   | mm  | in   | Kgf/mm <sup>2</sup> | Kgf/mm <sup>2</sup> | mm   | in   | mm  | in   | Kgf/mm <sup>2</sup> | Kgf/mm <sup>2</sup> |
| 0.6  | 0.02 | 3.0 | 0.12 | 9                   | 15                  | 0.6  | 0.02 | 1.2 | 0.05 | 23                  | 35                  |
| 0.8  | 0.03 | 3.0 | 0.12 | 12                  | 20                  | 0.8  | 0.03 | 1.6 | 0.06 | 32                  | 50                  |
| 1.0  | 0.04 | 3.5 | 0.14 | 15                  | 25                  | 1.0  | 0.04 | 1.0 | 0.04 | 40                  | 60                  |
| 1.25 | 0.05 | 3.5 | 0.14 | 17                  | 26                  | 1.25 | 0.05 | 2.5 | 0.10 | 50                  | 80                  |

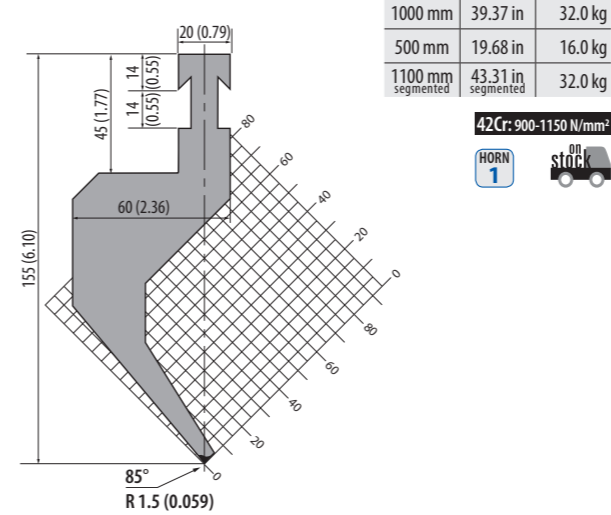
**BP155.85.R08-R** 500 kN/m max.



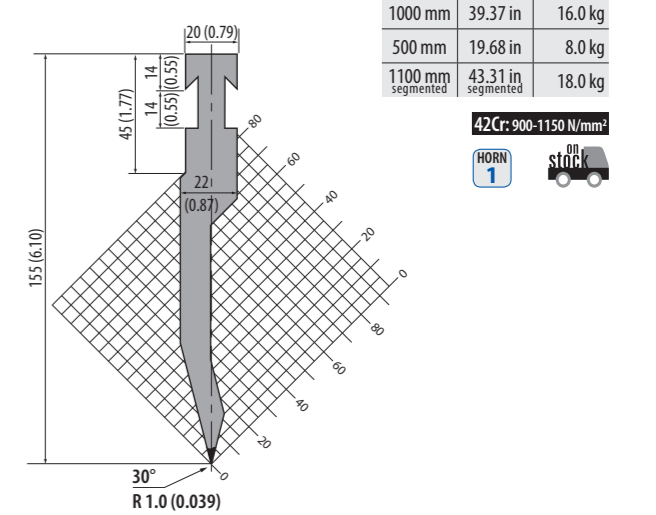
**BP155.85.R1-R** 1000 kN/m max.



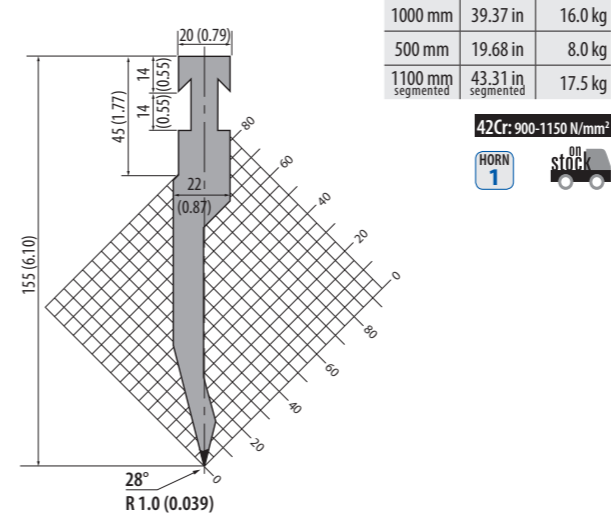
**BP155.85.R15-R** 500 kN/m max.



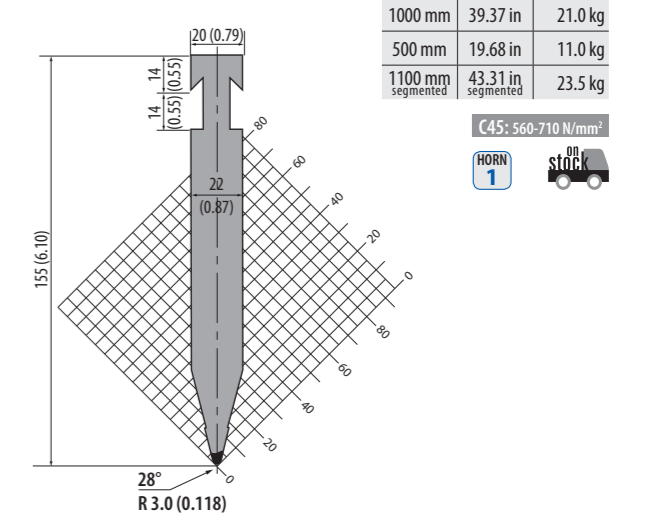
**BP155.30.R1-R** 800 kN/m max.



**BP155.28.R1-R** 800 kN/m max.

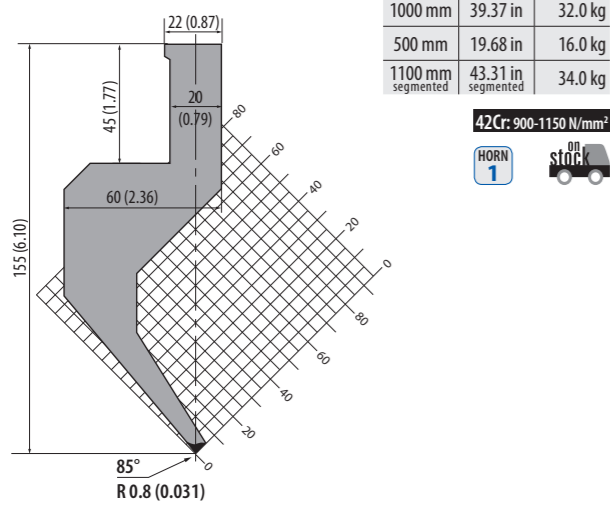


**BP155.28.R3-R** 1000 kN/m max.

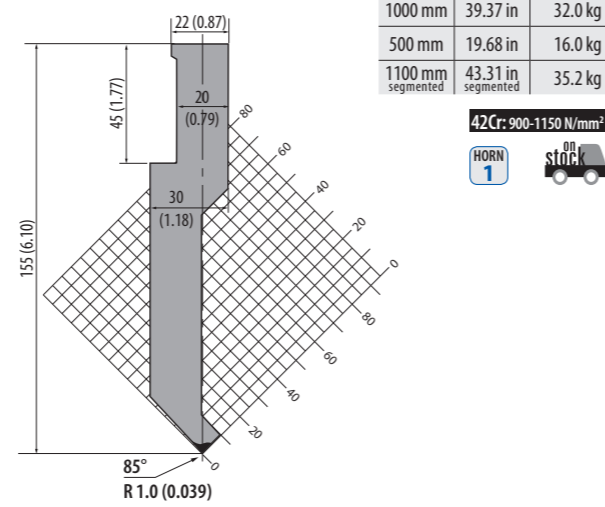




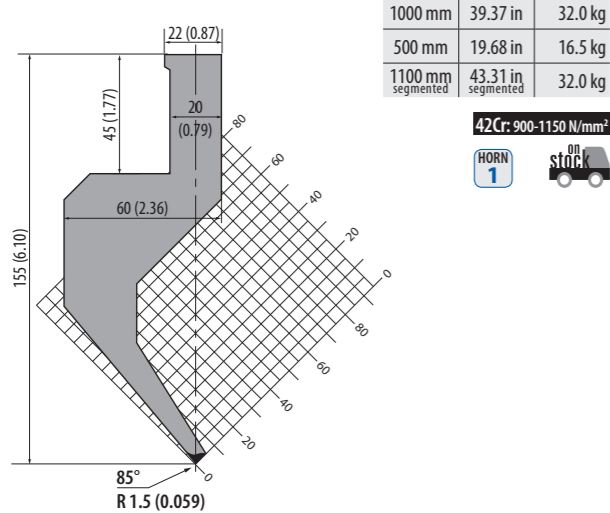
**BP155.85.R08-S** 500 kN/m max.



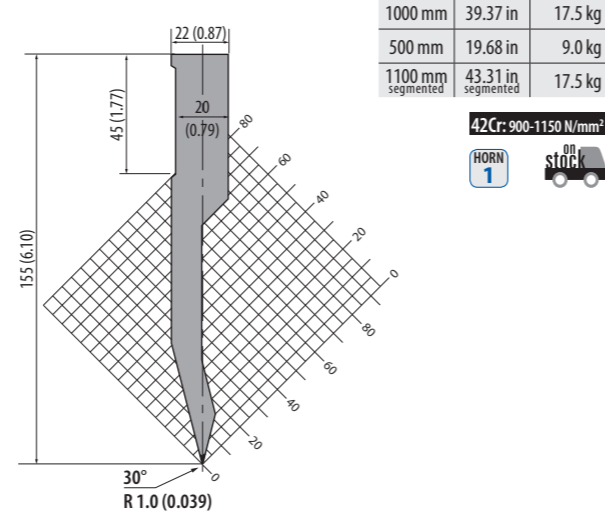
**BP155.85.R1-S** 1000 kN/m max.



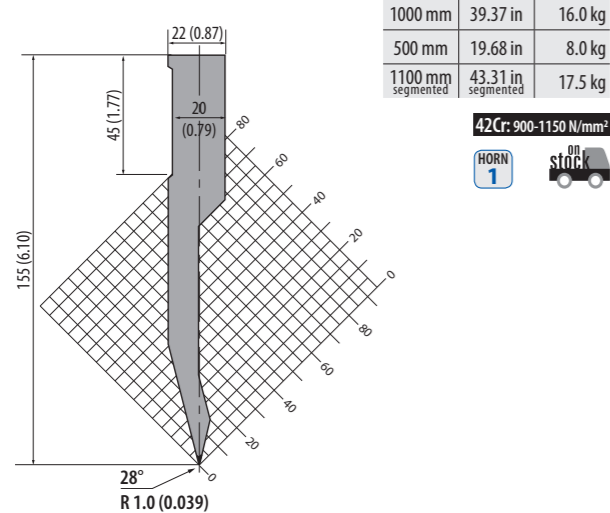
**BP155.85.R15-S** 500 kN/m max.



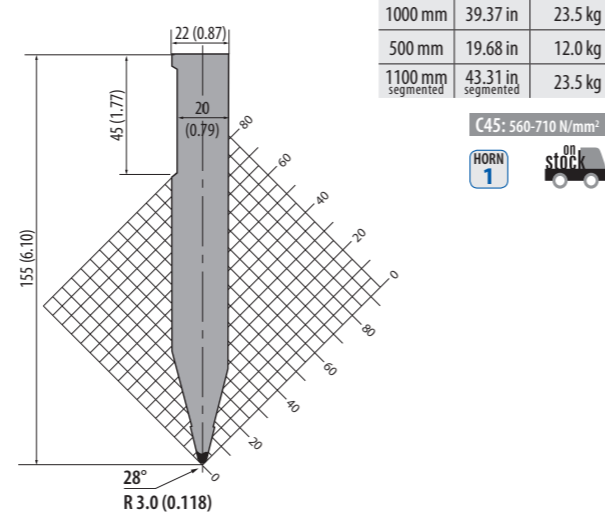
**BP155.30.R1-S** 800 kN/m max.



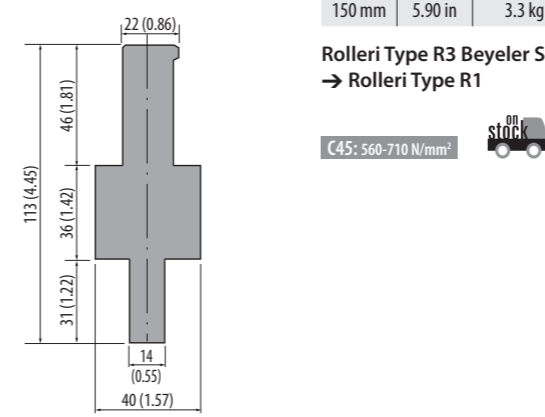
**BP155.28.R1-S** 800 kN/m max.



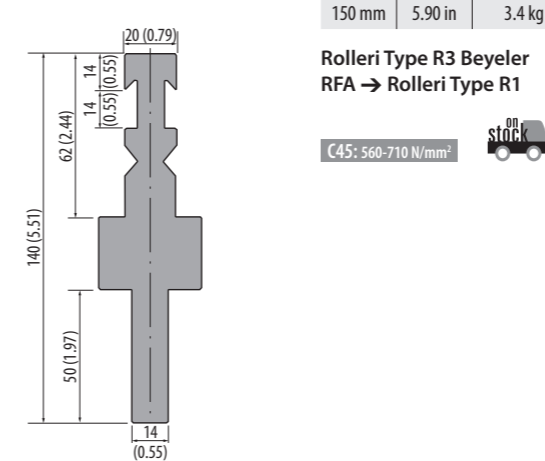
**BP155.28.R3-S** 1000 kN/m max.



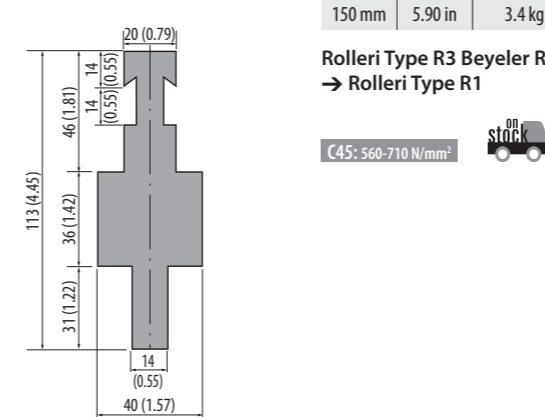
**AD3** 1000 kN/m max.



**AD10** 1000 kN/m max.



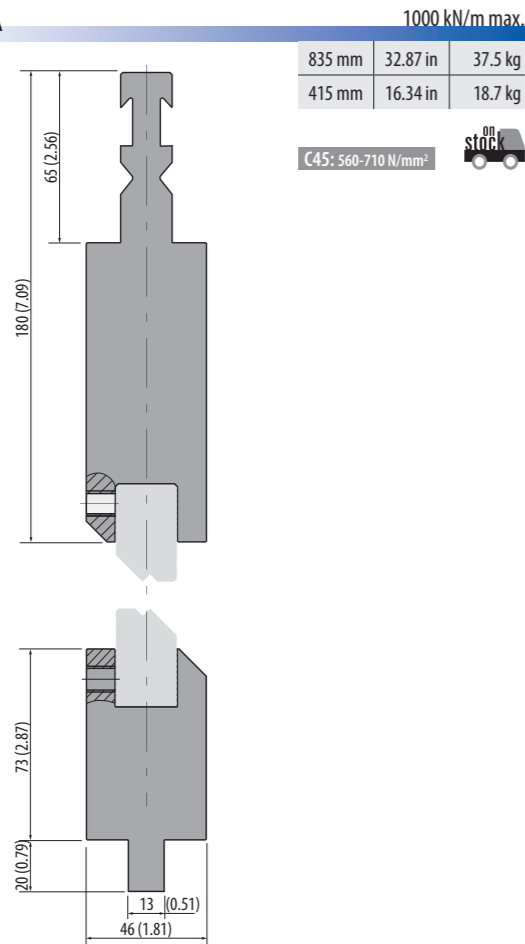
**AD22** 1000 kN/m max.



Articles on stock – Please note that delivery time varies according to your location.



**BPZ-RFA**



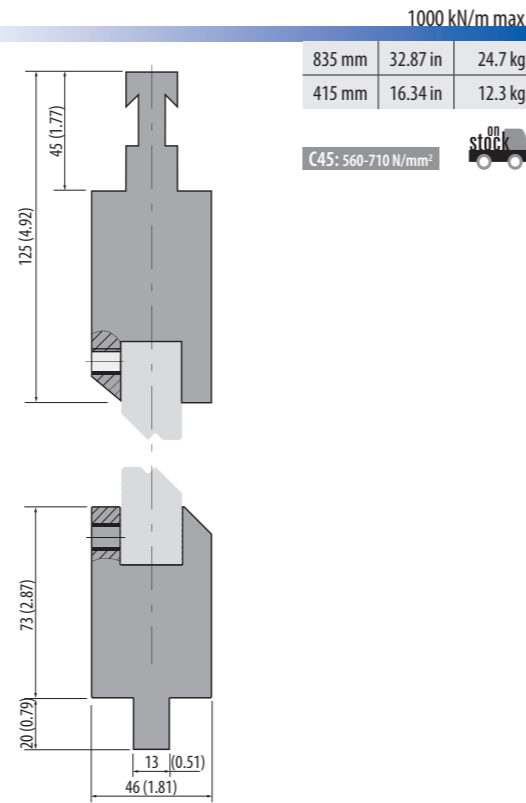
1000 kN/m max.

|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 37.5 kg |
| 415 mm | 16.34 in | 18.7 kg |

C45: 560-710 N/mm<sup>2</sup>

**BPZ-R**

**NEW**



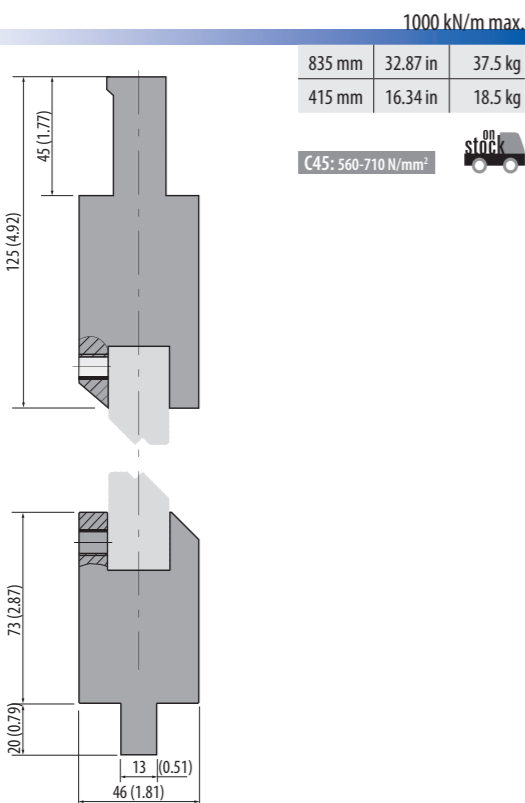
1000 kN/m max.

|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 24.7 kg |
| 415 mm | 16.34 in | 12.3 kg |

C45: 560-710 N/mm<sup>2</sup>

**BPZ-S**

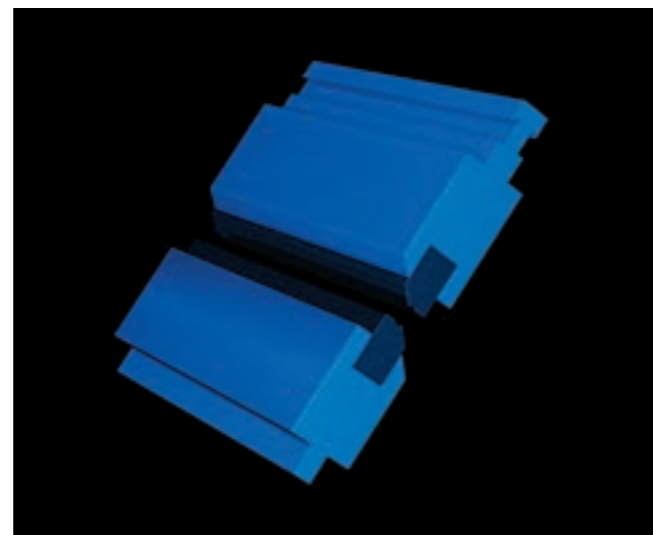
**NEW**



1000 kN/m max.

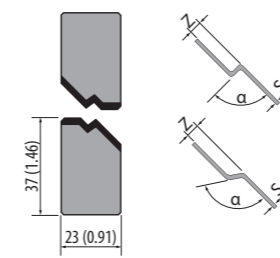
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 37.5 kg |
| 415 mm | 16.34 in | 18.5 kg |

C45: 560-710 N/mm<sup>2</sup>



**Rolleri Videos**  
find updated and helpful videos at:  
[www.rolleritools.com/videos/overview](http://www.rolleritools.com/videos/overview)

**Z-Tool Inserts 160° / 150° / 140° / 90°**



1000 kN/m max.

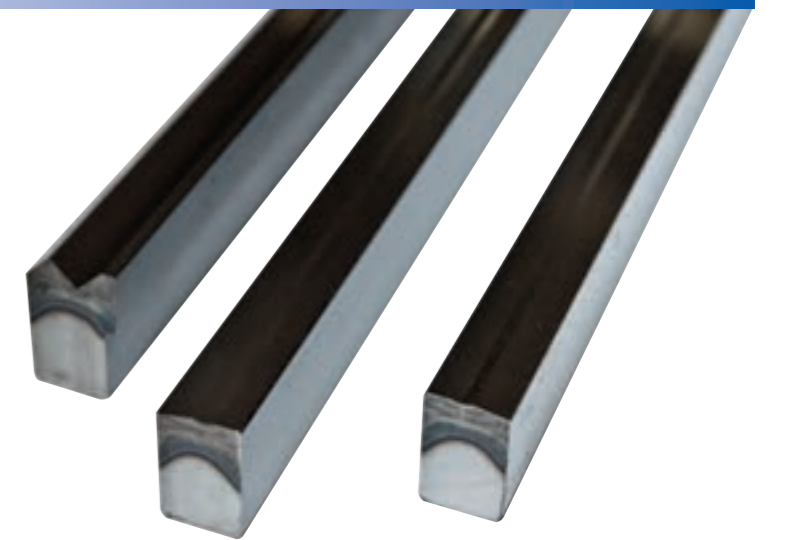
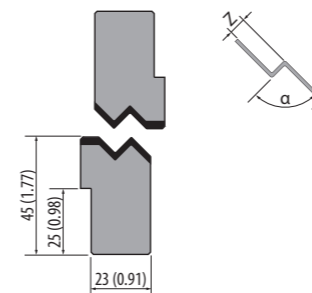
| Model      | Z mm | Z in | α    | S* mm | S* inch | Weight  | Weight |
|------------|------|------|------|-------|---------|---------|--------|
| CEZ 1.0    | 1.0  | 0.04 | 160° | 1.2   | 0.05    | 11.0 kg | 5.5 kg |
| CEZ 1.5    | 1.5  | 0.06 | 160° | 1.5   | 0.06    | 11.0 kg | 5.5 kg |
| CEZ 2.0    | 2.0  | 0.08 | 150° | 1.4   | 0.06    | 11.0 kg | 5.5 kg |
| CEZ 2.5    | 2.5  | 0.10 | 140° | 1.3   | 0.05    | 11.0 kg | 5.5 kg |
| CEZ 1.0/90 | 1.0  | 0.04 | 90°  | 0.3   | 0.01    | 11.0 kg | 5.5 kg |
| CEZ 1.5/90 | 1.5  | 0.06 | 90°  | 0.3   | 0.01    | 11.0 kg | 5.5 kg |
| CEZ 2.0/90 | 2.0  | 0.08 | 90°  | 0.4   | 0.02    | 11.0 kg | 5.5 kg |
| CEZ 2.5/90 | 2.5  | 0.10 | 90°  | 0.5   | 0.02    | 11.0 kg | 5.5 kg |
| CEZ 3.0    | 3.0  | 0.12 | 90°  | 1.0   | 0.04    | 10.3 kg | 5.1 kg |
| CEZ 3.5    | 3.5  | 0.14 | 90°  | 1.0   | 0.04    | 10.0 kg | 5.0 kg |
| CEZ 4.0    | 4.0  | 0.16 | 90°  | 1.2   | 0.05    | 10.0 kg | 5.0 kg |
| CEZ 4.5    | 4.5  | 0.18 | 90°  | 1.2   | 0.05    | 10.0 kg | 5.0 kg |
| CEZ 5.0    | 5.0  | 0.20 | 90°  | 1.3   | 0.05    | 10.0 kg | 5.0 kg |
| CEZ 5.5    | 5.5  | 0.22 | 90°  | 1.4   | 0.06    | 10.0 kg | 5.0 kg |
| CEZ 6.0    | 6.0  | 0.24 | 90°  | 1.5   | 0.06    | 10.0 kg | 5.0 kg |
| CEZ 6.5    | 6.5  | 0.26 | 90°  | 1.5   | 0.06    | 10.0 kg | 5.0 kg |
| CEZ 7.0    | 7.0  | 0.28 | 90°  | 1.5   | 0.06    | 10.0 kg | 5.0 kg |
| CEZ 7.5    | 7.5  | 0.30 | 90°  | 1.6   | 0.06    | 10.0 kg | 5.0 kg |
| CEZ 8.0    | 8.0  | 0.31 | 90°  | 1.6   | 0.06    | 10.0 kg | 5.0 kg |

C45: 560-710 N/mm<sup>2</sup>

835 mm / 32.87 in | 415 mm / 16.34 in

\* Fe Rmax = 42 Kg/mm<sup>2</sup>

**Z-Profile Inserts 90°**



1000 kN/m max.

| Model    | Z mm | Z in | α   | S* mm | S* inch | Weight  | Weight |
|----------|------|------|-----|-------|---------|---------|--------|
| CEZ 9.0  | 9    | 0.35 | 90° | 1.8   | 0.07    | 13.5 kg | 6.5 kg |
| CEZ 10.0 | 10   | 0.39 | 90° | 1.8   | 0.07    | 13.5 kg | 6.5 kg |
| CEZ 11.0 | 11   | 0.43 | 90° | 2     | 0.08    | 13.5 kg | 6.5 kg |
| CEZ 12.0 | 12   | 0.47 | 90° | 2     | 0.08    | 13.5 kg | 6.5 kg |
| CEZ 13.0 | 13   | 0.51 | 90° | 2     | 0.08    | 13.5 kg | 6.5 kg |
| CEZ 14.0 | 14   | 0.55 | 90° | 2     | 0.08    | 13.5 kg | 6.5 kg |
| CEZ 15.0 | 15   | 0.59 | 90° | 2.3   | 0.09    | 13.5 kg | 6.5 kg |

C45: 560-710 N/mm<sup>2</sup>

835 mm / 32.87 in | 415 mm / 16.34 in

\* Fe Rmax = 42 Kg/mm<sup>2</sup>

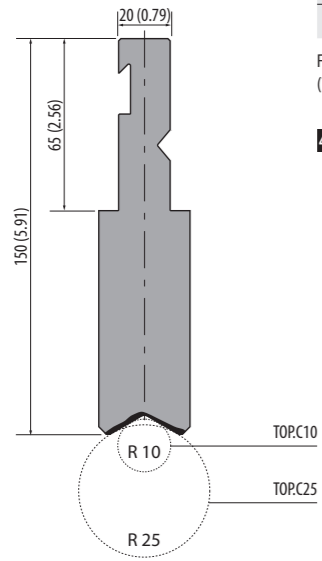
### BPR150.P10.10-RFA

1000 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 522 mm           | 20.55 in           | 16.5 kg |
| 495 mm segmented | 19.49 in segmented | 16.0 kg |

For Radius tools with R10-R25 (TOP.C10-TOP.C25) see below

42Cr: 900-1150 N/mm<sup>2</sup>



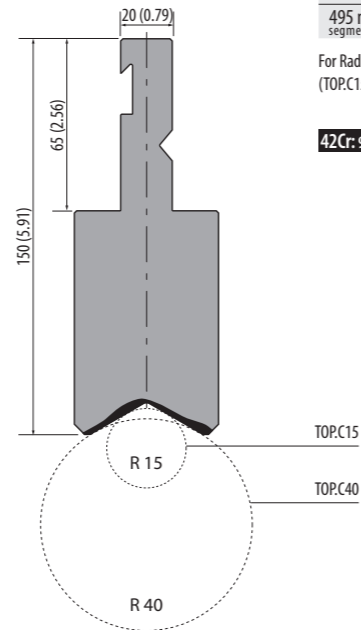
### BPR150.P10.15-RFA

1000 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 522 mm           | 20.55 in           | 23.0 kg |
| 495 mm segmented | 19.49 in segmented | 21.7 kg |

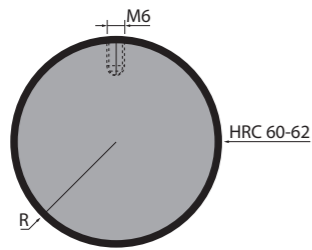
For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm<sup>2</sup>



### Radius Tools: R10-40

1000 kN/m max.



Material: C53 induction hardened 60-62HRC

C53: 610-760 N/mm<sup>2</sup>



| Model     | R mm | R in | Weight  | Weight  |
|-----------|------|------|---------|---------|
| TOP.C10   | 10   | 0.39 | 1.3 kg  | 2.7 kg  |
| TOP.C12.5 | 12.5 | 0.49 | 2.0 kg  | 2.8 kg  |
| TOP.C15   | 15   | 0.59 | 3.0 kg  | 3.8 kg  |
| TOP.C17.5 | 17.5 | 0.69 | 4.0 kg  | 4.7 kg  |
| TOP.C20   | 20   | 0.79 | 5.2 kg  | 6.6 kg  |
| TOP.C25   | 25   | 0.98 | 8.1 kg  | 7.5 kg  |
| TOP.C30   | 30   | 1.18 | 11.7 kg | 11.3 kg |
| TOP.C35   | 35   | 1.38 | 16.0 kg | 15.1 kg |
| TOP.C40   | 40   | 1.57 | 20.7 kg | 19.5 kg |

Articles on stock – Please note that delivery time varies according to your location.

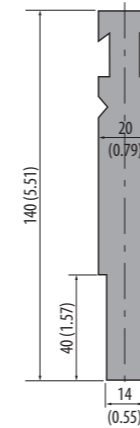


### BPU-RFA

800 kN/m max.

|        |          |         |
|--------|----------|---------|
| 830 mm | 32.68 in | 15.3 kg |
| 410 mm | 16.14 in | 7.6 kg  |

C45: 560-710 N/mm<sup>2</sup>

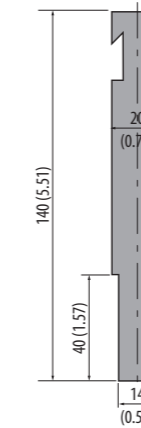


### BPU-R

800 kN/m max.

|        |          |         |
|--------|----------|---------|
| 830 mm | 32.68 in | 15.8 kg |
| 410 mm | 16.14 in | 7.8 kg  |

C45: 560-710 N/mm<sup>2</sup>

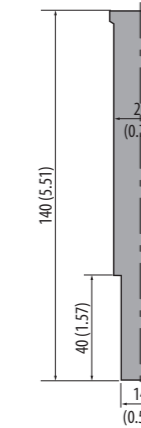


### BPU-S

800 kN/m max.

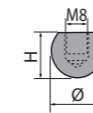
|        |          |         |
|--------|----------|---------|
| 830 mm | 32.68 in | 16.8 kg |
| 410 mm | 16.14 in | 8.3 kg  |

C45: 560-710 N/mm<sup>2</sup>



### Radius Tool: Ø 16-20 mm (0.63-0.79 in)

800 kN/m max.

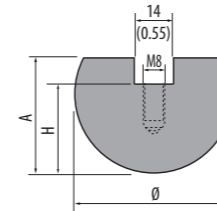


C45: 560-710 N/mm<sup>2</sup>

| Model  | Ø mm | Ø in | H mm | H in | Weight  | Weight  |
|--------|------|------|------|------|---------|---------|
| C13.08 | 16   | 0.63 | 13   | 0.51 | 2.00 kg | 1.00 kg |
| C13.09 | 18   | 0.71 | 16   | 0.63 | 2.00 kg | 1.00 kg |
| C16.10 | 20   | 0.79 | 16   | 0.63 | 2.00 kg | 1.00 kg |

### Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.



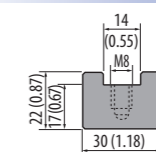
C45: 560-710 N/mm<sup>2</sup>

| Model  | Ø mm | Ø in | H mm | H in | A mm | A in | Weight  | Weight  |
|--------|------|------|------|------|------|------|---------|---------|
| C17.12 | 25   | 0.98 | 17   | 0.67 | 22   | 0.87 | 2.5 kg  | 1.2 kg  |
| C20.15 | 30   | 1.18 | 20   | 0.79 | 27   | 1.06 | 3.7 kg  | 1.8 kg  |
| C22.17 | 35   | 1.38 | 22   | 0.87 | 32   | 1.26 | 5.0 kg  | 2.4 kg  |
| C24.20 | 40   | 1.57 | 24   | 0.94 | 34   | 1.34 | 7.0 kg  | 3.5 kg  |
| C29.25 | 50   | 1.97 | 29   | 1.14 | 39   | 1.54 | 10.0 kg | 4.7 kg  |
| C34.30 | 60   | 2.36 | 34   | 1.34 | 44   | 1.73 | 13.5 kg | 6.7 kg  |
| C45.35 | 70   | 2.76 | 45   | 1.77 | 55   | 2.17 | 20.3 kg | 10.0 kg |
| C45.40 | 80   | 3.15 | 45   | 1.77 | 55   | 2.17 | 23.0 kg | 11.5 kg |
| C60.45 | 90   | 3.54 | 60   | 2.36 | 70   | 2.76 | 34.0 kg | 17.0 kg |
| C70.50 | 100  | 3.94 | 70   | 2.76 | 80   | 3.15 | 43.5 kg | 21.7 kg |



### E30.22

800 kN/m max.



|        |          |        |
|--------|----------|--------|
| 835 mm | 32.87 in | 3.5 kg |
| 415 mm | 16.34 in | 1.7 kg |

C45: 560-710 N/mm<sup>2</sup>



## DIES ROLLERI TYPE R3

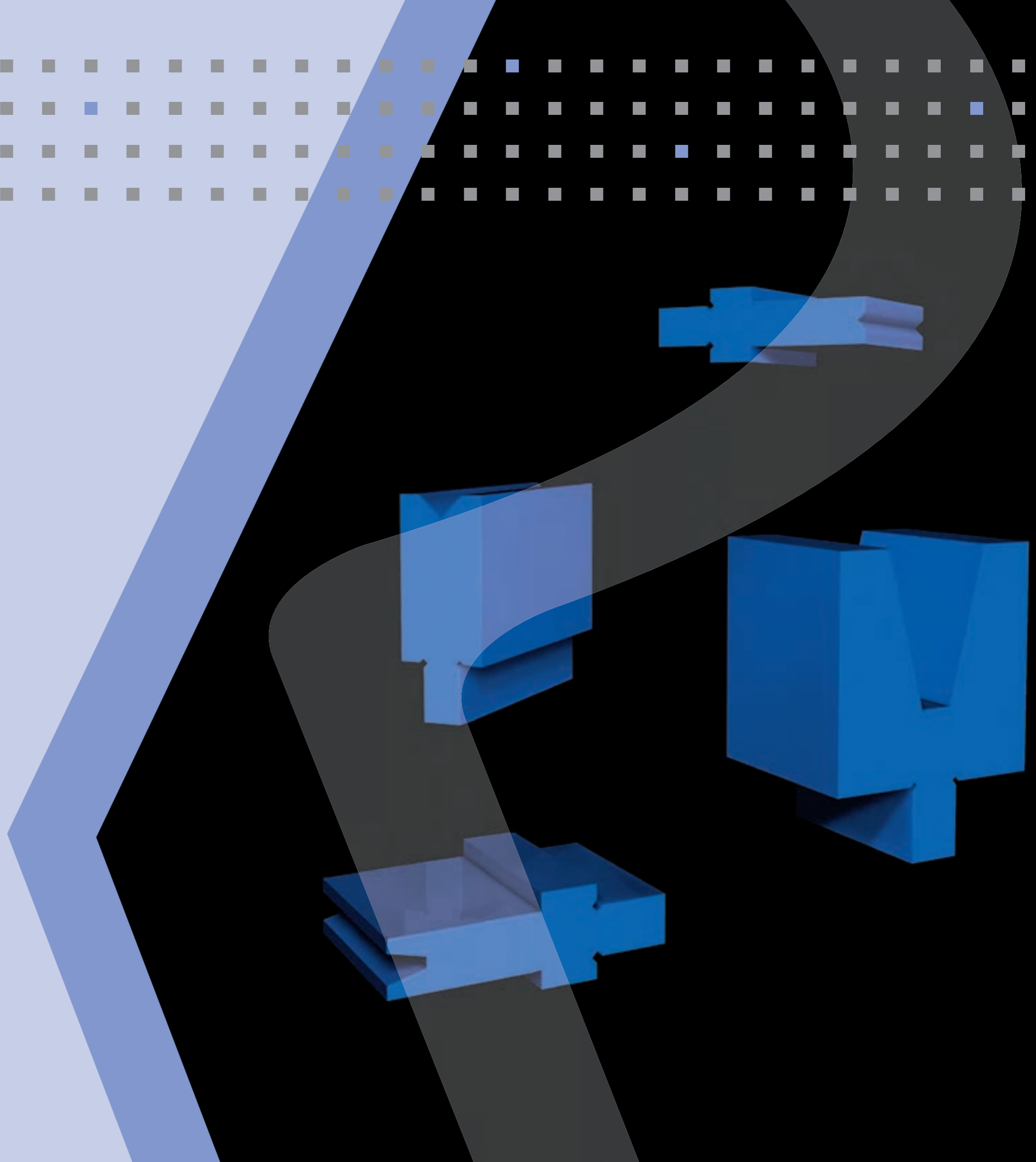
|  |           |
|--|-----------|
| Content Explanation                              | 136 - 137 |
| Dies 90°, H=55 (2.17)                            | 138       |
| Dies 88°, H=55 (2.17)                            | 139       |
| Dies 85°, H=55 (2.17)                            | 139       |
| Dies 80°, H=65 (2.56) / H=85 (3.35)              | 140       |
| Dies 60°, H=55 (2.17) / H=65 (2.56)              | 140       |
| Dies 30°, H=55 (2.17) / H=60 (2.36)              | 141       |
| Dies 30°, H=70 (2.76)                            | 142       |
| Dies, H=100 (3.94) / H=120 (4.72) / H=150 (5.91) | 143 - 145 |
| Hemming Dies                                     | 146       |
| Synthetic Dies, H=100 (3.94)                     | 147       |
| Die Adapters                                     | 147       |

### Compatibility

Dies Rolleri Type R3 are compatible with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

With Adapter-Systems the dies Rolleri Type R3 are also applicable on all other press brake machines.



### Compatibility

Dies Roller Type R3 are:

- compatible with press brake machines with a table groove for pins 13 x 20 mm: Bystronic-Beyeler, Bystronic-Hämmerle, Safan, SMD, Trumpf
- also applicable on all other press brake machines with **Adapter-Systems and Adapter Rails** (see pages 218-221).

### Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

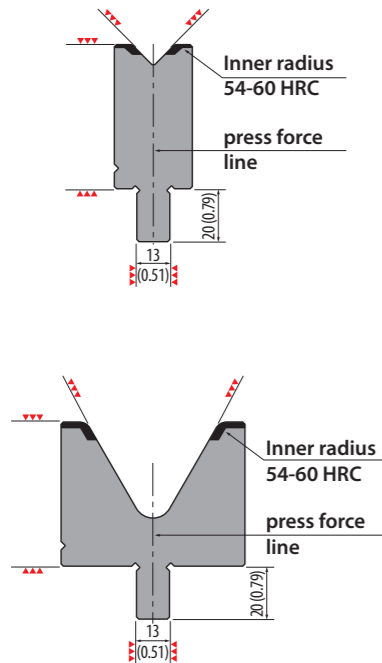
| Material Type | Mechanical resistance of the material and the tool body | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------------|---|--|--|
| 42CrMo4       | 900-1150 N/mm <sup>2</sup>                              | 29.1 - 36.9 HRC                            | 54 - 60 HRC  |
| C45           | 560-710 N/mm <sup>2</sup>                               | 12 - 15.5 HRC                              | 54 - 60 HRC  |

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

### Tang

All dies Roller Type R3 are by default equipped with a **13 x 20 mm (0.51 x 0.79 in) tail**.

Indications of precision ground surfaces:



### Our Advantages – Your Convenience

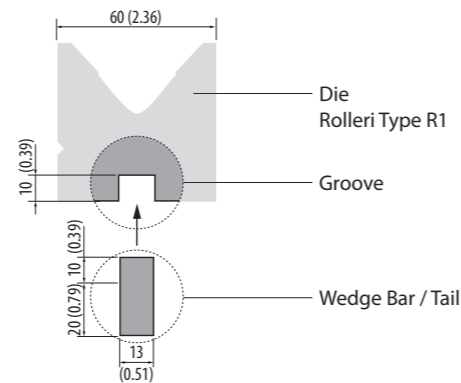
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- modifications possible (see pages 250-253)
- very large stock availability

### Modification: Wedge Bar / Tail

In order to also use Roller Type R1 Dies, a 10 mm (0.39 in) groove is milled and a percise grounded wedge bar / tail in 13 x 30 mm (0.51 x 1.18 in) is inserted.

For more specific information and prices go to page 252 in the Service Chapter.

### Example of Application



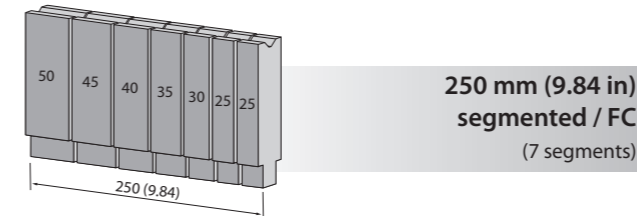
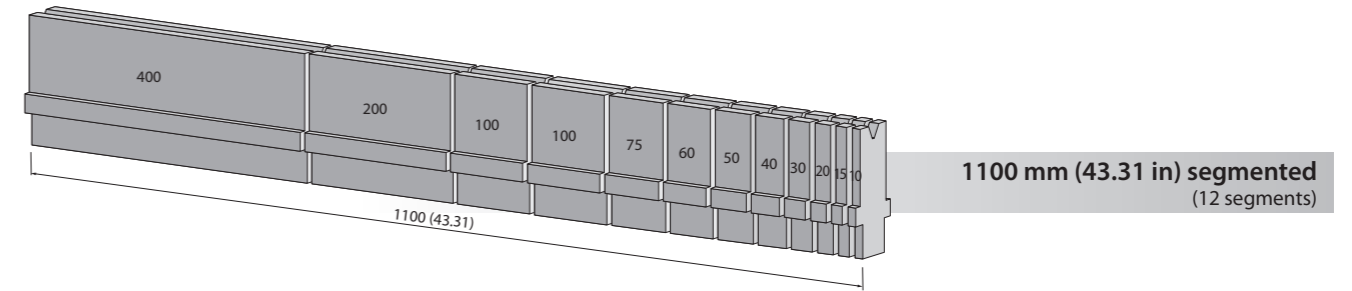
### Tool lengths and sectioning

Standard

1000 mm (39.37 in)

500 mm (19.68 in)

525 mm (20.67 in)



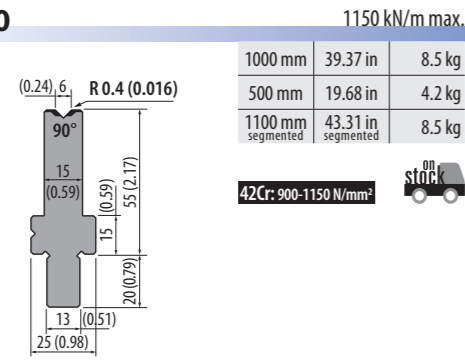
Segmented tools are delivered in complete sets. Single pieces are also available! More lengths and sectionings are possible upon request.



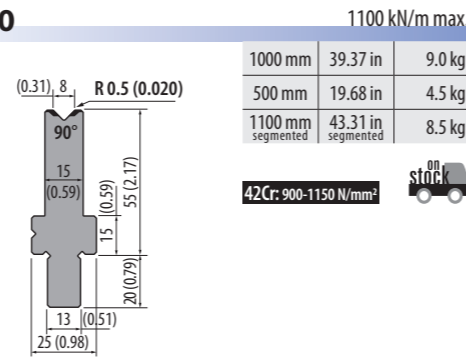
# R3 ROLLERI TYPE R3

Dies 90°, H=55 (2.17)

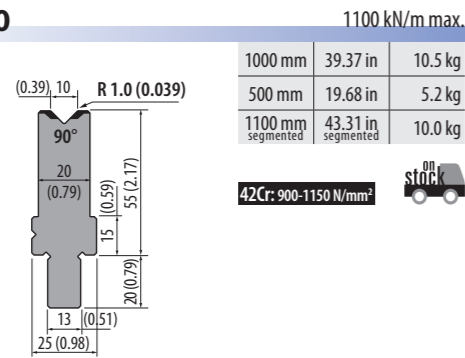
## BMR55.06.90



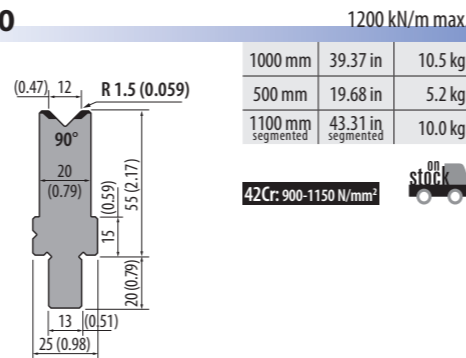
## BMR55.08.90



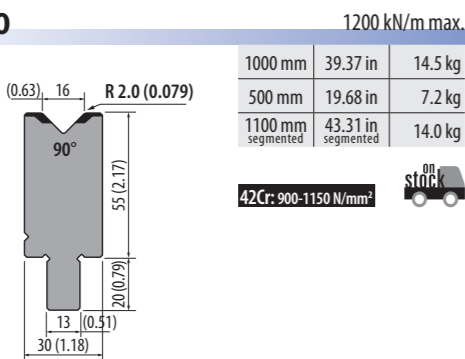
## BMR55.10.90



## BMR55.12.90



## BMR55.16.90

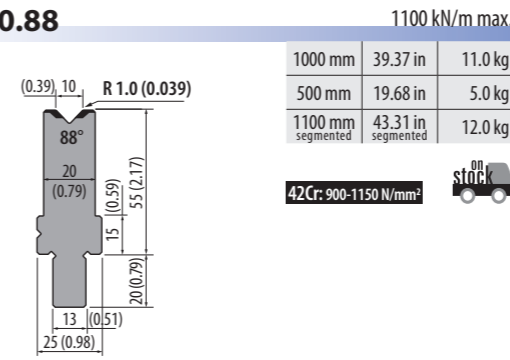


# R3 ROLLERI TYPE R3

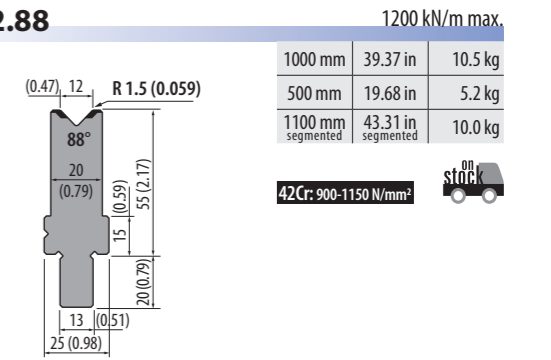
Dies 88°, H=55 (2.17)



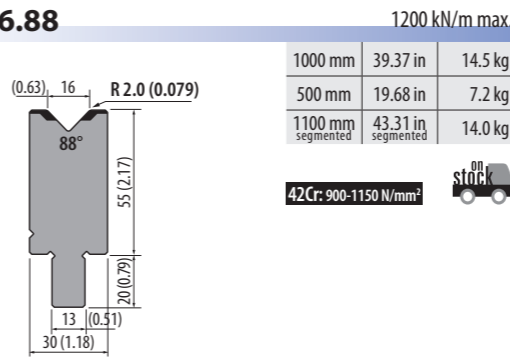
## BMR55.10.88



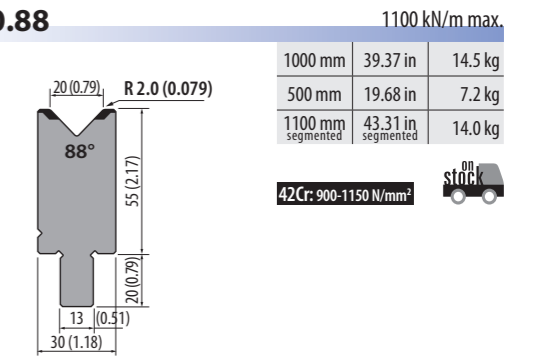
## BMR55.12.88



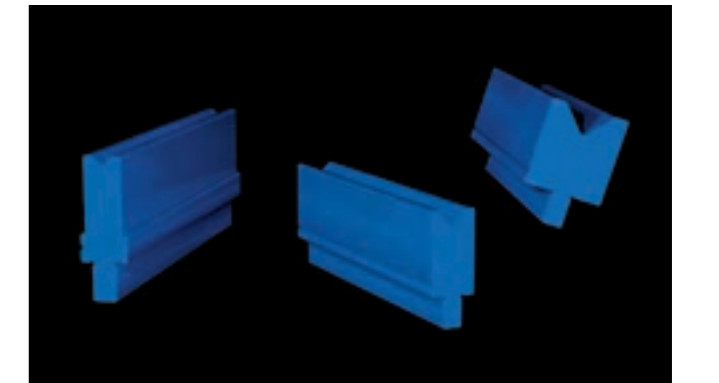
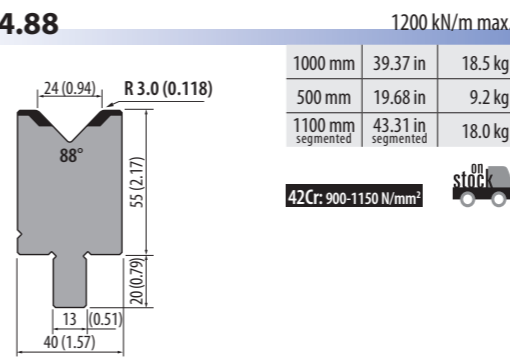
## BMR55.16.88



## BMR55.20.88

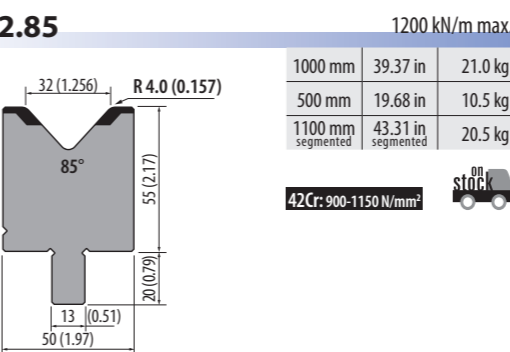


## BMR55.24.88

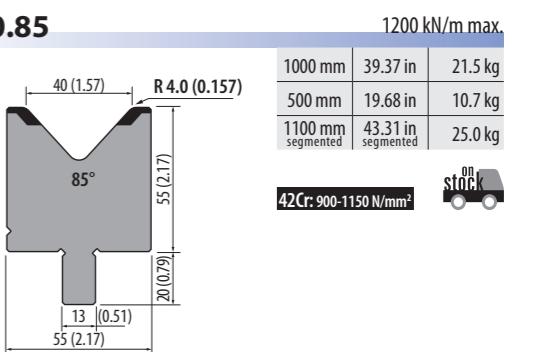


# Dies 85°, H=55 (2.17)

## BMR55.32.85



## BMR55.40.85

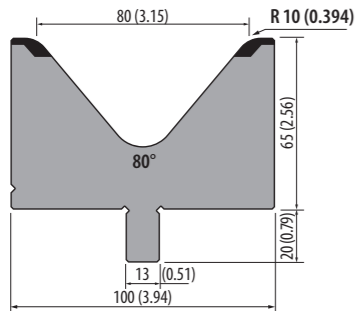


# R3 ROLLERI TYPE R3

Dies 80°, H=65 (2.56) / H=85 (3.35)

## BMR65.80.80

1700 kN/m max.



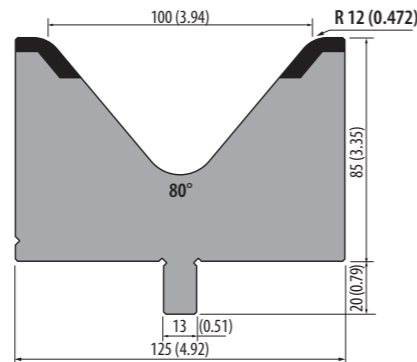
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 39.0 kg |
| 500 mm            | 19.68 in           | 20.0 kg |
| 1100 mm segmented | 43.31 in segmented | 43.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR85.100.80

2300 kN/m max.



|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 62.0 kg |
| 500 mm            | 19.68 in           | 31.0 kg |
| 1100 mm segmented | 43.31 in segmented | 69.0 kg |

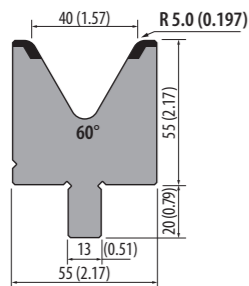
42Cr: 900-1150 N/mm<sup>2</sup>



# Dies 60°, H=55 (2.17), H=65 (2.56)

## BMR55.40.60

1300 kN/m max.



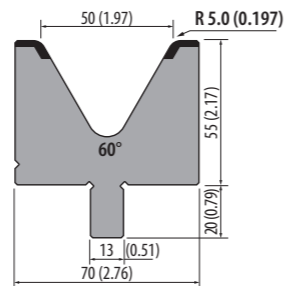
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 20.3 kg |
| 500 mm            | 19.68 in           | 10.5 kg |
| 1100 mm segmented | 43.31 in segmented | 22.3 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.50.60

1200 kN/m max.



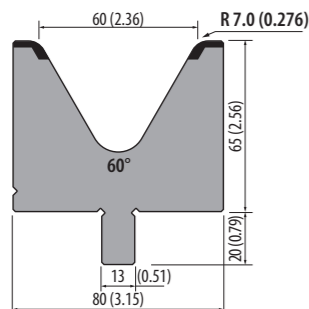
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 25.0 kg |
| 500 mm            | 19.68 in           | 12.0 kg |
| 1100 mm segmented | 43.31 in segmented | 21.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR65.60.60

1100 kN/m max.



|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 31.0 kg |
| 500 mm            | 19.68 in           | 15.5 kg |
| 1100 mm segmented | 43.31 in segmented | 34.1 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



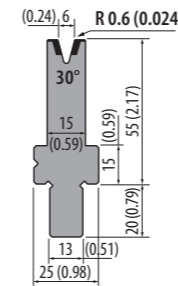
# R3 ROLLERI TYPE R3

Dies 30°, H=55 (2.17), H=60 (2.36)



## BMR55.06.30

350 kN/m max.



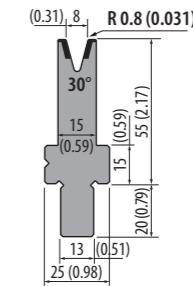
|                   |                    |        |
|-------------------|--------------------|--------|
| 1000 mm           | 39.37 in           | 8.0 kg |
| 500 mm            | 19.68 in           | 4.0 kg |
| 1100 mm segmented | 43.31 in segmented | 9.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.08.30

200 kN/m max.



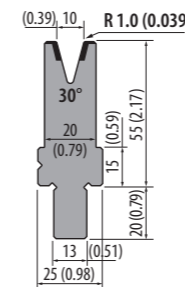
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 9.2 kg  |
| 500 mm            | 19.68 in           | 4.0 kg  |
| 1100 mm segmented | 43.31 in segmented | 10.1 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.10.30

350 kN/m max.



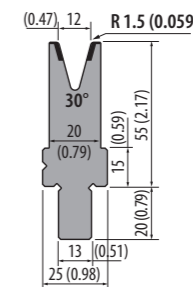
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 10.0 kg |
| 500 mm            | 19.68 in           | 5.0 kg  |
| 1100 mm segmented | 43.31 in segmented | 11.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.12.30

300 kN/m max.



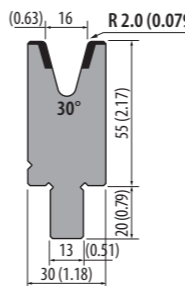
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 10.0 kg |
| 500 mm            | 19.68 in           | 5.0 kg  |
| 1100 mm segmented | 43.31 in segmented | 11.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.16.30

450 kN/m max.



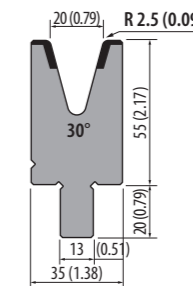
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 13.5 kg |
| 500 mm            | 19.68 in           | 6.7 kg  |
| 1100 mm segmented | 43.31 in segmented | 14.9 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.20.30

500 kN/m max.



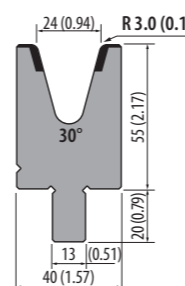
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 14.0 kg |
| 500 mm            | 19.68 in           | 7.0 kg  |
| 1100 mm segmented | 43.31 in segmented | 13.5 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR55.24.30

550 kN/m max.



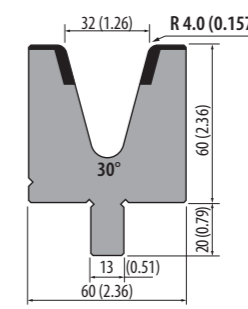
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 15.5 kg |
| 500 mm            | 19.68 in           | 7.8 kg  |
| 1100 mm segmented | 43.31 in segmented | 17.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



## BMR60.32.30

650 kN/m max.



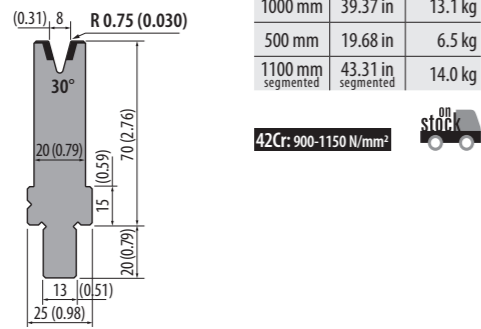
|                   |                    |         |
|-------------------|--------------------|---------|
| 1000 mm           | 39.37 in           | 23.0 kg |
| 500 mm            | 19.68 in           | 11.5 kg |
| 1100 mm segmented | 43.31 in segmented | 22.5 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



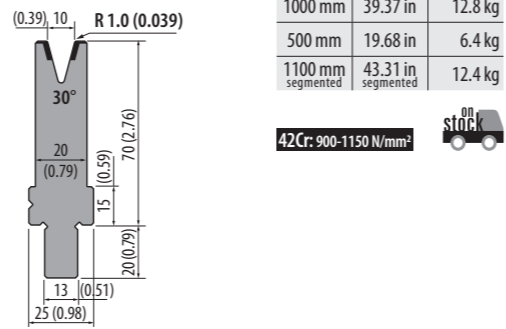
## BMR70.08.30

200 kN/m max.



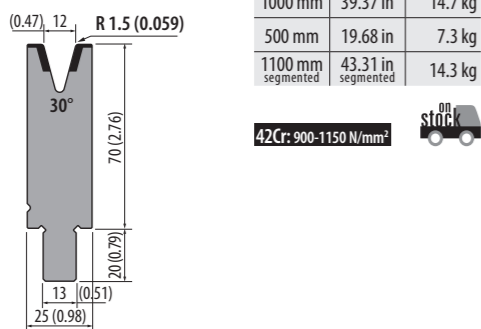
## BMR70.10.30

350 kN/m max.



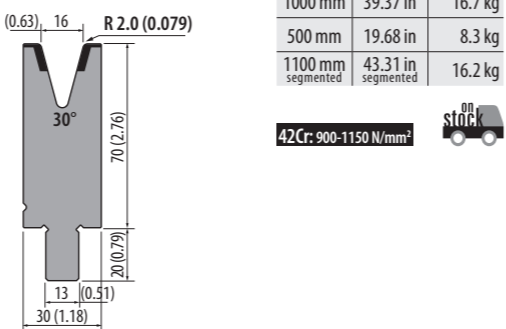
## BMR70.12.30

300 kN/m max.

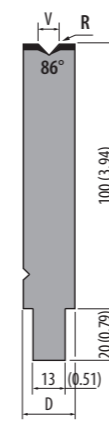


## BMR70.16.30

450 kN/m max.



## 86° Dies, H=100 (3.94)

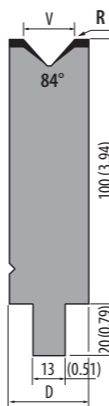


Individual drawings, available lengths and prices see pages 101-103

42Cr: 900-1150 N/mm<sup>2</sup>

| Model        | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|--------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR100.04.86 | 4      | 0.16   | 0.6    | 0.02   | 20     | 0.79   | 450       |
| TMR100.06.86 | 6      | 0.24   | 0.6    | 0.02   | 20     | 0.79   | 1200      |
| TMR100.08.86 | 8      | 0.31   | 0.8    | 0.03   | 20     | 0.79   | 1150      |
| WMR100.08.86 | 8      | 0.31   | 2.5    | 0.10   | 25     | 0.98   | 400       |
| TMR100.10.86 | 10     | 0.39   | 1.0    | 0.04   | 20     | 0.79   | 1100      |
| TMR100.12.86 | 12     | 0.47   | 1.0    | 0.04   | 25     | 0.98   | 1200      |
| WMR100.12.86 | 12     | 0.47   | 2.5    | 0.10   | 25     | 0.98   | 500       |
| TMR100.16.86 | 16     | 0.63   | 1.6    | 0.06   | 30     | 1.18   | 1200      |
| TMR100.20.86 | 20     | 0.79   | 2.0    | 0.08   | 30     | 1.18   | 1150      |
| TMR100.24.86 | 24     | 0.94   | 2.5    | 0.10   | 35     | 1.38   | 1200      |
| TMR100.30.86 | 30     | 1.18   | 3.0    | 0.12   | 45     | 1.77   | 1200      |
| TMR100.40.86 | 40     | 1.57   | 3.0    | 0.12   | 55     | 2.17   | 1200      |
| TMR100.50.86 | 50     | 1.97   | 3.0    | 0.12   | 75     | 2.95   | 1500      |

## 84° Dies, H=100 (3.94)

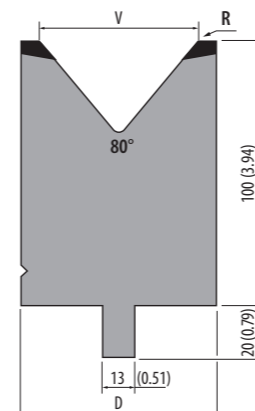


Individual drawings, available lengths and prices see pages 103-104

42Cr: 900-1150 N/mm<sup>2</sup>

| Model        | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|--------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR100.06.84 | 6      | 0.24   | 0.6    | 0.02   | 20     | 0.79   | 1200      |
| TMR100.08.84 | 8      | 0.31   | 0.8    | 0.03   | 20     | 0.79   | 1150      |
| TMR100.10.84 | 10     | 0.39   | 1.0    | 0.04   | 20     | 0.79   | 1100      |
| TMR100.12.84 | 12     | 0.47   | 1.0    | 0.04   | 25     | 0.98   | 1200      |
| TMR100.16.84 | 16     | 0.63   | 1.6    | 0.06   | 30     | 1.18   | 1200      |
| TMR100.20.84 | 20     | 0.79   | 2.0    | 0.08   | 30     | 1.18   | 1150      |
| TMR100.24.84 | 24     | 0.94   | 2.5    | 0.10   | 35     | 1.38   | 1200      |

## 80° Dies, H=100 (3.94) / H=120 (4.72)



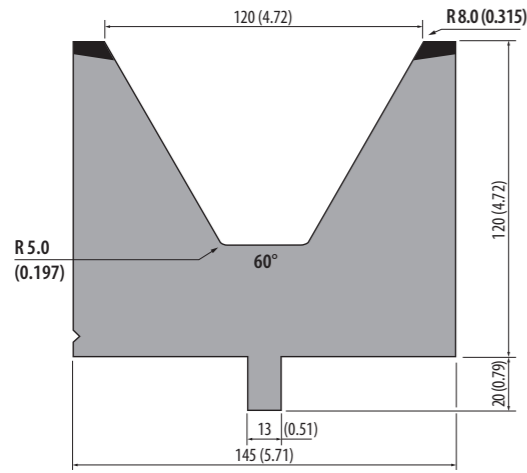
Individual drawings, available lengths and prices see page 105

42Cr: 900-1150 N/mm<sup>2</sup>

| Model         | V (mm) | V (in) | H (mm) | H (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|---------------|--------|--------|--------|--------|--------|--------|--------|--------|-----------|
| TMR100.60.80  | 60     | 2.36   | 100    | 3.94   | 5.0    | 0.20   | 75     | 2.95   | 1500      |
| TMR100.70.80  | 70     | 2.76   | 100    | 3.94   | 5.0    | 0.20   | 85     | 3.35   | 1500      |
| TMR100.80.80  | 80     | 3.15   | 100    | 3.94   | 5.0    | 0.20   | 100    | 3.94   | 1500      |
| TMR120.90.80  | 90     | 3.54   | 120    | 4.72   | 8.0    | 0.31   | 110    | 4.33   | 1500      |
| TMR120.100.80 | 100    | 3.94   | 120    | 4.72   | 8.0    | 0.31   | 120    | 4.72   | 1500      |



## 60° Die, H=120 (4.72)

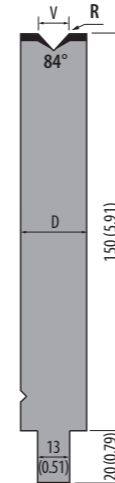


Individual drawings, available lengths and prices see page 106

| Model         | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|---------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR120.120.60 | 120    | 4.72   | 8.0    | 0.31   | 145    | 5.71   | 1000      |

42Cr: 900-1150 N/mm<sup>2</sup>

## 84° Dies, H=150 (5.91)

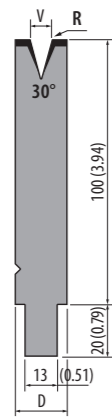


Individual drawings, available lengths and prices see pages 110-111

| Model        | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|--------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR150.06.84 | 6      | 0.24   | 0.6    | 0.02   | 20     | 0.79   | 400       |
| TMR150.08.84 | 8      | 0.31   | 0.8    | 0.03   | 20     | 0.79   | 400       |
| TMR150.10.84 | 10     | 0.39   | 1.0    | 0.04   | 20     | 0.79   | 500       |
| TMR150.12.84 | 12     | 0.47   | 1.0    | 0.04   | 25     | 0.98   | 500       |
| TMR150.16.84 | 16     | 0.63   | 1.6    | 0.06   | 30     | 1.18   | 700       |
| TMR150.20.84 | 20     | 0.79   | 2.0    | 0.08   | 30     | 1.18   | 700       |
| TMR150.24.84 | 24     | 0.94   | 2.5    | 0.10   | 35     | 1.38   | 700       |

42Cr: 900-1150 N/mm<sup>2</sup>

## 30° Dies, H=100 (3.94)

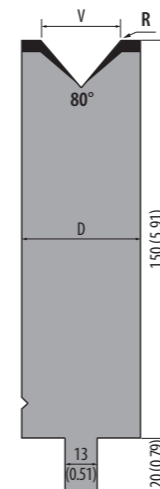


Individual drawings, available lengths and prices see pages 106-108

| Model        | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|--------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR100.04.30 | 4      | 0.16   | 0.6    | 0.02   | 20     | 0.79   | 150       |
| TMR100.06.30 | 6      | 0.24   | 0.6    | 0.02   | 20     | 0.79   | 400       |
| WMR100.06.30 | 6      | 0.24   | 2.0    | 0.08   | 20     | 0.79   | 400       |
| TMR100.08.30 | 8      | 0.31   | 1.0    | 0.04   | 20     | 0.79   | 400       |
| WMR100.08.30 | 8      | 0.31   | 2.5    | 0.10   | 20     | 0.79   | 400       |
| TMR100.10.30 | 10     | 0.39   | 1.0    | 0.04   | 20     | 0.79   | 400       |
| WMR100.10.30 | 10     | 0.39   | 2.5    | 0.10   | 25     | 0.98   | 400       |
| TMR100.12.30 | 12     | 0.47   | 1.0    | 0.04   | 25     | 0.98   | 400       |
| WMR100.12.30 | 12     | 0.47   | 3.0    | 0.12   | 25     | 0.98   | 400       |
| TMR100.16.30 | 16     | 0.63   | 1.6    | 0.06   | 30     | 1.18   | 500       |
| TMR100.20.30 | 20     | 0.79   | 2.0    | 0.08   | 30     | 1.18   | 600       |
| TMR100.24.30 | 24     | 0.94   | 2.5    | 0.10   | 40     | 1.57   | 650       |
| TMR100.30.30 | 30     | 1.18   | 3.0    | 0.12   | 55     | 2.17   | 900       |
| TMR100.40.30 | 40     | 1.57   | 5.0    | 0.20   | 60     | 2.36   | 900       |

42Cr: 900-1150 N/mm<sup>2</sup>

## 80° Dies, H=150 (5.91)

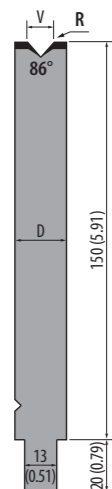


Individual drawings, available lengths and prices see page 112

| Model        | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|--------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR150.24.80 | 24     | 0.94   | 2.5    | 0.10   | 35     | 1.38   | 700       |
| TMR150.30.80 | 30     | 1.18   | 5.0    | 0.20   | 45     | 1.77   | 900       |
| TMR150.40.80 | 40     | 1.57   | 5.0    | 0.20   | 55     | 2.17   | 1200      |
| TMR150.50.80 | 50     | 1.97   | 5.0    | 0.20   | 65     | 2.56   | 1500      |

42Cr: 900-1150 N/mm<sup>2</sup>

## 86° Dies, H=150 (5.91)

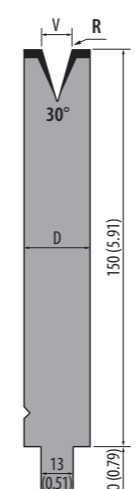


Individual drawings, available lengths and prices see pages 109-110

| Model        | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|--------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR150.06.86 | 6      | 0.24   | 0.6    | 0.02   | 20     | 0.79   | 400       |
| TMR150.08.86 | 8      | 0.31   | 0.8    | 0.03   | 20     | 0.79   | 400       |
| TMR150.10.86 | 10     | 0.39   | 1.0    | 0.04   | 20     | 0.79   | 500       |
| TMR150.12.86 | 12     | 0.47   | 1.0    | 0.04   | 25     | 0.98   | 500       |
| TMR150.16.86 | 16     | 0.63   | 1.6    | 0.06   | 30     | 1.18   | 700       |
| TMR150.20.86 | 20     | 0.79   | 2.0    | 0.08   | 30     | 1.18   | 700       |
| TMR150.24.86 | 24     | 0.94   | 2.5    | 0.10   | 35     | 1.38   | 700       |

42Cr: 900-1150 N/mm<sup>2</sup>

## 30° Dies, H=150 (5.91)

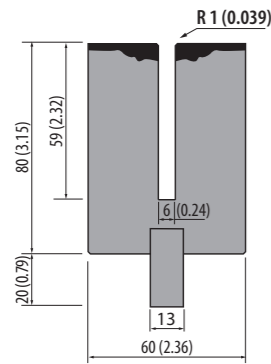


Individual drawings, available lengths and prices see pages 113-114

| Model        | V (mm) | V (in) | R (mm) | R (in) | D (mm) | D (in) | kN/m max. |
|--------------|--------|--------|--------|--------|--------|--------|-----------|
| TMR150.06.30 | 6      | 0.24   | 0.6    | 0.02   | 20     | 0.79   | 400       |
| TMR150.08.30 | 8      | 0.31   | 1.0    | 0.04   | 20     | 0.79   | 400       |
| TMR150.10.30 | 10     | 0.39   | 1.0    | 0.04   | 20     | 0.79   | 400       |
| TMR150.12.30 | 12     | 0.47   | 1.0    | 0.04   | 25     | 0.98   | 400       |
| TMR150.16.30 | 16     | 0.63   | 1.6    | 0.06   | 30     | 1.18   | 500       |
| TMR150.20.30 | 20     | 0.79   | 2.0    | 0.08   | 35     | 1.38   | 600       |
| TMR150.24.30 | 24     | 0.94   | 2.5    | 0.10   | 40     | 1.57   | 650       |
| TMR150.30.30 | 30     | 1.18   | 3.0    | 0.12   | 55     | 2.17   | 900       |
| TMR150.40.30 | 40     | 1.57   | 5.0    | 0.20   | 55     | 2.17   | 900       |

42Cr: 900-1150 N/mm<sup>2</sup>

### BPR.SM.195.28.6



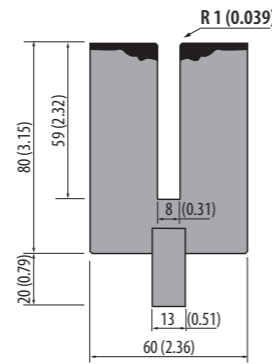
|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 12.0 kg |
| 495 mm segmented | 19.49 in segmented | 11.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



Only for thin material!  
Hemming punches  
see page 126

### BPR.SM.195.28.8

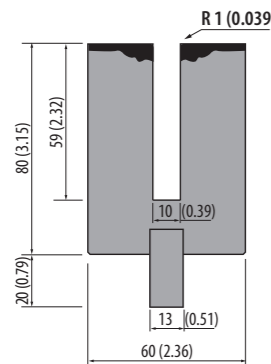


|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 12.0 kg |
| 495 mm segmented | 19.49 in segmented | 11.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



### BPR.SM.195.24.10

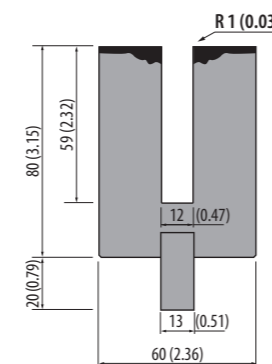


|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 11.8 kg |
| 495 mm segmented | 19.49 in segmented | 11.2 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



### BPR.SM.195.24.12



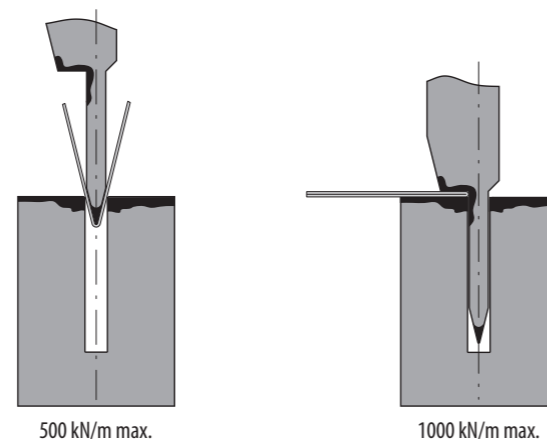
|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 11.5 kg |
| 495 mm segmented | 19.49 in segmented | 10.8 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



### Example of Application

| S    | S    | A   | A    | R.45                | R.70                | S    | S    | A   | A    | R.45                | R.70                |
|------|------|-----|------|---------------------|---------------------|------|------|-----|------|---------------------|---------------------|
| mm   | in   | mm  | in   | Kgf/mm <sup>2</sup> | Kgf/mm <sup>2</sup> | mm   | in   | mm  | in   | Kgf/mm <sup>2</sup> | Kgf/mm <sup>2</sup> |
| 0.6  | 0.02 | 3.0 | 0.12 | 9                   | 15                  | 0.6  | 0.02 | 1.2 | 0.05 | 23                  | 35                  |
| 0.8  | 0.03 | 3.0 | 0.12 | 12                  | 20                  | 0.8  | 0.03 | 1.6 | 0.06 | 32                  | 50                  |
| 1.0  | 0.04 | 3.5 | 0.14 | 15                  | 25                  | 1.0  | 0.04 | 1.0 | 0.04 | 40                  | 60                  |
| 1.25 | 0.05 | 3.5 | 0.14 | 17                  | 26                  | 1.25 | 0.05 | 2.5 | 0.10 | 50                  | 80                  |

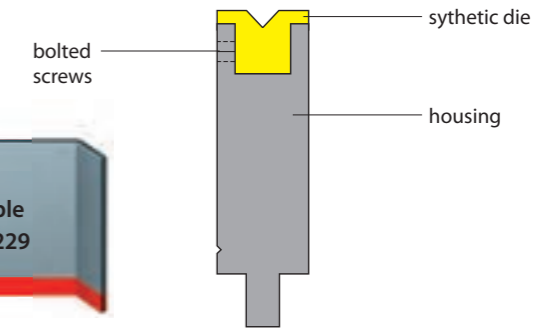


### Our Advantages – Your Convenience

- easy handling
- faster and easier exchange
- preventing bending marks
- decrease of post-processing of bended profiles
- no contact of materials
- higher product quality

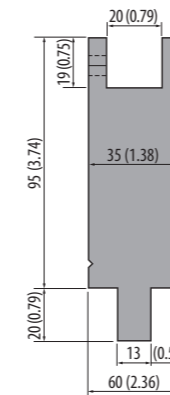
### Mounting example

Synthetic dies will be adjusted into the housing and secured with bolted screws.



More mark-free bending available see pages 222-229

### TMN95.20

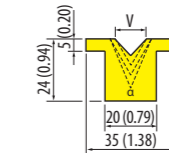


|                |          |         |
|----------------|----------|---------|
| 1000 kN/m max. |          |         |
| 835 mm         | 32.87 in | 12.0 kg |
| 415 mm         | 16.34 in | 6.0 kg  |

C45: 560-710 N/mm<sup>2</sup>



### INS20...



|               |          |         |
|---------------|----------|---------|
| 200 kN/m max. |          |         |
| 835 mm        | 32.87 in | 0.40 kg |
| 415 mm        | 16.34 in | 0.20 kg |

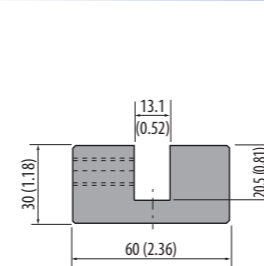


| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS20.06.88 | 88° | 6      | 0.24   |
| INS20.08.88 | 88° | 8      | 0.31   |
| INS20.10.88 | 88° | 10     | 0.39   |
| INS20.12.88 | 88° | 12     | 0.47   |
| INS20.16.88 | 88° | 16     | 0.63   |
| INS20.06.60 | 60° | 6      | 0.24   |
| INS20.08.60 | 60° | 8      | 0.31   |
| INS20.10.60 | 60° | 10     | 0.39   |
| INS20.12.60 | 60° | 12     | 0.47   |
| INS20.16.60 | 60° | 16     | 0.63   |

| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS20.06.45 | 45° | 6      | 0.24   |
| INS20.08.45 | 45° | 8      | 0.31   |
| INS20.10.45 | 45° | 10     | 0.39   |
| INS20.12.45 | 45° | 12     | 0.47   |
| INS20.06.30 | 30° | 6      | 0.24   |
| INS20.08.30 | 30° | 8      | 0.31   |
| INS20.10.30 | 30° | 10     | 0.39   |

### Die Adapters

#### AD6



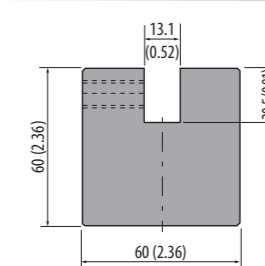
|                |          |         |
|----------------|----------|---------|
| 1000 kN/m max. |          |         |
| 1000 mm        | 39.37 in | 12.0 kg |
| 500 mm         | 19.68 in | 6.0 kg  |

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



#### AD5



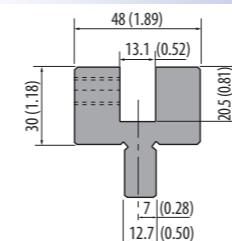
|                |          |         |
|----------------|----------|---------|
| 1000 kN/m max. |          |         |
| 1000 mm        | 39.37 in | 26.1 kg |
| 500 mm         | 19.68 in | 13.0 kg |

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



#### AD8-12.7



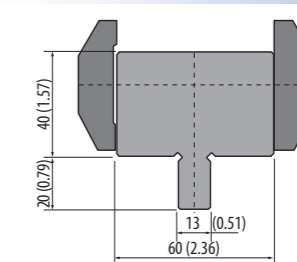
|                |          |         |
|----------------|----------|---------|
| 1000 kN/m max. |          |         |
| 1000 mm        | 39.37 in | 15.0 kg |
| 500 mm         | 19.68 in | 7.5 kg  |

Rolleri Type RX LVD  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>



#### AD7



|                |          |         |
|----------------|----------|---------|
| 1000 kN/m max. |          |         |
| 835 mm         | 32.87 in | 18.0 kg |
| 415 mm         | 16.34 in | 9.0 kg  |

Rolleri Type R2/R3  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



## TOOLS ROLLERI TYPE RX

|  |           |
|--|-----------|
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### Compatibility

Tools Roller Type RX are **compatible** with press brake machines from: EHT, Weinbrenner, American, Gasparini, Ajial-Axial, Colgar, LVD, Colly, Hämmerle-Bystronic, etc.

With **Adapter-Systems** the tools Roller Type RX are also applicable on all other press brake machines.



### Compatibility

Tools Rolleri Type RX are:

- **compatible** with press brake machines from: EHT, Weinbrenner, American, Gasparini, Ajjal-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 248-249)
- very large stock availability

### Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

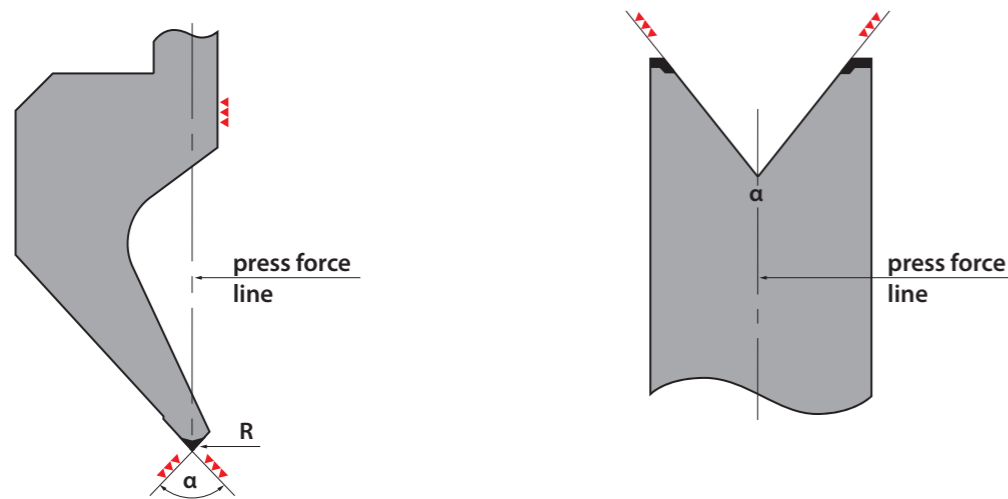
| Material Type | Mechanical resistance of the material and the tool body | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------------|---|--|--|
| 42CrMo4       | 900-1150 N/mm <sup>2</sup>                              | 29.1 - 36.9 HRC                            | 54 - 60 HRC  |
| C45           | 560-710 N/mm <sup>2</sup>                               | 12 - 15.5 HRC                              | 54 - 60 HRC  |

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

### Tang

Punches Rolleri R Type have various tangs.

Indications of precision ground areas:

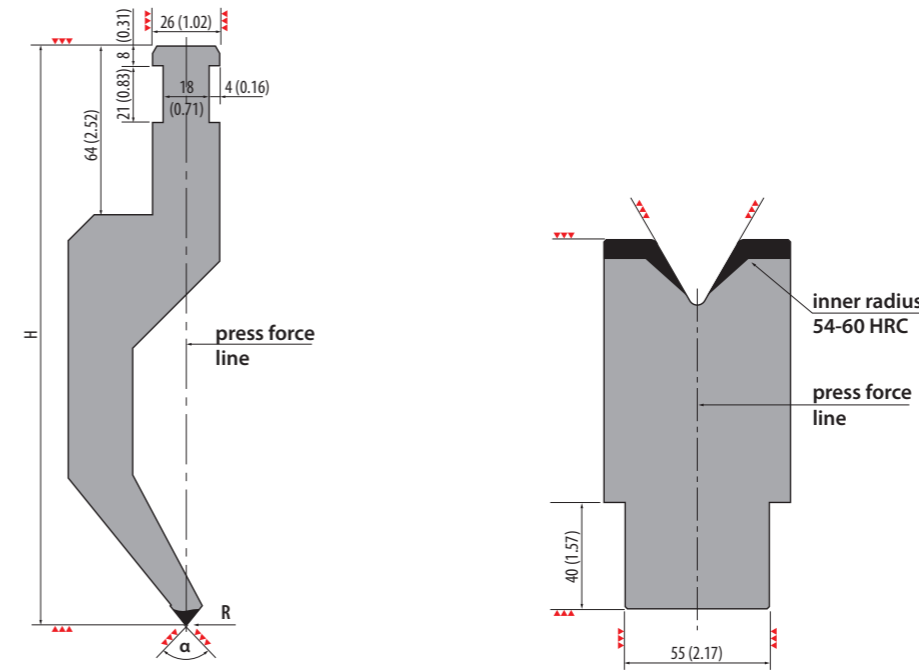


### Tool lengths, sectionings and horn types

- tools Rolleri type RX are available in any length
- customized sectioning available upon your measurements
- customized Horn pieces available upon request

### Explanation

We produce for you the Tools Rolleri Type RX EHT in a vast variety – custom, fast, economic and with precision.

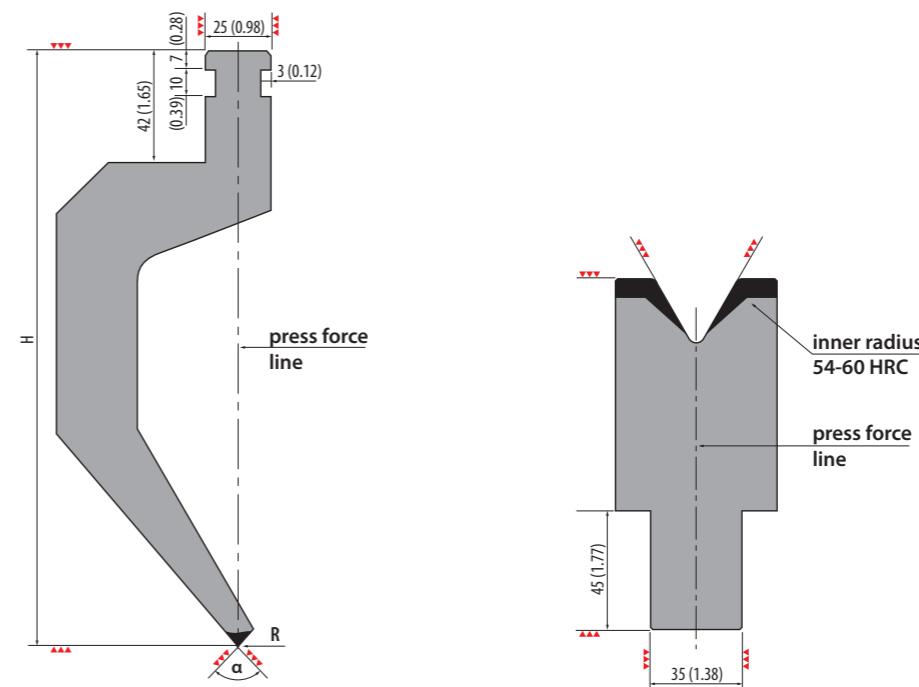


Adapters for Rolleri Type RX EHT see pages 213-220

## Weinbrenner

### Explanation

We produce for you the Tools Rolleri Type RX Weinbrenner in a vast variety – custom, fast, economic and with precision.



Adapters for Rolleri Type RX Weinbrenner see pages 213-221

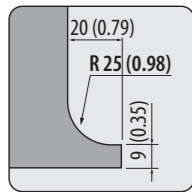
**Tool lengths, sectionings and horn types**

**Punches:**

- 838 mm (33 in)
- 415 mm (16.34 in)
- 805 mm (31.69 in) segmented  
9 segments (100 Horn left, 100, 50, 40, 20, 15, 10, 370, 100 Horn right)

**Dies:**

- 838 mm (33 in)
- 415 mm (16.34 in)
- 805 mm (31.69 in) segmented  
8 segments (200, 50, 40, 20, 15, 10, 370, 100)



**Standard-Horn Type**  
for all segmented  
Punches Rolleri  
Type RX American

**Punches American**

**ASP-135** 900 kN/m max.

|                    |                    |                                |
|--------------------|--------------------|--------------------------------|
| <b>ASP-135-16</b>  |                    | H=125 (4.92) / R=0.4 (0.016)   |
| 838 mm             | 33.00 in           | 21.0 kg                        |
| 415 mm             | 16.34 in           | 10.4 kg                        |
| 805 mm segmented   | 31.69 in segmented | 20.1 kg                        |
| <b>ASP-135-31</b>  |                    | H=125 (4.92) / R=0.8 (0.031)   |
| 838 mm             | 33.00 in           | 21.0 kg                        |
| 415 mm             | 16.34 in           | 10.4 kg                        |
| 805 mm segmented   | 31.69 in segmented | 20.1 kg                        |
| <b>ASP-135-62</b>  |                    | H=124.5 (4.90) / R=1.6 (0.062) |
| 838 mm             | 33.00 in           | 21.0 kg                        |
| 415 mm             | 16.34 in           | 10.4 kg                        |
| 805 mm segmented   | 31.69 in segmented | 20.1 kg                        |
| <b>ASP-135-125</b> |                    | H=123.8 (4.87) / R=3.2 (0.125) |
| 838 mm             | 33.00 in           | 21.0 kg                        |
| 415 mm             | 16.34 in           | 10.4 kg                        |
| 805 mm segmented   | 31.69 in segmented | 20.1 kg                        |

C45: 560-710 N/mm<sup>2</sup>

**ASP-24** 700 kN/m max.

|                   |                    |                                |
|-------------------|--------------------|--------------------------------|
| <b>ASP-24-16</b>  |                    | H=127 (5.00) / R=0.4 (0.016)   |
| 838 mm            | 33.00 in           | 31.8 kg                        |
| 415 mm            | 16.34 in           | 15.8 kg                        |
| 805 mm segmented  | 31.69 in segmented | 30.6 kg                        |
| <b>ASP-24-31</b>  |                    | H=127 (5.00) / R=0.8 (0.031)   |
| 838 mm            | 33.00 in           | 31.8 kg                        |
| 415 mm            | 16.34 in           | 15.8 kg                        |
| 805 mm segmented  | 31.69 in segmented | 30.6 kg                        |
| <b>ASP-24-62</b>  |                    | H=126.5 (4.98) / R=1.6 (0.062) |
| 838 mm            | 33.00 in           | 31.8 kg                        |
| 415 mm            | 16.34 in           | 15.8 kg                        |
| 805 mm segmented  | 31.69 in segmented | 30.6 kg                        |
| <b>ASP-24-125</b> |                    | H=125.9 (4.96) / R=3.2 (0.125) |
| 838 mm            | 33.00 in           | 31.8 kg                        |
| 415 mm            | 16.34 in           | 15.8 kg                        |
| 805 mm segmented  | 31.69 in segmented | 30.6 kg                        |

C45: 560-710 N/mm<sup>2</sup>

Please find the  
Punch Adapters in  
the adapter chapter  
on page 215

**ASP-9** 660 kN/m max.

|                  |                    |                               |
|------------------|--------------------|-------------------------------|
| <b>ASP-9-16</b>  |                    | H=96 (3.78) / R=0.4 (0.016)   |
| 838 mm           | 33.00 in           | 12.8 kg                       |
| 415 mm           | 16.34 in           | 6.2 kg                        |
| 805 mm segmented | 31.69 in segmented | 12.1 kg                       |
| <b>ASP-9-31</b>  |                    | H=96 (3.78) / R=0.8 (0.031)   |
| 838 mm           | 33.00 in           | 12.8 kg                       |
| 415 mm           | 16.34 in           | 6.2 kg                        |
| 805 mm segmented | 31.69 in segmented | 12.1 kg                       |
| <b>ASP-9-63</b>  |                    | H=95.5 (3.76) / R=1.6 (0.062) |
| 838 mm           | 33.00 in           | 12.8 kg                       |
| 415 mm           | 16.34 in           | 6.2 kg                        |
| 805 mm segmented | 31.69 in segmented | 12.1 kg                       |
| <b>ASP-9-125</b> |                    | H=94.8 (3.73) / R=3.2 (0.125) |
| 838 mm           | 33.00 in           | 12.8 kg                       |
| 415 mm           | 16.34 in           | 6.2 kg                        |
| 805 mm segmented | 31.69 in segmented | 12.1 kg                       |

C45: 560-710 N/mm<sup>2</sup>

**ASP-15** 1000 kN/m max.

|                   |                    |               |
|-------------------|--------------------|---------------|
| <b>ASP-15-16</b>  |                    | R=0.4 (0.016) |
| 838 mm            | 33.00 in           | 13.4 kg       |
| 415 mm            | 16.34 in           | 6.6 kg        |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg       |
| <b>ASP-15-31</b>  |                    | R=0.8 (0.031) |
| 838 mm            | 33.00 in           | 13.4 kg       |
| 415 mm            | 16.34 in           | 6.6 kg        |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg       |
| <b>ASP-15-63</b>  |                    | R=1.6 (0.063) |
| 838 mm            | 33.00 in           | 13.4 kg       |
| 415 mm            | 16.34 in           | 6.6 kg        |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg       |
| <b>ASP-15-98</b>  |                    | R=2.5 (0.098) |
| 838 mm            | 33.00 in           | 13.4 kg       |
| 415 mm            | 16.34 in           | 6.6 kg        |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg       |
| <b>ASP-15-125</b> |                    | 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       |

C45: 560-710 N/mm<sup>2</sup>

**ASP-14** 1000 kN/m max.

|                   |                    |                                |
|-------------------|--------------------|--------------------------------|
| <b>ASP-14-16</b>  |                    | H=127 (5.00) / R=0.4 (0.016)   |
| 838 mm            | 33.00 in           | 13.4 kg                        |
| 415 mm            | 16.34 in           | 6.6 kg                         |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg                        |
| <b>ASP-14-31</b>  |                    | H=127 (5.00) / R=0.8 (0.031)   |
| 838 mm            | 33.00 in           | 13.4 kg                        |
| 415 mm            | 16.34 in           | 6.6 kg                         |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg                        |
| <b>ASP-14-62</b>  |                    | H=126.5 (4.98) / R=1.6 (0.062) |
| 838 mm            | 33.00 in           | 13.4 kg                        |
| 415 mm            | 16.34 in           | 6.6 kg                         |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg                        |
| <b>ASP-14-125</b> |                    | H=126 (4.96) / R=3.2 (0.125)   |
| 838 mm            | 33.00 in           | 13.4 kg                        |
| 415 mm            | 16.34 in           | 6.6 kg                         |
| 805 mm segmented  | 31.69 in segmented | 12.9 kg                        |

C45: 560-710 N/mm<sup>2</sup>

**ASP-18** 1000 kN/m max.

|                   |                    |                               |
|-------------------|--------------------|-------------------------------|
| <b>ASP-18-31</b>  |                    | H=96 (3.78) / R=0.8 (0.031)   |
| 838 mm            | 33.00 in           | 10.9 kg                       |
| 415 mm            | 16.34 in           | 5.4 kg                        |
| 805 mm segmented  | 31.69 in segmented | 10.5 kg                       |
| <b>ASP-18-62</b>  |                    | H=93.4 (3.68) / R=1.6 (0.062) |
| 838 mm            | 33.00 in           | 10.9 kg                       |
| 415 mm            | 16.34 in           | 5.4 kg                        |
| 805 mm segmented  | 31.69 in segmented | 10.5 kg                       |
| <b>ASP-18-125</b> |                    | H=87.5 (3.44) / R=3.2 (0.125) |
| 838 mm            | 33.00 in           | 10.9 kg                       |
| 415 mm            | 16.34 in           | 5.4 kg                        |
| 805 mm segmented  | 31.69 in segmented | 10.5 kg                       |

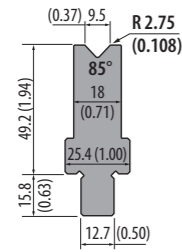
C45: 560-710 N/mm<sup>2</sup>

**ASP-19** 860 kN/m max.

|                   |                    |                                |
|-------------------|--------------------|--------------------------------|
| <b>ASP-19-31</b>  |                    | H=127 (5.00) / R=0.8 (0.031)   |
| 838 mm            | 33.00 in           | 13.8 kg                        |
| 415 mm            | 16.34 in           | 6.8 kg                         |
| 805 mm segmented  | 31.69 in segmented | 13.3 kg                        |
| <b>ASP-19-62</b>  |                    | H=124.5 (4.90) / R=1.6 (0.062) |
| 838 mm            | 33.00 in           | 13.8 kg                        |
| 415 mm            | 16.34 in           | 6.8 kg                         |
| 805 mm segmented  | 31.69 in segmented | 13.3 kg                        |
| <b>ASP-19-125</b> |                    | H=118.5 (4.67) / R=3.2 (0.125) |
| 838 mm            | 33.00 in           | 13.8 kg                        |
| 415 mm            | 16.34 in           | 6.8 kg                         |
| 805 mm segmented  | 31.69 in segmented | 13.3 kg                        |

C45: 560-710 N/mm<sup>2</sup>

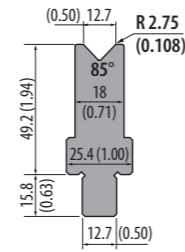
**ASD-85-375** 1000 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 838 mm           | 33.00 in           | 8.0 kg |
| 415 mm           | 16.34 in           | 3.9 kg |
| 805 mm segmented | 31.69 in segmented | 7.6 kg |

C45: 560-710 N/mm<sup>2</sup>

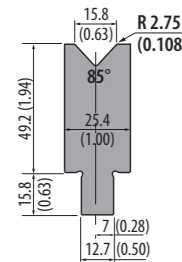
**ASD-85-500** 1000 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 838 mm           | 33.00 in           | 8.0 kg |
| 415 mm           | 16.34 in           | 3.9 kg |
| 805 mm segmented | 31.69 in segmented | 7.6 kg |

C45: 560-710 N/mm<sup>2</sup>

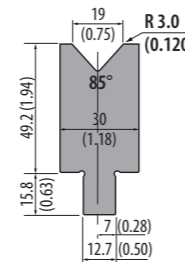
**ASD-85-625** 1000 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 838 mm           | 33.00 in           | 9.2 kg |
| 415 mm           | 16.34 in           | 4.6 kg |
| 805 mm segmented | 31.69 in segmented | 8.9 kg |

C45: 560-710 N/mm<sup>2</sup>

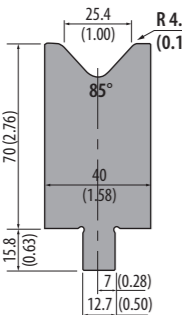
**ASD-85-750** 1080 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 838 mm           | 33.00 in           | 10.5 kg |
| 415 mm           | 16.34 in           | 5.2 kg  |
| 805 mm segmented | 31.69 in segmented | 10.1 kg |

C45: 560-710 N/mm<sup>2</sup>

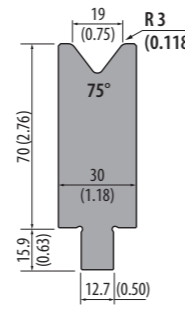
**ASD-85-100** 950 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 838 mm           | 33.00 in           | 17.6 kg |
| 415 mm           | 16.34 in           | 8.7 kg  |
| 805 mm segmented | 31.69 in segmented | 19.9 kg |

C45: 560-710 N/mm<sup>2</sup>

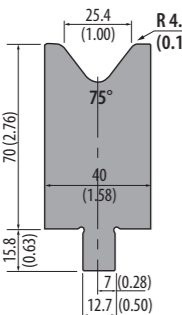
**ASD-75-750** 1000 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 838 mm           | 33.00 in           | 14.7 kg |
| 415 mm           | 16.34 in           | 7.3 kg  |
| 805 mm segmented | 31.69 in segmented | 14.1 kg |

C45: 560-710 N/mm<sup>2</sup>

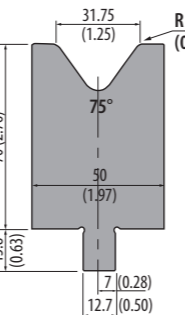
**ASD-75-100** 950 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 838 mm           | 33.00 in           | 17.6 kg |
| 415 mm           | 16.34 in           | 8.7 kg  |
| 805 mm segmented | 31.69 in segmented | 16.9 kg |

C45: 560-710 N/mm<sup>2</sup>

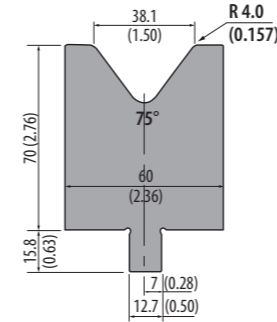
**ASD-75-125** 1000 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 838 mm           | 33.00 in           | 22.2 kg |
| 415 mm           | 16.34 in           | 11.0 kg |
| 805 mm segmented | 31.69 in segmented | 21.3 kg |

C45: 560-710 N/mm<sup>2</sup>

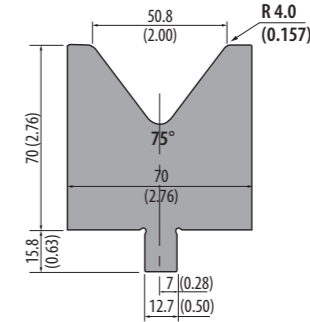
**ASD-75-150** 1000 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 838 mm           | 33.00 in           | 25.6 kg |
| 415 mm           | 16.34 in           | 12.7 kg |
| 805 mm segmented | 31.69 in segmented | 24.6 kg |

C45: 560-710 N/mm<sup>2</sup>

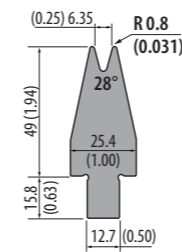
**ASD-75-200** 1000 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 838 mm           | 33.00 in           | 27.7 kg |
| 415 mm           | 16.34 in           | 13.7 kg |
| 805 mm segmented | 31.69 in segmented | 25.6 kg |

C45: 560-710 N/mm<sup>2</sup>

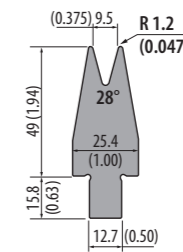
**ASD-28-250** 450 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 838 mm           | 33.00 in           | 7.2 kg |
| 415 mm           | 16.34 in           | 3.6 kg |
| 805 mm segmented | 31.69 in segmented | 6.9 kg |

C45: 560-710 N/mm<sup>2</sup>

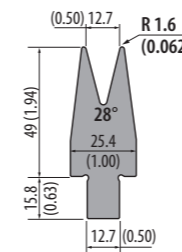
**ASD-28-375** 600 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 838 mm           | 33.00 in           | 7.8 kg |
| 415 mm           | 16.34 in           | 3.9 kg |
| 805 mm segmented | 31.69 in segmented | 7.5 kg |

C45: 560-710 N/mm<sup>2</sup>

**ASD-28-500** 860 kN/m max.



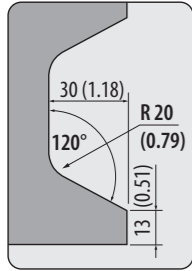
|                  |                    |        |
|------------------|--------------------|--------|
| 838 mm           | 33.00 in           | 8.4 kg |
| 415 mm           | 16.34 in           | 4.2 kg |
| 805 mm segmented | 31.69 in segmented | 8.1 kg |

C45: 560-710 N/mm<sup>2</sup>

## Tool lengths, sectionings and horn types

### Punches:

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented  
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 500 mm (19.68 in) segmented  
3 segments (100 Horn left, 300, 100 Horn right)



Standard-Horn Type  
for all segmented  
Punches Rolleri  
Type RX Gasparini

### Radius Tools Holder:

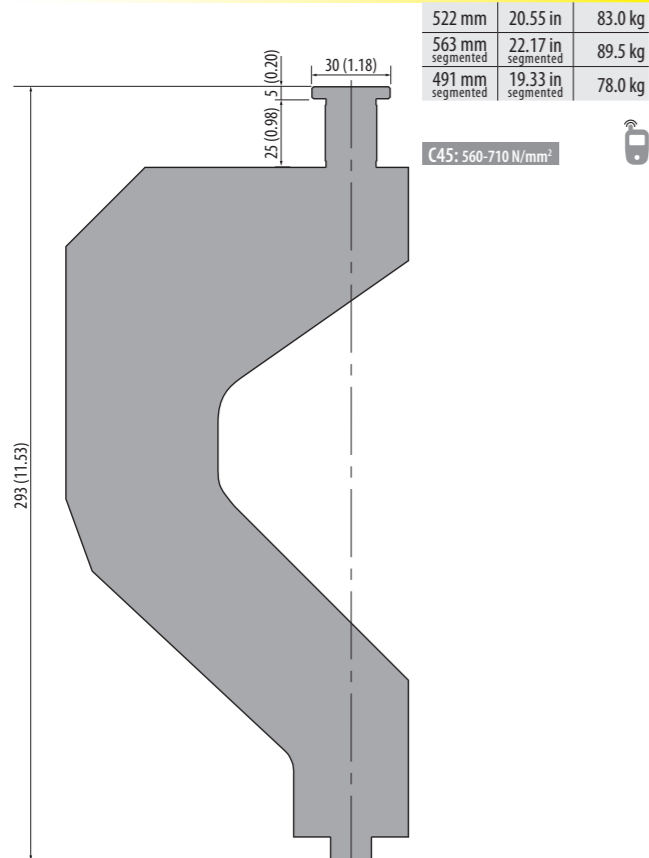
- 522 mm (20.55 in)
- 563 mm (22.17 in) segmented  
9 segments (42, 47, 52, 57, 62, 67, 72, 77, 87)
- 491 mm (19.33 in) segmented  
3 segments (97, 297, 97)

### Radius Tools:

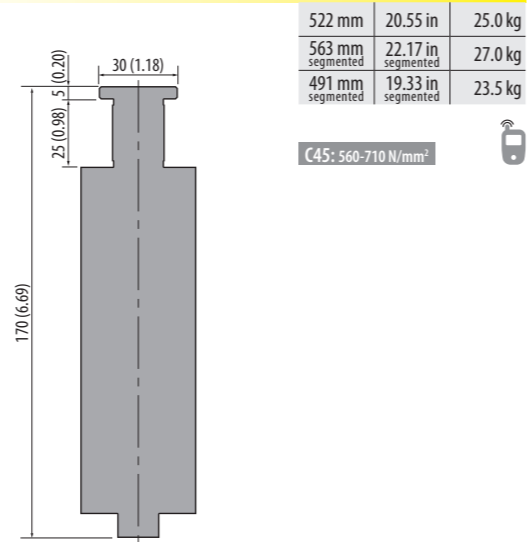
- 525 mm (20.67 in)
- 590 mm (23.23 in) segmented  
9 segments (45, 50, 55, 60, 65, 70, 75, 80, 90)
- 500 mm (19.68 in) segmented  
3 segments (100, 300, 100)

## Radius Tools Gasparini

### GASP293-16 1000 kN/m max.



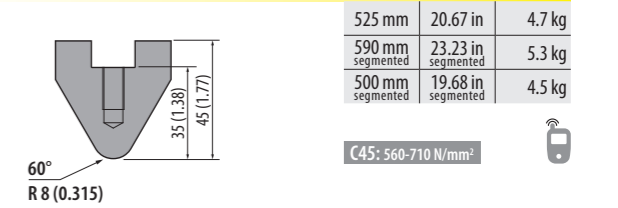
### GASP170-16 1800 kN/m max.



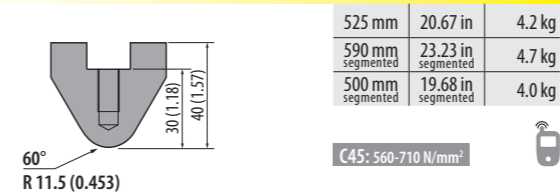
### GASP40.60.03 1000 kN/m max.



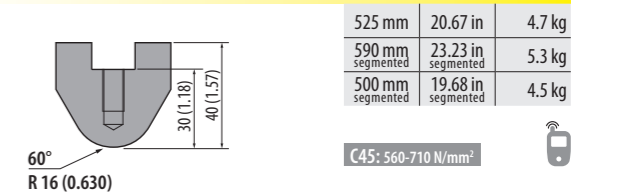
### GASP35.60.08 1000 kN/m max.



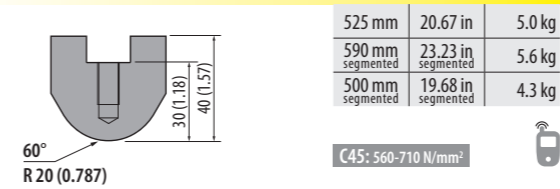
### GASP30.60.11.5 1000 kN/m max.



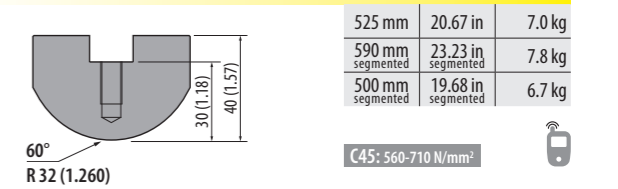
### GASP30.60.16 1000 kN/m max.



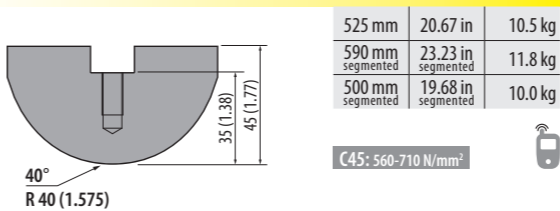
### GASP30.60.20 1000 kN/m max.



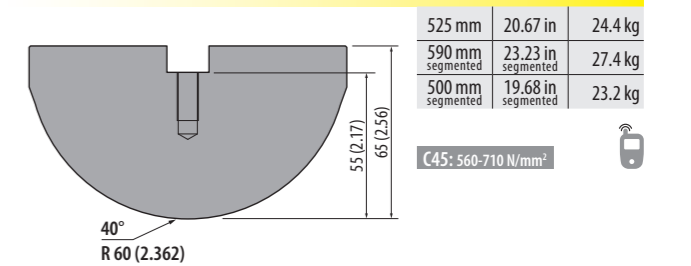
### GASP30.60.32 1000 kN/m max.



### GASP35.40.40 1500 kN/m max.



### GASP55.40.60 1800 kN/m max.

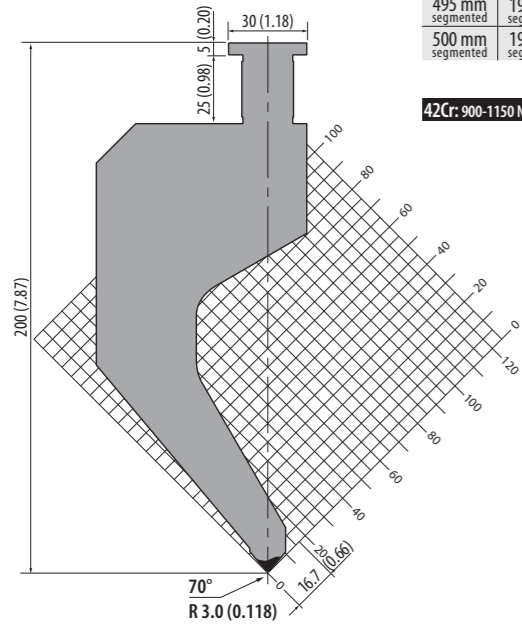


### GASP200.70.R3-30

1000 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 31.8 kg |
| 495 mm segmented | 19.49 in segmented | 30.0 kg |
| 500 mm segmented | 19.68 in segmented | 30.3 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



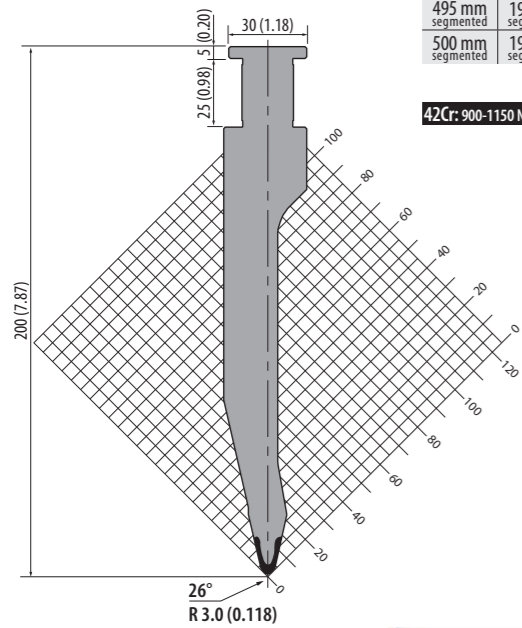
Many more tools available for Heavy Duty on pages 234-235

### GASP200.26.R3-30

1300 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 16.9 kg |
| 495 mm segmented | 19.49 in segmented | 10.6 kg |
| 500 mm segmented | 19.68 in segmented | 10.7 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

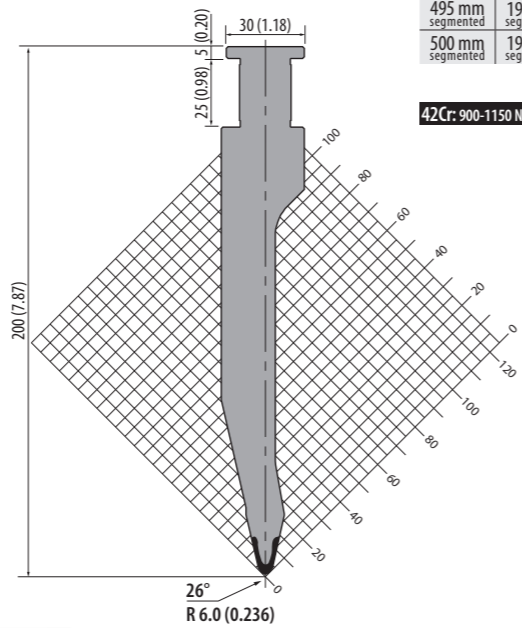


### GASP200.26.R6-30

1300 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 16.9 kg |
| 495 mm segmented | 19.49 in segmented | 10.6 kg |
| 500 mm segmented | 19.68 in segmented | 10.7 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

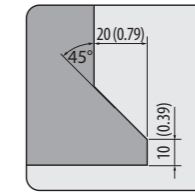


Many more tools available upon request. Compatible adapters see pages 213 and 217

### Tool lengths, sectionings and horn types

Punches:

- 1020 mm (40.16 in)
- 990 mm (38.98 in) segmented  
9 segments (100 Horn left, 500, 100, 50, 45, 40, 35, 20, 100 Horn right)



Standard-Horn Pieces for all segmented Punches Rolleri Type RX Ajial-Axial

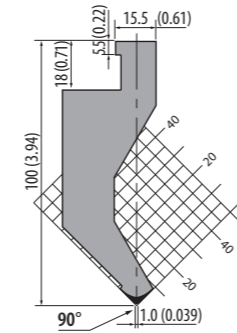
### Punches Ajial-Axial

#### AXP.100.90.1

1000 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 1020 mm          | 40.16 in           | 16.3 kg |
| 990 mm segmented | 38.98 in segmented | 15.8 kg |

C45: 560-710 N/mm<sup>2</sup>

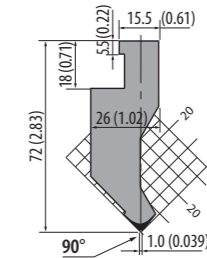


#### AXP.72.90.1

1000 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 1020 mm          | 40.16 in           | 10.0 kg |
| 990 mm segmented | 38.98 in segmented | 9.7 kg  |

C45: 560-710 N/mm<sup>2</sup>

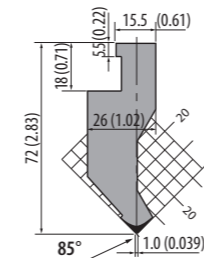


#### AXP.72.85.1

1000 kN/m max.

|                  |                    |         |
|------------------|--------------------|---------|
| 1020 mm          | 40.16 in           | 10.0 kg |
| 990 mm segmented | 38.98 in segmented | 9.7 kg  |

C45: 560-710 N/mm<sup>2</sup>

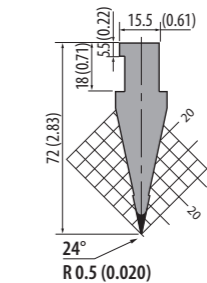


#### AXP.72.24.R05

1000 kN/m max.

|                  |                    |        |
|------------------|--------------------|--------|
| 1020 mm          | 40.16 in           | 7.1 kg |
| 990 mm segmented | 38.98 in segmented | 6.9 kg |

C45: 560-710 N/mm<sup>2</sup>



### Adapters Ajial-Axial

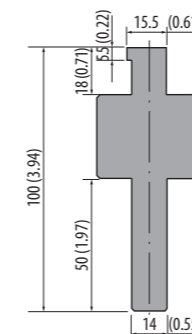
#### AD15

1000 kN/m max.

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 4.0 kg |
|--------|---------|--------|

Rolleri Type RX Ajial-Axial → Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



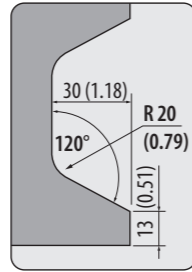
More Punches and Dies available upon request. Compatible Adapter see pages 217



**Tool lengths, sectionings and horn types**

**Punches:**

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented  
8 segments (25, 30, 35, 40, 45, 50, 100, 170)
- 500 mm (19.68 in) segmented  
3 segments (100 Horn left, 300, 100 Horn right)



**Standard-Horn Pieces**  
for all segmented  
**Punches Rolleri**  
**Type RX Colgar**



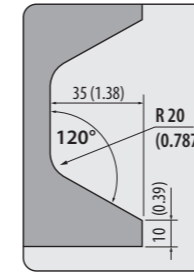
**Tool lengths, sectionings and horn types**

**Punches:**

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented  
9 segments  
(100 Horn left, 25, 30, 35, 40, 45, 50, 125, 100 Horn right)

**Dies:**

- 508 mm (20.00 in)
- 550 mm (21.65 in) segmented  
9 segments (25, 25, 30, 35, 40, 45, 50, 100, 200)



**Standard-Horn Pieces**  
for all segmented  
**Punches Rolleri**  
**Type RX LVD**

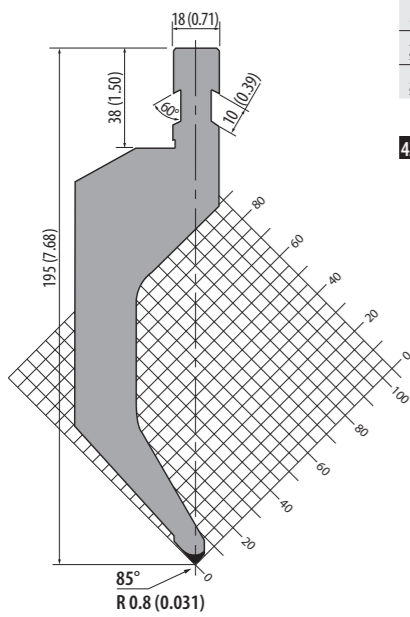
**Hemming Tools:**

- 525 mm (20.67 in)
- 495 mm (19.49 in) segmented  
8 segments (25, 30, 35, 40, 45, 50, 100, 170)

**Punches and Radius Tools Colgar**

**PAC195.85.R08**

1000 kN/m max.

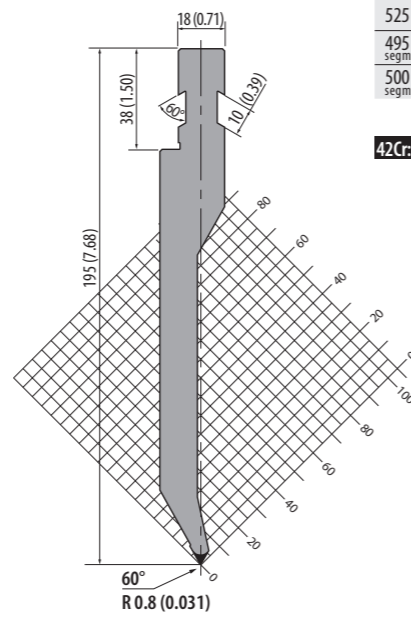


|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 20.6 kg |
| 495 mm segmented | 19.49 in segmented | 19.4 kg |
| 500 mm segmented | 19.68 in segmented | 19.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**PAC195.60.R08**

1000 kN/m max.

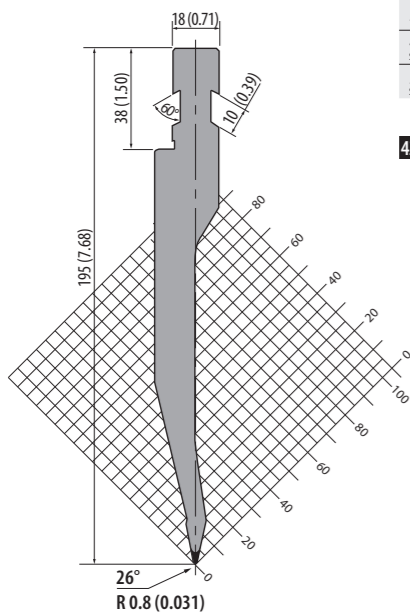


|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 12.0 kg |
| 495 mm segmented | 19.49 in segmented | 11.3 kg |
| 500 mm segmented | 19.68 in segmented | 11.4 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**PAC195.26.R08**

1000 kN/m max.

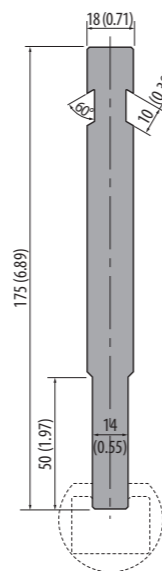


|                  |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 12.0 kg |
| 495 mm segmented | 19.49 in segmented | 11.3 kg |
| 500 mm segmented | 19.68 in segmented | 11.4 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**PAC175.14**

1000 kN/m max.



|        |          |         |
|--------|----------|---------|
| 830 mm | 32.68 in | 18.0 kg |
| 412 mm | 16.22 in | 9.0 kg  |

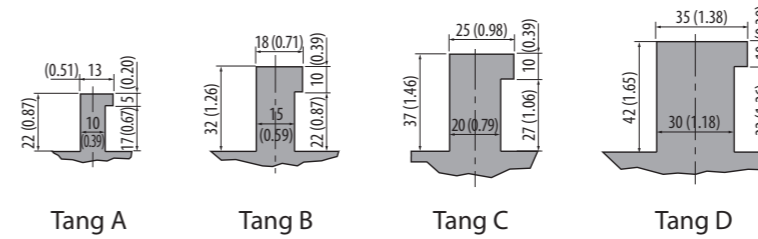
C45: 560-710 N/mm<sup>2</sup>

Compatible  
Radius holders  
see page 33

More Punches and Dies  
available upon request.  
Compatible adapter  
see pages 213, 216

**Punch Tangs**

Punches LVD have the following  
4 different tangs

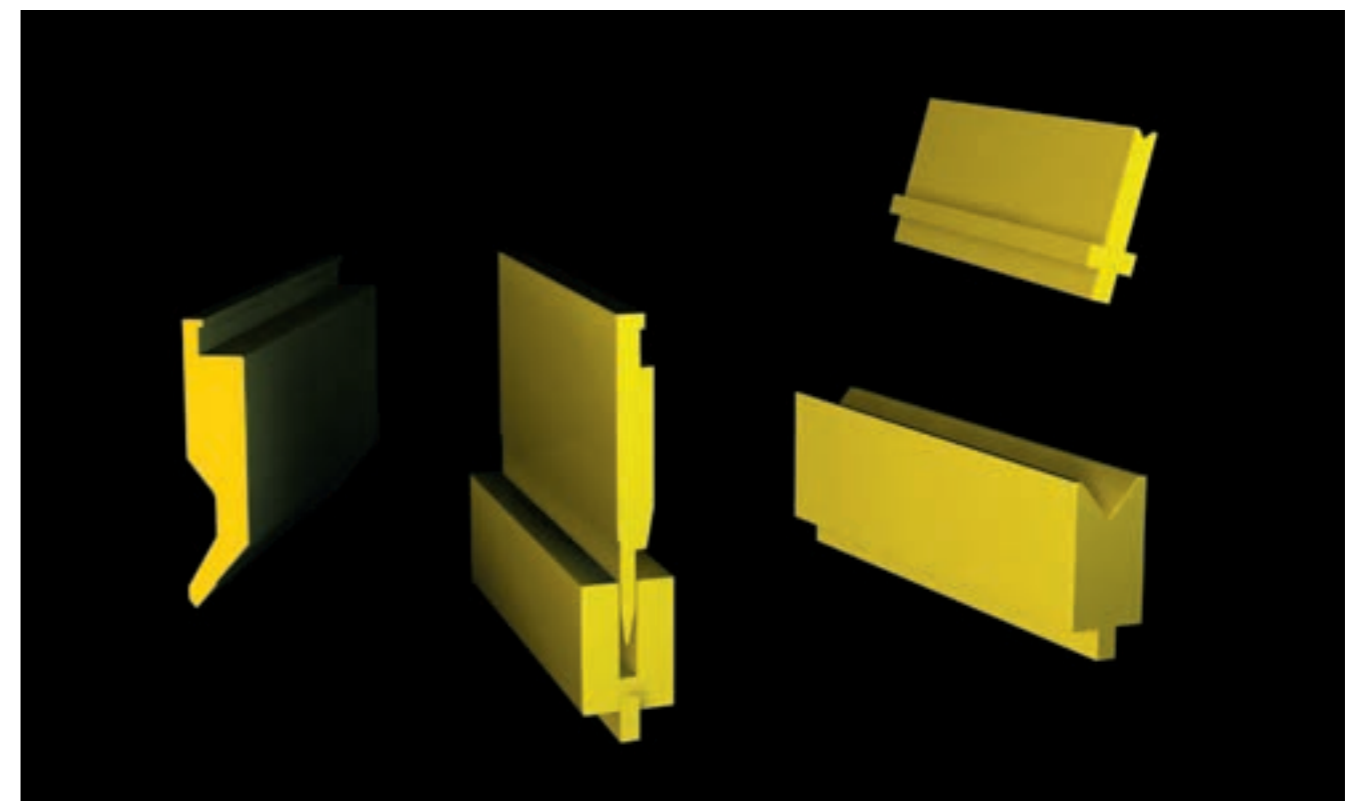


Tang A

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/mm<sup>2</sup>

**LP180.78.R1-B** 450 kN/m max.

| Tang A: LPA180.78.R1-B |                    |         |
|------------------------|--------------------|---------|
| 508 mm                 | 20.00 in           | 22.0 kg |
| 550 mm segmented       | 21.65 in segmented | 24.0 kg |
| Tang B: LPB180.78.R1-B |                    |         |
| 508 mm                 | 20.00 in           | 22.0 kg |
| 550 mm segmented       | 21.65 in segmented | 24.0 kg |
| Tang C: LPC180.78.R1-B |                    |         |
| 508 mm                 | 20.00 in           | 22.0 kg |
| 550 mm segmented       | 21.65 in segmented | 24.0 kg |
| Tang D: LPD180.78.R1-B |                    |         |
| 508 mm                 | 20.00 in           | 22.0 kg |
| 550 mm segmented       | 21.65 in segmented | 24.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP180.78.R1-C** 500 kN/m max.

| Tang A: LPA180.78.R1-C |                    |         |
|------------------------|--------------------|---------|
| 508 mm                 | 20.00 in           | 11.0 kg |
| 550 mm segmented       | 21.65 in segmented | 12.0 kg |
| Tang B: LPB180.78.R1-C |                    |         |
| 508 mm                 | 20.00 in           | 11.0 kg |
| 550 mm segmented       | 21.65 in segmented | 12.0 kg |
| Tang C: LPC180.78.R1-C |                    |         |
| 508 mm                 | 20.00 in           | 11.0 kg |
| 550 mm segmented       | 21.65 in segmented | 12.0 kg |
| Tang D: LPD180.78.R1-C |                    |         |
| 508 mm                 | 20.00 in           | 11.0 kg |
| 550 mm segmented       | 21.65 in segmented | 12.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP180.78-R2** 1000 kN/m max.

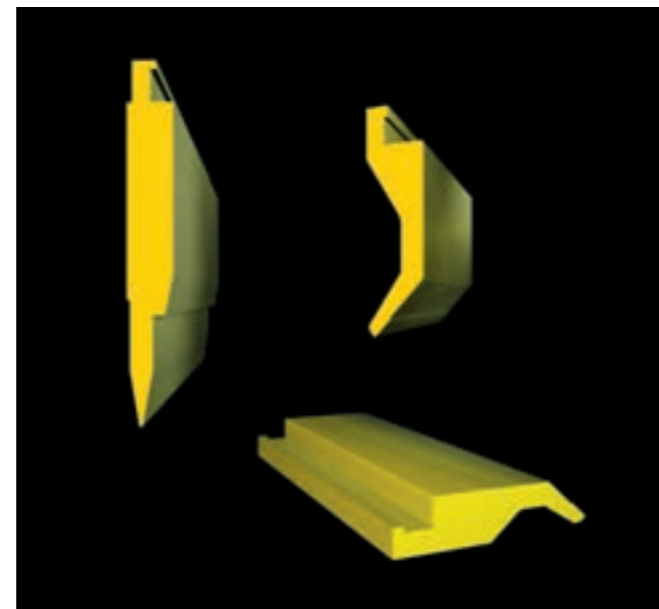
| Tang A: LPA180.78-R2 |                    |        |
|----------------------|--------------------|--------|
| 508 mm               | 20.00 in           | 9.0 kg |
| 550 mm segmented     | 21.65 in segmented | 9.7 kg |
| Tang B: LPB180.78-R2 |                    |        |
| 508 mm               | 20.00 in           | 9.0 kg |
| 550 mm segmented     | 21.65 in segmented | 9.7 kg |
| Tang C: LPC180.78-R2 |                    |        |
| 508 mm               | 20.00 in           | 9.0 kg |
| 550 mm segmented     | 21.65 in segmented | 9.7 kg |
| Tang D: LPD180.78-R2 |                    |        |
| 508 mm               | 20.00 in           | 9.0 kg |
| 550 mm segmented     | 21.65 in segmented | 9.7 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP180.26-R1** 500 kN/m max.

| Tang A: LPA180.26-R1 |                    |         |
|----------------------|--------------------|---------|
| 508 mm               | 20.00 in           | 9.0 kg  |
| 550 mm segmented     | 21.65 in segmented | 10.0 kg |
| Tang B: LPB180.26-R1 |                    |         |
| 508 mm               | 20.00 in           | 9.0 kg  |
| 550 mm segmented     | 21.65 in segmented | 10.0 kg |
| Tang C: LPC180.26-R1 |                    |         |
| 508 mm               | 20.00 in           | 9.0 kg  |
| 550 mm segmented     | 21.65 in segmented | 10.0 kg |
| Tang D: LPD180.26-R1 |                    |         |
| 508 mm               | 20.00 in           | 9.0 kg  |
| 550 mm segmented     | 21.65 in segmented | 10.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>



**LP.SP-190.20.8**

| Tang A: LPA.SP-190.20.8 |                    |         |
|-------------------------|--------------------|---------|
| 525 mm                  | 20.67 in           | 13.4 kg |
| 495 mm segmented        | 19.49 in segmented | 12.6 kg |
| Tang B: LPB.SP-190.20.8 |                    |         |
| 525 mm                  | 20.67 in           | 13.4 kg |
| 495 mm segmented        | 19.49 in segmented | 12.6 kg |
| Tang C: LPC.SP-190.20.8 |                    |         |
| 525 mm                  | 20.67 in           | 13.4 kg |
| 495 mm segmented        | 19.49 in segmented | 12.6 kg |
| Tang D: LPD.SP-190.20.8 |                    |         |
| 525 mm                  | 20.67 in           | 13.4 kg |
| 495 mm segmented        | 19.49 in segmented | 12.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP.SP-190.20.10**

| Tang A: LPA.SP-190.20.10 |                    |         |
|--------------------------|--------------------|---------|
| 525 mm                   | 20.67 in           | 13.1 kg |
| 495 mm segmented         | 19.49 in segmented | 12.3 kg |
| Tang B: LPB.SP-190.20.10 |                    |         |
| 525 mm                   | 20.67 in           | 13.1 kg |
| 495 mm segmented         | 19.49 in segmented | 12.3 kg |
| Tang C: LPC.SP-190.20.10 |                    |         |
| 525 mm                   | 20.67 in           | 13.1 kg |
| 495 mm segmented         | 19.49 in segmented | 12.3 kg |
| Tang D: LPD.SP-190.20.10 |                    |         |
| 525 mm                   | 20.67 in           | 13.1 kg |
| 495 mm segmented         | 19.49 in segmented | 12.3 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP.SP-190.20.12**

| Tang A: LPA.SP-190.20.12 |                    |         |
|--------------------------|--------------------|---------|
| 525 mm                   | 20.67 in           | 13.6 kg |
| 495 mm segmented         | 19.49 in segmented | 12.8 kg |
| Tang B: LPB.SP-190.20.12 |                    |         |
| 525 mm                   | 20.67 in           | 13.6 kg |
| 495 mm segmented         | 19.49 in segmented | 12.8 kg |
| Tang C: LPC.SP-190.20.12 |                    |         |
| 525 mm                   | 20.67 in           | 13.6 kg |
| 495 mm segmented         | 19.49 in segmented | 12.8 kg |
| Tang D: LPD.SP-190.20.12 |                    |         |
| 525 mm                   | 20.67 in           | 13.6 kg |
| 495 mm segmented         | 19.49 in segmented | 12.8 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP.SM-190.20.8-12.7 / -12**

| B=12.7 mm        |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 18.7 kg |
| 495 mm segmented | 19.49 in segmented | 17.7 kg |
| B=12 mm          |                    |         |
| 525 mm           | 20.67 in           | 18.7 kg |
| 495 mm segmented | 19.49 in segmented | 17.7 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP.SM-190.20.10-12.7 / -12**

| B=12.7 mm        |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 18.3 kg |
| 495 mm segmented | 19.49 in segmented | 17.2 kg |
| B=12 mm          |                    |         |
| 525 mm           | 20.67 in           | 18.3 kg |
| 495 mm segmented | 19.49 in segmented | 17.2 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LP.SM-190.20.12-12.7 / -12**

| B=12.7 mm        |                    |         |
|------------------|--------------------|---------|
| 525 mm           | 20.67 in           | 17.8 kg |
| 495 mm segmented | 19.49 in segmented | 16.7 kg |
| B=12 mm          |                    |         |
| 525 mm           | 20.67 in           | 17.8 kg |
| 495 mm segmented | 19.49 in segmented | 16.7 kg |

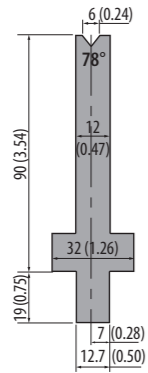
42Cr: 900-1150 N/mm<sup>2</sup>

**Example of Application**

| S    | S    | A   | A    | R.45                | R.70 | S    | S    | A   | A    | R.45                | R.70 |
|------|------|-----|------|---------------------|------|------|------|-----|------|---------------------|------|
| mm   | in   | mm  | in   | Kgf/mm <sup>2</sup> | t/m  | mm   | in   | mm  | in   | Kgf/mm <sup>2</sup> | t/m  |
| 0.6  | 0.02 | 3.0 | 0.12 | 9                   | 15   | 0.6  | 0.02 | 1.2 | 0.05 | 23                  | 35   |
| 0.8  | 0.03 | 3.0 | 0.12 | 12                  | 20   | 0.8  | 0.03 | 1.6 | 0.06 | 32                  | 50   |
| 1.0  | 0.04 | 3.5 | 0.14 | 15                  | 25   | 1.0  | 0.04 | 1.0 | 0.04 | 40                  | 60   |
| 1.25 | 0.05 | 3.5 | 0.14 | 17                  | 26   | 1.25 | 0.05 | 2.5 | 0.10 | 50                  | 80   |

**LM90.06.78**

400 kN/m max.

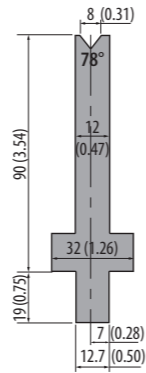


|                  |                    |        |
|------------------|--------------------|--------|
| 508 mm           | 20.00 in           | 8.0 kg |
| 550 mm segmented | 21.65 in segmented | 8.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.08.78**

400 kN/m max.

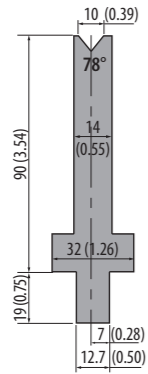


|                  |                    |        |
|------------------|--------------------|--------|
| 508 mm           | 20.00 in           | 8.0 kg |
| 550 mm segmented | 21.65 in segmented | 8.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.10.78**

500 kN/m max.

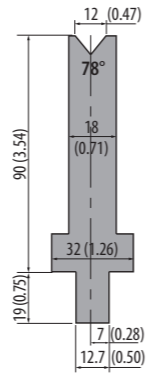


|                  |                    |        |
|------------------|--------------------|--------|
| 508 mm           | 20.00 in           | 7.0 kg |
| 550 mm segmented | 21.65 in segmented | 7.5 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.12.78**

600 kN/m max.

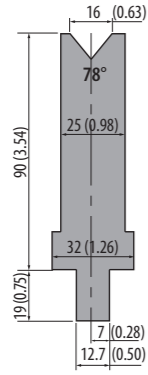


|                  |                    |        |
|------------------|--------------------|--------|
| 508 mm           | 20.00 in           | 8.0 kg |
| 550 mm segmented | 21.65 in segmented | 8.7 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.16.78**

800 kN/m max.

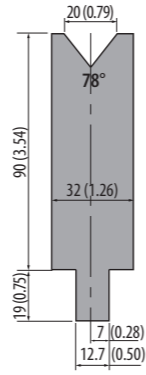


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 10.0 kg |
| 550 mm segmented | 21.65 in segmented | 10.8 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.20.78**

1000 kN/m max.

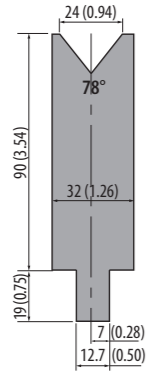


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 11.9 kg |
| 550 mm segmented | 21.65 in segmented | 12.8 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.24.78**

1000 kN/m max.

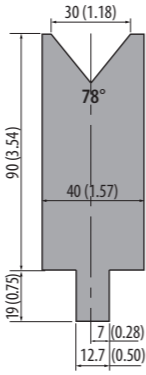


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 10.0 kg |
| 550 mm segmented | 21.65 in segmented | 10.8 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.30.78**

1100 kN/m max.

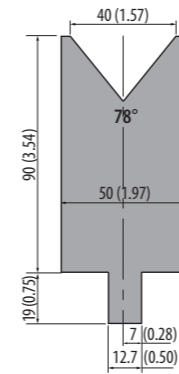


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 12.0 kg |
| 550 mm segmented | 21.65 in segmented | 13.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.40.78**

1300 kN/m max.

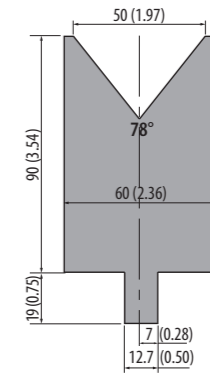


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 13.0 kg |
| 550 mm segmented | 21.65 in segmented | 14.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.50.78**

1500 kN/m max.

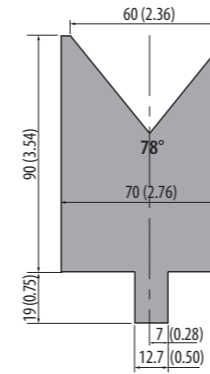


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 19.5 kg |
| 550 mm segmented | 21.65 in segmented | 21.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.60.78**

1500 kN/m max.

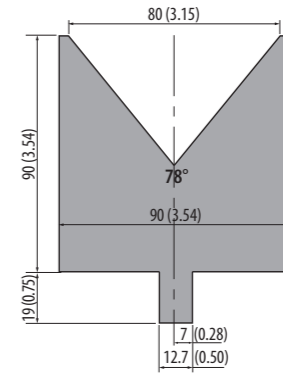


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 23.0 kg |
| 550 mm segmented | 21.65 in segmented | 24.9 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.80.78**

1500 kN/m max.

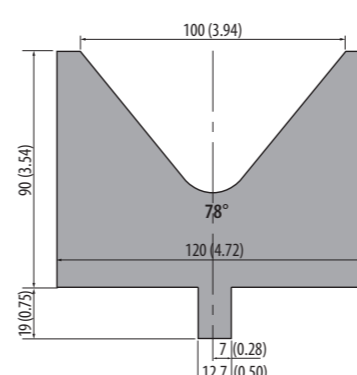


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 25.5 kg |
| 550 mm segmented | 21.65 in segmented | 27.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**LM90.100.78**

1200 kN/m max.



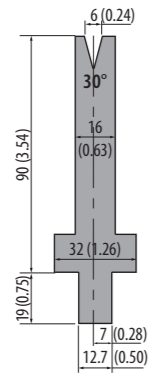
|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 31.0 kg |
| 550 mm segmented | 21.65 in segmented | 33.5 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

**NEW**

Articles on stock – Please note that delivery time varies according to your location.

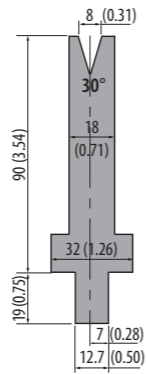
### LM90.06.30 200 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 508 mm           | 20.00 in           | 8.0 kg |
| 550 mm segmented | 21.65 in segmented | 8.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

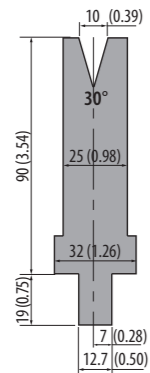
### LM90.08.30 220 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 508 mm           | 20.00 in           | 8.0 kg |
| 550 mm segmented | 21.65 in segmented | 8.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

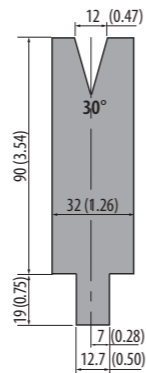
### LM90.10.30 300 kN/m max.



|                  |                    |        |
|------------------|--------------------|--------|
| 508 mm           | 20.00 in           | 8.0 kg |
| 550 mm segmented | 21.65 in segmented | 8.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

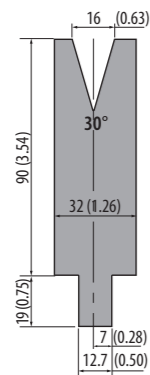
### LM90.12.30 380 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 11.9 kg |
| 550 mm segmented | 21.65 in segmented | 12.6 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

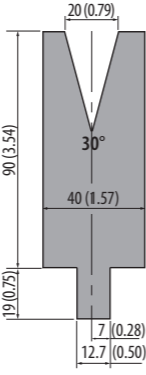
### LM90.16.30 380 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 11.5 kg |
| 550 mm segmented | 21.65 in segmented | 12.4 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

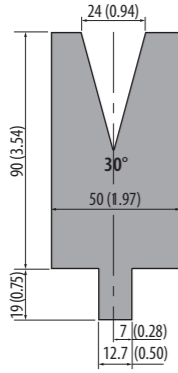
### LM90.20.30 380 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 13.8 kg |
| 550 mm segmented | 21.65 in segmented | 15.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

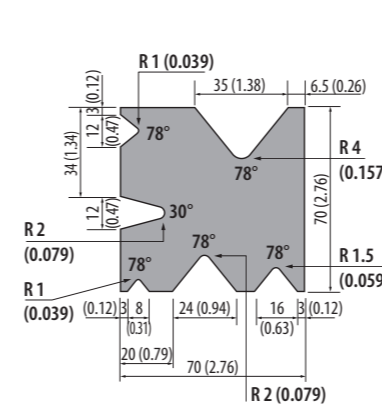
### LM90.24.30 550 kN/m max.



|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 13.0 kg |
| 550 mm segmented | 21.65 in segmented | 14.0 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

### LM70

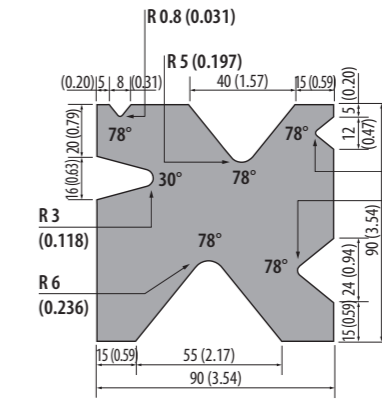


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 16.8 kg |
| 550 mm segmented | 21.65 in segmented | 18.2 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

|           | V1        | V2        | V3        | V4        | V5        | V6       |
|-----------|-----------|-----------|-----------|-----------|-----------|----------|
| V mm      | 12 (0.47) | 12 (0.47) | 35 (1.38) | 24 (0.94) | 16 (0.63) | 8 (0.31) |
| Angle     | 30°       | 78°       | 78°       | 78°       | 78°       | 78°      |
| kN/m max. | 1300      | 600       | 1300      | 1200      | 950       | 500      |

### LM90

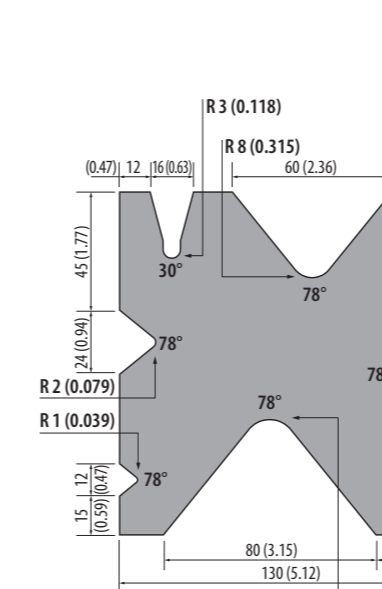


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 25.4 kg |
| 550 mm segmented | 21.65 in segmented | 27.5 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

|           | V1       | V2        | V3        | V4        | V5        | V6        |
|-----------|----------|-----------|-----------|-----------|-----------|-----------|
| V mm      | 8 (0.31) | 40 (1.57) | 12 (0.47) | 24 (0.94) | 55 (2.17) | 16 (0.63) |
| Angle     | 78°      | 78°       | 78°       | 78°       | 78°       | 30°       |
| kN/m max. | 550      | 1400      | 550       | 650       | 1000      | 1000      |

### LM130

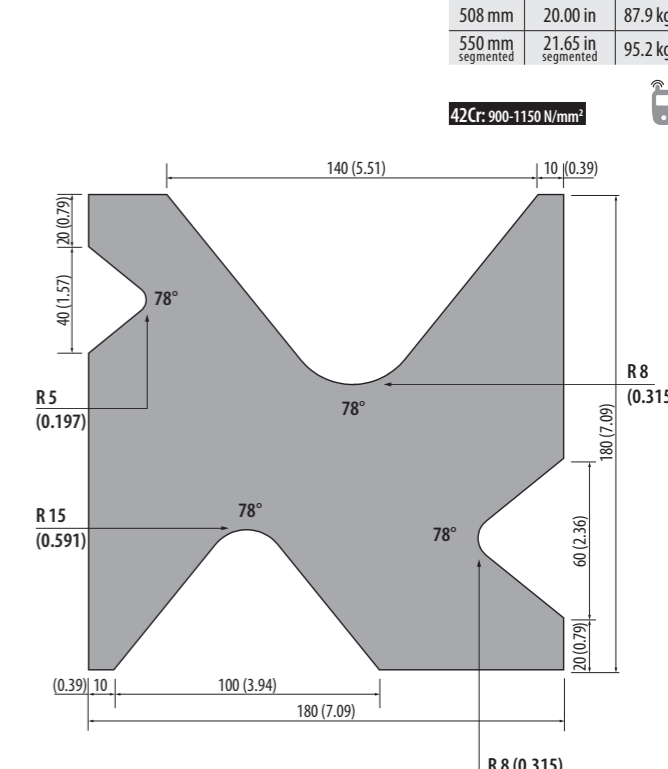


|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 51.8 kg |
| 550 mm segmented | 21.65 in segmented | 56.1 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

|           | V1        | V2        | V3        | V4        | V5        | V6        | V7        |
|-----------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|
| V mm      | 16 (0.63) | 60 (2.36) | 10 (0.39) | 80 (3.15) | 40 (1.57) | 12 (0.47) | 24 (0.94) |
| Angle     | 30°       | 78°       | 78°       | 78°       | 78°       | 78°       | 78°       |
| kN/m max. | 650       | 1500      | 650       | 1250      | 1500      | 480       | 1500      |

### LM180



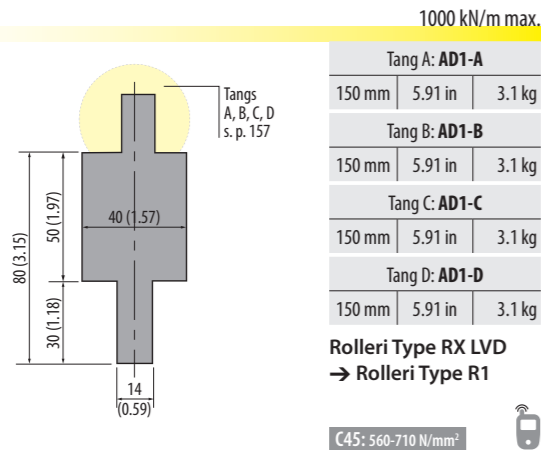
|                  |                    |         |
|------------------|--------------------|---------|
| 508 mm           | 20.00 in           | 87.9 kg |
| 550 mm segmented | 21.65 in segmented | 95.2 kg |

42Cr: 900-1150 N/mm<sup>2</sup>

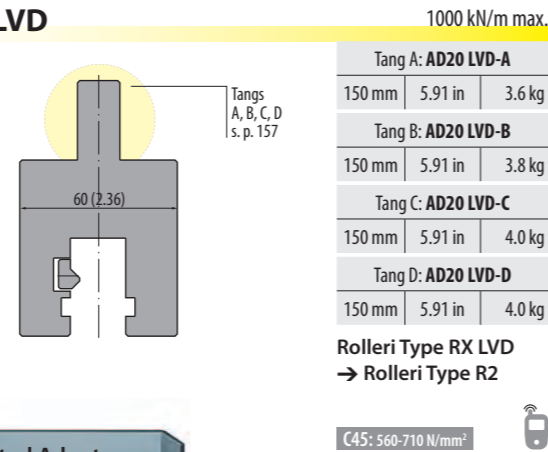
|           | V1         | V2        | V3         | V4        |
|-----------|------------|-----------|------------|-----------|
| V mm      | 140 (5.51) | 60 (2.36) | 100 (3.94) | 40 (1.57) |
| Angle     | 78°        | 78°       | 78°        | 78°       |
| kN/m max. | 550        | 650       | 700        | 320       |

7  
RX

### AD1

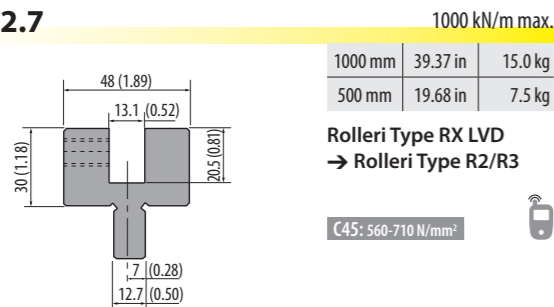


### AD20 LVD

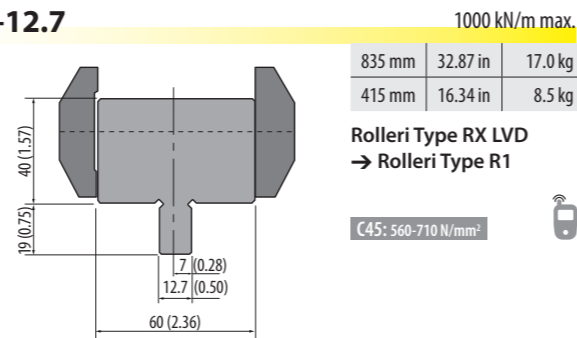


**Bolted Adapters**  
AW1 A-D  
see page 216

### AD8-12.7



### AD9-12.7

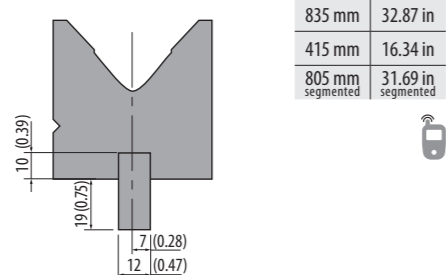


## Modification: Wedge Bar / Tail

To use Dies Rolleri Type R1, a 10 mm (0.39 in) groove is milled and polished in order to fit a wedge bar / tail of the required measurement.

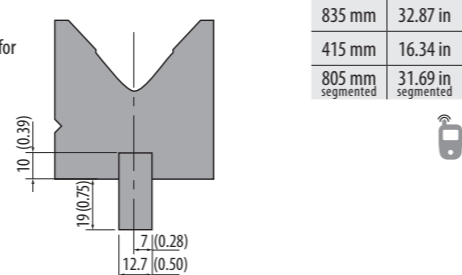
### A31

Wedge Bar / Tail:  
12 x 29 mm (0.47 x 1.14) for  
• Rolleri Type RX LVD



### A32

Wedge Bar / Tail:  
12.7 x 29 mm (0.50 x 1.14) for  
• Rolleri Type RX LVD



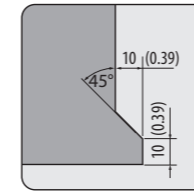
## Tool lengths, sectionings and horn types

### Punches:

- 1020 mm (40.16 in)
- 1250 mm (49.21 in) segmented  
15 segments (100 Horn left, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 100, 100 Horn right)

### Dies:

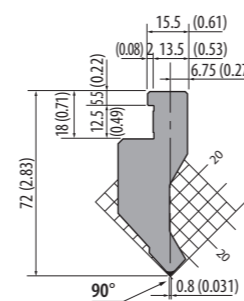
- 1020 mm (40.16 in)
- 1250 mm (49.21 in) segmented  
14 segments (100, 30, 30, 30, 35, 40, 40, 45, 45, 50, 50, 55, 500, 200)



Standard-Horn Pieces  
for all segmented  
Punches Rolleri  
Type RX Colly

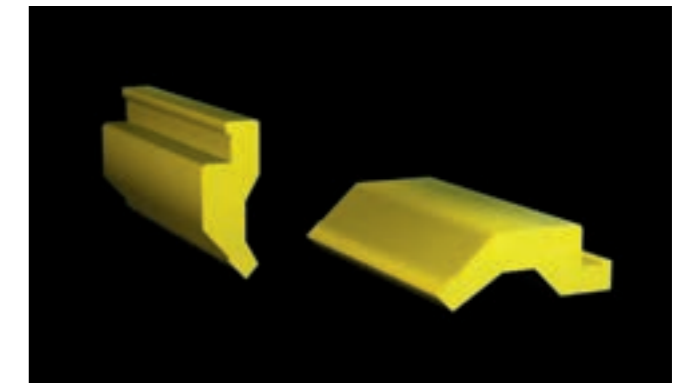
## Punches Colly

### CP72.90.08

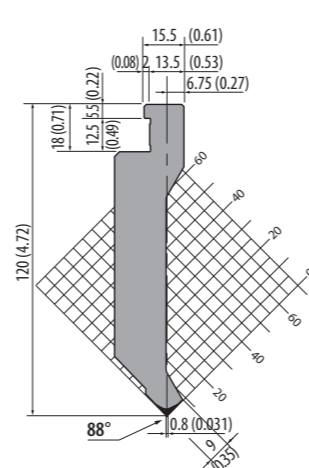


|                   |                    |         |
|-------------------|--------------------|---------|
| 1020 mm           | 40.16 in           | 10.2 kg |
| 1250 mm segmented | 49.21 in segmented | 12.5 kg |

C45: 560-710 N/mm<sup>2</sup>



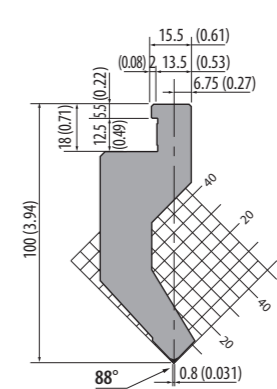
### CP120.88.08



|                   |                    |         |
|-------------------|--------------------|---------|
| 1020 mm           | 40.16 in           | 18.5 kg |
| 1250 mm segmented | 49.21 in segmented | 22.6 kg |

C45: 560-710 N/mm<sup>2</sup>

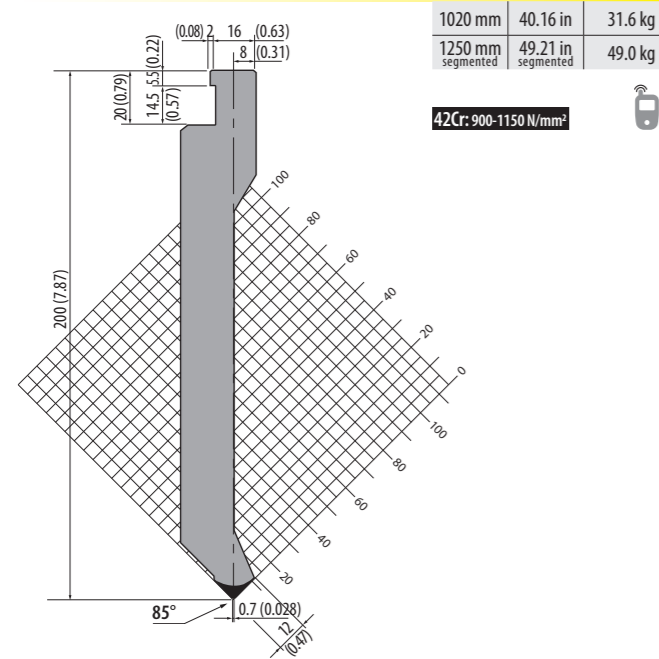
### CP100.88.08-A



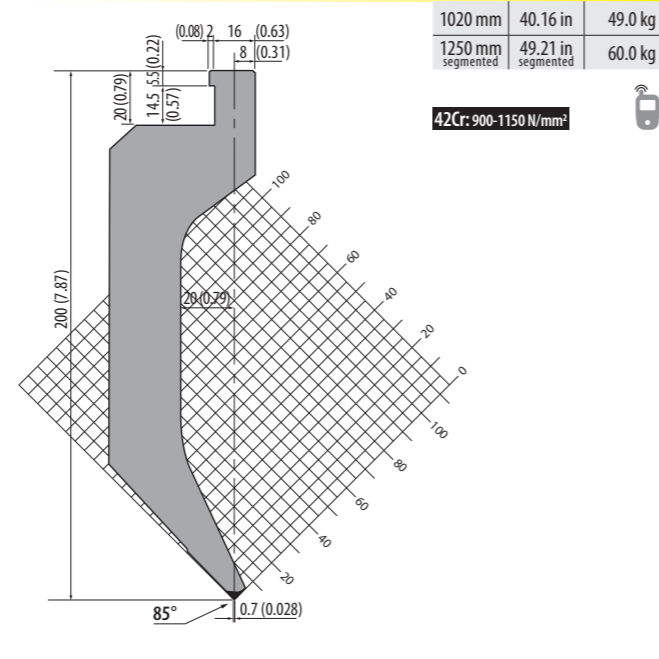
|                   |                    |         |
|-------------------|--------------------|---------|
| 1020 mm           | 40.16 in           | 16.7 kg |
| 1250 mm segmented | 49.21 in segmented | 20.4 kg |

C45: 560-710 N/mm<sup>2</sup>

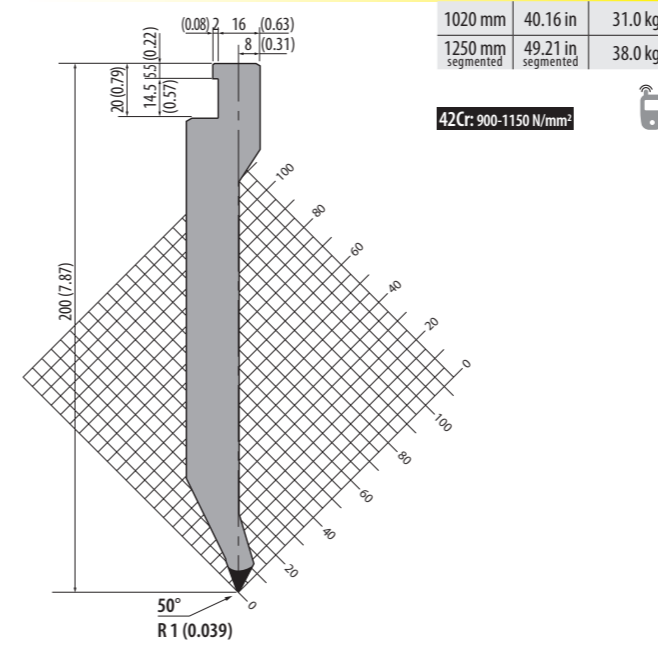
**CP200.85.07**



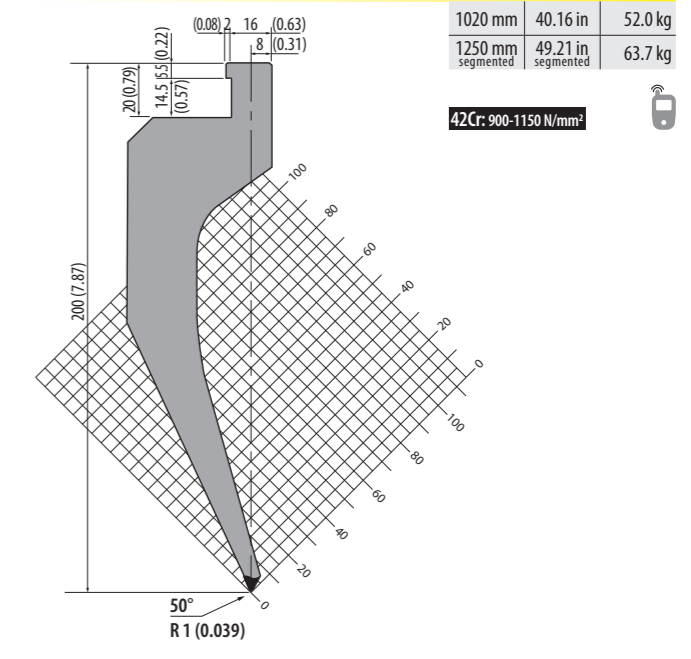
**CP200.85.07-A**



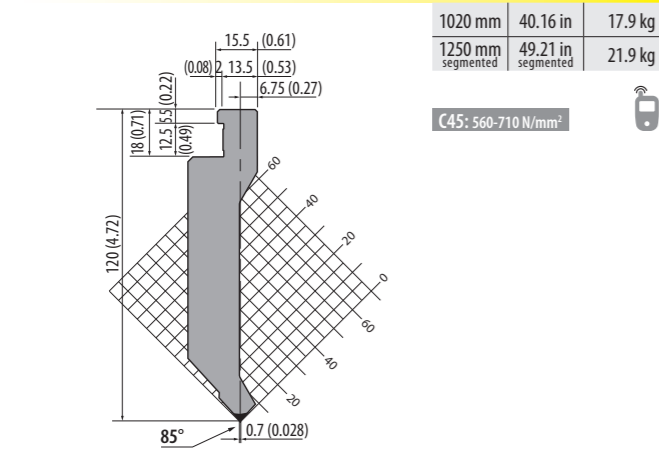
**CP200.50.R1**



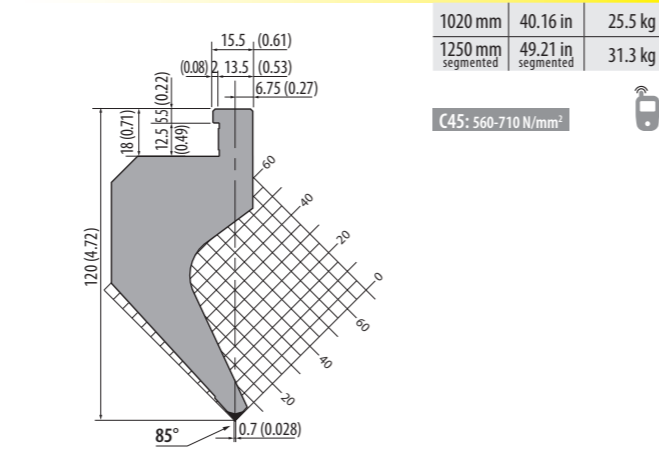
**CP200.50.R1-A**



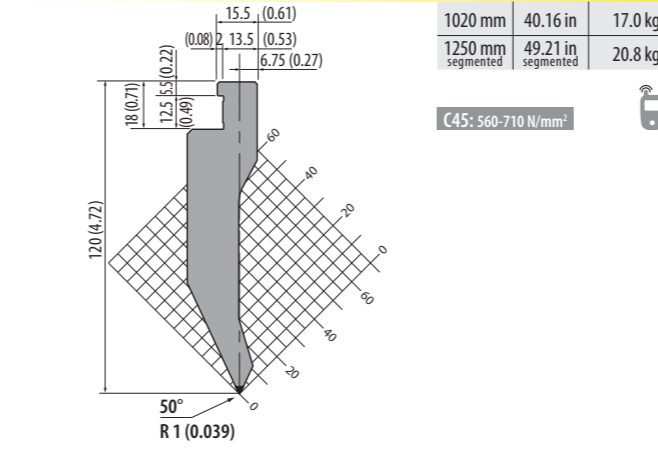
**CP120.85.07**



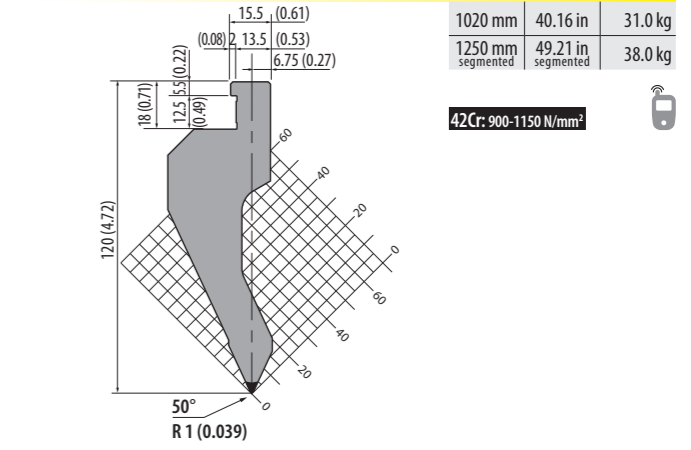
**CP120.85.07-A**



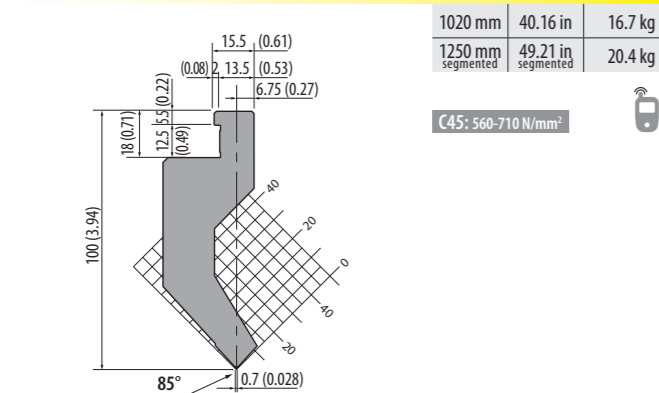
**CP120.50.R1**



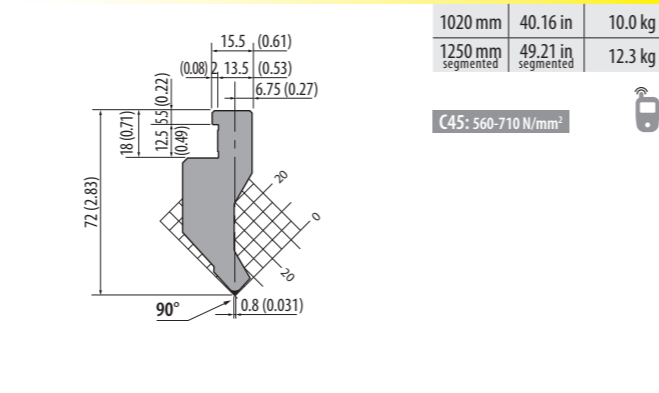
**CP120.50.R1-A**



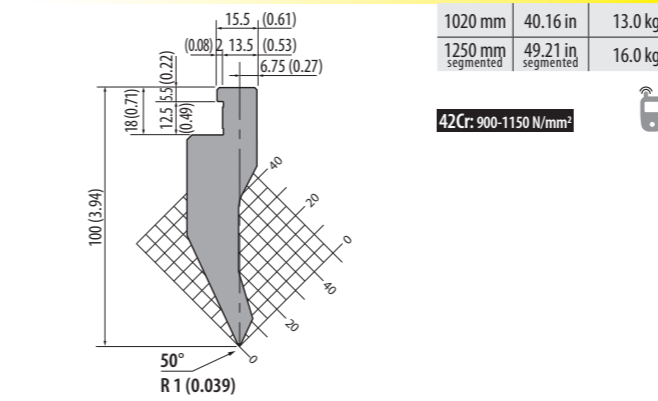
**CP100.85.07-A**



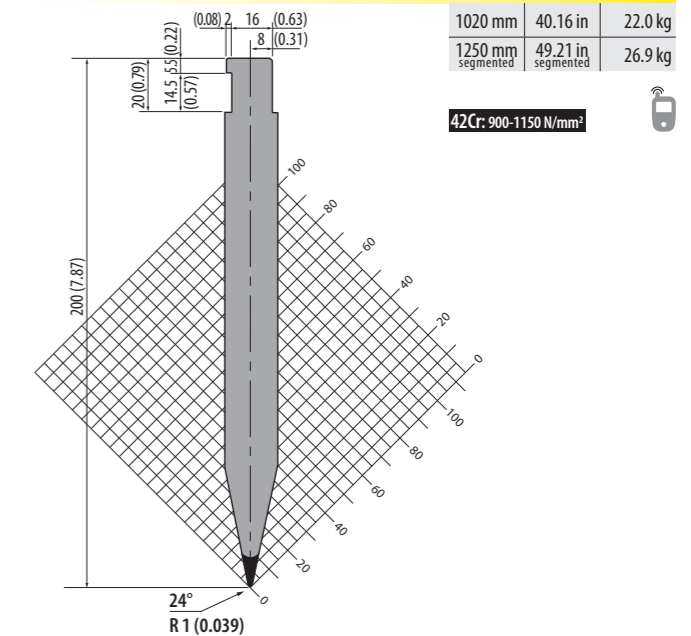
**CP72.85.07**



**CP100.50.R1**



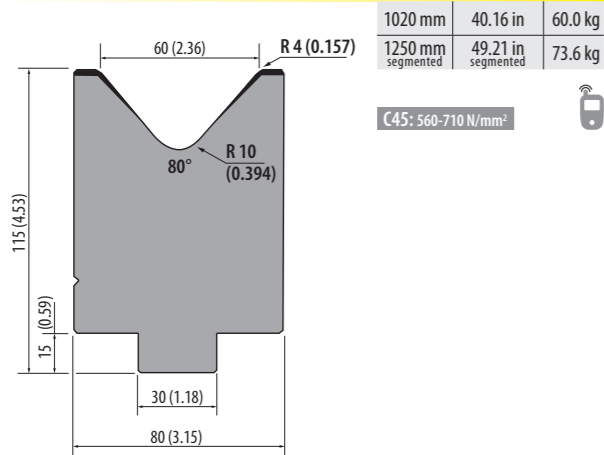
**CP200.24.R1**



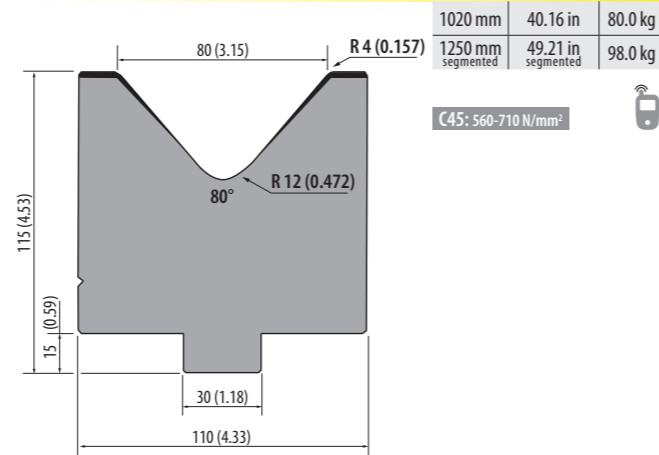
Bolted Adapters  
see page 217

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RX

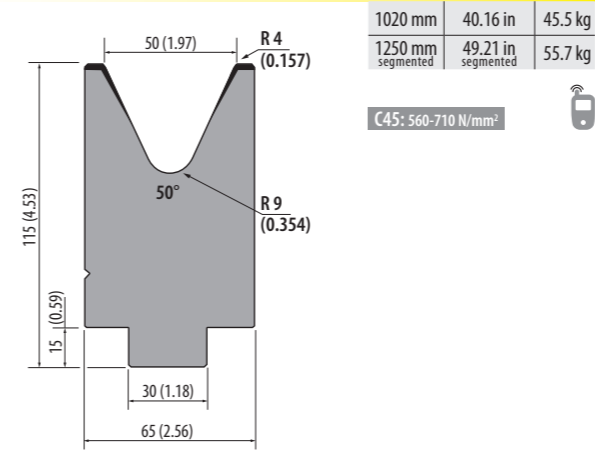
**M115.80.60**



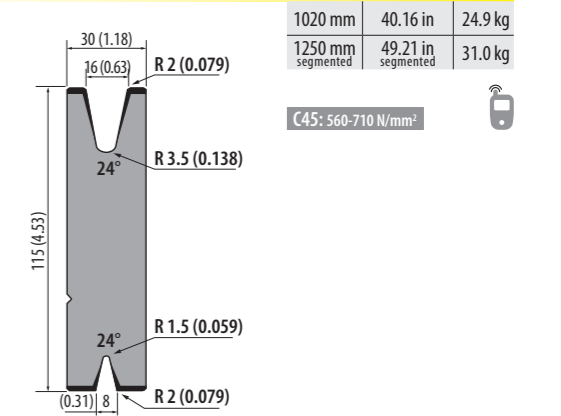
**M115.80.80**



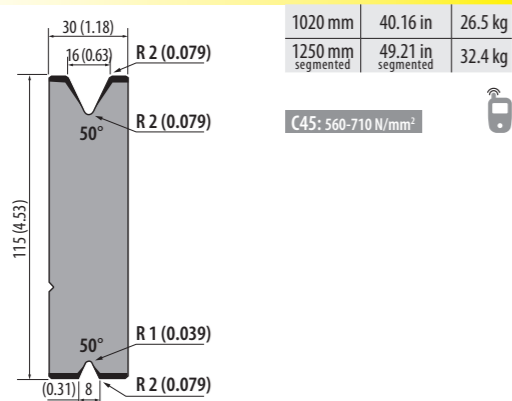
**M115.50.50**



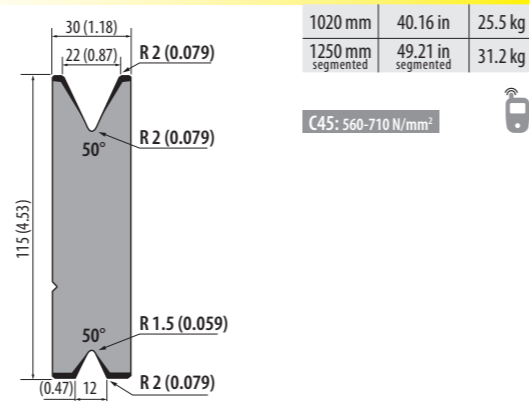
**M115.24.16**



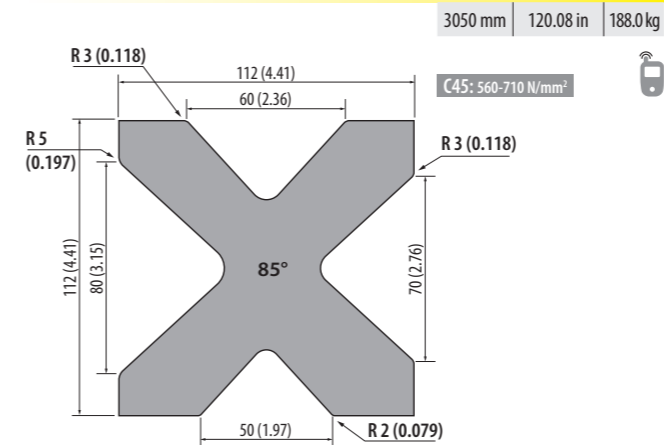
**M115.50.16**



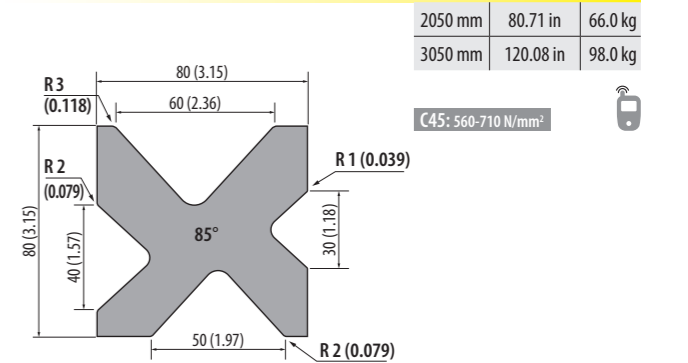
**M115.50.22**



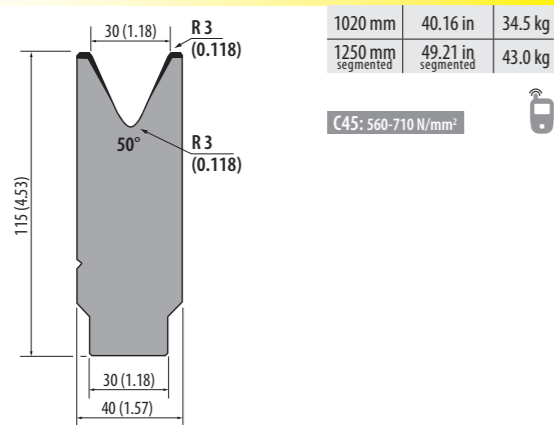
**MC112.3050**



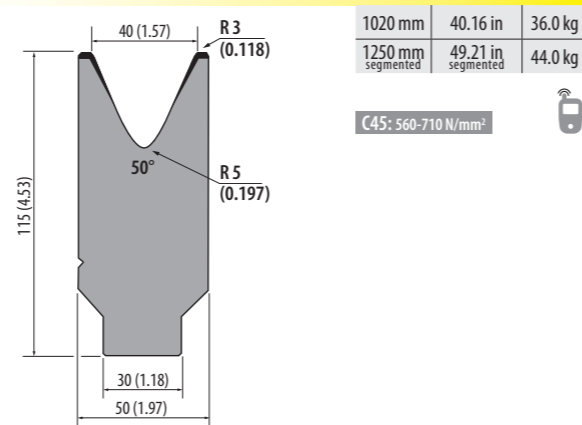
**MC80.2050 / MC80.3050**



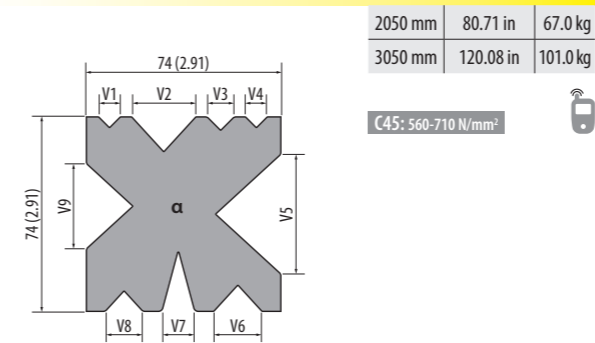
**M115.50.30**



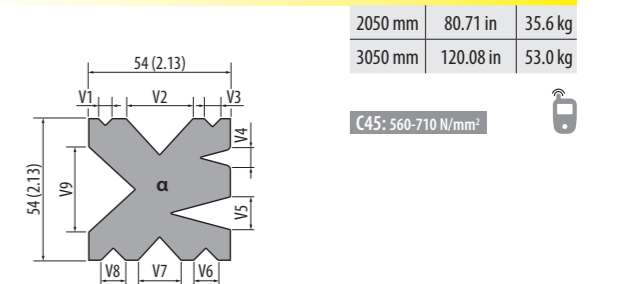
**M115.50.40**



**MC74.2050 / MC74.3050**



**MC54.2050 / MC54.3050**



|       | V1             | V2             | V3             | V4             | V5             | V6             | V7             | V8             | V9             |
|-------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|
| V mm  | 8<br>(0.31)    | 24<br>(0.94)   | 10<br>(0.39)   | 8<br>(0.31)    | 45<br>(1.77)   | 18<br>(0.71)   | 12<br>(0.47)   | 14<br>(0.55)   | 32<br>(1.26)   |
| Angle | 90°            | 85°            | 90°            | 90°            | 85°            | 85°            | 30°            | 85°            | 85°            |
| R mm  | 0.8<br>(0.031) | 0.8<br>(0.031) | 2.0<br>(0.079) | 0.8<br>(0.031) | 2.0<br>(0.079) | 1.0<br>(0.039) | 2.0<br>(0.079) | 2.0<br>(0.079) | 2.0<br>(0.079) |

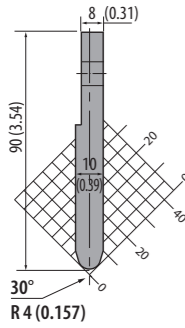
|       | V1             | V2             | V3             | V4             | V5             | V6             | V7             | V8             | V9             |
|-------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|
| V mm  | 6<br>(0.24)    | 25<br>(0.98)   | 6<br>(0.24)    | 6<br>(0.24)    | 12<br>(0.47)   | 9<br>(0.35)    | 16<br>(0.63)   | 9<br>(0.35)    | 32<br>(1.26)   |
| Angle | 90°            | 85°            | 90°            | 30°            | 30°            | 90°            | 85°            | 90°            | 85°            |
| R mm  | 0.5<br>(0.020) | 1.0<br>(0.039) | 0.5<br>(0.020) | 2.0<br>(0.079) | 0.5<br>(0.020) | 1.0<br>(0.039) | 0.5<br>(0.020) | 1.5<br>(0.059) | 1.0<br>(0.039) |

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RX





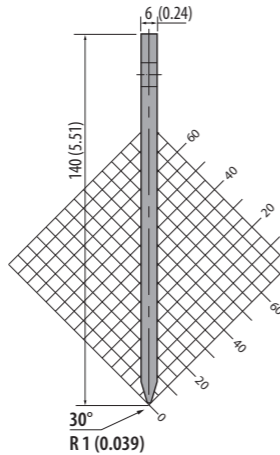
**H11.034.0** 1000 kN/m max.



| 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 |

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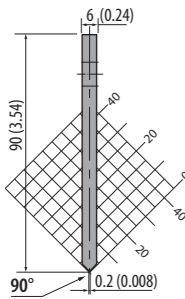
**H11.003.0** 1000 kN/m max.



| 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

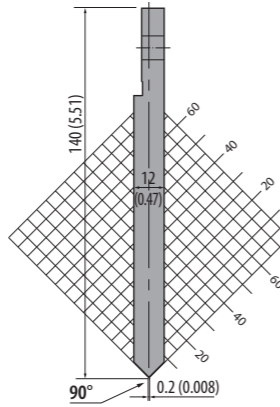
**H11.005.0** 1000 kN/m max.



| 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

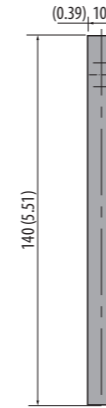
**H11.009.1** 1000 kN/m max.



| 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 |

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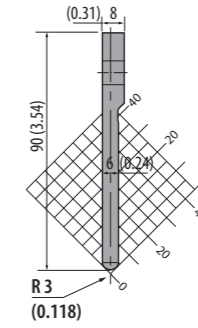
**H14.021.0** 1000 kN/m max.



| 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.

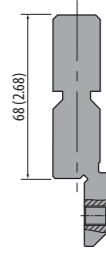


| Model         | Length | Weight          |
|---------------|--------|-----------------|
| H11.033.11.01 | 100    | 3.94 0.46 kg    |
| H11.033.12.01 | 50     | 1.97 0.23 kg    |
| H11.033.12.02 | 55     | 2.17 0.25 kg    |
| H11.033.12.03 | 60     | 2.36 0.28 kg    |
| H11.033.12.04 | 65     | 2.56 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 |

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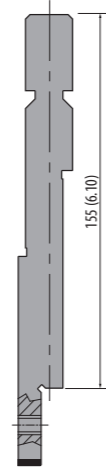
**H21.003.0** 1000 kN/m max.



| Model         | Length | Weight  |
|---------------|--------|---------|
| H21.003.01.01 | 100    | 3.94    |
| H21.003.01.03 | 200    | 7.87    |
| H21.003.02.01 | 50     | 1.97    |
| H21.003.02.02 | 55     | 2.17    |
| H21.003.02.03 | 60     | 2.36    |
| H21.003.02.04 | 65     | 2.56    |
| H21.003.02.05 | 70     | 2.76    |
| H21.003.02.06 | 75     | 2.95    |
| H21.003.02.07 | 80     | 3.15    |
| H21.003.02.08 | 85     | 3.35    |
| H21.003.02.09 | 90     | 3.54    |
| H21.003.02.10 | 95     | 3.74    |
| H21.003.04.01 | 75 DX  | 2.95 DX |
| H21.003.04.02 | 85 DX  | 3.35 DX |
| H21.003.04.03 | 95 DX  | 3.74 DX |
| H21.003.04.04 | 105 DX | 4.13 DX |
| H21.003.04.05 | 115 DX | 4.53 DX |
| H21.003.04.06 | 80 SX  | 3.15 SX |
| H21.003.05.01 | 75 SX  | 2.95 SX |
| H21.003.05.02 | 85 SX  | 3.35 SX |
| H21.003.05.03 | 95 SX  | 3.74 SX |
| H21.003.05.04 | 105 SX | 4.13 SX |
| H21.003.05.05 | 115 SX | 4.53 SX |
| H21.003.05.06 | 80 DX  | 3.15 DX |

C45: 560-710 N/mm<sup>2</sup>

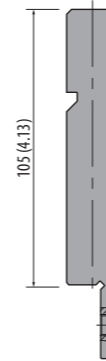
**H21.002.0** 1000 kN/m max.



| Model         | Length | Weight  |
|---------------|--------|---------|
| H21.002.01.01 | 100    | 3.94    |
| H21.002.01.03 | 200    | 7.87    |
| H21.002.02.01 | 50     | 1.97    |
| H21.002.02.02 | 55     | 2.17    |
| H21.002.02.03 | 60     | 2.36    |
| H21.002.02.04 | 65     | 2.56    |
| H21.002.02.05 | 70     | 2.76    |
| H21.002.02.06 | 75     | 2.95    |
| H21.002.02.07 | 80     | 3.15    |
| H21.002.02.08 | 85     | 3.35    |
| H21.002.02.09 | 90     | 3.54    |
| H21.002.02.10 | 95     | 3.74    |
| H21.002.04.01 | 75 DX  | 2.95 DX |
| H21.002.04.02 | 85 DX  | 3.35 DX |
| H21.002.04.03 | 95 DX  | 3.74 DX |
| H21.002.04.04 | 105 DX | 4.13 DX |
| H21.002.04.05 | 115 DX | 4.53 DX |
| H21.002.04.06 | 80 SX  | 3.15 SX |
| H21.002.05.01 | 75 SX  | 2.95 SX |
| H21.002.05.02 | 85 SX  | 3.35 SX |
| H21.002.05.03 | 95 SX  | 3.74 SX |
| H21.002.05.04 | 105 SX | 4.13 SX |
| H21.002.05.05 | 115 SX | 4.53 SX |
| H21.002.05.06 | 80 DX  | 3.15 DX |

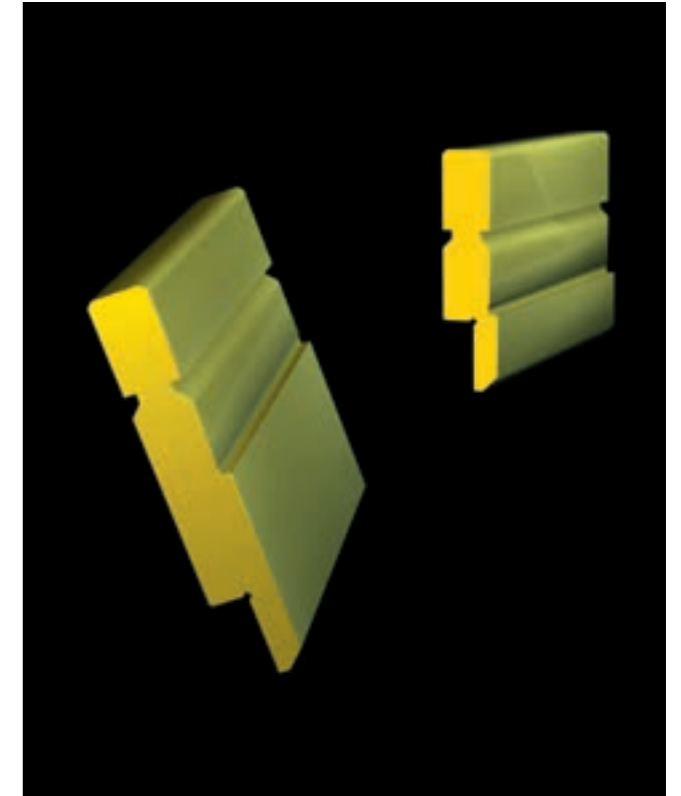
C45: 560-710 N/mm<sup>2</sup>

**H21.004.0** 1000 kN/m max.

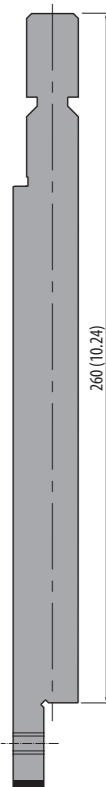


| Model         | Length | Weight  |
|---------------|--------|---------|
| H21.004.01.01 | 100    | 3.94    |
| H21.004.01.03 | 200    | 7.87    |
| H21.004.02.01 | 50     | 1.97    |
| H21.004.02.02 | 55     | 2.17    |
| H21.004.02.03 | 60     | 2.36    |
| H21.004.02.04 | 65     | 2.56    |
| H21.004.02.05 | 70     | 2.76    |
| H21.004.02.06 | 75     | 2.95    |
| H21.004.02.07 | 80     | 3.15    |
| H21.004.02.08 | 85     | 3.35    |
| H21.004.02.09 | 90     | 3.54    |
| H21.004.02.10 | 95     | 3.74    |
| H21.004.04.01 | 75 DX  | 2.95 DX |
| H21.004.04.02 | 85 DX  | 3.35 DX |
| H21.004.04.03 | 95 DX  | 3.74 DX |
| H21.004.04.04 | 105 DX | 4.13 DX |
| H21.004.04.05 | 115 DX | 4.53 DX |
| H21.004.04.06 | 80 SX  | 3.15 SX |
| H21.004.05.01 | 75 SX  | 2.95 SX |
| H21.004.05.02 | 85 SX  | 3.35 SX |
| H21.004.05.03 | 95 SX  | 3.74 SX |
| H21.004.05.04 | 105 SX | 4.13 SX |
| H21.004.05.05 | 115 SX | 4.53 SX |
| H21.004.05.06 | 80 DX  | 3.15 DX |

C45: 560-710 N/mm<sup>2</sup>



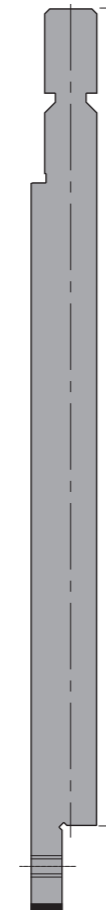
**H21.005.0** 1000 kN/m max.



| Model         | Length | Weight  |
|---------------|--------|---------|
| H21.005.01.01 | 100    | 3.94    |
| H21.005.01.03 | 200    | 7.87    |
| H21.005.02.01 | 50     | 1.97    |
| H21.005.02.02 | 55     | 2.17    |
| H21.005.02.03 | 60     | 2.36    |
| H21.005.02.04 | 65     | 2.56    |
| H21.005.02.05 | 70     | 2.76    |
| H21.005.02.06 | 75     | 2.95    |
| H21.005.02.07 | 80     | 3.15    |
| H21.005.02.08 | 85     | 3.35    |
| H21.005.02.09 | 90     | 3.54    |
| H21.005.02.10 | 95     | 3.74    |
| H21.005.04.01 | 75 DX  | 2.95 DX |
| H21.005.04.02 | 85 DX  | 3.35 DX |
| H21.005.04.03 | 95 DX  | 3.74 DX |
| H21.005.04.04 | 105 DX | 4.13 DX |
| H21.005.04.05 | 115 DX | 4.53 DX |
| H21.005.04.06 | 80 SX  | 3.15 SX |
| H21.005.05.01 | 75 SX  | 2.95 SX |
| H21.005.05.02 | 85 SX  | 3.35 SX |
| H21.005.05.03 | 95 SX  | 3.74 SX |
| H21.005.05.04 | 105 SX | 4.13 SX |
| H21.005.05.05 | 115 SX | 4.53 SX |
| H21.005.05.06 | 80 DX  | 3.15 DX |

C45: 560-710 N/mm<sup>2</sup>

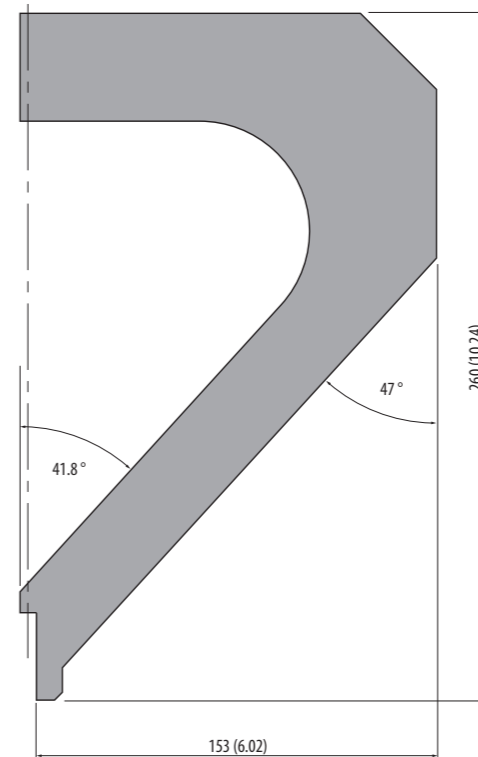
**H21.010.0** 1000 kN/m max.



| Model         | Length | Weight  |
|---------------|--------|---------|
| H21.010.01.01 | 100    | 3.94    |
| H21.010.01.03 | 200    | 7.87    |
| H21.010.02.01 | 50     | 1.97    |
| H21.010.02.02 | 55     | 2.17    |
| H21.010.02.03 | 60     | 2.36    |
| H21.010.02.04 | 65     | 2.56    |
| H21.010.02.05 | 70     | 2.76    |
| H21.010.02.06 | 75     | 2.95    |
| H21.010.02.07 | 80     | 3.15    |
| H21.010.02.08 | 85     | 3.35    |
| H21.010.02.09 | 90     | 3.54    |
| H21.010.02.10 | 95     | 3.74    |
| H21.010.04.01 | 75 DX  | 2.95 DX |
| H21.010.04.02 | 85 DX  | 3.35 DX |
| H21.010.04.03 | 95 DX  | 3.74 DX |
| H21.010.04.04 | 105 DX | 4.13 DX |
| H21.010.04.05 | 115 DX | 4.53 DX |
| H21.010.04.06 | 80 SX  | 3.15 SX |
| H21.010.05.01 | 75 SX  | 2.95 SX |
| H21.010.05.02 | 85 SX  | 3.35 SX |
| H21.010.05.03 | 95 SX  | 3.74 SX |
| H21.010.05.04 | 105 SX | 4.13 SX |
| H21.010.05.05 | 115 SX | 4.53 SX |
| H21.010.05.06 | 80 DX  | 3.15 DX |

C45: 560-710 N/mm<sup>2</sup>

**H22.006.0** 600 kN/m max.

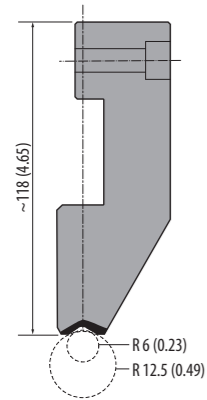


| Model         | Length | Weight |
|---------------|--------|--------|
| H22.006.01.01 | 100    | 3.94   |
| H22.006.02.01 | 50     | 1.97   |
| H22.006.02.02 | 55     | 2.17   |
| H22.006.02.03 | 60     | 2.36   |
| H22.006.02.04 | 65     | 2.56   |
| H22.006.02.05 | 70     | 2.76   |
| H22.006.02.06 | 75     | 2.95   |
| H22.006.02.07 | 80     | 3.15   |
| H22.006.02.08 | 85     | 3.35   |
| H22.006.02.09 | 90     | 3.54   |
| H22.006.02.10 | 95     | 3.74   |

42Cr: 900-1150 N/mm<sup>2</sup>

**H22.013.0**

1000 kN/m max.

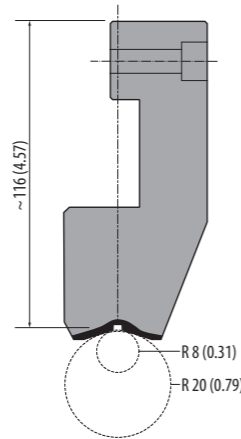


| Model         | Length | Weight  |
|---------------|--------|---------|
| H22.013.01.01 | 100    | 2.82 kg |
| H22.013.02.01 | 50     | 1.41 kg |
| H22.013.02.02 | 55     | 1.55 kg |
| H22.013.02.03 | 60     | 1.69 kg |
| H22.013.02.04 | 65     | 1.83 kg |
| H22.013.02.05 | 70     | 1.97 kg |
| H22.013.02.06 | 75     | 2.12 kg |
| H22.013.02.07 | 80     | 2.26 kg |
| H22.013.02.08 | 85     | 2.40 kg |
| H22.013.02.09 | 90     | 2.54 kg |
| H22.013.02.10 | 95     | 2.68 kg |

C45: 560-710 N/mm<sup>2</sup>

**H22.014.0**

1000 kN/m max.

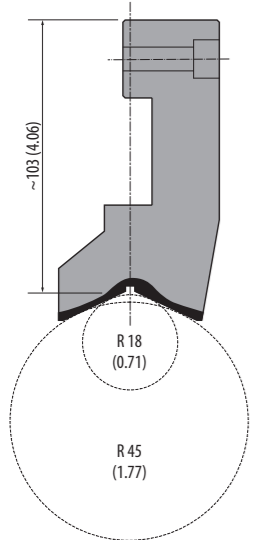


| Model         | Length | Weight  |
|---------------|--------|---------|
| H22.014.01.01 | 100    | 3.06 kg |
| H22.014.02.01 | 50     | 1.53 kg |
| H22.014.02.02 | 55     | 1.68 kg |
| H22.014.02.03 | 60     | 1.83 kg |
| H22.014.02.04 | 65     | 1.98 kg |
| H22.014.02.05 | 70     | 2.14 kg |
| H22.014.02.06 | 75     | 2.29 kg |
| H22.014.02.07 | 80     | 2.44 kg |
| H22.014.02.08 | 85     | 2.59 kg |
| H22.014.02.09 | 90     | 2.75 kg |
| H22.014.02.10 | 95     | 2.90 kg |

C45: 560-710 N/mm<sup>2</sup>

**H22.015.0**

1000 kN/m max.



| Model         | Length | Weight  |
|---------------|--------|---------|
| H22.015.01.01 | 100    | 3.28 kg |
| H22.015.02.01 | 50     | 1.64 kg |
| H22.015.02.02 | 55     | 1.80 kg |
| H22.015.02.03 | 60     | 1.97 kg |
| H22.015.02.04 | 65     | 2.13 kg |
| H22.015.02.05 | 70     | 2.30 kg |
| H22.015.02.06 | 75     | 2.46 kg |
| H22.015.02.07 | 80     | 2.62 kg |
| H22.015.02.08 | 85     | 2.79 kg |
| H22.015.02.09 | 90     | 2.95 kg |
| H22.015.02.10 | 95     | 3.12 kg |

C45: 560-710 N/mm<sup>2</sup>



**H61.100.01 / H61.500.01**

| Model      | Length | Weight  |
|------------|--------|---------|
| H61.100.01 | 100    | 0.63 kg |
| H61.500.01 | 500    | 3.15 kg |

C45: 560-710 N/mm<sup>2</sup>

**H61.100.02 / H61.500.02**

| Model      | Length | Weight  |
|------------|--------|---------|
| H61.100.02 | 100    | 0.70 kg |
| H61.500.02 | 500    | 3.50 kg |

C45: 560-710 N/mm<sup>2</sup>

**H61.100.03 / H61.500.03**

| Model      | Length | Price | Weight  |
|------------|--------|-------|---------|
| H61.100.03 | 100    | 3.94  | 0.70 kg |
| H61.500.03 | 500    | 19.68 | 3.50 kg |

C45: 560-710 N/mm<sup>2</sup>

**H61.100.04 / H61.500.04**

| Model      | Length | Weight  |
|------------|--------|---------|
| H61.100.04 | 100    | 0.63 kg |
| H61.500.04 | 500    | 3.15 kg |

C45: 560-710 N/mm<sup>2</sup>

**H61.100.05 / H61.500.05**

| Model      | Length | Weight  |
|------------|--------|---------|
| H61.100.05 | 100    | 0.30 kg |
| H61.500.05 | 500    | 1.50 kg |

C45: 560-710 N/mm<sup>2</sup>

**H61.100.06 / H61.500.06**

| Model      | Length | Weight  |
|------------|--------|---------|
| H61.100.06 | 100    | 0.63 kg |
| H61.500.06 | 500    | 3.15 kg |

C45: 560-710 N/mm<sup>2</sup>

**H61.100.07**

| Model      | Length | Weight  |
|------------|--------|---------|
| H61.100.07 | 100    | 0.65 kg |

C45: 560-710 N/mm<sup>2</sup>

**H61.100.08 / H61.500.08**

| Model      | Length | Weight  |
|------------|--------|---------|
| H61.100.08 | 100    | 0.70 kg |
| H61.500.08 | 500    | 3.50 kg |

C45: 560-710 N/mm<sup>2</sup>



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videos/overview](http://www.rolleritools.com/videos/overview)





**H31.007.0** 500 kN/m max.

| Model         | Length | Weight  |
|---------------|--------|---------|
| H31.007.01.01 | 100    | 3.94    |
| H31.007.02.01 | 50 SX  | 1.97 SX |
| H31.007.02.02 | 55 DX  | 2.17 DX |
| H31.007.02.03 | 60 DX  | 2.36 DX |
| H31.007.02.04 | 65 DX  | 2.56 DX |
| H31.007.02.05 | 70 DX  | 2.76 DX |
| H31.007.02.06 | 75 DX  | 2.95 DX |
| H31.007.02.07 | 80 DX  | 3.15 DX |
| H31.007.02.08 | 85 DX  | 3.35 DX |
| H31.007.02.09 | 90 DX  | 3.54 DX |
| H31.007.02.10 | 95 DX  | 3.74 DX |
| H31.007.03.01 | 50 DX  | 1.97 DX |
| H31.007.03.02 | 55 SX  | 2.17 SX |
| H31.007.03.03 | 60 SX  | 2.36 SX |
| H31.007.03.04 | 65 SX  | 2.56 SX |
| H31.007.03.05 | 70 SX  | 2.76 SX |
| H31.007.03.06 | 75 SX  | 2.95 SX |
| H31.007.03.07 | 80 SX  | 3.15 SX |
| H31.007.03.08 | 85 SX  | 3.35 SX |
| H31.007.03.09 | 90 SX  | 3.54 SX |
| H31.007.03.10 | 95 SX  | 3.74 SX |

42Cr: 900-1150 N/mm<sup>2</sup>

**H31.007.2** 500 kN/m max.

| Model         | Length | Weight  |
|---------------|--------|---------|
| H31.007.21.01 | 100    | 3.94    |
| H31.007.22.01 | 50 SX  | 1.97 SX |
| H31.007.22.02 | 55 DX  | 2.17 DX |
| H31.007.22.03 | 60 DX  | 2.36 DX |
| H31.007.22.04 | 65 DX  | 2.56 DX |
| H31.007.22.05 | 70 DX  | 2.76 DX |
| H31.007.22.06 | 75 DX  | 2.95 DX |
| H31.007.22.07 | 80 DX  | 3.15 DX |
| H31.007.22.08 | 85 DX  | 3.35 DX |
| H31.007.22.09 | 90 DX  | 3.54 DX |
| H31.007.22.10 | 95 DX  | 3.74 DX |
| H31.007.23.01 | 50 DX  | 1.97 DX |
| H31.007.23.02 | 55 SX  | 2.17 SX |
| H31.007.23.03 | 60 SX  | 2.36 SX |
| H31.007.23.04 | 65 SX  | 2.56 SX |
| H31.007.23.05 | 70 SX  | 2.76 SX |
| H31.007.23.06 | 75 SX  | 2.95 SX |
| H31.007.23.07 | 80 SX  | 3.15 SX |
| H31.007.23.08 | 85 SX  | 3.35 SX |
| H31.007.23.09 | 90 SX  | 3.54 SX |
| H31.007.23.10 | 95 SX  | 3.74 SX |

42Cr: 900-1150 N/mm<sup>2</sup>

**H31.090.01.01** 1500 kN/m max.

| Model         | Length | Weight |
|---------------|--------|--------|
| H31.090.01.01 | 100    | 3.94   |

C45: 560-710 N/mm<sup>2</sup>

**H31.013.0** 500 kN/m max.

| Model         | Length | Weight  |
|---------------|--------|---------|
| H31.013.01.01 | 100    | 3.94    |
| H31.013.02.01 | 50 SX  | 1.97 SX |
| H31.013.02.02 | 55 DX  | 2.17 DX |
| H31.013.02.03 | 60 DX  | 2.36 DX |
| H31.013.02.04 | 65 DX  | 2.56 DX |
| H31.013.02.05 | 70 DX  | 2.76 DX |
| H31.013.02.06 | 75 DX  | 2.95 DX |
| H31.013.02.07 | 80 DX  | 3.15 DX |
| H31.013.02.08 | 85 DX  | 3.35 DX |
| H31.013.02.09 | 90 DX  | 3.54 DX |
| H31.013.02.10 | 95 DX  | 3.74 DX |
| H31.013.03.01 | 50 DX  | 1.97 DX |
| H31.013.03.02 | 55 SX  | 2.17 SX |
| H31.013.03.03 | 60 SX  | 2.36 SX |
| H31.013.03.04 | 65 SX  | 2.56 SX |
| H31.013.03.05 | 70 SX  | 2.76 SX |
| H31.013.03.06 | 75 SX  | 2.95 SX |
| H31.013.03.07 | 80 SX  | 3.15 SX |
| H31.013.03.08 | 85 SX  | 3.35 SX |
| H31.013.03.09 | 90 SX  | 3.54 SX |
| H31.013.03.10 | 95 SX  | 3.74 SX |

C45: 560-710 N/mm<sup>2</sup>

**H31.012.0** 500 kN/m max.

| Model         | Length | Weight  |
|---------------|--------|---------|
| H31.012.01.01 | 100    | 3.94    |
| H31.012.02.01 | 50 SX  | 1.97 SX |
| H31.012.02.02 | 55 DX  | 2.17 DX |
| H31.012.02.03 | 60 DX  | 2.36 DX |
| H31.012.02.04 | 65 DX  | 2.56 DX |
| H31.012.02.05 | 70 DX  | 2.76 DX |
| H31.012.02.06 | 75 DX  | 2.95 DX |
| H31.012.02.07 | 80 DX  | 3.15 DX |
| H31.012.02.08 | 85 DX  | 3.35 DX |
| H31.012.02.09 | 90 DX  | 3.54 DX |
| H31.012.02.10 | 95 DX  | 3.74 DX |
| H31.012.03.01 | 50 DX  | 1.97 DX |
| H31.012.03.02 | 55 SX  | 2.17 SX |
| H31.012.03.03 | 60 SX  | 2.36 SX |
| H31.012.03.04 | 65 SX  | 2.56 SX |
| H31.012.03.05 | 70 SX  | 2.76 SX |
| H31.012.03.06 | 75 SX  | 2.95 SX |
| H31.012.03.07 | 80 SX  | 3.15 SX |
| H31.012.03.08 | 85 SX  | 3.35 SX |
| H31.012.03.09 | 90 SX  | 3.54 SX |
| H31.012.03.10 | 95 SX  | 3.74 SX |

C45: 560-710 N/mm<sup>2</sup>

**H31.110.01.01** 1500 kN/m max.

| Model         | Length | Weight |
|---------------|--------|--------|
| H31.110.01.01 | 100    | 3.94   |

C45: 560-710 N/mm<sup>2</sup>

**H31.006.0** 350 kN/m max.

| Model         | Length | Weight  |
|---------------|--------|---------|
| H31.006.01.01 | 100    | 3.94    |
| H31.006.02.01 | 50 SX  | 1.97 SX |
| H31.006.02.02 | 55 DX  | 2.17 DX |
| H31.006.02.03 | 60 DX  | 2.36 DX |
| H31.006.02.04 | 65 DX  | 2.56 DX |
| H31.006.02.05 | 70 DX  | 2.76 DX |
| H31.006.02.06 | 75 DX  | 2.95 DX |
| H31.006.02.07 | 80 DX  | 3.15 DX |
| H31.006.02.08 | 85 DX  | 3.35 DX |
| H31.006.02.09 | 90 DX  | 3.54 DX |
| H31.006.02.10 | 95 DX  | 3.74 DX |
| H31.006.03.01 | 50 DX  | 1.97 DX |
| H31.006.03.02 | 55 SX  | 2.17 SX |
| H31.006.03.03 | 60 SX  | 2.36 SX |
| H31.006.03.04 | 65 SX  | 2.56 SX |
| H31.006.03.05 | 70 SX  | 2.76 SX |
| H31.006.03.06 | 75 SX  | 2.95 SX |
| H31.006.03.07 | 80 SX  | 3.15 SX |
| H31.006.03.08 | 85 SX  | 3.35 SX |
| H31.006.03.09 | 90 SX  | 3.54 SX |
| H31.006.03.10 | 95 SX  | 3.74 SX |

42Cr: 900-1150 N/mm<sup>2</sup>

**H31.060.0** 1500 kN/m max.

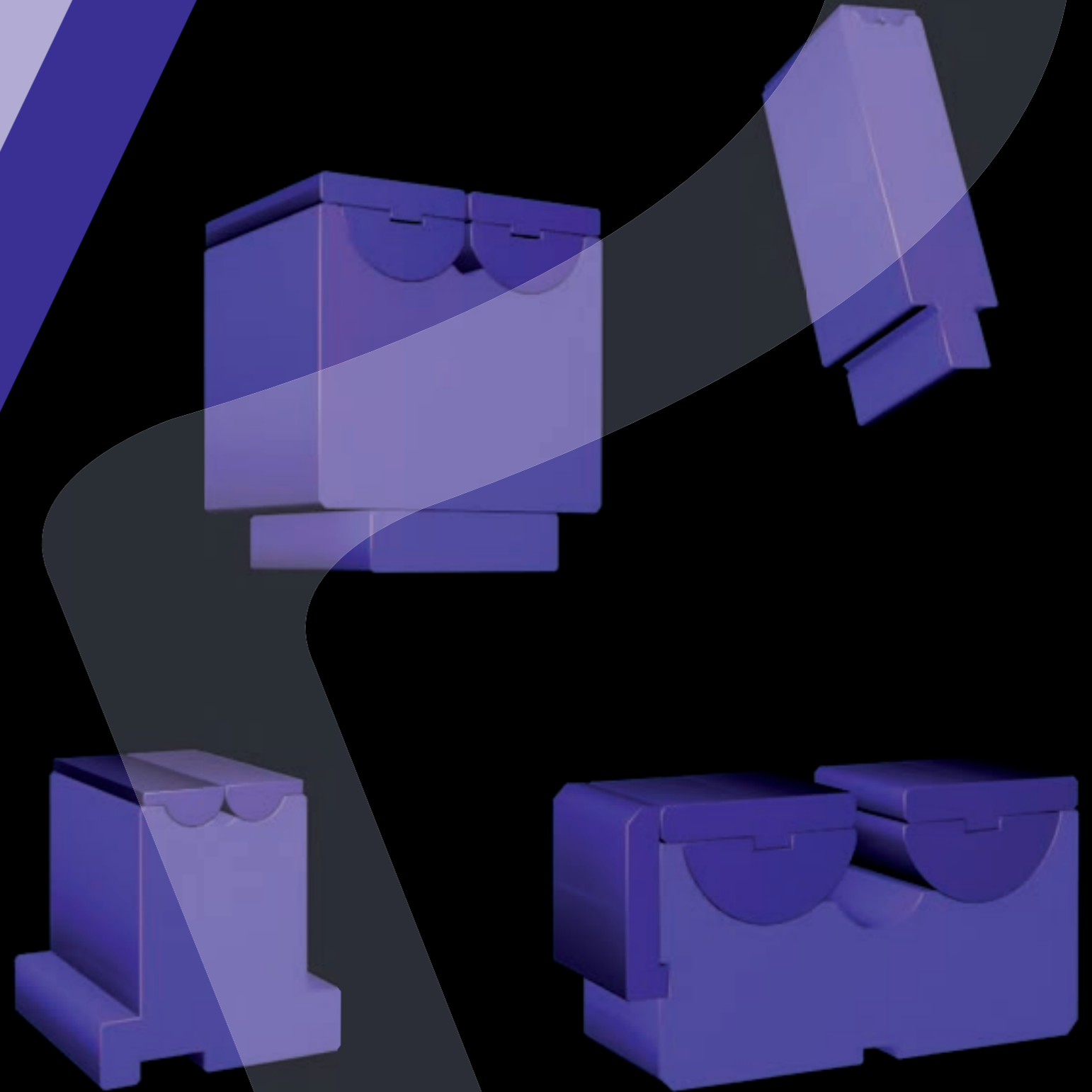
| Model         | Length | Weight  |
|---------------|--------|---------|
| H31.060.01.01 | 100    | 3.94    |
| H31.060.02.01 | 50 SX  | 1.97 SX |
| H31.060.02.02 | 55 DX  | 2.17 DX |
| H31.060.02.03 | 60 DX  | 2.36 DX |
| H31.060.02.04 | 65 DX  | 2.56 DX |
| H31.060.02.05 | 70 DX  | 2.76 DX |
| H31.060.02.06 | 75 DX  | 2.95 DX |
| H31.060.02.07 | 80 DX  | 3.15 DX |
| H31.060.02.08 | 85 DX  | 3.35 DX |
| H31.060.02.09 | 90 DX  | 3.54 DX |
| H31.060.02.10 | 95 DX  | 3.74 DX |
| H31.060.03.01 | 50 DX  | 1.97 DX |
| H31.060.03.02 | 55 SX  | 2.17 SX |
| H31.060.03.03 | 60 SX  | 2.36 SX |
| H31.060.03.04 | 65 SX  | 2.56 SX |
| H31.060.03.05 | 70 SX  | 2.76 SX |
| H31.060.03.06 | 75 SX  | 2.95 SX |
| H31.060.03.07 | 80 SX  | 3.15 SX |
| H31.060.03.08 | 85 SX  | 3.35 SX |
| H31.060.03.09 | 90 SX  | 3.54 SX |
| H31.060.03.10 | 95 SX  | 3.74 SX |

C45: 560-710 N/mm<sup>2</sup>



## ROLLERI DIES ROLLA-V

|                           |           |
|---------------------------|-----------|
| Content Explanation       | 186 - 187 |
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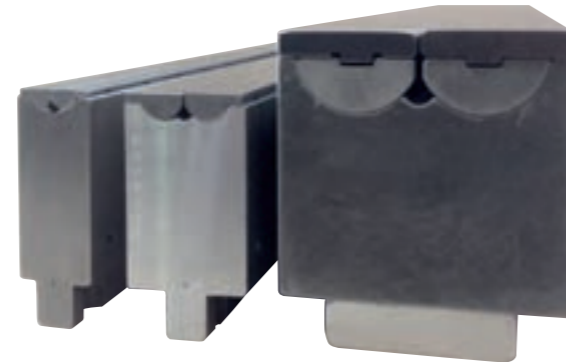


Compatibility

- RVP Dies (Models 1, 2, 3) are compatible with press brake machines (60 mm / 2.36 in die holder) from: ACL, Accurpress, Amada, Atlantic, Adira, Baykal, BL, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Dener, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- RVS Dies (Models 1, 2, 3) are compatible with press brake machines (14 mm / 0.55 in pins) from: Amada Single V style
- RVT Dies (Models 1, 2, 3) are compatible with press brake machines (12.7 mm / 0.50 in / 13 mm / 0.51 in pins) from: Bystronic, Hämmerle, Beyeler, Edwards, Safan, SMD, Trumpf
- RVT90 Dies (Models 1, 2, 3) are compatible with press brakes machines (12.7 mm / 0.50 in pins) from: LVD
- RVM Dies (Models 2.5, 3, 4) are compatible with all press brake machines (various die holders)
- all dies are compatible on other press brakes machines with the means of adapter-systems or customized die holders.

Our Advantages – Your Convenience

- high precision grounded
- Interchangability guaranteed
- exact Parallelism
- avoiding bending marks on the sheet metals
- minimum borders bending mark free
- no tool contamination throughout the bending of galvanized sheet metal or aluminum
- extremely short flanges
- less tool exchange
- ideal for diagonal or tapered edges



Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

|         | Model               | Material Type | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------|---------------------|---------------|--|--|
| Body    | 1 / 2 / 2.5 / 3 / 4 | 42CrMo4       | 1100-1200 N/mm <sup>2</sup>                | 50 - 55 HRC  |
| Inserts | 1                   | Toolox 44     | 1450 N/mm <sup>2</sup>                     | through hardened 44 HRC                                      |
| Inserts | 2 / 2.5 / 3 / 4     | Toolox 33     | 1100 N/mm <sup>2</sup>                     | 55 - 58 HRC  |

• Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN.**

|   | Equivalent V size mm (in) | Material Thickness mm (in) | min. outside flange mm (in) | needed press force (kN) | max. tool load (kN/m) | min. bending angle |
|---|---------------------------|----------------------------|-----------------------------|-------------------------|-----------------------|--------------------|
| Model 1<br>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<br>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<br>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°                |
| Model 3<br>Max. recommended thickness = 6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)    | 38 (1.50)                 | 4.00 (0.16)                | 22.5 (0.89)                 | 270                     | 2500                  | 47°                |
|   |                           | 6.00 (0.24)                | 22.5 (0.89)                 | 800                     | 2500                  | 50°                |

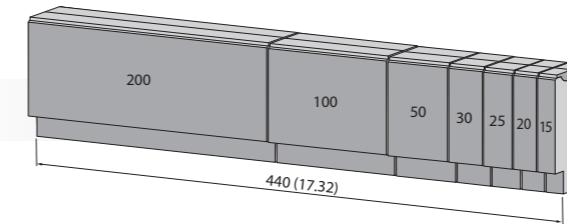
Tool lengths and sectioning

Standard

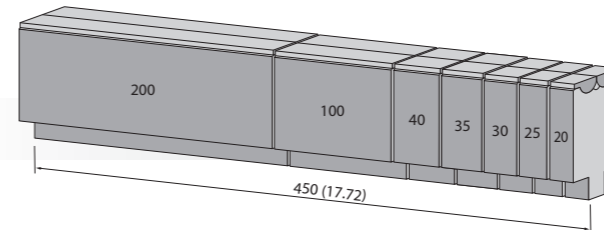


Segmented tools are delivered in complete sets. Single pieces are also available!  
More lengths and sectionings are possible upon request.

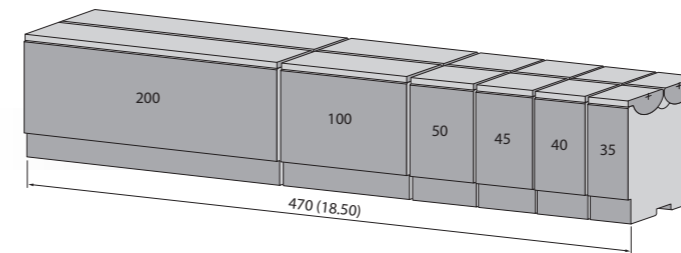
500 mm (19.68 in)  
200 mm (7.87 in)



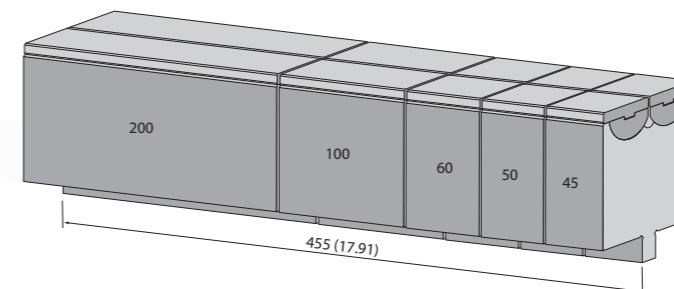
Model 1, 440 mm (17.32 in) segmented (7 segments)



Model 2, 450 mm (17.72 in) segmented (7 segments)



Model 2.5, 470 mm (18.50 in) segmented (6 segments)



Model 3, 455 mm (17.91 in) segmented (5 segments)



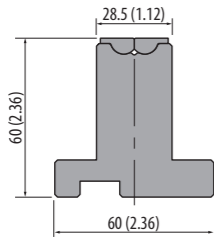


# DIES ROLLA-V


## Model 1

### RVP60-1 1000 kN/m max.

**NEW**

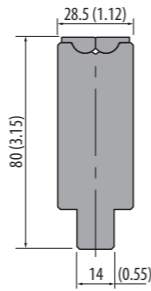


|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 6.9 kg |
| 440 mm segmented | 17.32 in segmented | 6.1 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVS80-1 1000 kN/m max.

**NEW**

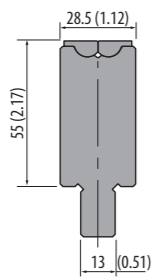


|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 6.3 kg |
| 440 mm segmented | 17.32 in segmented | 5.8 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVT55-1 1000 kN/m max.

**NEW**

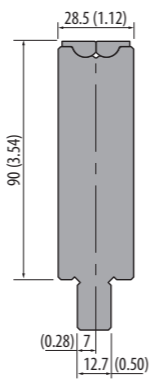


|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 5.5 kg |
| 440 mm segmented | 17.32 in segmented | 5.0 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVT90-1 1000 kN/m max.

**NEW**

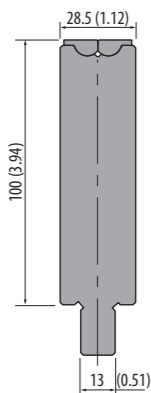


|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 8.5 kg |
| 440 mm segmented | 17.32 in segmented | 7.8 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVT100-1 1000 kN/m max.

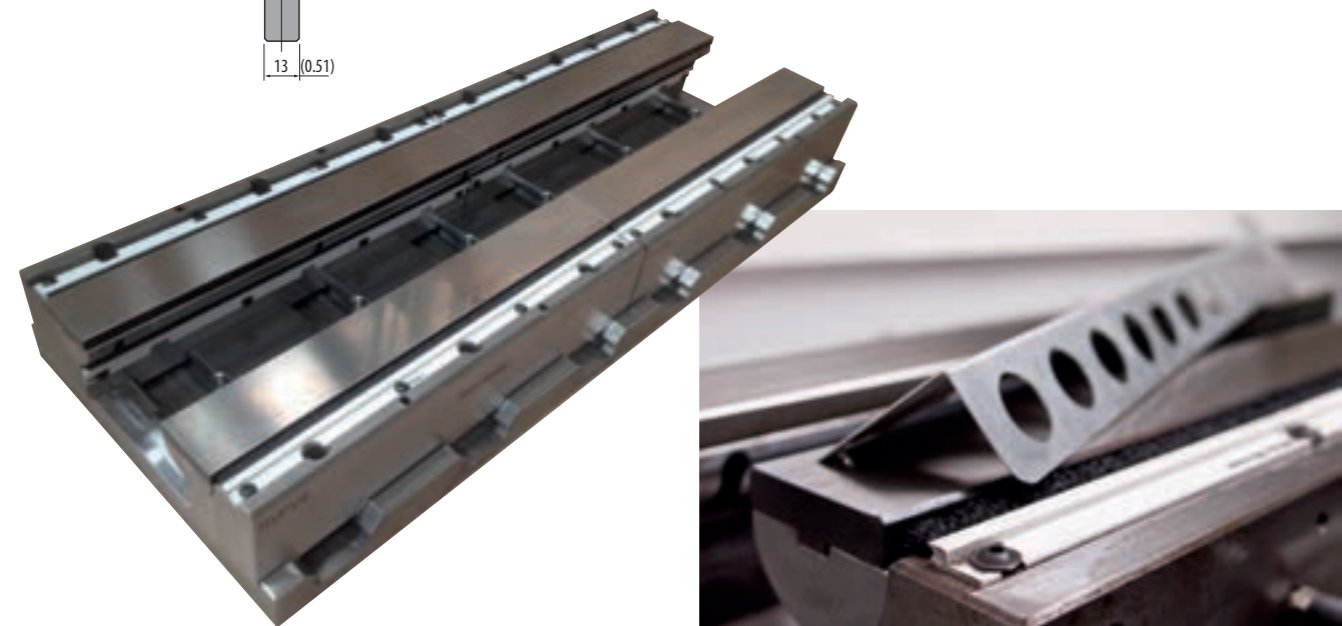
**NEW**



|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 9.4 kg |
| 440 mm segmented | 17.32 in segmented | 8.6 kg |

42Cr: 1100-1200 N/mm<sup>2</sup> 

**Ideal for thick material!**  
Making the impossible, possible ...

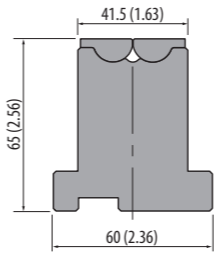


# DIES ROLLA-V


## Model 2

### RVP65-2 1500 kN/m max.

**NEW**

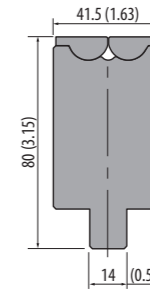


|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 7.9 kg |
| 450 mm segmented | 17.72 in segmented | 7.4 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVS80-2 1500 kN/m max.

**NEW**

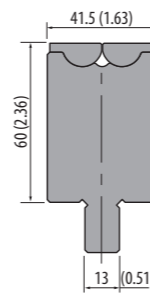


|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 8.3 kg |
| 450 mm segmented | 17.72 in segmented | 7.8 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVT60-2 1500 kN/m max.

**NEW**

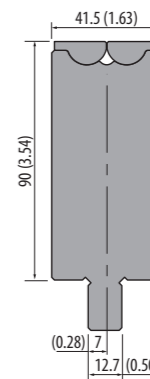


|                  |                    |        |
|------------------|--------------------|--------|
| 500 mm           | 16.68 in           | 7.9 kg |
| 450 mm segmented | 17.72 in segmented | 7.4 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVT90-2 1500 kN/m max.

**NEW**

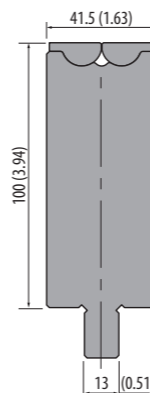


|                  |                    |         |
|------------------|--------------------|---------|
| 500 mm           | 16.68 in           | 11.3 kg |
| 450 mm segmented | 17.72 in segmented | 10.6 kg |


42Cr: 1100-1200 N/mm<sup>2</sup> 

### RVT100-2 1500 kN/m max.

**NEW**



|                  |                    |         |
|------------------|--------------------|---------|
| 500 mm           | 16.68 in           | 12.4 kg |
| 450 mm segmented | 17.72 in segmented | 11.7 kg |

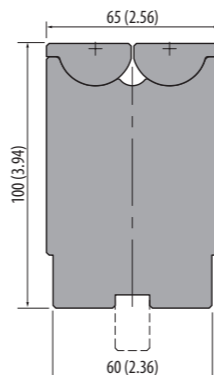
42Cr: 1100-1200 N/mm<sup>2</sup> 




## Model 2.5

### RVM2.5 2000 kN/m max.

**NEW**



|                  |                    |         |
|------------------|--------------------|---------|
| 500 mm           | 16.68 in           | 22.0 kg |
| 470 mm segmented | 18.50 in segmented | 21.0 kg |

42Cr: 1100-1200 N/mm<sup>2</sup> 

**Rolleri Videos**



Use and application of Rolla-V dies  
[www.rolleritools.com/videos/rolla-v](http://www.rolleritools.com/videos/rolla-v)



## DIES ROLLA-V

### Model 3

#### RVP100-3 2500 kN/m max.

**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 500 mm           | 16.68 in           | 28.8 kg |
| 455 mm segmented | 17.91 in segmented | 26.2 kg |

42Cr: 1100-1200 N/mm<sup>2</sup>

#### RVM70-3 2500 kN/m max.

**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 500 mm           | 16.68 in           | 20.6 kg |
| 455 mm segmented | 17.91 in segmented | 18.7 kg |

42Cr: 1100-1200 N/mm<sup>2</sup>

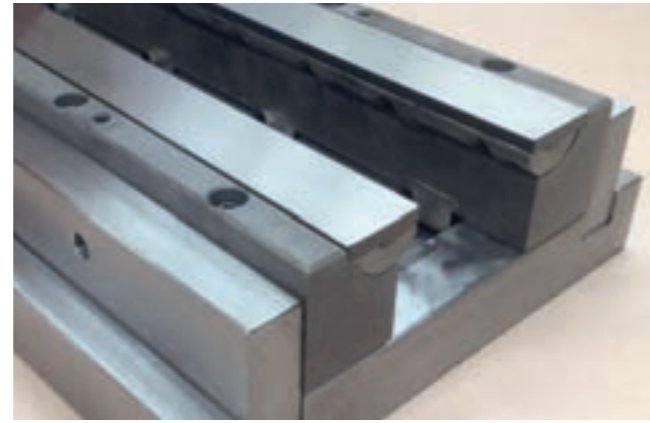
Possible Die Holders:  
 - 60 mm (2.36 in)  
 - 13 mm (0.51 in) pin  
 - 12.7 mm (0.50 in) pin  
 - 12.8 mm (0.50 in) offset pin

#### RVT100-3 2500 kN/m max.

**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 500 mm           | 16.68 in           | 30.9 kg |
| 455 mm segmented | 17.91 in segmented | 28.5 kg |

42Cr: 1100-1200 N/mm<sup>2</sup>



### Model 4

#### Our Advantages – Your Convenience

The **model 4 tools** and the **adjustable dies** are for bending thick material and large radii. Material specifications vary greatly, therefore no specific data can be given.

- Minimum borders are highly dependant on the squareness of the component.
- Enlargement and hole distortion will be greatly reduced, however will be influenced depending on the type of material
- Radius bending is strongly influenced by the elastic return of specific material and flange-size.

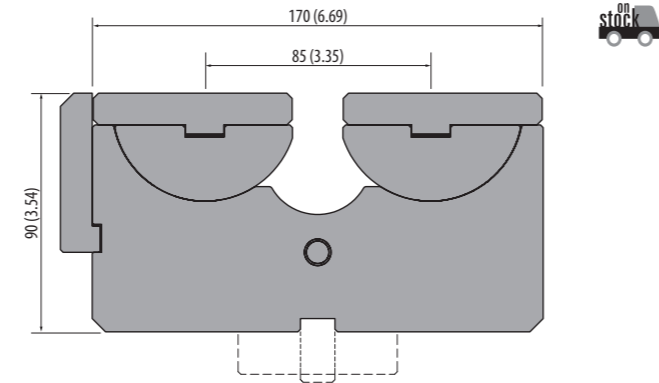
For advice please contact us!

#### RVM90-4 3000 kN/m max.

**NEW**

|        |          |         |
|--------|----------|---------|
| 500 mm | 16.68 in | 56.6 kg |
| 200 mm | 7.87 in  | 22.7 kg |

42Cr: 1100-1200 N/mm<sup>2</sup>



Possible Die Holders:  
 - 60 mm (2.36 in)  
 - 13 mm (0.51 in) pin  
 - 12.7 mm (0.50 in) pin  
 - 12.8 mm (0.50 in) offset pin

## DIES ROLLA-V

### Adjustable Dies



#### Our advantages – Your Convenience

- bending possible up to the thickness of 30 mm (1.18 in)
- inserts hardened
- no bending marks
- adjustable openings  
 RVPV3 = 39-94 mm (1.54-3.70 in)  
 RVHD3 = 39-118 mm (1.54-4.65 in)  
 RVPV4 = 69-180 mm (2.72-7.09 in)
- bends laser-cut sheet metal without damaging the tool
- exact inner radius

#### RVPV3 2500 kN/m max.

**NEW**

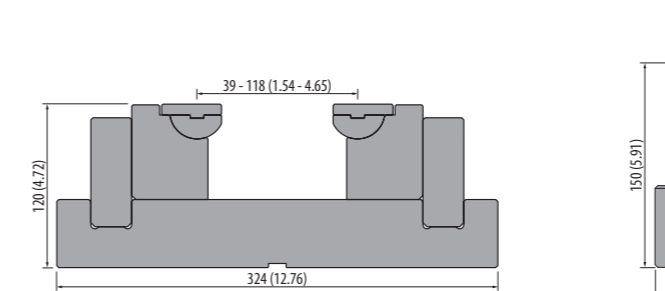
|        |          |         |
|--------|----------|---------|
| 500 mm | 16.68 in | 50.0 kg |
| 200 mm | 7.87 in  | 20.0 kg |

42Cr: 1100-1200 N/mm<sup>2</sup>

#### RVHD3 3500 kN/m max.

**NEW**

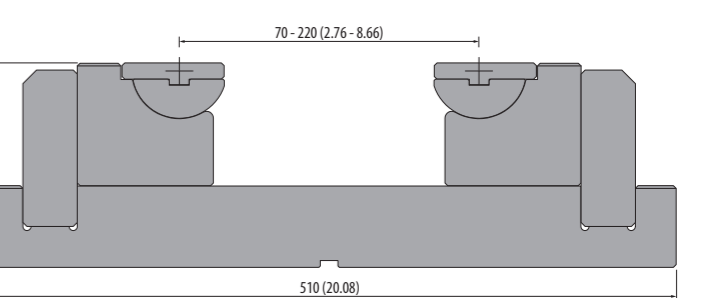
|        |          |         |
|--------|----------|---------|
| 500 mm | 16.68 in | 98.0 kg |
| 200 mm | 7.87 in  | 38.1 kg |



#### RVHD4 4000 kN/m max.

**NEW**

|        |          |          |
|--------|----------|----------|
| 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/mm<sup>2</sup>

#### Joggle Tool

**NEW**

|           |                    |
|-----------|--------------------|
| per piece | Price upon request |
|-----------|--------------------|

Production according to your specifications

42Cr: 1100-1200 N/mm<sup>2</sup>

## ROLLERI CLAMPING SYSTEMS

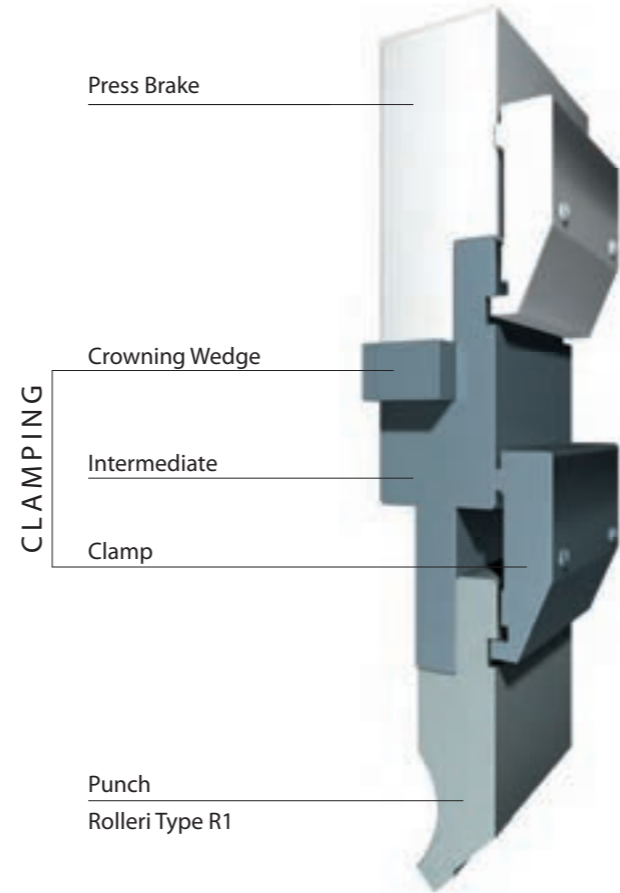
|   |           |
|---|-----------|
| Content Explanation                           | 198       |
| Intermediates                                 | 199       |
| Clamps  | 200 - 201 |
| ROL100-System for Punches Roller Type R1      | 202 - 203 |
| ROL1-System for Punches Roller Type R1        | 204 - 205 |
| ROL4-System for Punches Roller Type R1        | 205       |
| W-ROL PN-System for Punches Roller Type R2    | 206       |
| ROL3-System for Punches Roller Type R3 and RX | 207       |
| ROL2-System for Dies Roller Type R1           | 208 - 209 |
| Movable Die Clamps for Dies Roller Type R1    | 209       |



**Content Explanation**

**Standard-Clamping**

- for Punches Roller Type R1
- made of: Tensioning device + intermediate
- dual sided clamping (KDS-System)
- **horizontal tool exchange**
- see pages 199-201



**ROL100 Clamping**

- for Punches Roller Type R1
- **vertical tool exchange**
- can be used **without modifying** Punches Roller Type R1
- safety guard
- including selectable intermediates
- manual and pneumatic models available
- see pages 202-203



**ROL1 Clamping**

- for Punches Roller Type R1
- **vertical tool exchange**
- **modification necessary:** Punches Roller 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**

- for Punches Roller Type R1
- **horizontal tool exchange**
- can be used **without modifying** Punches Roller Type R1
- safety guard
- including selectable intermediates
- manual and hydraulic models available
- dual sided clamping integrated
- see pages 205



**W-ROL PN Clamping**

- for Punches Roller 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**

- for Punches Roller Type R3/RX
- **vertical or horizontal tool exchange**
- custom manufacturing
- safety guard
- hydraulic model available only
- see page 207



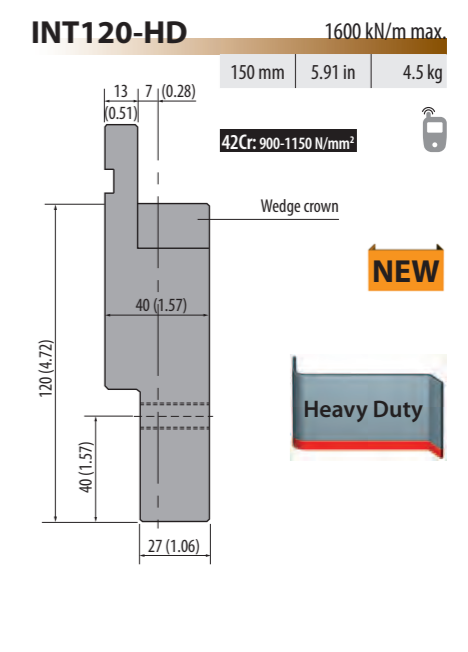
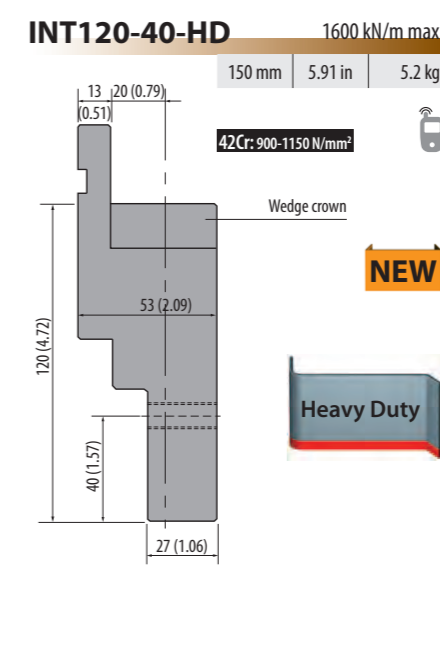
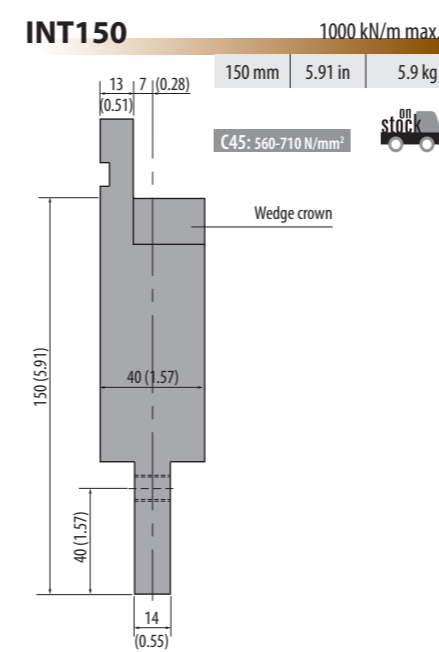
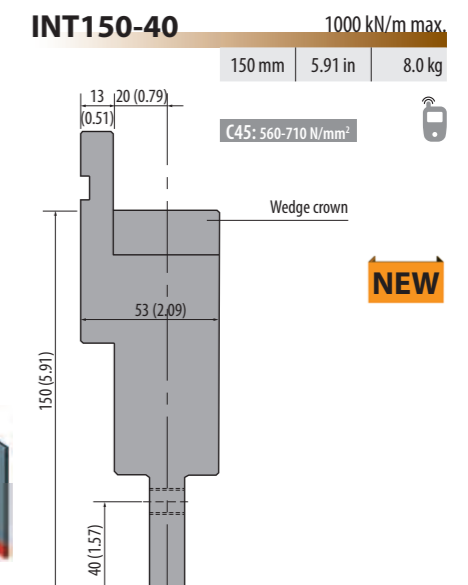
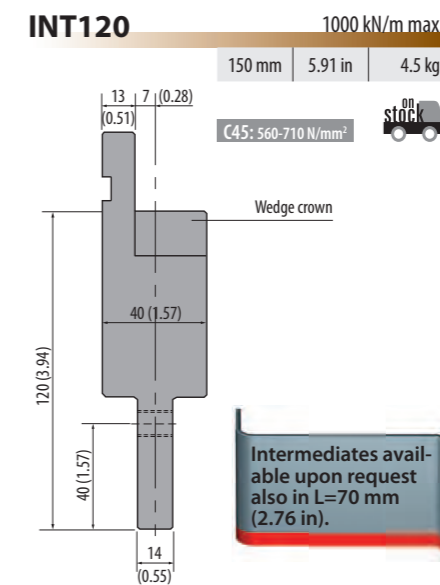
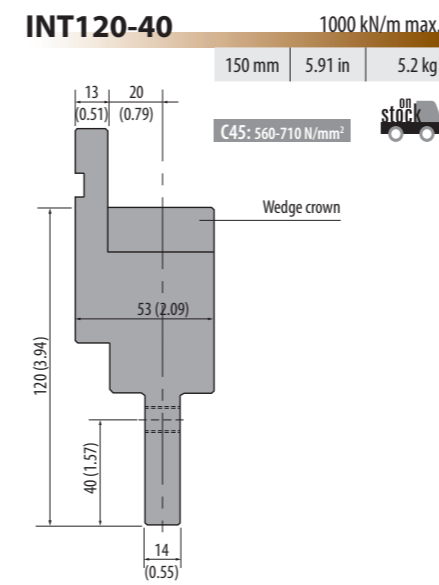
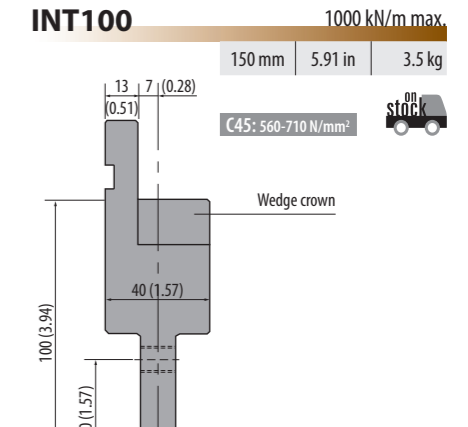
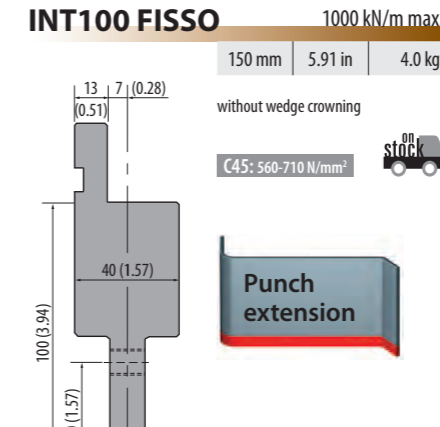
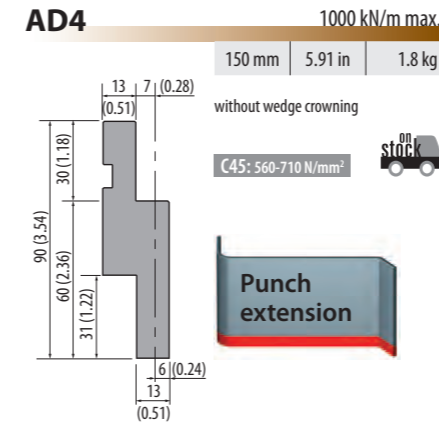
**ROL2 Clamping**

- for Dies Roller Type R1
- manual, pneumatic and hydraulic models available
- see pages 208-209

**Movable Die Clamps**

- for Dies Roller Type R1
- manual model available only
- see page 209

**Intermediates**



# R1 ROLLERI CLAMPING SYSTEMS

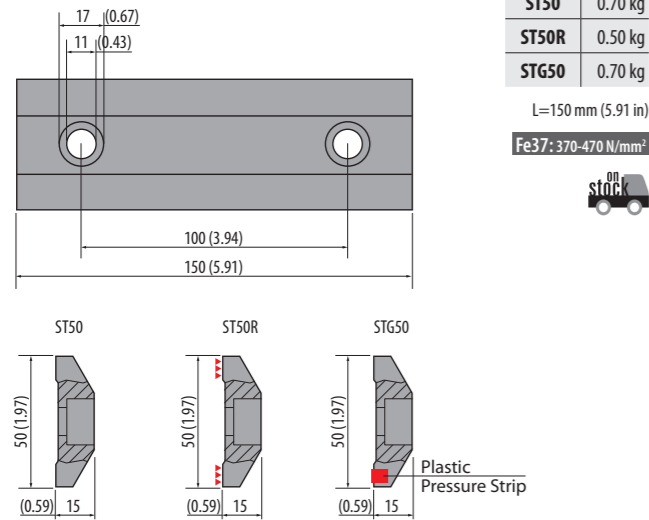
## Clamps

### Our Advantages – Your Convenience

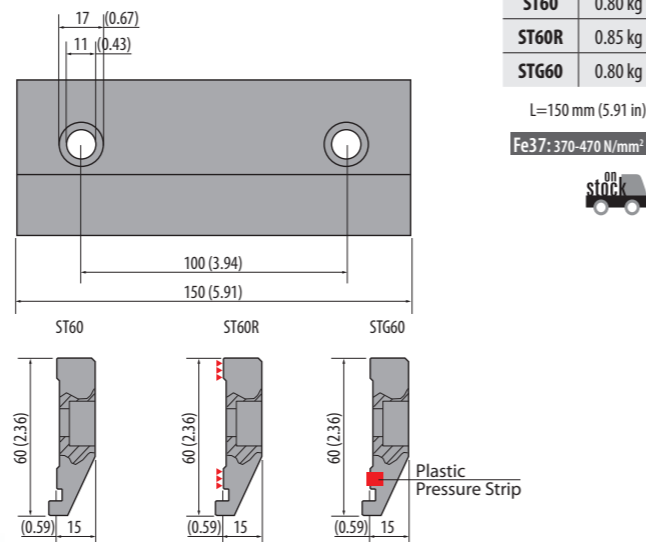
- Rapid Clamping Systems allow a fast horizontal tool exchange
- Plastic Pressure Strip improves the clamping especially with short tool pieces.

| needed clamps | Length of press brake |
|---------------|-----------------------|
| 4 pieces      | 835 mm (32.87 in)     |
| 6 pieces      | 1250 mm (49.21 in)    |
| 11 pieces     | 2100 mm (82.68 in)    |
| 14 pieces     | 2600 mm (102.36 in)   |
| 16 pieces     | 3100 mm (122.05 in)   |
| 21 pieces     | 4100 mm (161.42 in)   |

### ST50 / ST50R / STG50

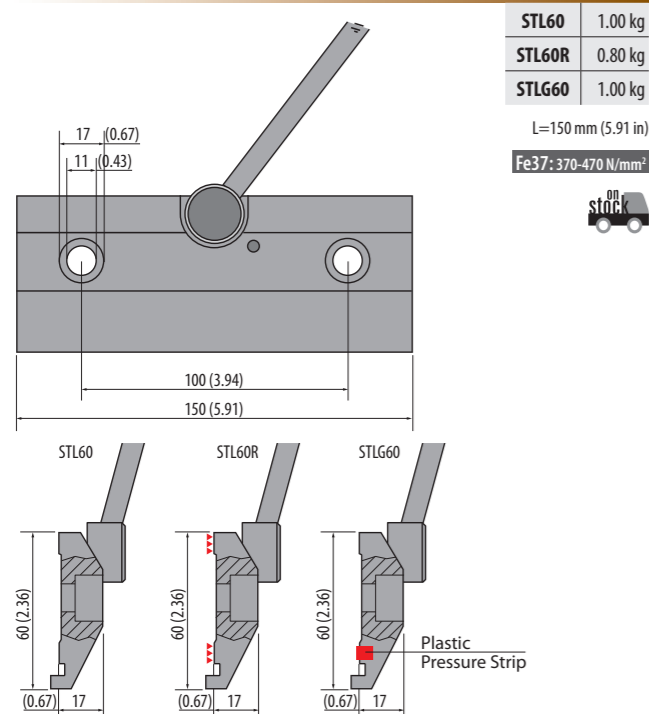


### ST60 / ST60R / STG60

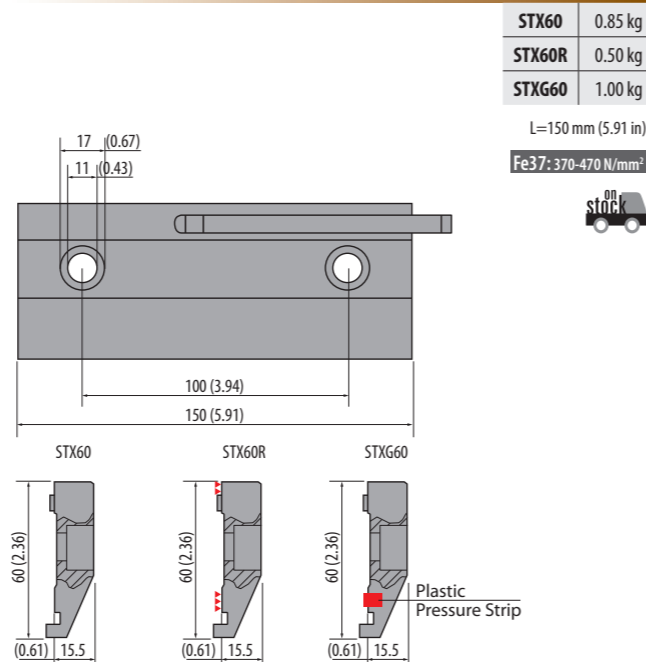


Compatible Intermediates on page 199

### STL60 / STL60R / STL60



### STX60 / STX60R / STX60

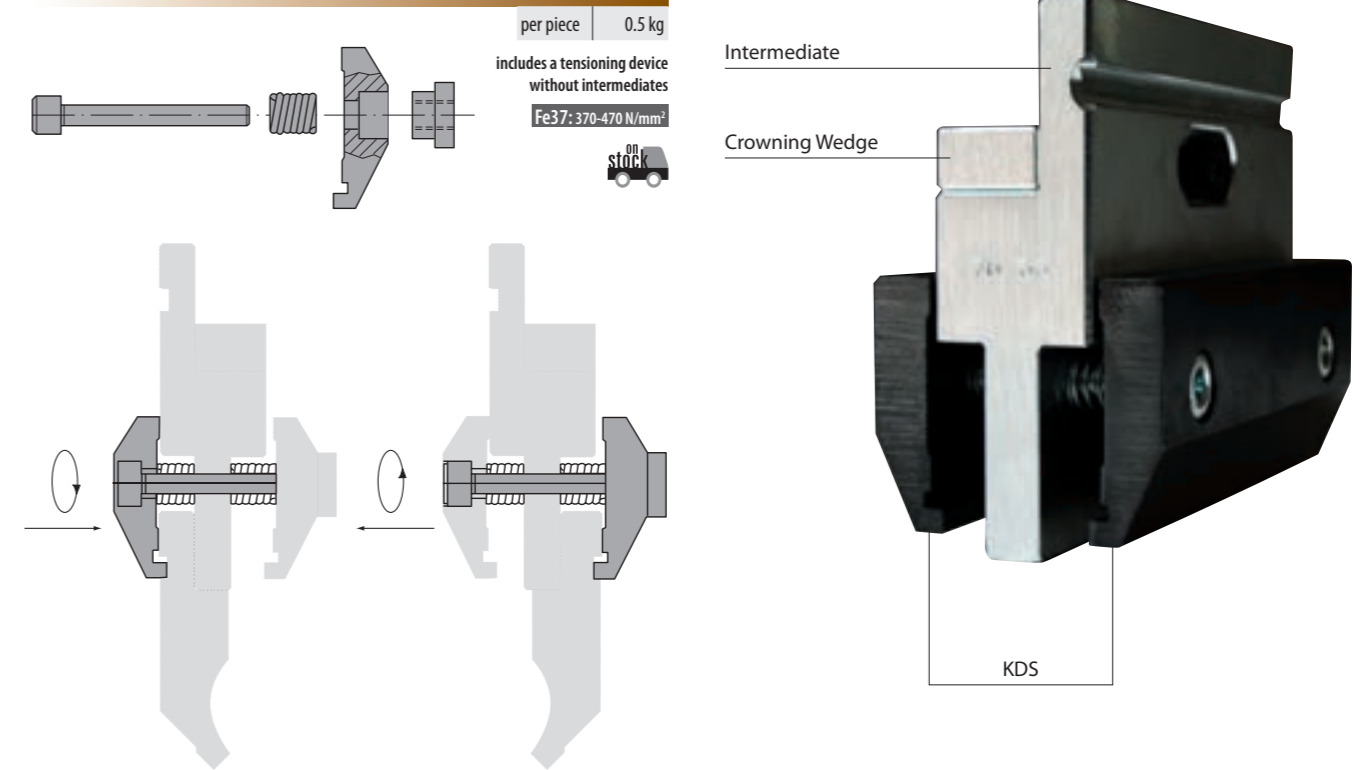


# R1 ROLLERI CLAMPING SYSTEMS

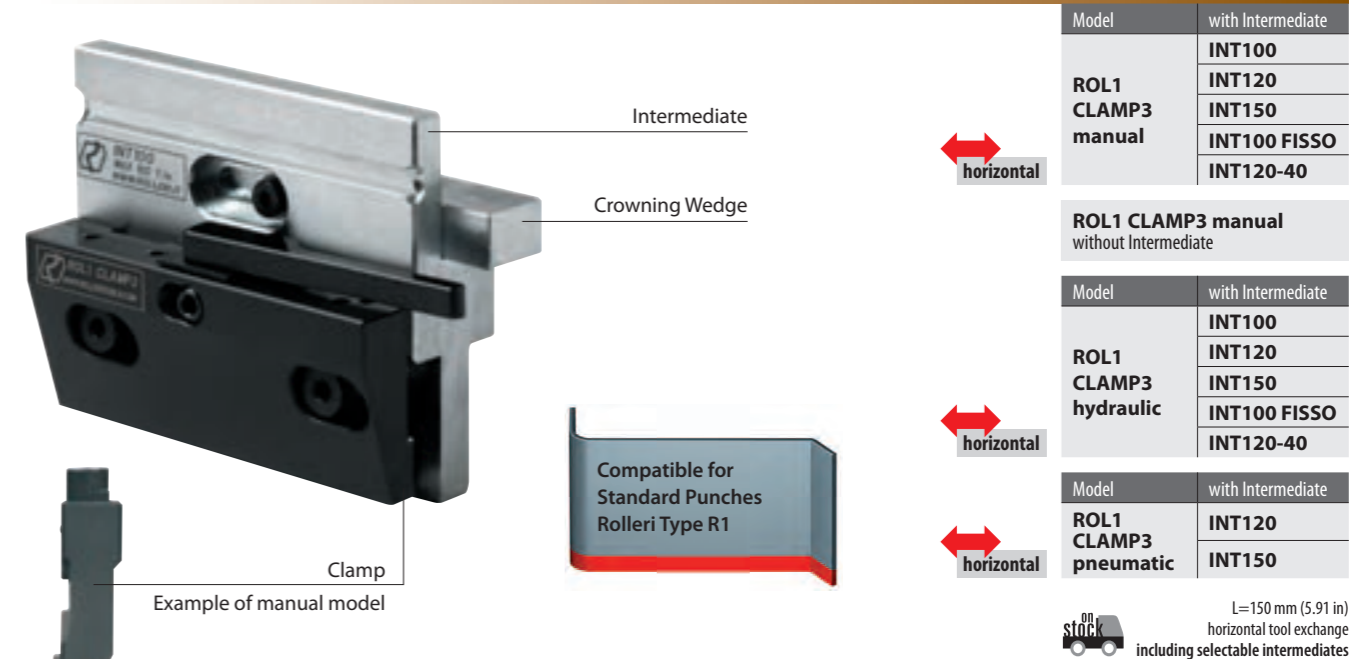
## Clamps



### KDS



### ROL1 CLAMP3 – manual – hydraulic – pneumatic



Compatible for Standard Punches Roller Type R1

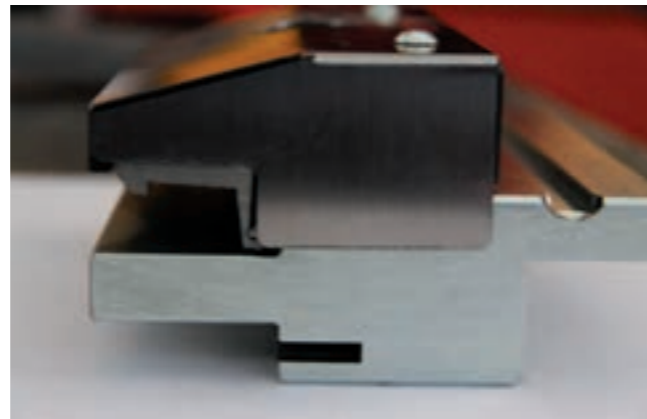
**Rolleri Videos**  
Application of Clamping System  
ROL1 CLAMP3: [www.rolleritools.com/videos/rol1-clamp3](http://www.rolleritools.com/videos/rol1-clamp3)

# R1 ROLLERI CLAMPING SYSTEMS

## ROL100-System for Punches Roller Type R1

### ... the newest innovation from our Research and Development Department

- fast **vertical** tool exchange for all Punches Roller Type R1
- can be used without modifying Punches Roller Type R1
- safe and fast tool exchange
- significant savings on your setup costs
- no falling out of tools
- available in manual and pneumatic models
- Mounting:  
Simply from the bottom into the housing, tighten – DONE!
- Disassembly:  
Untighten, gently lift tool and remove downwards.
- Easy to mount on your press brake.  
A conversion of the press brake is not necessary.
- For Press Brake Machines and Punches Roller Type R1:  
(ACL, Accurpress, Amada, Atlantic, Adira, Baykal, BL, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Dener, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturraspe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.)



Articles on stock – Please note that delivery time varies according to your location. 



# R1 ROLLERI CLAMPING SYSTEMS

## ROL100-System for Punches Roller Type R1



### ROL100 – manual

**NEW**



| Model         | with Intermediate |
|---------------|-------------------|
| ROL100 manual | INT100            |
|               | INT120            |
|               | INT150            |
|               | INT100 FISSO      |

 vertical

L=150 mm (5.91 in)  
vertical tool exchange  
including selectable intermediates



The ROL100-System is suited for Standard-Punches. There are no modifications necessary!

### ROL100 – pneumatic

**NEW**



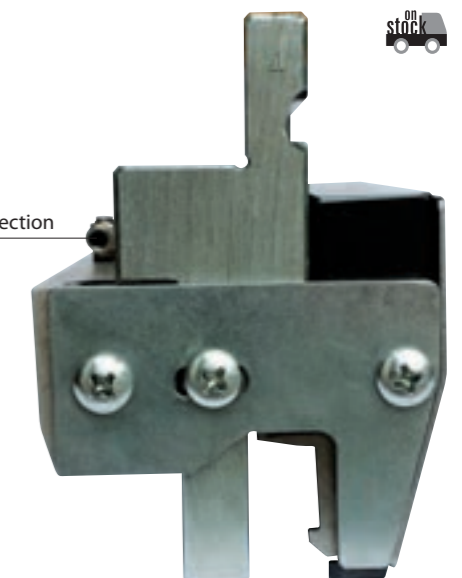
| Model            | with Intermediate |
|------------------|-------------------|
| ROL100 pneumatic | INT100            |
|                  | INT120            |
|                  | INT150            |
|                  | INT100 FISSO      |

 vertical

L=150 mm (5.91 in)  
vertical tool exchange  
including selectable intermediates



Pneumatic connection



# R1 ROLLERI CLAMPING SYSTEMS

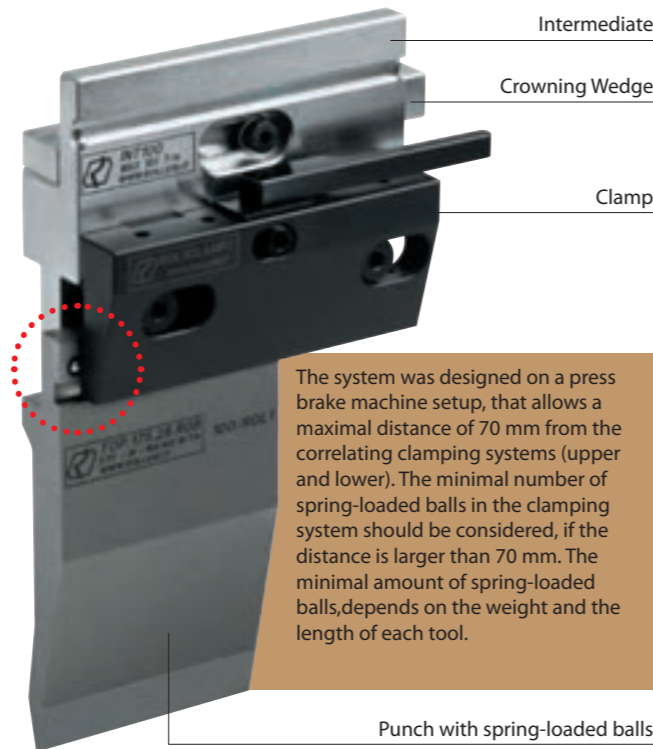
## ROL1-System for Punches Roller Type R1

In order to use the ROL1 System, the punches are modified and equipped with spring-loaded balls.

ROL1 can be used on all press brakes with standard tang intermediates of Roller Type R1.

### Our Advantages – Your Convenience

- **vertical clamping** of tools is possible on press brakes thanks to a row of **spring-loaded balls** which are also used as **safety guards** to prevent the falling out of tools.
- complete mechanic functioning fast clamping system for press brake machines.
- Productivity and Versatility of the press brake machines will be increased.
- Significant **reduction in the set-up times** when changing tools



### ROL1 CLAMP1 – manual

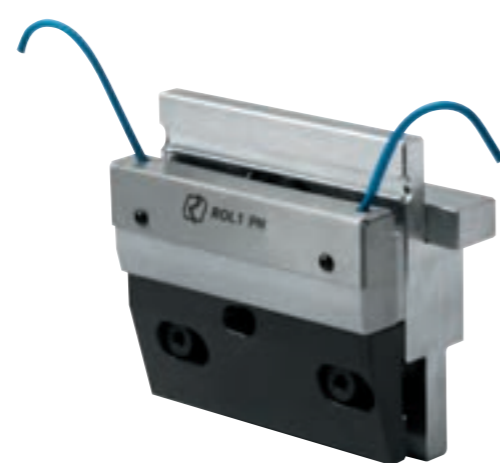
| Model       | with Intermediate | L=150 mm (5.91 in)<br>vertical tool exchange<br>including selectable intermediates |
|-------------|-------------------|--|
| ROL1 CLAMP1 | INT100            | vertical<br>stock  |
|             | INT120            |  |
|             | INT150            |  |
|             | INT100 FISSO      |  |
|             | INT120-40         |  |

ROL1 CLAMP1  
without Intermediate

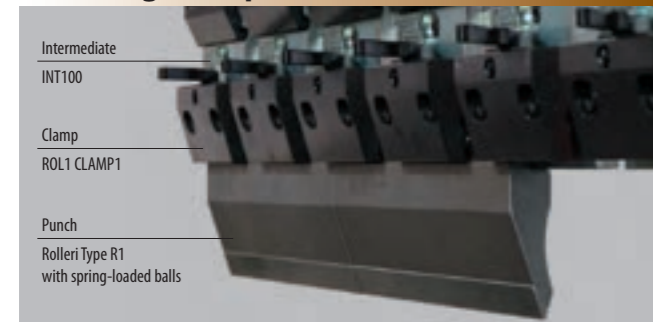


### ROL1 PN CLAMP1 – pneumatic

| Model          | with Intermediate | L=150 mm (5.91 in)<br>vertical tool exchange<br>including selectable intermediates |
|----------------|-------------------|--|
| ROL1 PN CLAMP1 | INT120            | vertical<br>stock  |
|                | INT150            |  |
|                |                   |  |



### Mounting example



**Rolleri Videos**  
Application of Clamping Systems  
ROL1 CLAMP1: [www.rolleritools.com/videos/rol1-clamp1](http://www.rolleritools.com/videos/rol1-clamp1)

# R1 ROLLERI CLAMPING SYSTEMS

## ROL1-System for Punches Roller Type R1



### ROL1 HYD CLAMP1 – hydraulic

| Model           | with Intermediate | L=150 mm (5.91 in)<br>vertical tool exchange<br>including selectable intermediates |
|-----------------|-------------------|--|
| ROL1 HYD CLAMP1 | INT100            | vertical<br>stock  |
|                 | INT120            |  |
|                 | INT150            |  |
|                 | INT100 FISSO      |  |
|                 | INT120-40         |  |



### ROL1 KDS

| Model    | with Intermediate | with Clamp1       | with Clamp3         | L=150 mm<br>vertical tool exchange<br>including selectable intermediates |
|----------|-------------------|-------------------|---------------------|--|
| ROL1 KDS | INT100            | vertical<br>stock | horizontal<br>stock |  |
|          | INT120            |                   |                     |  |
|          | INT150            |                   |                     |  |
|          | INT100 FISSO      |                   |                     |  |
|          | INT120-40         |                   |                     |  |



Detailed information  
about intermediates  
on page 199

## ROL4-System for Punches Roller Type R1

### ROL4 – manual

| Model       | with Intermediate | L=150 mm (5.91 in)<br>horizontal tool exchange<br>including selectable intermediates<br>integrated KDS-System |
|-------------|-------------------|---|
| ROL4 manual | INT100            | horizontal<br>stock   |
|             | INT120            |   |
|             | INT150            |   |
|             | INT100 FISSO      |   |
|             |                   |   |



### ROL4 – hydraulic

| Model          | with Intermediate | L=150 mm (5.91 in)<br>horizontal tool exchange<br>including selectable intermediates<br>integrated KDS-System |
|----------------|-------------------|---|
| ROL4 hydraulic | INT100            | horizontal<br>stock   |
|                | INT120            |   |
|                | INT150            |   |
|                | INT100 FISSO      |   |
|                | INT120-40         |   |



**Rolleri Videos**  
Application of hydraulic clamping ROL4  
[www.rolleritools.com/videos/rol4-hydraulic-clamping](http://www.rolleritools.com/videos/rol4-hydraulic-clamping)

The ROL4-System is suitable for Standard-Punches Roller Type R1. There are no modifications necessary!

# R2 ROLLERI CLAMPING SYSTEMS

W-ROL PN for Punches Roller Type R2

W-ROL PN – pneumatic

515 mm | 20.28 in | 26.8 kg/m

vertical



## Our Advantages – Your Convenience

- vertical tool exchange of punches with:
  - ROL1-System
  - QuickLock-System
- Horizontal tool exchange of punches with safety pins
- significantly more efficient bending productivity



# R3/RX ROLLERI CLAMPING SYSTEMS

ROL3-System for Punches Roller Type R3 and RX



ROL3 HYD – hydraulic

500 mm | 19.68 in

vertical

horizontal



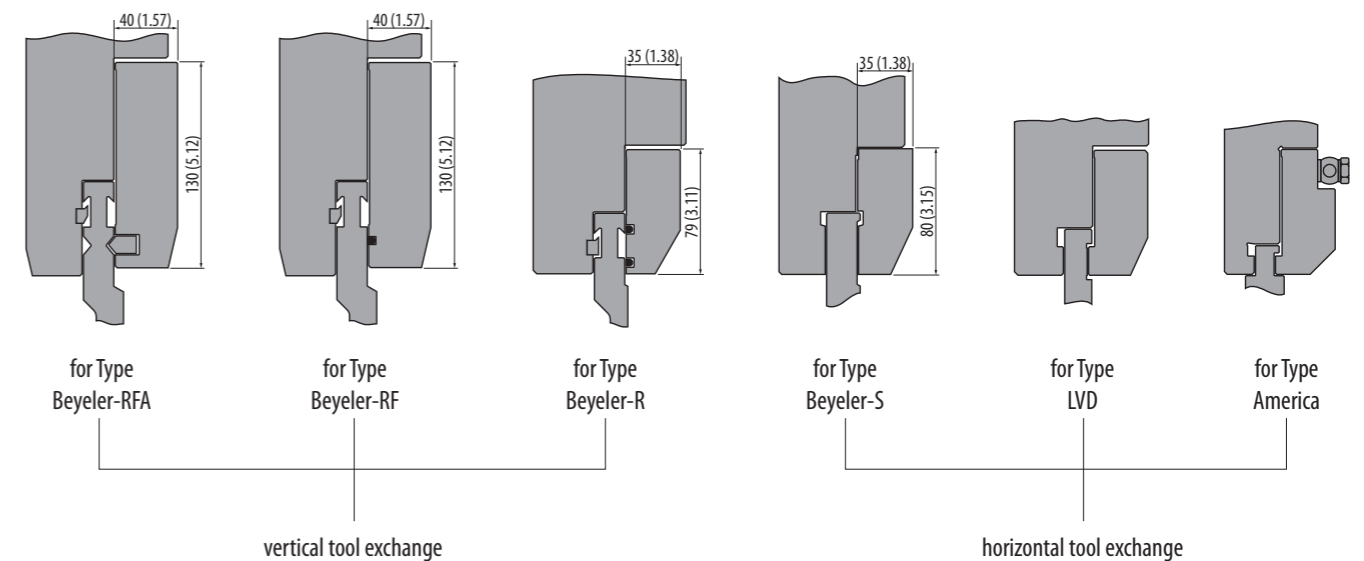
## Our Advantages – Your Convenience

- can be used on press brake machines with different tang types
- custom manufacturing possible upon request
- significantly more efficient bending productivity



Equip your press brake with our ROL3 system in order to use the advantages of a hydraulic clamping system!

## Examples of ROL3 with various systems





# R1 ROLLERI CLAMPING SYSTEMS

## ROL2-System for Dies Roller Type R1

### ■ Explanations

The **ROL2 System** is a system which is used to secure the die into place. It is made up of a special bar (known as **ROL2 CLAMP1**, L=500 mm / 19.68 in), which is operated through a centralized lever.

The **ROL2 System** has a built in spring mechanism and the clamp plates **ROL2 CLAMP1** are positioned in the inner lining of the system, which can be opened or tightened for the die to be perfectly secured.

A special rubber insert inside the clamp plates grants the best positioning for the tools. The press force of the clamp plates is evenly distributed along the complete length. Therefore short tools are also securely fastened.

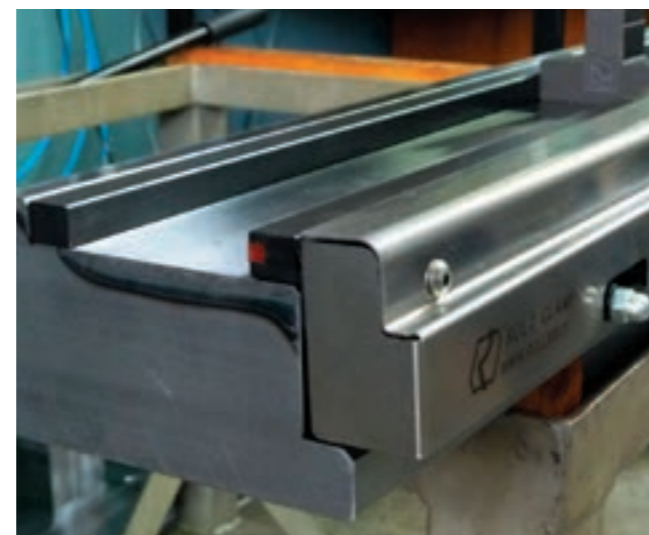
At a press brake of 3 meters (118.11 in), for example; all dies are secured with 6 simple hand movements.

### ■ Application

- **Directly on the die holder with 60 mm / 2.36 in width**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - alternatively modifications of the existing threaded holes necessary
  - system is compatible for press brakes with automatic coving tables
- **Directly on the die holder with 90 mm / 3.54 in width**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - alternatively modifications of the existing threaded holes necessary
  - for the use of dies Roller Type R1, two 15 mm / 0.59 in wide inserts are mounted and ground (securing with pins)
  - with rubber corners, the use of short tools is possible and are perfectly secured.
- **With Die Holder on the Die Rail**
  - 60 x 55 mm / 2.36 x 2.167 in Die Holder, ground and induction hardened.

### ■ Our Advantages – Your Convenience

- fast exchange of tools
- very time saving
- reduced production costs
- significantly increased profitability
- improved competitiveness



# R1 ROLLERI CLAMPING SYSTEMS

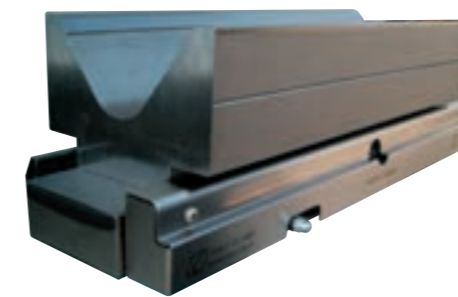
## ROL2-System for Dies Roller Type R1



### ROL2 – manual

| Clamp incl. Die holder |         |         |
|------------------------|---------|---------|
| table: 60 mm           | 2.36 in | 38.0 kg |
| table: 90 mm           | 3.54 in | 58.0 kg |

L=1075 mm (42.32 in)



| only Clamp   |         |        |
|--------------|---------|--------|
| table: 60 mm | 2.36 in | 4.0 kg |
| table: 90 mm | 3.54 in | 4.5 kg |

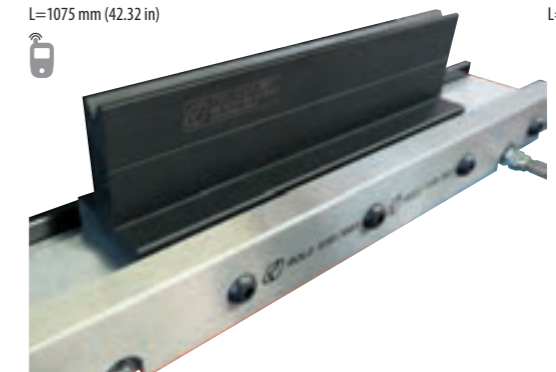
L=500 mm (19.68 in)



### ROL2 – hydraulic

| Clamp incl. Die holder |         |         |
|------------------------|---------|---------|
| table: 60 mm           | 2.36 in | 23.0 kg |
| table: 90 mm           | 3.54 in | 31.7 kg |

L=1075 mm (42.32 in)



| only Clamp   |         |        |
|--------------|---------|--------|
| table: 60 mm | 2.36 in | 5.0 kg |
| table: 90 mm | 3.54 in | 5.5 kg |

L=500 mm (19.68 in)



### ROL2 – pneumatic

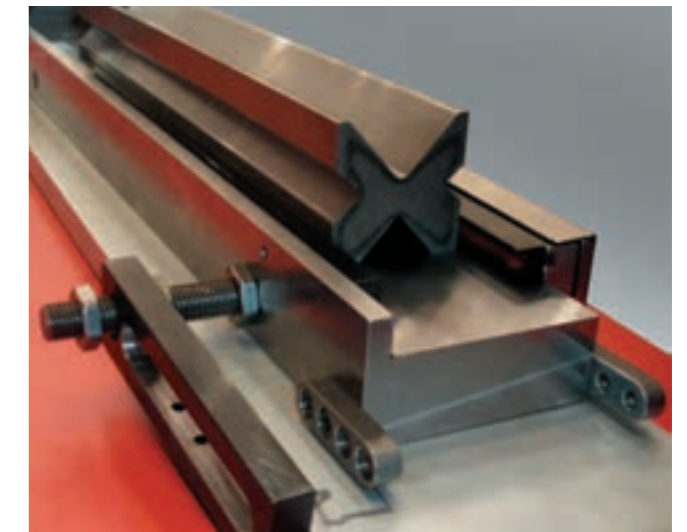
| Clamp incl. Die holder |         |         |
|------------------------|---------|---------|
| table: 60 mm           | 2.36 in | 23.0 kg |
| table: 90 mm           | 3.54 in | 31.7 kg |

L=1075 mm (42.32 in)



| only Clamp   |         |        |
|--------------|---------|--------|
| table: 60 mm | 2.36 in | 5.0 kg |
| table: 90 mm | 3.54 in | 5.5 kg |

L=500 mm (19.68 in)



## Movable Die Clamps for Dies Roller Type R1

### ■ Our Advantages – Your Convenience

- lowerable clamping plate
- significantly easier exchange of tools, due the possibility of removing the tool by sliding it out and not lifting the tool.



### Rolleri Videos

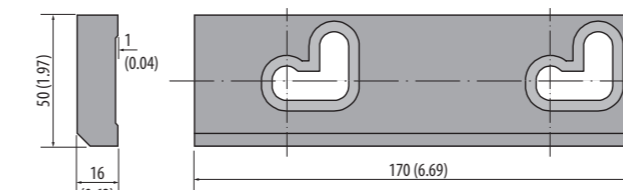
movable die holders ST50-S:  
[www.rolleritools.com/videos/movable-die-holders](http://www.rolleritools.com/videos/movable-die-holders)



### ST50-S

per piece 0.70 kg

Fe37: 370-470 N/mm<sup>2</sup>



## ROLLERI ADAPTERS

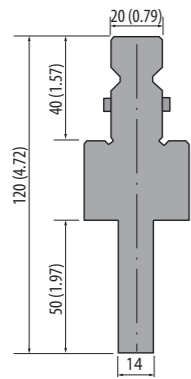
|                                |           |
|--------------------------------|-----------|
| Punch Adapters                 | 208 - 211 |
| Bolted Adapters                | 212 - 213 |
| Die Adapter Rails              | 214       |
| Die Adapters                   | 215 - 217 |
| Modification: Wedge Bar / Tail | 217       |



# ROLLERI ADAPTERS

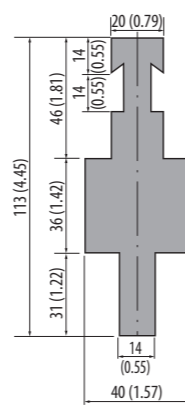
## Punch Adapters

### AD11 1000 kN/m max.



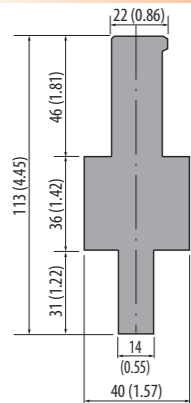
150 mm 5.91 in 3.0 kg  
 Rolleri Type R2  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

### AD22 1000 kN/m max.



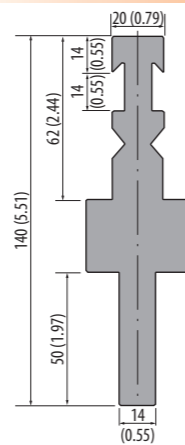
150 mm 5.91 in 3.4 kg  
 Rolleri Type R3 Beyeler R  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

### AD3 1000 kN/m max.



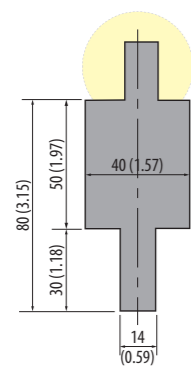
150 mm 5.91 in 3.3 kg  
 Rolleri Type R3 Beyeler S  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

### AD10 1000 kN/m max.



150 mm 5.91 in 3.4 kg  
 Rolleri Type R3 Beyeler  
 RFA → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

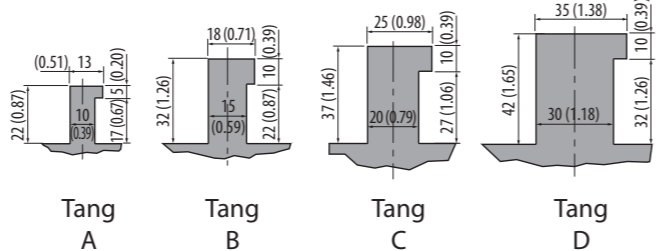
### AD1 1000 kN/m max.



|               |         |        |
|---------------|---------|--------|
| 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/mm<sup>2</sup>

### Tangs LVD



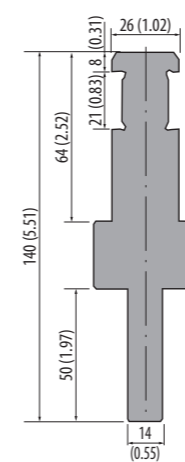
With adapters you can use the vast amount of Punches Rolleri Type R1!

# ROLLERI ADAPTERS

## Punch Adapters

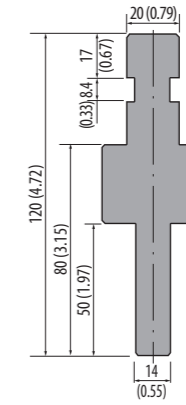


### AD13 1000 kN/m max.



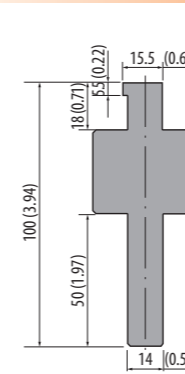
150 mm 5.91 in 3.0 kg  
 Rolleri Type RX EHT  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

### AD14 1000 kN/m max.



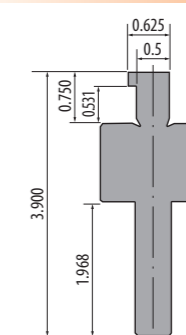
150 mm 5.91 in 3.2 kg  
 Rolleri Type RX Gasparini  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

### AD15 1000 kN/m max.



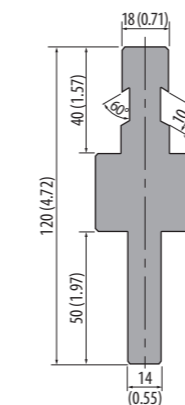
150 mm 5.91 in 4.0 kg  
 Rolleri Type RX Ajial-Axial  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

### AD16 1000 kN/m max.



5.9 inch 5.91 in 4.0 kg  
 Rolleri Type American  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

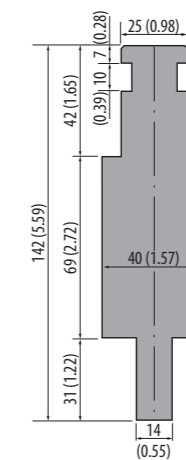
### AD12 1000 kN/m max.



150 mm 5.91 in 1.5 kg  
 Rolleri Type RX Colgar  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

### AD23 1000 kN/m max.

**NEW**



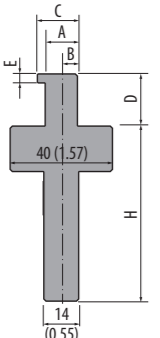
150 mm 5.91 in 5.0 kg  
 Rolleri Type RX Weinbrenner  
 → Rolleri Type R1  
 C45: 560-710 N/mm<sup>2</sup>

# ROLLERI ADAPTERS

## Punch Adapters

**ADX** 1000 kN/m max.

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 3.5 kg |
|--------|---------|--------|



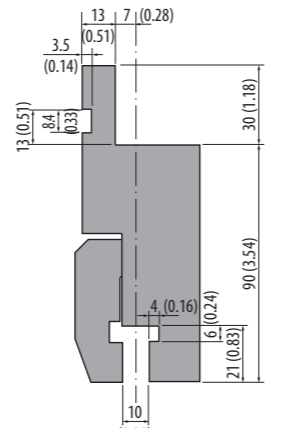
Type X  
→ **Rolleri Type R1**

Production according to your specifications

C45: 560-710 N/mm<sup>2</sup>

**AD19-A** 1000 kN/m max.

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 6.0 kg |
|--------|---------|--------|



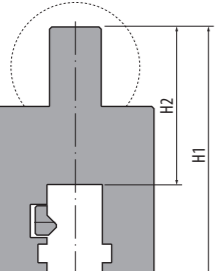
Rolleri Type R1  
→ **Rolleri Type RX LVD**

C45: 560-710 N/mm<sup>2</sup>

**ADX2** 1000 kN/m max.

**NEW**

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 4.0 kg |
|--------|---------|--------|



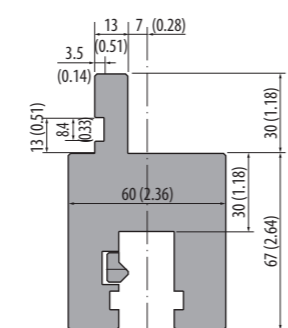
Type X  
→ **Rolleri Type R2**

Production according to your specifications

C45: 560-710 N/mm<sup>2</sup>

**AD20** 1000 kN/m max.

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 4.0 kg |
|--------|---------|--------|



Rolleri Type R1  
→ **Rolleri Type R2**

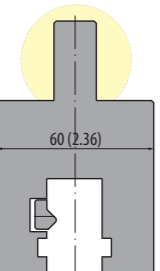
C45: 560-710 N/mm<sup>2</sup>

**Pneumatic Adapters**  
see page 206

**AD20 LVD** 1000 kN/m max.

**NEW**

|                    |        |         |        |
|--------------------|--------|---------|--------|
| Tang A: AD20 LVD-A | 150 mm | 5.91 in | 3.6 kg |
| Tang B: AD20 LVD-B | 150 mm | 5.91 in | 3.8 kg |
| Tang C: AD20 LVD-C | 150 mm | 5.91 in | 4.0 kg |
| Tang D: AD20 LVD-D | 150 mm | 5.91 in | 4.0 kg |



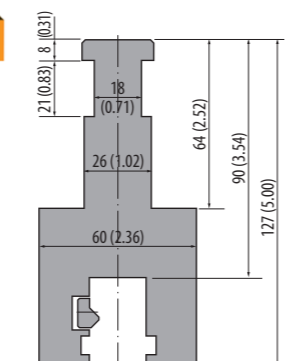
Rolleri Type RX LVD  
→ **Rolleri Type R2**

C45: 560-710 N/mm<sup>2</sup>

**AD28** 1000 kN/m max.

**NEW**

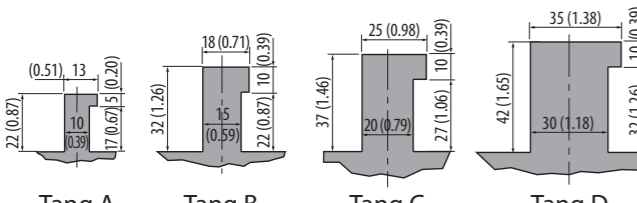
|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 5.0 kg |
|--------|---------|--------|



Rolleri Type RX EHT  
→ **Rolleri Type R2**

C45: 560-710 N/mm<sup>2</sup>

**Tangs LVD**



Tang A: 22 (0.87), 13 (0.51), 10 (0.39), 17 (0.67), 5 (0.20)

Tang B: 32 (1.26), 18 (0.71), 15 (0.59), 22 (0.87), 10 (0.39)

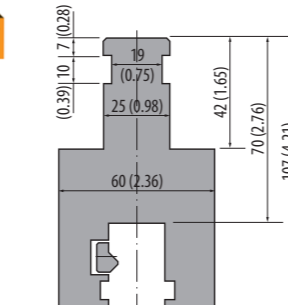
Tang C: 25 (0.98), 37 (1.46), 20 (0.79), 27 (1.06), 10 (0.39)

Tang D: 35 (1.38), 42 (1.65), 30 (1.18), 32 (1.26), 10 (0.39)

**AD29** 1000 kN/m max.

**NEW**

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 4.5 kg |
|--------|---------|--------|



Rolleri Type RX Weinbrenner  
→ **Rolleri Type R2**

C45: 560-710 N/mm<sup>2</sup>

**Rolleri Videos**

Bolted Adapters AW, P. 216-217

[www.rolleritools.com/videos/bolted-adapters](http://www.rolleritools.com/videos/bolted-adapters)

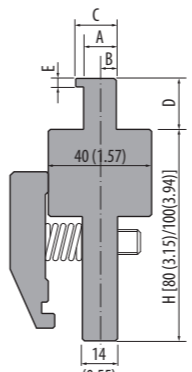


# ROLLERI ADAPTERS

## Punch Adapters

**INT80-100** 1000 kN/m max.

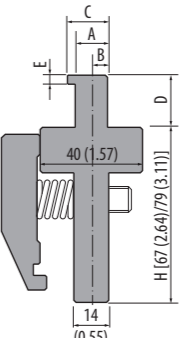
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 25.0 kg |
| 415 mm | 16.34 in | 12.5 kg |



C45: 560-710 N/mm<sup>2</sup>

**INT67-79** 1000 kN/m max.

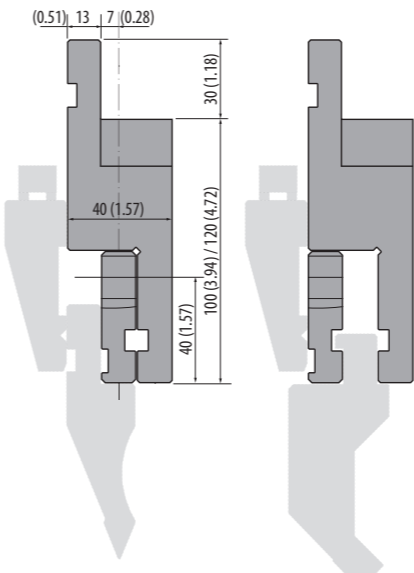
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 20.5 kg |
| 415 mm | 16.34 in | 10.0 kg |



C45: 560-710 N/mm<sup>2</sup>

**INT100-A / INT120-A** 1000 kN/m max.

|                 |        |         |        |
|-----------------|--------|---------|--------|
| <b>INT100-A</b> | 150 mm | 5.91 in | 3.5 kg |
| <b>INT120-A</b> | 150 mm | 5.91 in | 5.2 kg |



C45: 560-710 N/mm<sup>2</sup>

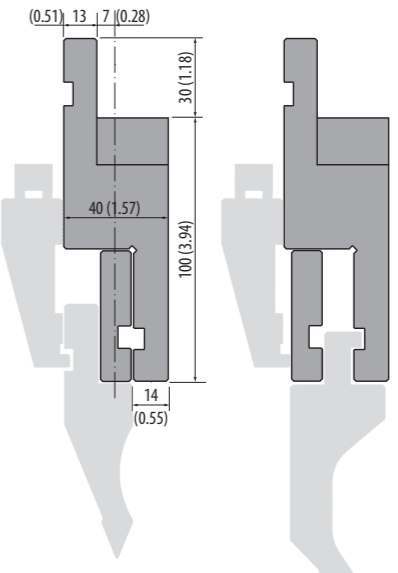
**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Pneumatic system only on INT120-A (ROL1 Clamp3 PN), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

**horizontal**

**INT100-N (Newton)** 1000 kN/m max.

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 3.5 kg |
|--------|---------|--------|



C45: 560-710 N/mm<sup>2</sup>

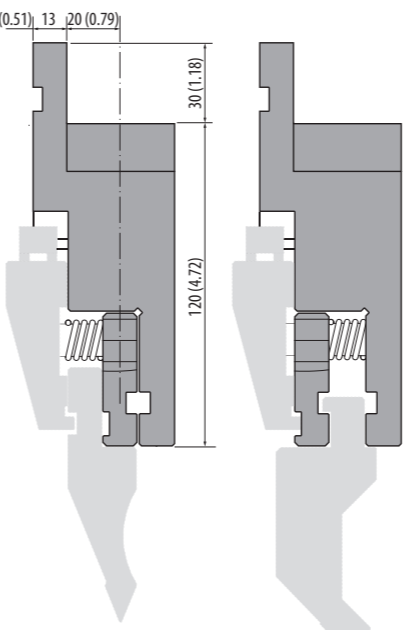
**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

**horizontal**

**INT120-40-A** 1000 kN/m max.

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 6.0 kg |
|--------|---------|--------|



C45: 560-710 N/mm<sup>2</sup>

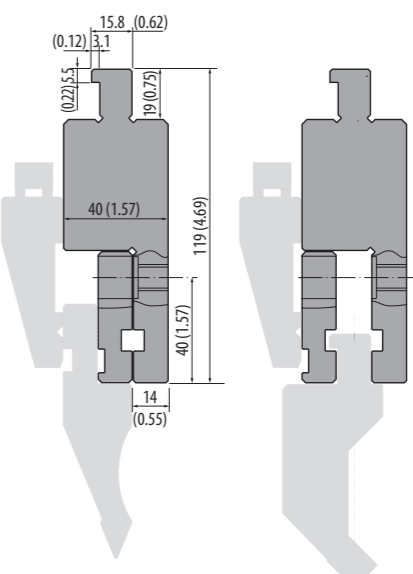
**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201

**horizontal**

**INT100-A (American)** 1000 kN/m max.

|        |         |        |
|--------|---------|--------|
| 150 mm | 5.91 in | 3.5 kg |
|--------|---------|--------|



C45: 560-710 N/mm<sup>2</sup>

**suitable Models:**

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

**horizontal**

# ROLLERI ADAPTERS

## Bolted Adapters

**AW11** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 3.0 kg |
| 415 mm           | 16.34 in           | 1.5 kg |
| 805 mm segmented | 31.69 in segmented | 2.9 kg |

Rolleri Type R2  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

Do you prefer our QuickLock or ROL1-System? Contact us now!

**AW3** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 9.0 kg |
| 415 mm           | 16.34 in           | 4.5 kg |
| 805 mm segmented | 31.69 in segmented | 8.7 kg |

Rolleri Type R3 Beyeler S  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW10** 1000 kN/m max.

**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 10.0 kg |
| 415 mm           | 16.34 in           | 5.0 kg  |
| 805 mm segmented | 31.69 in segmented | 9.6 kg  |

Rolleri Type R3 Beyeler RFA  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW12** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 7.0 kg |
| 415 mm           | 16.34 in           | 3.5 kg |
| 805 mm segmented | 31.69 in segmented | 6.7 kg |

Rolleri Type RX Colgar  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-A** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 4.5 kg |
| 415 mm           | 16.34 in           | 2.2 kg |
| 805 mm segmented | 31.69 in segmented | 4.3 kg |

Rolleri Type RX LVD A  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-B** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 6.3 kg |
| 415 mm           | 16.34 in           | 3.1 kg |
| 805 mm segmented | 31.69 in segmented | 6.0 kg |

Rolleri Type RX LVD B  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-C** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 9.7 kg |
| 415 mm           | 16.34 in           | 4.8 kg |
| 805 mm segmented | 31.69 in segmented | 9.4 kg |

Rolleri Type RX LVD C  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW1-D** 1000 kN/m max.

**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 11.5 kg |
| 415 mm           | 16.34 in           | 5.7 kg  |
| 805 mm segmented | 31.69 in segmented | 11.1 kg |

Rolleri Type RX LVD D  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

# ROLLERI ADAPTERS

## Bolted Adapters



**AW13** 1000 kN/m max.

**NEW**

|                  |                    |         |
|------------------|--------------------|---------|
| 835 mm           | 32.87 in           | 12.6 kg |
| 415 mm           | 16.34 in           | 6.3 kg  |
| 805 mm segmented | 31.69 in segmented | 12.1 kg |

Rolleri Type RX EHT  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW14** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 8.0 kg |
| 415 mm           | 16.34 in           | 4.0 kg |
| 805 mm segmented | 31.69 in segmented | 7.7 kg |

Rolleri Type RX Gasparini  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AW15** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 4.6 kg |
| 415 mm           | 16.34 in           | 2.3 kg |
| 805 mm segmented | 31.69 in segmented | 4.4 kg |

Rolleri Type RX Ajial-Axial  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AWC16** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 5.0 kg |
| 415 mm           | 16.34 in           | 2.5 kg |
| 805 mm segmented | 31.69 in segmented | 4.8 kg |

Rolleri Type RX Colly  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AWC13.5** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 4.8 kg |
| 415 mm           | 16.34 in           | 2.4 kg |
| 805 mm segmented | 31.69 in segmented | 4.6 kg |

Rolleri Type RX Colly  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**AWX** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 3.0 kg |
| 415 mm           | 16.34 in           | 1.5 kg |
| 805 mm segmented | 31.69 in segmented | 3.0 kg |

Individual  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

**INT35** 1000 kN/m max.

**NEW**

|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 4.0 kg |
| 525 mm           | 20.67 in           | 2.5 kg |
| 805 mm segmented | 31.69 in segmented | 3.9 kg |

C45: 560-710 N/mm<sup>2</sup>

**INT35-A** 1000 kN/m max.

**NEW**

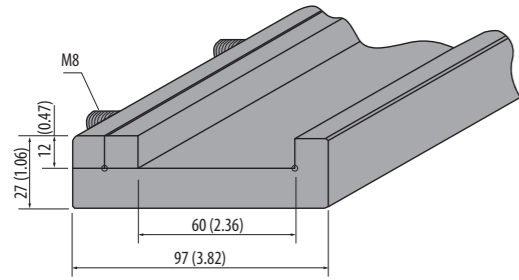
|                  |                    |        |
|------------------|--------------------|--------|
| 835 mm           | 32.87 in           | 5.0 kg |
| 415 mm           | 16.34 in           | 2.5 kg |
| 805 mm segmented | 31.69 in segmented | 4.8 kg |

C45: 560-710 N/mm<sup>2</sup>

# ROLLERI ADAPTERS

## Die Adapter Rails

### C 2000/S / C 2500/S / C 3000/S / C 4000/S



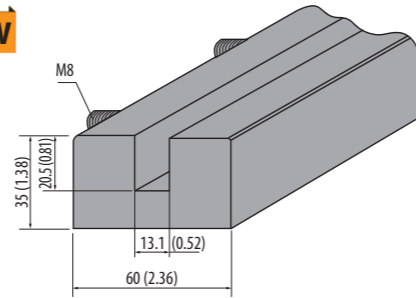
| Model    | Length (mm) | Length (in) | Weight  |
|----------|-------------|-------------|---------|
| C 2000/S | 2100        | 82.68       | 27.0 kg |
| C 2500/S | 2600        | 102.36      | 34.0 kg |
| C 3000/S | 3100        | 122.05      | 40.0 kg |
| C 4000/S | 4100        | 161.42      | 53.0 kg |



C45: 560-710 N/mm<sup>2</sup>

### TC 2000/S / TC 2500/S / TC 3000/S / TC 4000/S

**NEW**

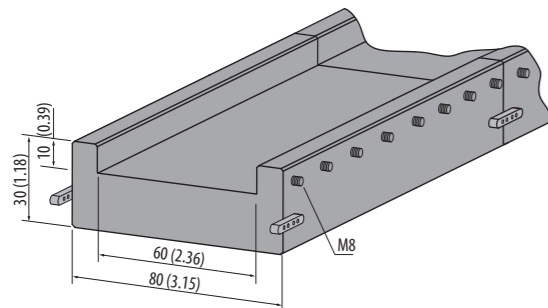


| Model     | Length (mm) | Length (in) | Weight  |
|-----------|-------------|-------------|---------|
| TC 2000/S | 2100 mm     | 82.68       | 30.0 kg |
| TC 2500/S | 2600 mm     | 102.36      | 37.0 kg |
| TC 3000/S | 3100 mm     | 122.05      | 44.0 kg |
| TC 4000/S | 4100 mm     | 161.42      | 59.0 kg |



C45: 560-710 N/mm<sup>2</sup>

### C 1050/R

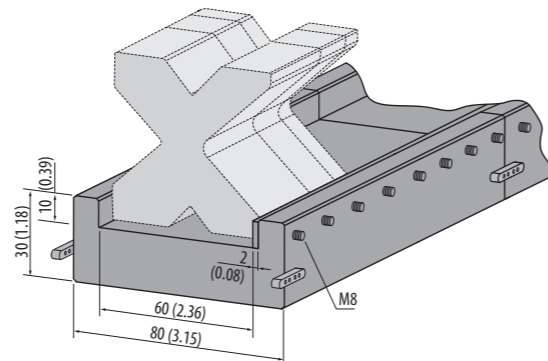


| Model      | Length (mm) | Length (in) | Weight  |
|------------|-------------|-------------|---------|
| C 1050/R   | 1050        | 41.34       | 15.0 kg |
| C 1050/R/C | 520         | 20.47       | 7.5 kg  |



C45: 560-710 N/mm<sup>2</sup>

### C 1050/RS

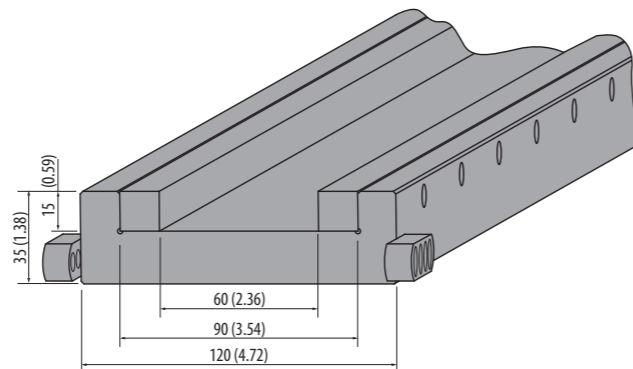
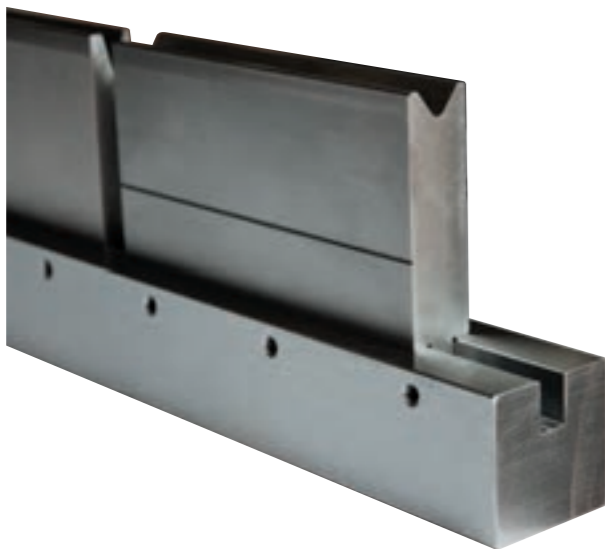


| Model       | Length (mm) | Length (in) | Weight  |
|-------------|-------------|-------------|---------|
| C 1050/RS   | 1050 mm     | 41.34       | 15.0 kg |
| C 1050/RS/C | 520 mm      | 20.47       | 7.5 kg  |



C45: 560-710 N/mm<sup>2</sup>

### C 1050-90



| Model       | Length (mm) | Length (in) | Weight  |
|-------------|-------------|-------------|---------|
| C 1050-90   | 1050        | 41.34       | 27.2 kg |
| C 1050-90/C | 520         | 20.47       | 13.5 kg |



C45: 560-710 N/mm<sup>2</sup>

# ROLLERI ADAPTERS

## Die Adapters



### AD6

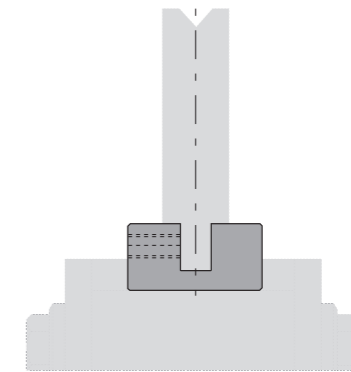
1000 kN/m max.

|         |          |         |
|---------|----------|---------|
| 1000 mm | 39.37 in | 12.0 kg |
| 500 mm  | 19.68 in | 6.0 kg  |

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>

### AD6 Example of Application



### AD5

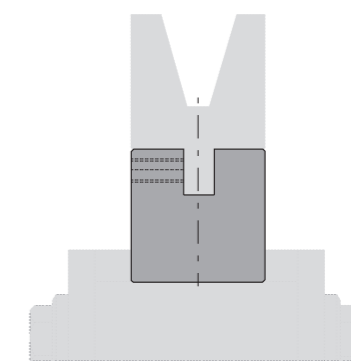
1000 kN/m max.

|         |          |         |
|---------|----------|---------|
| 1000 mm | 39.37 in | 26.1 kg |
| 500 mm  | 19.68 in | 13.0 kg |

Rolleri Type R1  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>

### AD5 Example of Application



### AD7

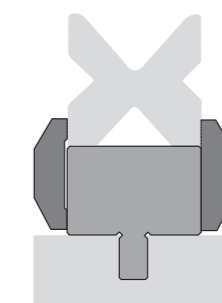
1000 kN/m max.

|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 18.0 kg |
| 415 mm | 16.34 in | 9.0 kg  |

Rolleri Type R2/R3  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

### AD7 Example of Application



### AD24

1000 kN/m max.

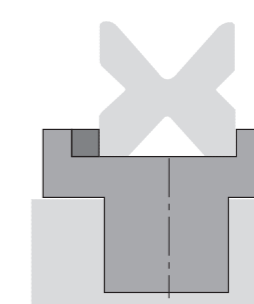
|        |          |         |
|--------|----------|---------|
| 835 mm | 32.87 in | 28.5 kg |
| 415 mm | 16.34 in | 14.2 kg |

**NEW**

Rolleri Type RX EHT  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>

### AD24 Example of Application

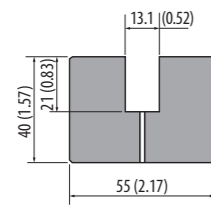


## ROLLERI ADAPTERS

### Die Adapters

#### AD25

**NEW**



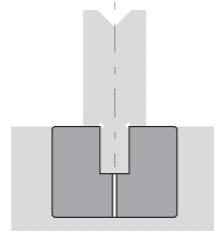
1000 kN/m max.  
500 mm 19.68 in 7.5 kg

Rolleri Type RX EHT  
→ Rolleri Type R2/R3

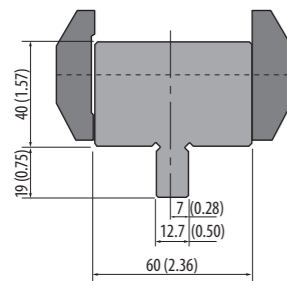
C45: 560-710 N/mm<sup>2</sup>



#### AD25 Example of Application



#### AD9-12.7



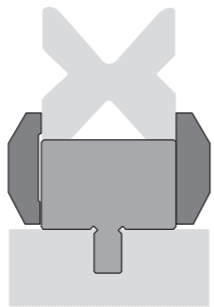
1000 kN/m max.  
835 mm 32.87 in 17.0 kg  
415 mm 16.34 in 8.5 kg

Rolleri Type RX LVD  
→ Rolleri Type R1

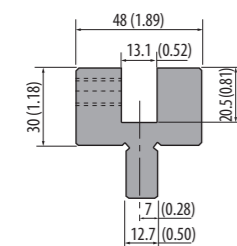
C45: 560-710 N/mm<sup>2</sup>



#### AD9-12.7 Example of Application



#### AD8-12.7



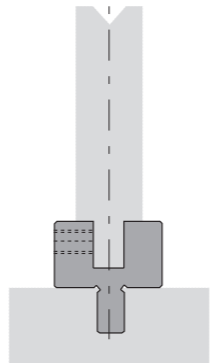
1000 kN/m max.  
1000 mm 39.37 in 15.0 kg  
500 mm 19.68 in 7.5 kg

Rolleri Type RX LVD  
→ Rolleri Type R2/R3

C45: 560-710 N/mm<sup>2</sup>

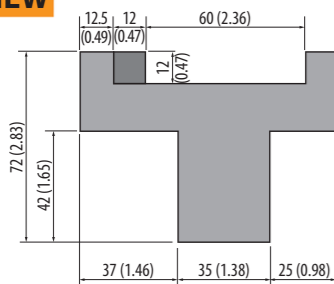


#### AD8-12.7 Example of Application



#### AD26

**NEW**



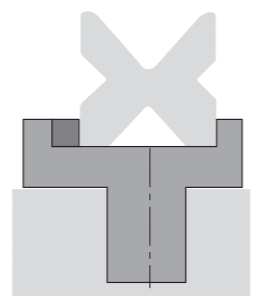
1000 kN/m max.  
835 mm 32.87 in 23.0 kg  
415 mm 16.34 in 11.4 kg

Rolleri Type RX  
Weinbrenner  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



#### AD26 Example of Application



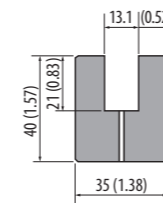
## ROLLERI ADAPTERS

### Die Adapters



#### AD27

**NEW**



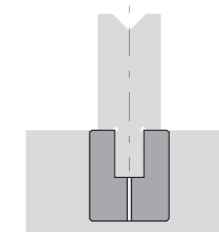
1000 kN/m max.  
500 mm 19.68 in 4.5 kg

Rolleri Type RX  
Weinbrenner  
→ Rolleri Type R2/R3

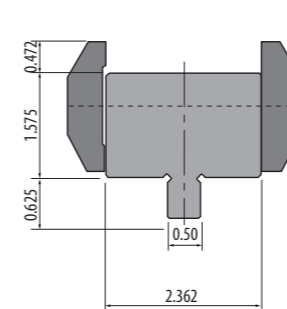
C45: 560-710 N/mm<sup>2</sup>



#### AD27 Example of Application



#### AD17



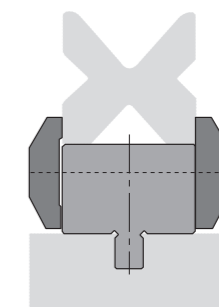
1000 kN/m max.  
835 mm 32.87 in 18.0 kg  
415 mm 16.34 in 9.0 kg

Type American  
→ Rolleri Type R1

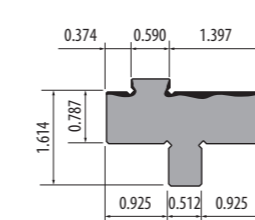
C45: 560-710 N/mm<sup>2</sup>



#### AD17 Example of Application



#### AD18



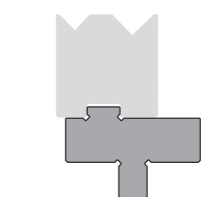
1000 kN/m max.  
835 mm 32.87 in 18.0 kg  
415 mm 16.34 in 9.0 kg

Type American  
→ Rolleri Type R1

C45: 560-710 N/mm<sup>2</sup>



#### AD18 Example of Application



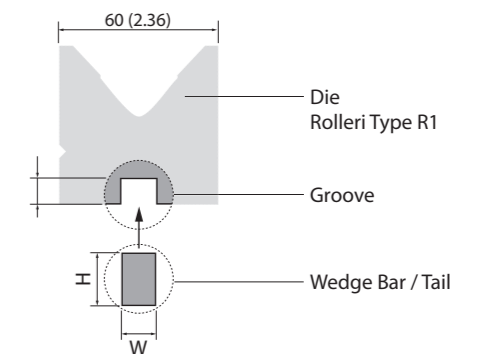
### Modification: Wedge Bar / Tail

In order to use the dies Rolleri Type R1 on other press brake machines, a 10 mm (0.39 in) groove is milled to insert a ground wedge bar / tail into the die.

| Wedge Bar / Tail (W x H)      | System  |
|-------------------------------|---|
| 13 x 30 mm (0.51 x 1.18 in)   | Rolleri Type R2 and R3<br>(Bystronic-Beyeler/Safan/Trumpf etc.) |
| 55 x 55 mm (2.17 x 2.17 in)   | Rolleri Type RX EHT   |
| 12.7 x 29 mm (0.50 x 1.14 in) | Rolleri Type RX LVD   |
| 35 x 55 mm (1.38 x 2.17 in)   | Rolleri Type RX Weinbrenner                                     |

Specific information and prizes are found in the Rolleri Service / Modifications Chapter (see page 252)

### Mounting example



## ROLLERI MARK FREE BENDING

|                               |           |
|-------------------------------|-----------|
| Prevention of Bending Marks   | 224       |
| Bending Foil Holder/Tensioner | 224       |
| Bending Foil                  | 225       |
| PU-Holder and PU-Upholstery   | 226 - 227 |
| Synthetic Dies                | 228 - 229 |





## ROLLERI MARK FREE BENDING

### Prevention of Bending Marks

One of the challenges of bending is to prevent the profile of having bending marks, such as; scratches and abrasions on the surface areas.

Especially of Profile made of:

- Stainless Steel
- Aluminium
- painted metal panels

It is often the case of a line building from the contact of the sheet metal with the die. This is the cause of friction of sheet metal on small radius.

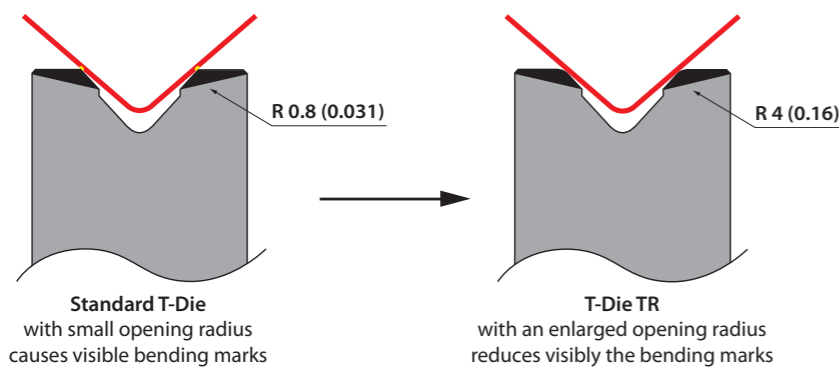
In order to prevent this markings, the following solutions are possible:

- Bending Foil
- PU-Upholstery
- Plastic Dies
- enlarged opening radius on special T-Dies



### Our Advantages – Your Convenience

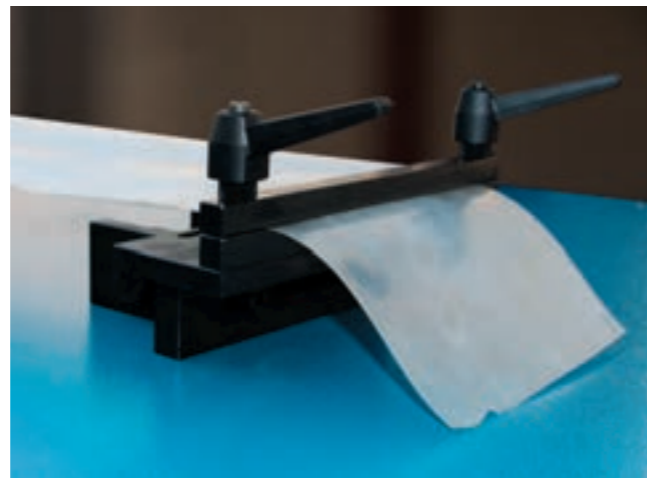
- Prevention of scratches and abrasions on bent sheet metals
- No post-processing necessary, therefore time and cost saving
- No contamination of bended pieces
- increases the product quality
- easy handling



T-Dies (TR) with an enlarged opening radius for the prevention of bending marks see pages 54-55, 60-61

### Bending Foil - Holder / Tensioner

CT



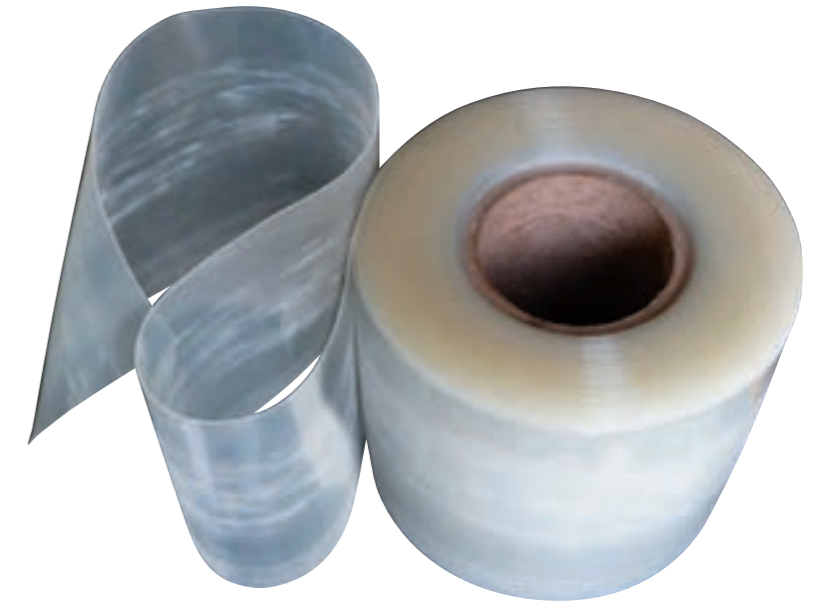
## ROLLERI MARK FREE BENDING

### Bending Foil



### Our Advantages – Your Convenience

- easy handling
- can be used flexibly
- Prevention of Bending Marks
- decrease of post-processing of bent parts
- no contamination of the material
- increased product quality



Bending Foil:  
Practical, easy and economic!

### ROLFILM



| Model              | Thickness (mm) | Thickness (in) | Width (mm) | Width (in) | Length (m) | Length (in) |
|--------------------|----------------|----------------|------------|------------|------------|-------------|
| Rolfilm 3-0.4-100  | 0.4            | 0.016          | 100        | 3.94       | 3          | 118.11      |
| Rolfilm 10-0.4-100 | 0.4            | 0.016          | 100        | 3.94       | 10         | 393.70      |
| Rolfilm 20-0.4-100 | 0.4            | 0.016          | 100        | 3.94       | 20         | 787.40      |
| Rolfilm 30-0.4-100 | 0.4            | 0.016          | 100        | 3.94       | 30         | 1181.10     |
| Rolfilm 3-0.4-150  | 0.4            | 0.016          | 150        | 5.91       | 3          | 118.11      |
| Rolfilm 10-0.4-150 | 0.4            | 0.016          | 150        | 5.91       | 10         | 393.70      |
| Rolfilm 20-0.4-150 | 0.4            | 0.016          | 150        | 5.91       | 20         | 787.40      |
| Rolfilm 30-0.4-150 | 0.4            | 0.016          | 150        | 5.91       | 30         | 1181.10     |
| Rolfilm 3-0.6-150  | 0.6            | 0.024          | 150        | 5.91       | 3          | 118.11      |
| Rolfilm 10-0.6-150 | 0.6            | 0.024          | 150        | 5.91       | 10         | 393.70      |
| Rolfilm 20-0.6-150 | 0.6            | 0.024          | 150        | 5.91       | 20         | 787.40      |
| Rolfilm 30-0.6-150 | 0.6            | 0.024          | 150        | 5.91       | 30         | 1181.10     |
| Rolfilm 3-0.6-200  | 0.6            | 0.024          | 200        | 7.87       | 3          | 118.11      |
| Rolfilm 10-0.6-200 | 0.6            | 0.024          | 200        | 7.87       | 10         | 393.70      |
| Rolfilm 20-0.6-200 | 0.6            | 0.024          | 200        | 7.87       | 20         | 787.40      |
| Rolfilm 30-0.6-200 | 0.6            | 0.024          | 200        | 7.87       | 30         | 1181.10     |
| Rolfilm 3-2-150    | 2.0            | 0.079          | 150        | 5.91       | 3          | 118.11      |
| Rolfilm 10-2-150   | 2.0            | 0.079          | 150        | 5.91       | 10         | 393.70      |
| Rolfilm 20-2-150   | 2.0            | 0.079          | 150        | 5.91       | 20         | 787.40      |
| Rolfilm 30-2-150   | 2.0            | 0.079          | 150        | 5.91       | 30         | 1181.10     |



### Rolleri Videos

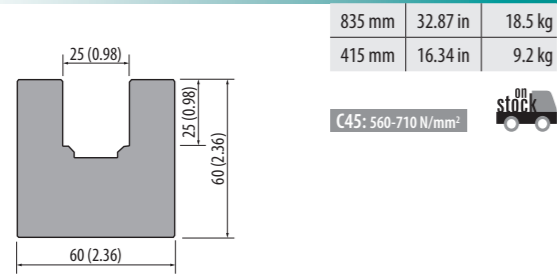
mark free bending:  
[www.rolleritools.com/videos/mark-free-bending](http://www.rolleritools.com/videos/mark-free-bending)



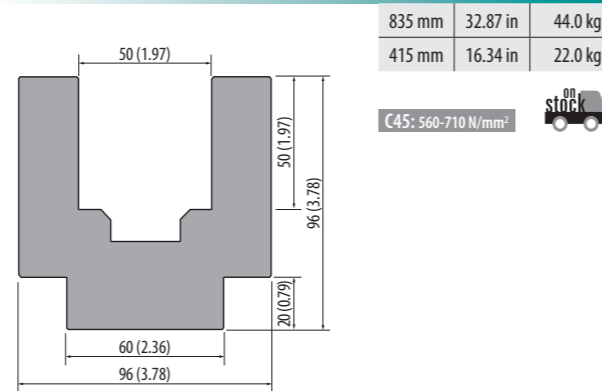
# ROLLERI MARK FREE BENDING

## PU-Holders and PU-Upholstery

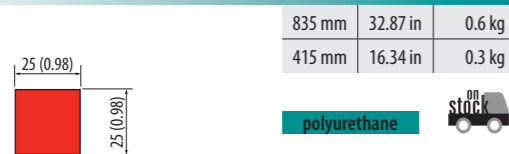
### MPG25



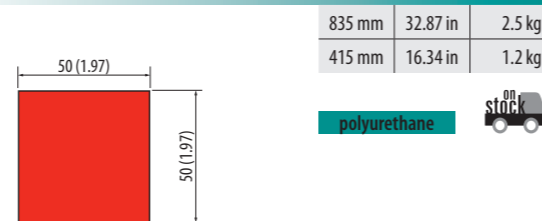
### MPG50



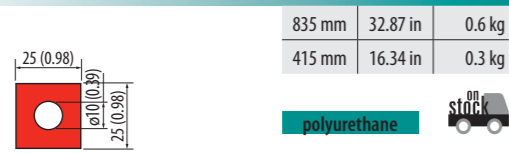
### GM 25x25



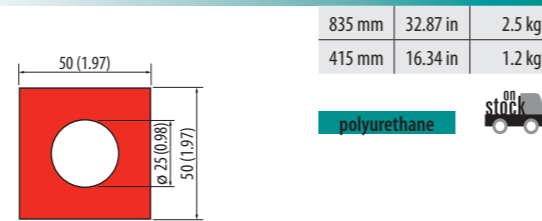
### GM 50x50



### GMF 25x25x10



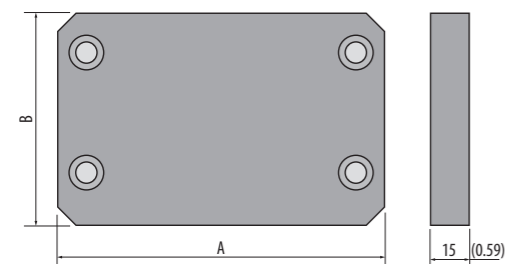
### GMF 50x50x25



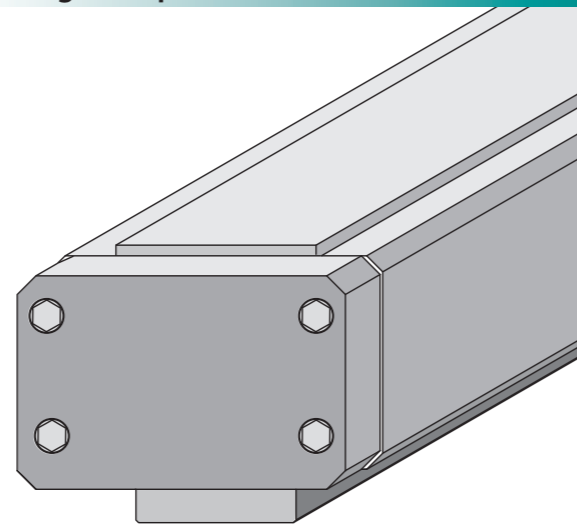
### PSTCON

| cover plate | Model     | A (mm) | A (in) | R (mm) | R (in) | Weight |
|-------------|-----------|--------|--------|--------|--------|--------|
|             | PSTCON25  | 58     | 2.28   | 58     | 2.28   | 1.2 kg |
|             | PSTCON50  | 108    | 4.25   | 75     | 2.95   | 0.6 kg |
|             | PSTCON75  | 123    | 4.84   | 80     | 3.15   | 0.8 kg |
|             | PSTCON100 | 153    | 6.02   | 80     | 3.15   | 1.0 kg |

C45: 560-710 N/mm<sup>2</sup>



### Mounting example

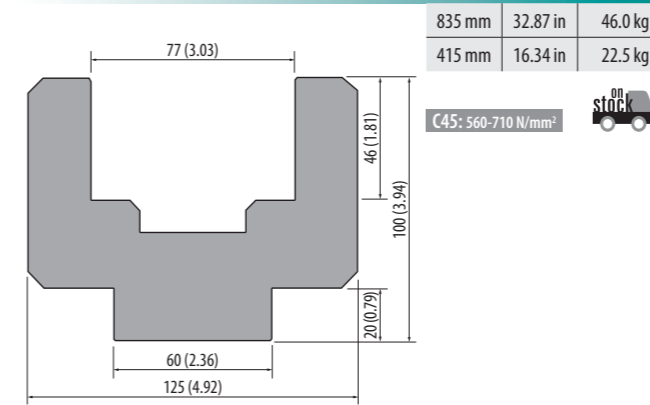


# ROLLERI MARK FREE BENDING

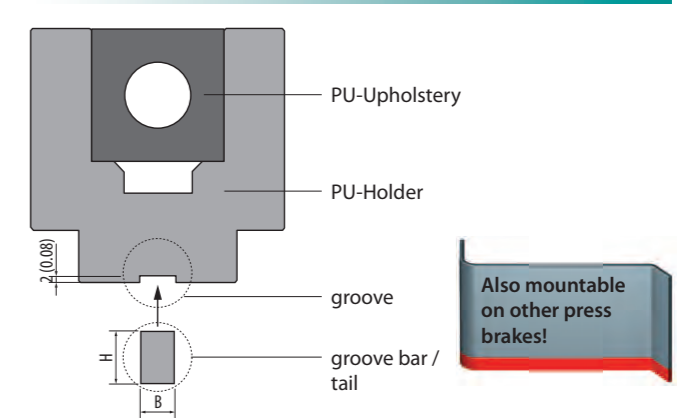
## PU-Holders and PU-Upholstery



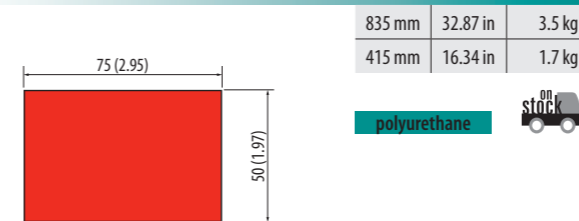
### MPG75



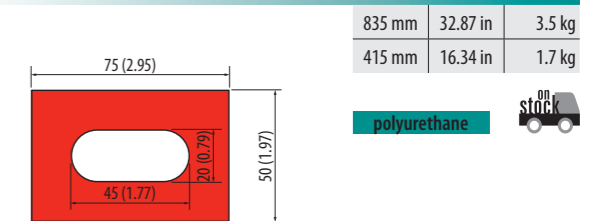
### Mounting example



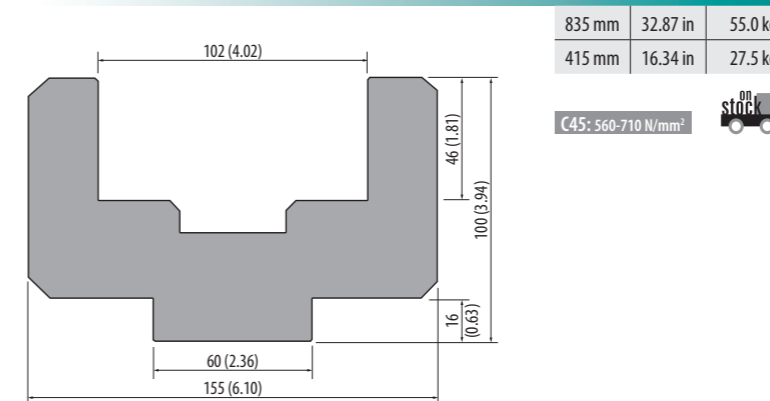
### GM 75x50



### GMF 75x50x20

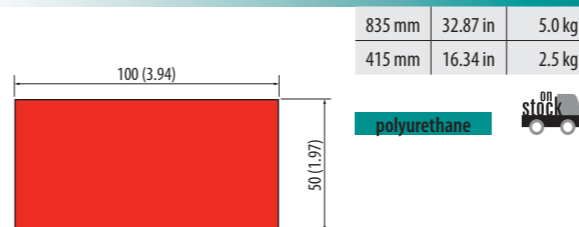


### MPG100

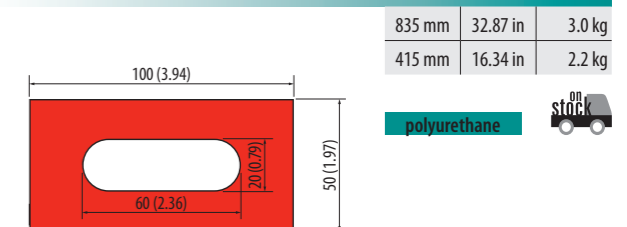


PU-Upholstery are suitable for radius- and U-profile bendings, etc.

### GM 100x50



### GMF 100x50x20



# ROLLERI MARK FREE BENDING

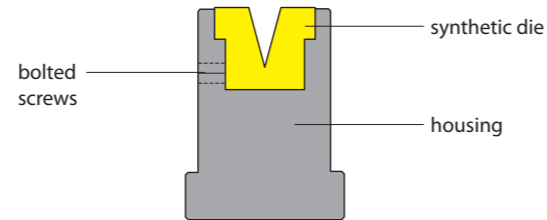
## Synthetic Dies

### Our Advantages – Your Convenience

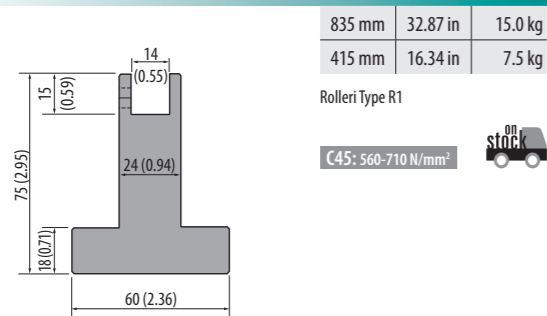
- easy Handling
- faster and easier exchange of plastic dies
- prevention of bending marks
- decrease of post-processing of bent pieces
- no contamination of the materials
- increased product quality

### Mounting example

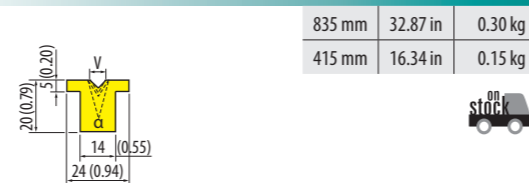
Synthetic dies will be adjusted into the housing and secured with bolted screws.



### TN80.14 1000 kN/m max.



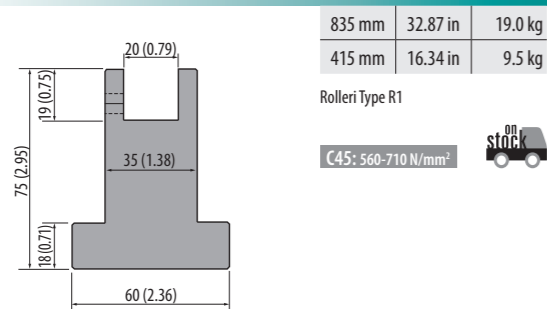
### INS14... 200 kN/m max.



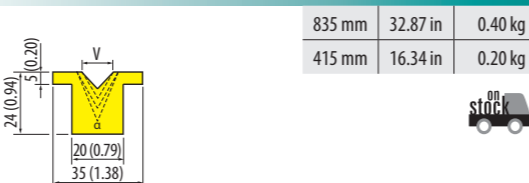
| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS14.06.88 | 88° | 6      | 0.24   |
| INS14.08.88 | 88° | 8      | 0.31   |
| INS14.10.88 | 88° | 10     | 0.39   |
| INS14.06.60 | 60° | 6      | 0.24   |
| INS14.08.60 | 60° | 8      | 0.31   |
| INS14.10.60 | 60° | 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.



### INS20... 200 kN/m max.



| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS20.06.88 | 88° | 6      | 0.24   |
| INS20.08.88 | 88° | 8      | 0.31   |
| INS20.10.88 | 88° | 10     | 0.39   |
| INS20.12.88 | 88° | 12     | 0.47   |
| INS20.16.88 | 88° | 16     | 0.63   |
| INS20.06.60 | 60° | 6      | 0.24   |
| INS20.08.60 | 60° | 8      | 0.31   |
| INS20.10.60 | 60° | 10     | 0.39   |
| INS20.12.60 | 60° | 12     | 0.47   |
| INS20.16.60 | 60° | 16     | 0.63   |

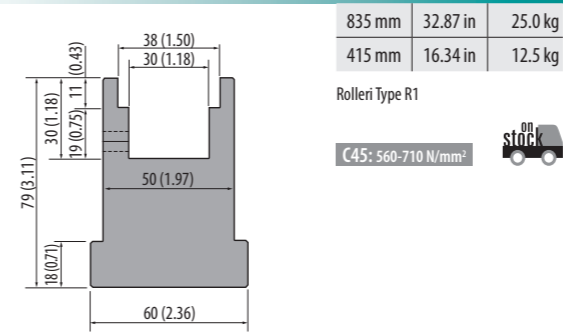
| Model       | α   | V (mm) | V (in) |
|-------------|-----|--------|--------|
| INS20.06.45 | 45° | 6      | 0.24   |
| INS20.08.45 | 45° | 8      | 0.31   |
| INS20.10.45 | 45° | 10     | 0.39   |
| INS20.12.45 | 45° | 12     | 0.47   |
| INS20.06.30 | 30° | 6      | 0.24   |
| INS20.08.30 | 30° | 8      | 0.31   |
| INS20.10.30 | 30° | 10     | 0.39   |

# ROLLERI MARK FREE BENDING

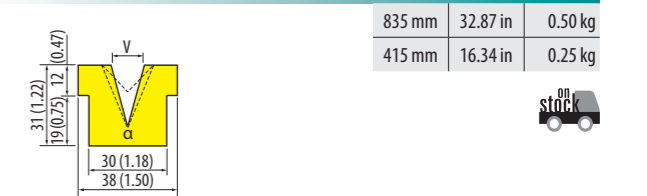
## Synthetic Dies



### TN80.30 1000 kN/m max.

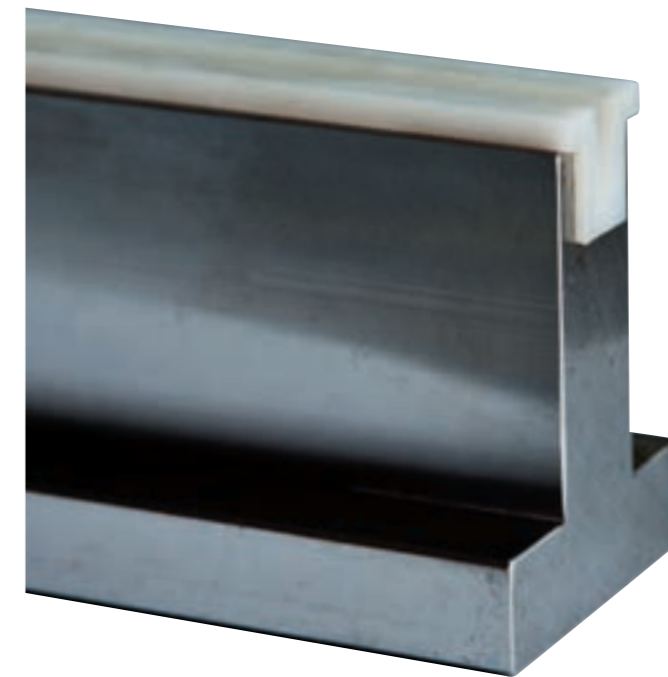


### INS30... 200 kN/m max.



| 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     | 0.99   |
| 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.

## ROLLERI SPECIAL AND HEAVY DUTY TOOLS

|                                 |           |
|---------------------------------|-----------|
| Explanation of Special Tools    | 232       |
| Explanation of Heavy Duty Tools | 233       |
| Heavy Duty Tools                | 234 - 235 |
| Examples of Special Tools       | 236 - 238 |
| Dies with Rollers               | 239 - 241 |
| ROL6-System                     | 242       |
| Panelling Tools                 | 242       |
| BLACKFIRE                       | 243       |

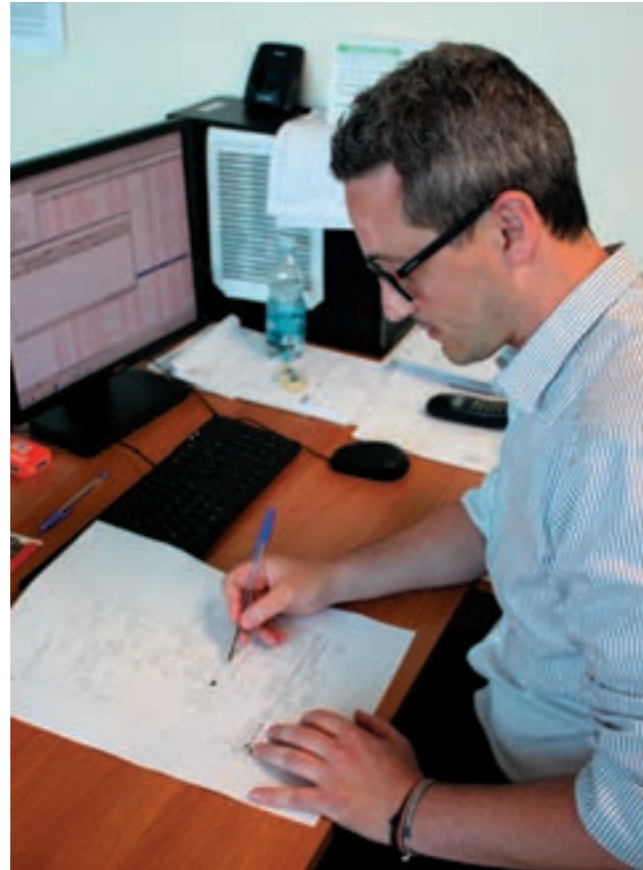


**Our Advantages – Your Convenience**

- in-house construction and production (no reseller or dealer)
- competent consulting
- client specific developments
- tracking of every tool possible, with a unique serial number on every article after the quality control check
- precision grinding (tolerance of +/-0.01mm)
- guaranteed tool reproduction
- exact parallelism
- bending tests upon request

**Special Tooling for:**

- Z-Profiles
- Hat-Profiles
- Trapezoidal Profiles
- Pressed contours
- Foldings
- Hinges
- Radii
- Beads
- Special Profiles
- etc.



**Material**

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

| Material Type | Mechanical resistance of the material and the tool body | Hardness of the material and the tool body | Hardness of the operating surfaces after induction hardening |
|---------------|---|--|--|
| 42CrMo4       | 900-1150 N/mm <sup>2</sup>                              | 29.1 - 36.9 HRC                            | 54 - 60 HRC  |
| C45           | 560-710 N/mm <sup>2</sup>                               | 12 - 15.5 HRC                              | 54 - 60 HRC  |
| 1.2767        | 830 N/mm <sup>2</sup>                                   | 22 - 25 HRC                                | 54 - 60 HRC  |

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.



**Our Advantages – Your Convenience**

The bending of materials with extreme high resistance, (Hardox, Weldom, etc.), has developed into an important task.

The Heavy Duty tools of Rollerli are built and finished for these challenges.

Tools that have a press force up to 4000 kN/m, offer you many production possibility.

Our many years of experience in the area of special and heavy duty tooling, along with our own developing department, guarantee you functional and economic solutions in the bending sector.

From the compatible tang to the punch onto the compatible die; we manufacture everything in our own production facilities.

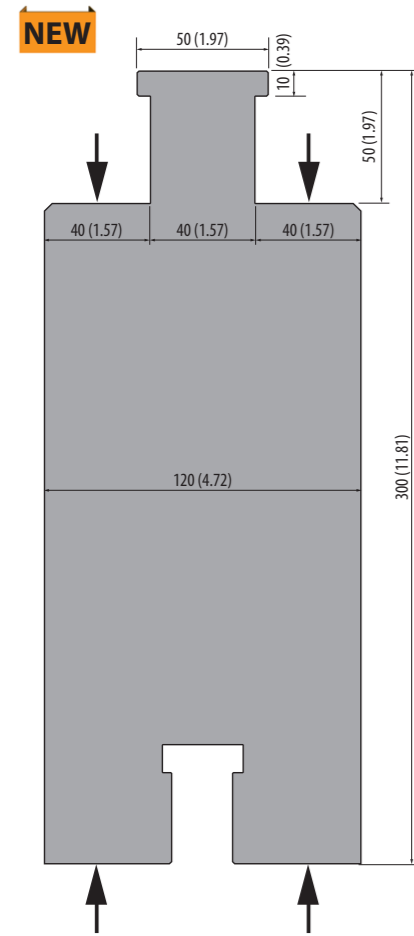
Take advantage of the direct contact to the manufacturer and the benefits which come along with it.



Contact us now!  
We are here to help you!



RHD.300



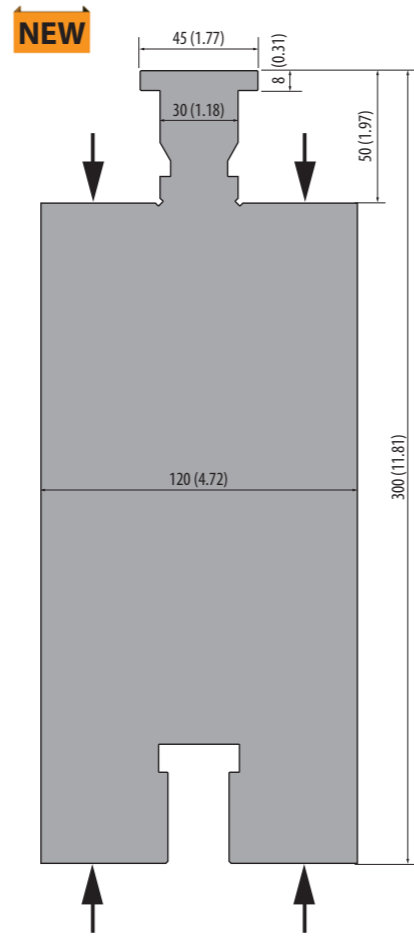
| RHD.300-250 |          |          |
|-------------|----------|----------|
| 500 mm      | 19.68 in | 122.0 kg |

2500 kN/m max.  
42Cr: 900-1150 N/mm<sup>2</sup>

| RHD.300-400 |          |          |
|-------------|----------|----------|
| 500 mm      | 19.68 in | 122.0 kg |

4000 kN/m max.  
1.2767: 830 N/mm<sup>2</sup>

RHD.300 HYD



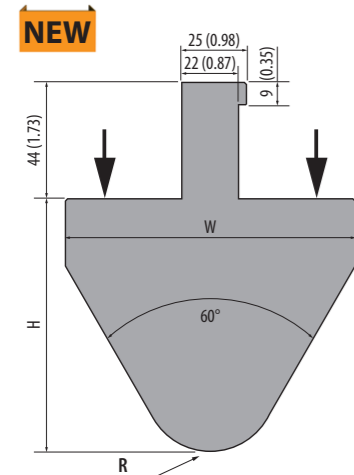
| RHD.300-250 HYD |          |          |
|-----------------|----------|----------|
| 500 mm          | 19.68 in | 120.0 kg |

2500 kN/m max.  
42Cr: 900-1150 N/mm<sup>2</sup>

| RHD.300-400 HYD |          |          |
|-----------------|----------|----------|
| 500 mm          | 19.68 in | 120.0 kg |

4000 kN/m max.  
1.2767: 830 N/mm<sup>2</sup>

RHDP.60



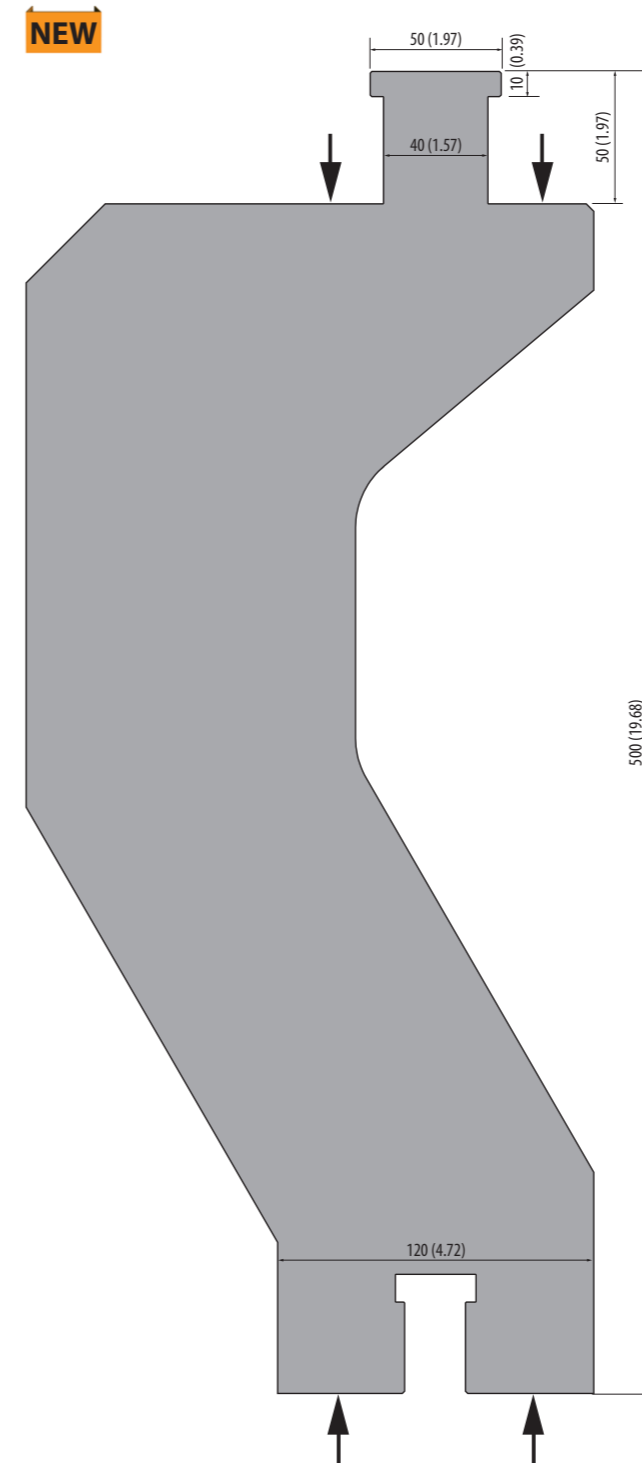
| Model           | 2500 kN/m max. |        |        |        |        |        |
|-----------------|----------------|--------|--------|--------|--------|--------|
|                 | H (mm)         | H (in) | W (mm) | W (in) | R (mm) | R (in) |
| RHDP.60.20-250  | 96             | 3.78   | 110    | 4.33   | 20     | 0.79   |
| RHDP.60.25-250  | 96             | 3.78   | 110    | 4.33   | 25     | 0.98   |
| RHDP.60.30-250  | 96             | 3.78   | 110    | 4.33   | 30     | 1.18   |
| RHDP.60.40-250  | 96             | 3.78   | 110    | 4.33   | 40     | 1.57   |
| RHDP.60.50-250  | 96             | 3.78   | 110    | 4.33   | 50     | 1.97   |
| RHDP.60.60-250  | 96             | 3.78   | 110    | 4.33   | 60     | 2.36   |
| RHDP.60.70-250  | 86             | 3.39   | 140    | 5.51   | 70     | 2.76   |
| RHDP.60.80-250  | 86             | 3.39   | 150    | 5.91   | 80     | 3.15   |
| RHDP.60.90-250  | 86             | 3.39   | 165    | 6.50   | 90     | 3.54   |
| RHDP.60.100-250 | 86             | 3.39   | 185    | 7.28   | 100    | 3.94   |

| Model           | 4000 kN/m max. |        |        |        |        |        |
|-----------------|----------------|--------|--------|--------|--------|--------|
|                 | H (mm)         | H (in) | W (mm) | W (in) | R (mm) | R (in) |
| RHDP.60.20-400  | 96             | 3.78   | 110    | 4.33   | 20     | 0.79   |
| RHDP.60.25-400  | 96             | 3.78   | 110    | 4.33   | 25     | 0.98   |
| RHDP.60.30-400  | 96             | 3.78   | 110    | 4.33   | 30     | 1.18   |
| RHDP.60.40-400  | 96             | 3.78   | 110    | 4.33   | 40     | 1.57   |
| RHDP.60.50-400  | 96             | 3.78   | 110    | 4.33   | 50     | 1.97   |
| RHDP.60.60-400  | 96             | 3.78   | 110    | 4.33   | 60     | 2.36   |
| RHDP.60.70-400  | 86             | 3.39   | 140    | 5.51   | 70     | 2.76   |
| RHDP.60.80-400  | 86             | 3.39   | 150    | 5.91   | 80     | 3.15   |
| RHDP.60.90-400  | 86             | 3.39   | 165    | 6.50   | 90     | 3.54   |
| RHDP.60.100-400 | 86             | 3.39   | 185    | 7.28   | 100    | 3.94   |

42Cr: 900-1150 N/mm<sup>2</sup>

1.2767: 830 N/mm<sup>2</sup>

RHD.500-200



2000 kN/m max.  
150 mm 19.68 in 253.0 kg

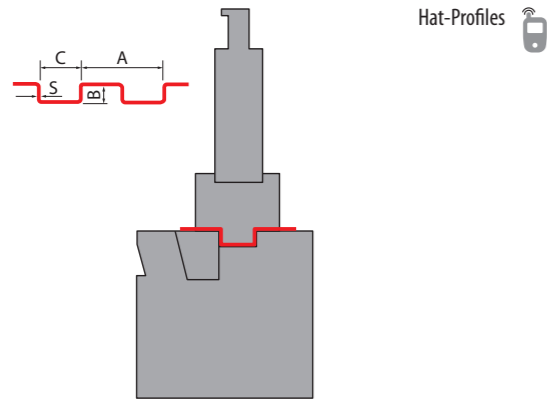
42Cr: 900-1150 N/mm<sup>2</sup>

More Tools for Heavy Duty operations can be found on pages 156-158

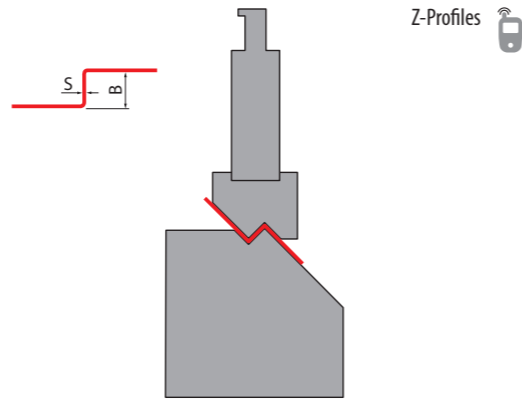


Tool examples

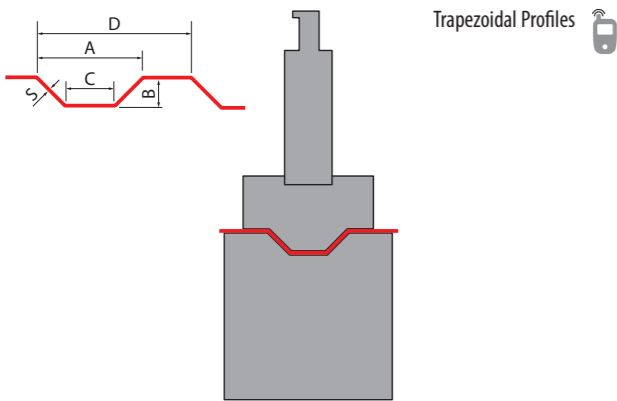
SPE1 Hat-Profiles



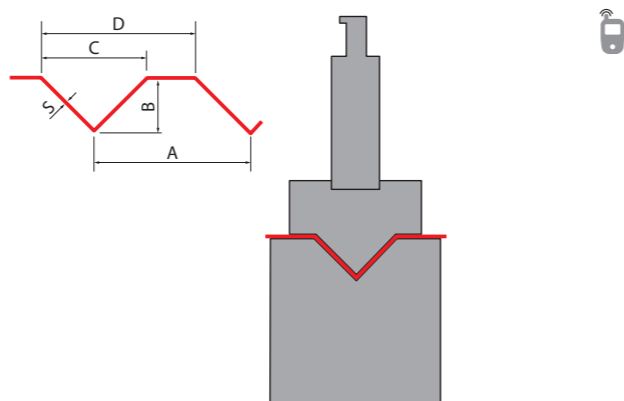
SPE2 Z-Profiles



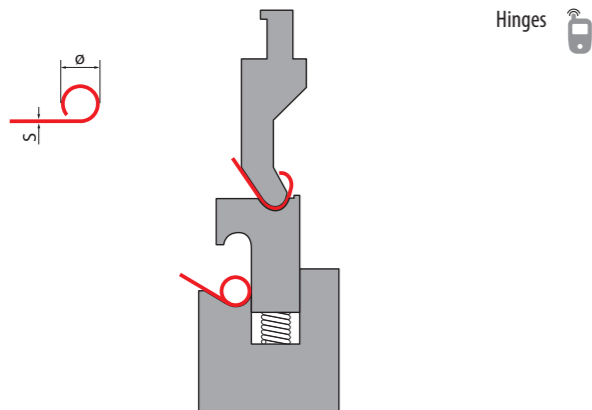
SPE3 Trapezoidal Profiles



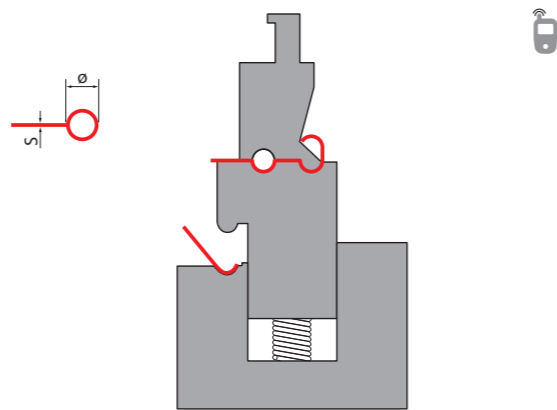
SPE4 Trapezoidal Profiles



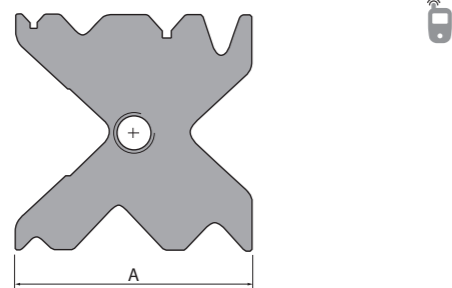
SPE5 Hinges



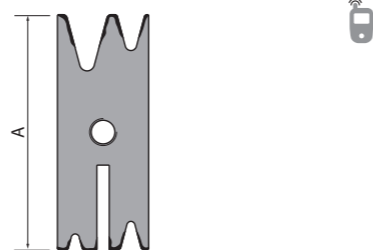
SPE6 Hinges



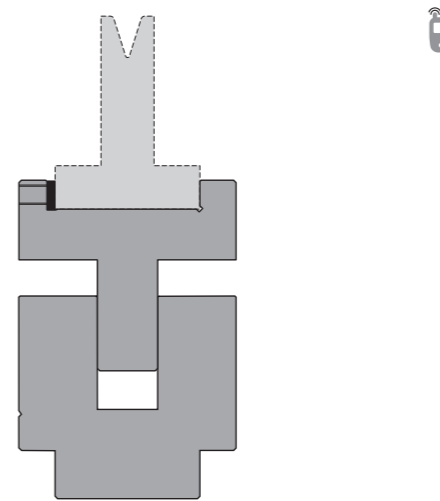
SPE7



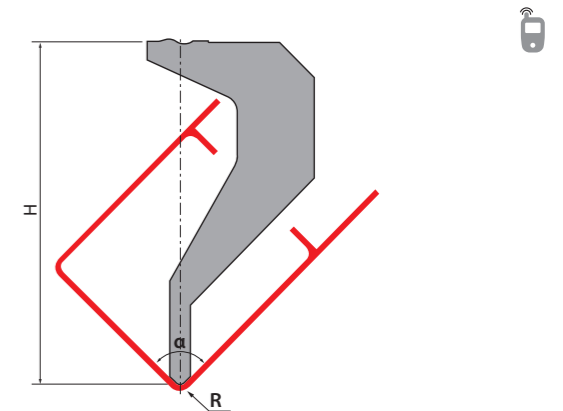
SPE-X



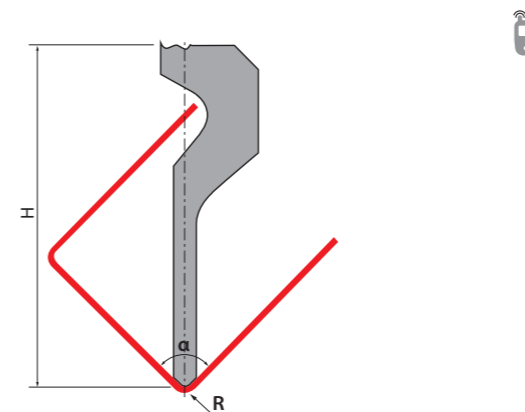
SPE9



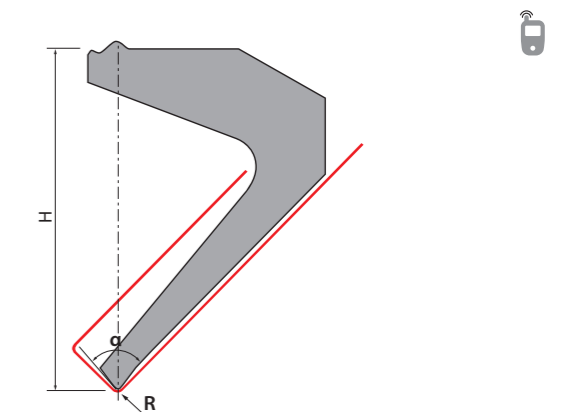
SPE-P1



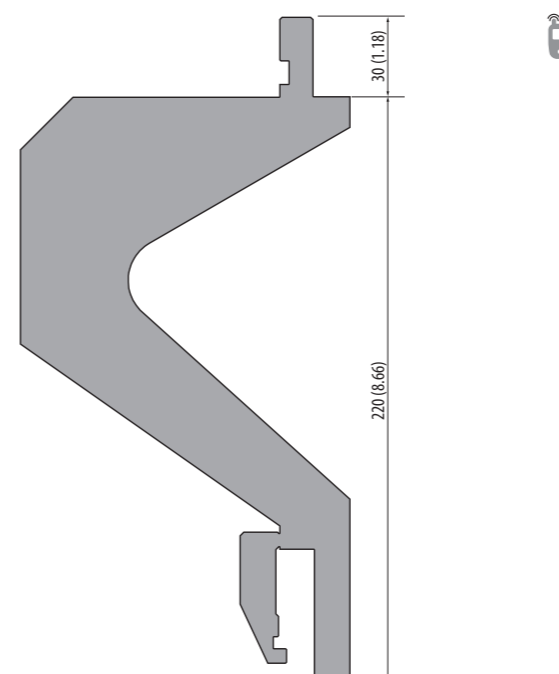
SPE-P2



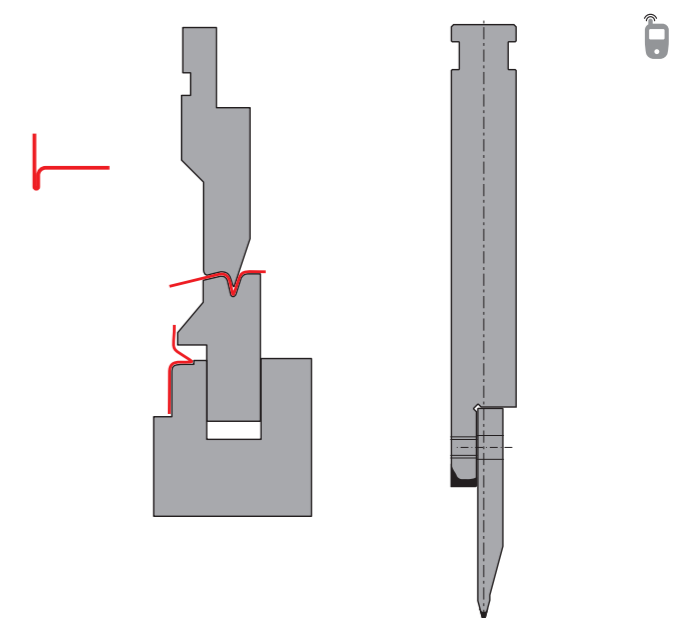
SPE-P3



SPE-P4

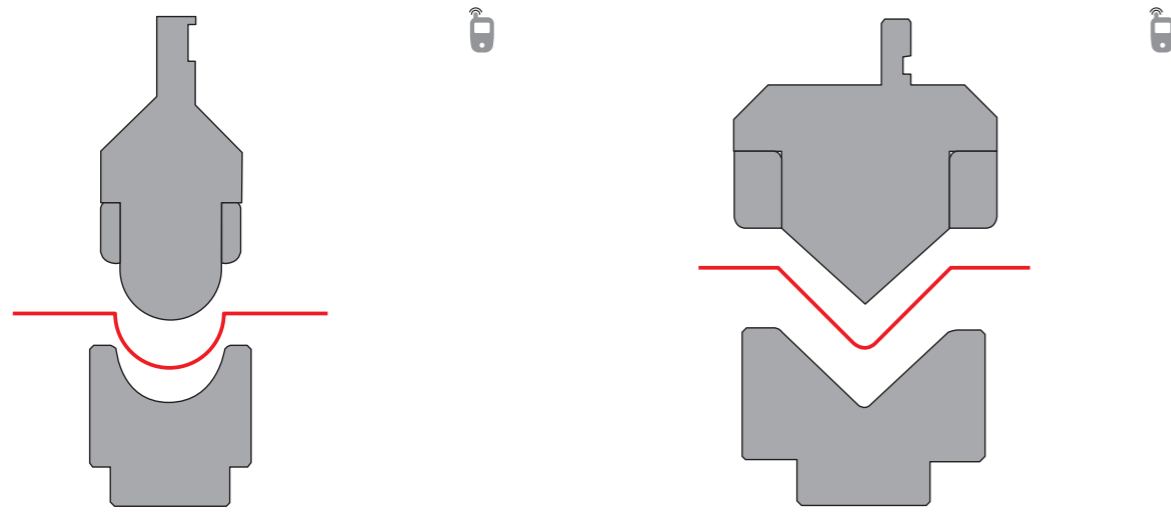


Front- and Hemming Tool (Foldings)

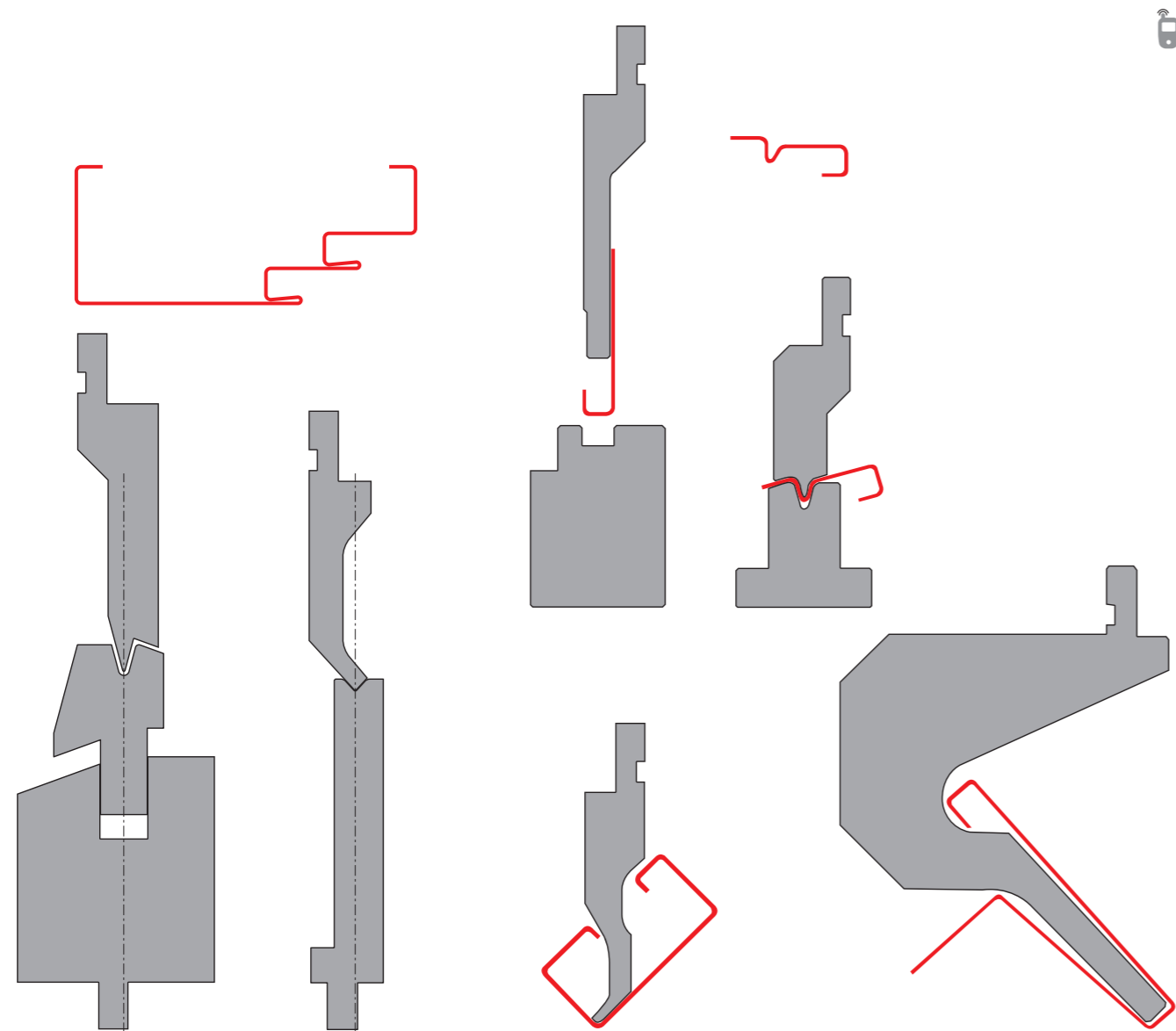


Tool examples

Radii Pressing

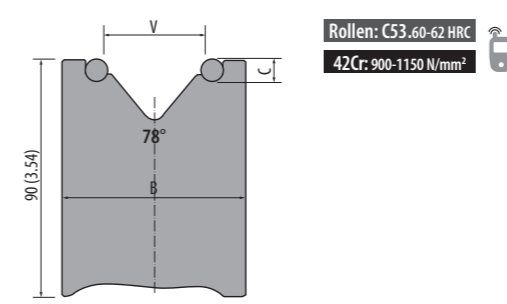


Special Profiles

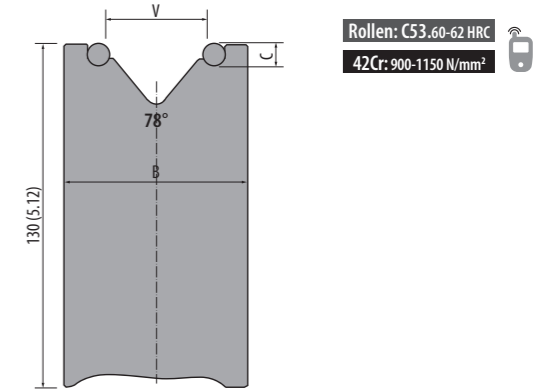


Dies with Rollers

MR90



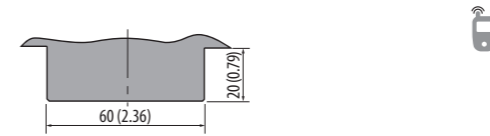
MR130



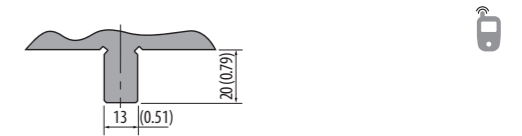
| Model      | V (mm) | V (in) | B (mm) | B (in) | C (mm) | C (in) | Length (mm) | Length (in) | Weight (kg) |
|------------|--------|--------|--------|--------|--------|--------|-------------|-------------|-------------|
| MR90.20.78 | 20     | 0.79   | 45     | 1.77   | 6      | 0.24   | 835         | 32.87       | 15.0        |
| MR90.24.78 | 24     | 0.94   | 49     | 1.93   | 6      | 0.24   | 835         | 32.87       | 17.0        |
| MR90.30.78 | 30     | 1.18   | 60     | 2.36   | 8      | 0.31   | 835         | 32.87       | 21.0        |
| MR90.40.78 | 40     | 1.57   | 70     | 2.76   | 8      | 0.31   | 835         | 32.87       | 24.0        |
| MR90.50.78 | 50     | 1.97   | 84     | 3.31   | 10     | 0.39   | 835         | 32.87       | 28.0        |
| MR90.60.78 | 60     | 2.36   | 94     | 3.70   | 10     | 0.39   | 835         | 32.87       | 31.0        |
| MR90.70.78 | 70     | 2.76   | 104    | 4.09   | 10     | 0.39   | 835         | 32.87       | 35.0        |

| Model        | V (mm) | V (in) | B (mm) | B (in) | C (mm) | C (in) | Length (mm) | Length (in) | Weight (kg) |
|--------------|--------|--------|--------|--------|--------|--------|-------------|-------------|-------------|
| MR130.20.78  | 20     | 0.79   | 45     | 1.77   | 6      | 0.24   | 835         | 32.87       | 22.0        |
| MR130.24.78  | 24     | 0.94   | 49     | 1.93   | 6      | 0.24   | 835         | 32.87       | 25.0        |
| MR130.30.78  | 30     | 1.18   | 60     | 2.36   | 8      | 0.31   | 835         | 32.87       | 28.0        |
| MR130.40.78  | 40     | 1.57   | 70     | 2.76   | 8      | 0.31   | 835         | 32.87       | 34.0        |
| MR130.50.78  | 50     | 1.97   | 84     | 3.31   | 10     | 0.39   | 835         | 32.87       | 40.0        |
| MR130.60.78  | 60     | 2.36   | 94     | 3.70   | 10     | 0.39   | 835         | 32.87       | 45.0        |
| MR130.75.78  | 75     | 2.95   | 118    | 4.65   | 16     | 0.63   | 835         | 32.87       | 50.0        |
| MR130.80.78  | 80     | 3.15   | 123    | 4.84   | 16     | 0.63   | 835         | 32.87       | 55.0        |
| MR130.90.78  | 90     | 3.54   | 133    | 5.24   | 16     | 0.63   | 835         | 32.87       | 60.0        |
| MR130.100.78 | 100    | 3.94   | 143    | 5.63   | 16     | 0.63   | 835         | 32.87       | 65.0        |
| MR130.120.78 | 120    | 4.72   | 163    | 6.42   | 16     | 0.63   | 835         | 32.87       | 70.0        |

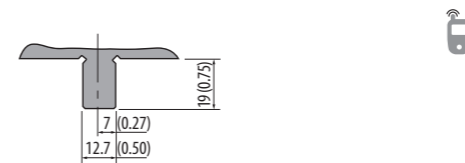
A10



A11



A13





Our Advantages – Your Convenience

- increase in wear resistance through rollers
- induction hardened rollers (approx. 60 HRC)
- decrease in bending marks
- decrease in press force
- easy and economic exchange of rollers

AD MR13

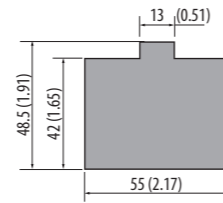
NEW



98 mm 3.86 in  
Adapter for Roller Type R2/R3  
C45: 560-710 N/mm<sup>2</sup>

AD MR55

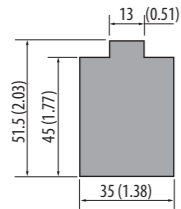
NEW



98 mm 3.86 in  
Adapter for Roller Type RX EHT  
C45: 560-710 N/mm<sup>2</sup>

AD MR35

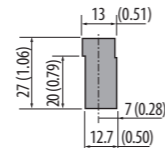
NEW



98 mm 3.86 in  
Adapter for Roller Type RX Weinbrenner  
C45: 560-710 N/mm<sup>2</sup>

AD MR12.7

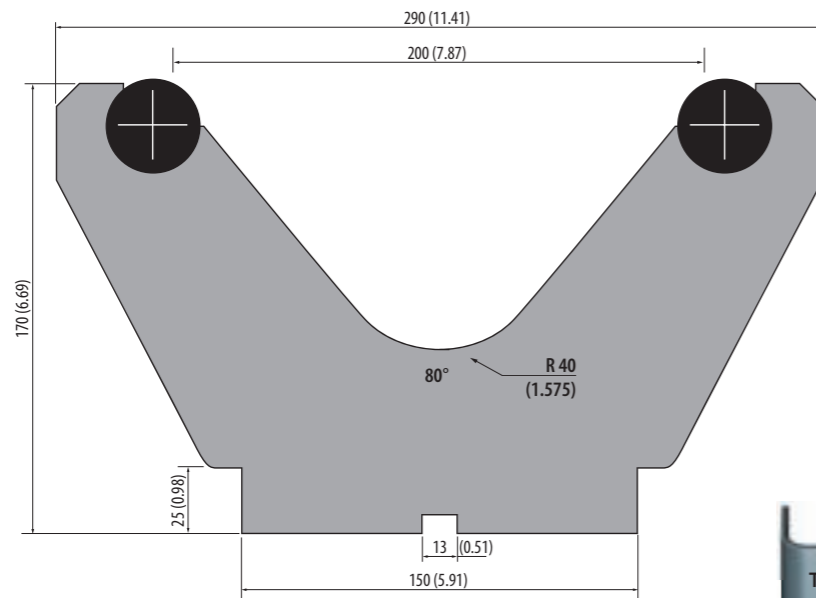
NEW



98 mm 3.86 in  
Adapter for Roller Type RX LVD  
C45: 560-710 N/mm<sup>2</sup>

MR170.200.80

NEW

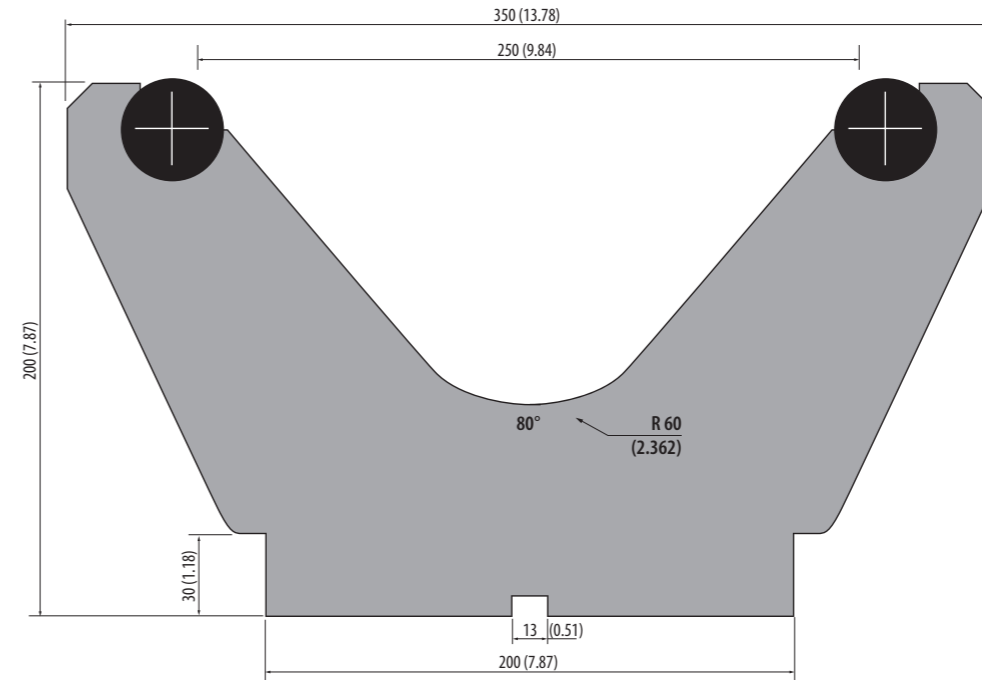


2000 kN/m max.  
100 mm 3.94 in 19.0 kg  
42Cr: 900-1150 N/mm<sup>2</sup>

Take advantage of our dies with rollers with means of groove bars/tails to use on other press brake machines.

MR200.250.80

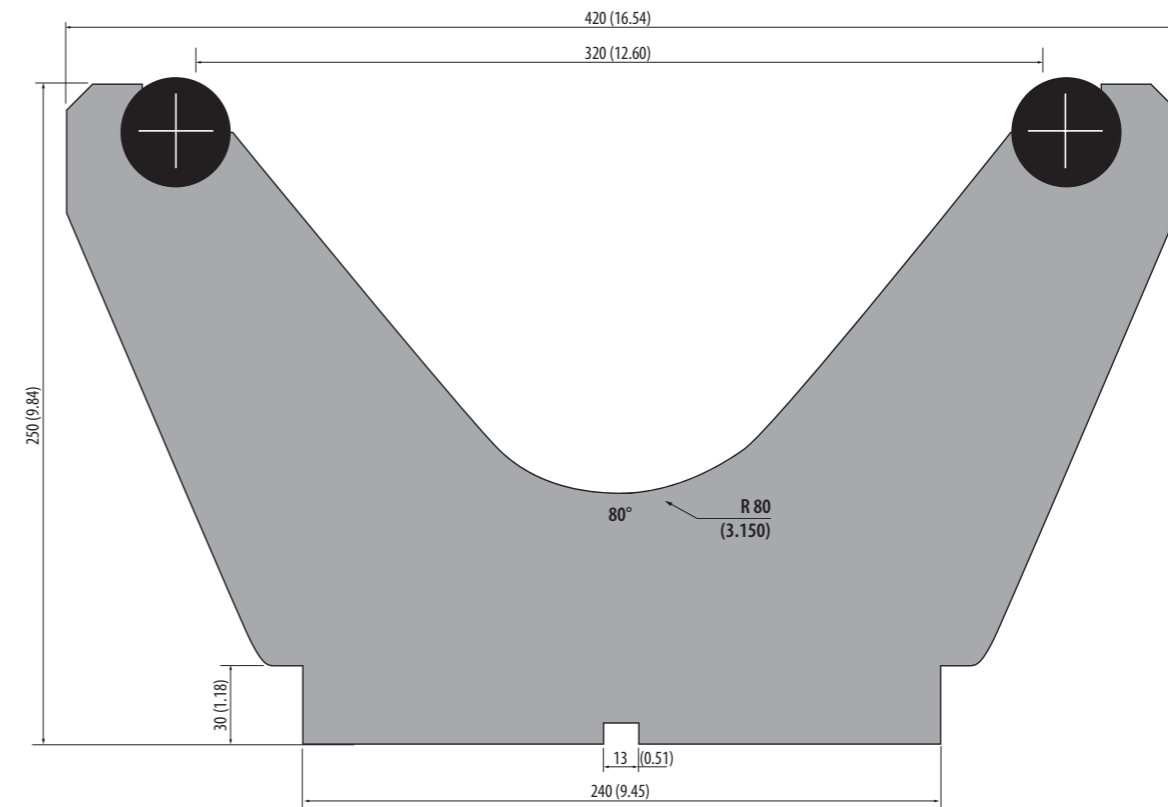
NEW



2000 kN/m max.  
100 mm 3.94 in 28.0 kg  
42Cr: 900-1150 N/mm<sup>2</sup>

MR250.320.80

NEW



2000 kN/m max.  
100 mm 3.94 in 42.0 kg  
42Cr: 900-1150 N/mm<sup>2</sup>

ROL6-System

Our Advantages – Your Convenience

- various V-Openings: 40-360 mm (1.57-14.17 in)
- Instructions:
  - secured manually with steering wheel
  - driven by gear motor or
  - CNC-system

While using the manual version, the opening is set in place by a turn of the steering wheel, or with a gear reduction which is attached to the die.

The automatic version, on the other hand, is operated by a control panel. The standard system does not come with the CNC-Connection for the press brake. It is available upon request at an additional cost.

The base of the ROL6-system is 720 mm (28.35 in) wide, but can also be fitted onto narrow designed tables. There is a adapter available in order to secure the system onto a table with a width of 400 mm (15.75 in). The inserts in the opening radius are exchangeable. The standard version comes with an opening radius of R=10 mm (0.39 in).

Die weight: approx. 1 ton/m

ROL6



42Cr: 900-1150 N/mm<sup>2</sup>

| bending angle | kN/m max. |
|---------------|-----------|
| 0°            | 6000      |
| 90°           | 6000      |
| 60°           | 4000      |



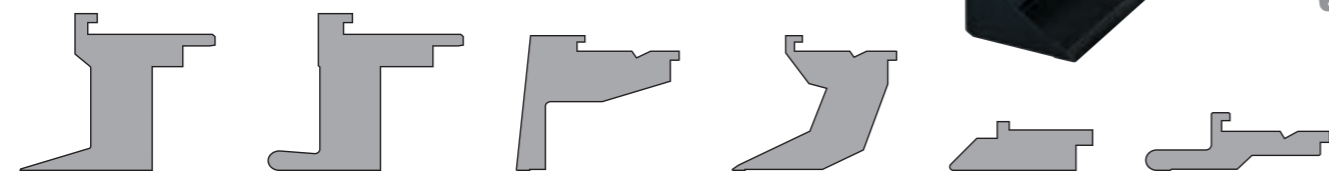
Rolleri Videos

Application of various dies ROL6:  
[www.rolleritools.com/videos/rol6](http://www.rolleritools.com/videos/rol6)

Panelling Tools

Our Advantages – Your Convenience

- in-house construction (no reseller or dealer)
- production according to your specifications
- tracking of every tool possible, with a unique serial number on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- exact parallelism
- use of the best materials, guaranteed high resistance and tensile strength



BLACKFIRE



The Unique Coating

Rolleri BLACKFIRE is a particular coating of your tools which defines itself by its increased corrosion resistance and special design.

The chemical treatment permanently solves the problem of oxidation.

The top surface of the metals changes through the phosphate process. It builds phosphate-like crystals, that attach themselves chemically on the substance. This improves the durability of the surface against corrosion.

Your equipment will have a long-term lifecycle left unchanged. The glossy black color of BLACKFIRE is compatible with the new technology and that allows a unique and esthetic look which connects well with the advantages of it.

You can have the BLACKFIRE treatment on all standard tools with a surcharge of 30%.

Please note that the delivery times vary by a BLACKFIRE Treatment.

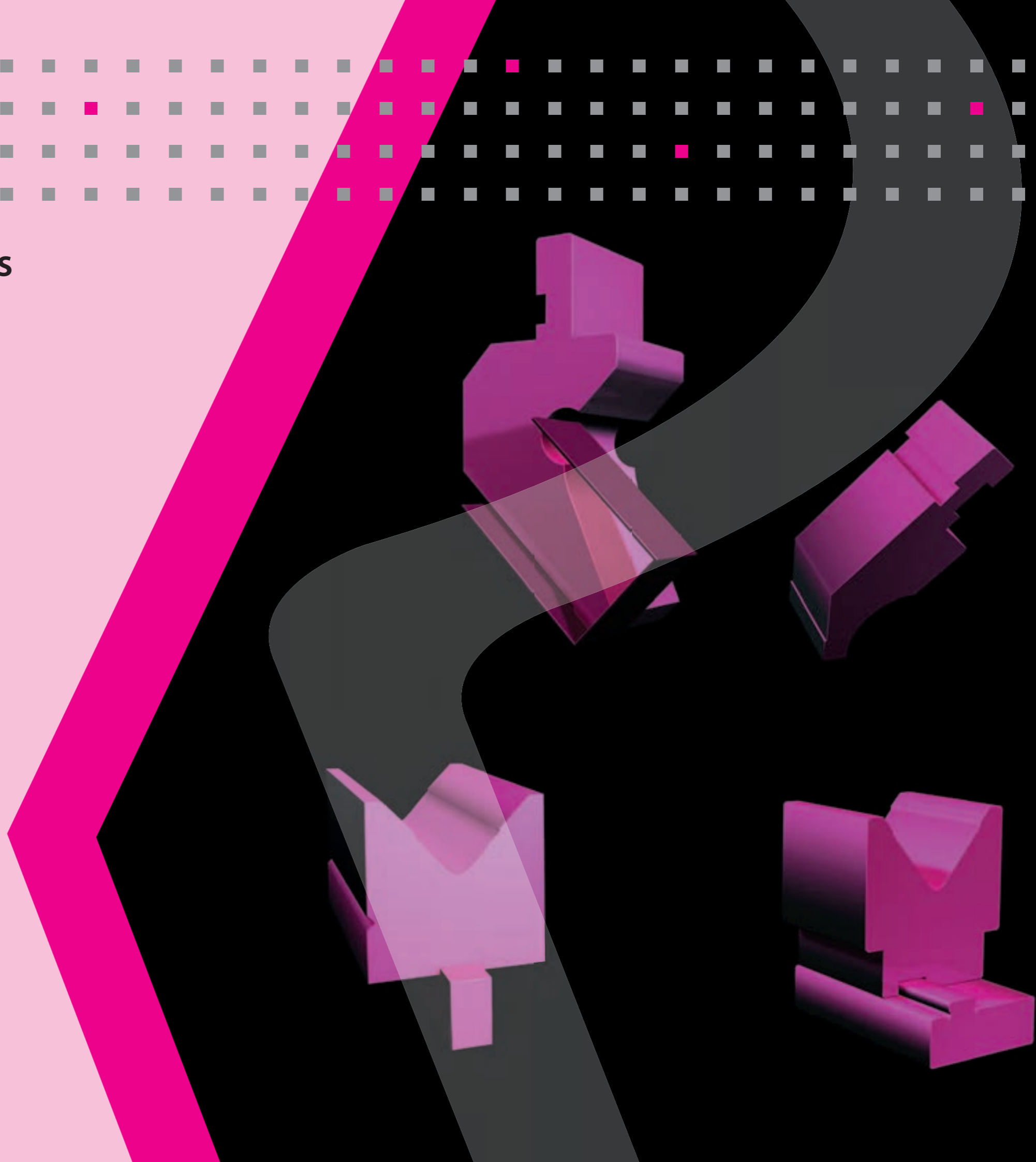
Our Advantages – Your Convenience

- no corrosion
- better gliding by the exchange of tools
- appealing design
- long-life cycle



## ROLLERI SERVICES / MODIFICATIONS

|  |           |
|--|-----------|
| Our Production Department              | 246 - 247 |
| Modified Tangs                         | 248 - 249 |
| Special Sectioning                     | 250       |
| Horn Pieces                            | 250       |
| Modifying the V-Opening                | 250       |
| Radius and Angle Modification          | 251       |
| Grooves for Dies                       | 251       |
| Grooves and Groove Bars/Tails for Dies | 252       |
| Gaps and Windows                       | 253       |



**Our Machine Park**

Our comprehensive machinery with state-of-the-art technology ensures you the highest quality in tools.

In addition to the manufactured standard and special tools, we perform all modifications individually according to your requirements.

Take advantage the modifications to reduce costs and increase the productivity of your existing tools!



**CNC-Milling**

With our state-of-the-art milling centers we can do your modification requests fast, precise and with high-quality.

Swivel milling heads with high swivel range allows flexible and universal production.

This is where, grooves, gaps, and openings are created.

**CNC-Profile Grinding**

Our CNC-Professional grinding machines guarantee, highest precision ground (tolerance of +/-0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tool pieces. Radius and angle modifications are percisely grounded after your measurements.



**Hardening**

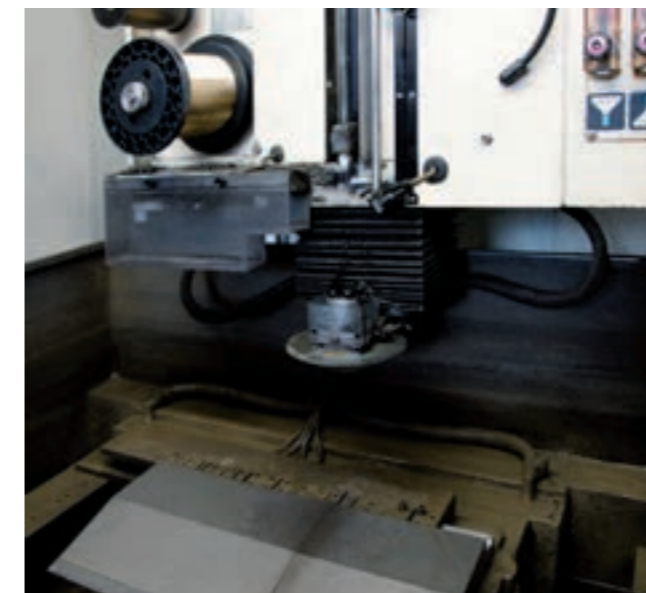
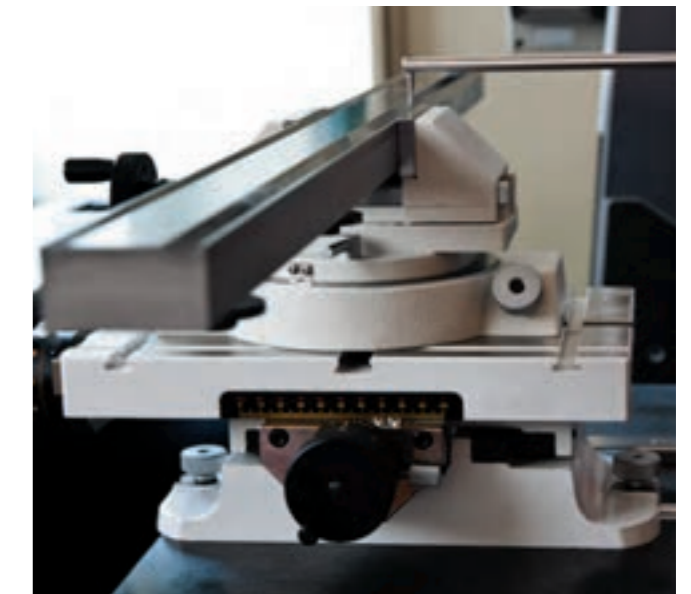
The surface areas of the tools are exposed to the highest mechanical stress. Due to the fact that, the whole press force of the press brake machine is focused on small surface of the sheet metal. Therefore the stress is very high on these surfaces. During the bending process of the sheet metal, friction occurs.

For more resistance strength the hardening of the surfaces can be increased. The depth of the hardening must be at least 3 mm to avoid deformations. We use the electromagnetic technique also known as induction hardening to the best quality for your money's worth.

**Quality Control and Laser Marking**

After the laser marking, tracking of every tool is possible with a unique serial number on every article. Therefore the tracking of your tools is guaranteed and a new productions with the exact same meausrements (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.

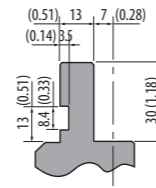
## ROLLERI MODIFICATIONS

... for standard tangs

### 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

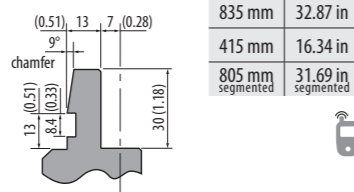
### Standard Rolleri Type R1



Fast delivery on these items guaranteed. Please note that delivery terms vary according to your location.

### OT

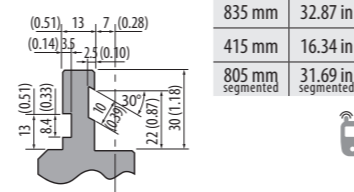
- Modification for:
- for Amada fast clamping system



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

### A1

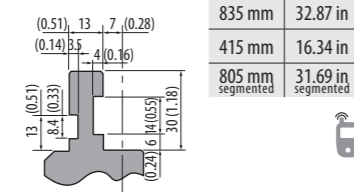
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- pneumatic clamping system



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

### A6

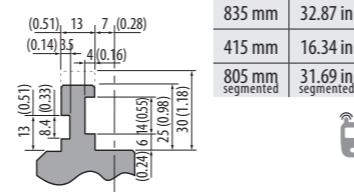
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- Rolleri Type R3
  - Bystronic-Beyeler Euro
  - Safan



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

### A7

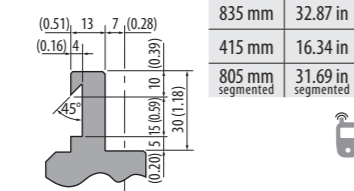
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
- Rolleri Type R3
  - Bystronic-Beyeler Euro
  - Safan



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

### A8

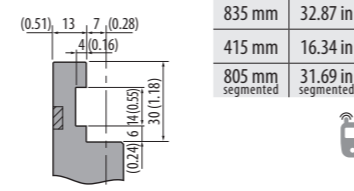
- Groove Bar/Tail for:
- hydraulic clamping system Gasparini



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

### A41

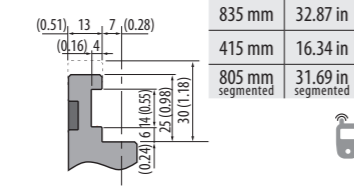
- older clamping system



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

### A42

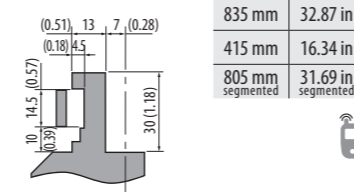
- older clamping system



|                  |                    |
|------------------|--------------------|
| 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



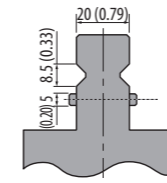
|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

## ROLLERI MODIFICATIONS

... for standard tangs

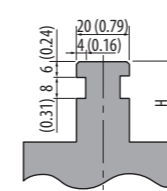


### Standard Rolleri Type R2

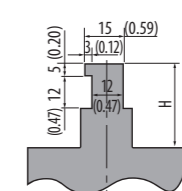


### Modification examples Type R2

production according to your specifications

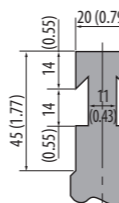


production according to your specifications



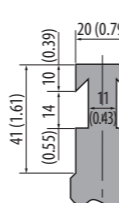
Take advantage of your existing tools with means of modifications.

### Standard Rolleri Type R3

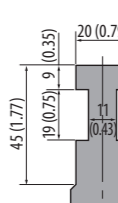


### Modification examples Type R3

production according to your specifications



production according to your specifications



## ROLLERI MODIFICATIONS

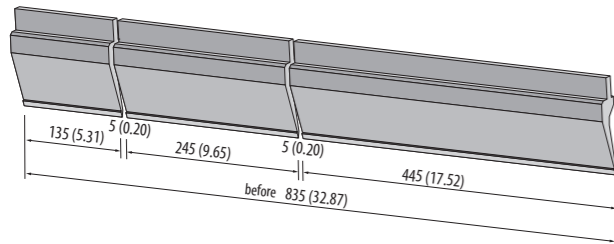
### Special Sectioning

- Individual sectioning of your punches and dies
- fast, economic, percise

Pro separation cutting causes a decrease in length of approx. 5 mm

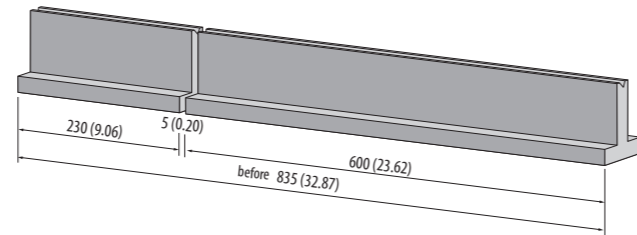
#### Special Sectioning of Punches

Example of punches production according to your specifications



#### Special Sectioning of Dies

Example of Dies production according to your specifications

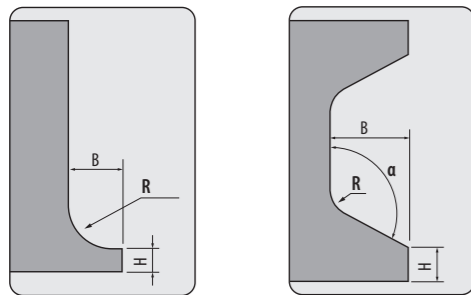


## Horn Pieces

- individual horn pieces on punches and dies
- on one or both sides
- fast, economic, percise

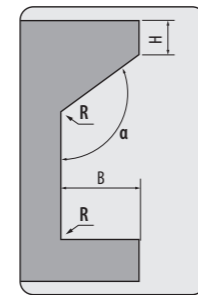
#### Horn Pieces for Punches

Punch example production according to your specifications



#### Horn Pieces for Dies

Die example production according to your specifications

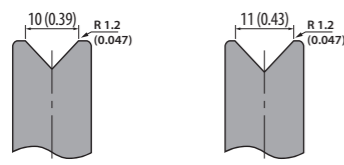


## Modifying the V-Opening

- individual modification for dies
- fast, economic, percise

#### Modifying the V-Opening

Example production according to your specifications



Give us a call for more information!

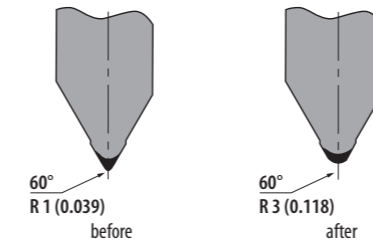
## ROLLERI MODIFICATIONS

### Radius and Angle Modifications

- Individual modifications of your punches and dies
- fast, economic, percise

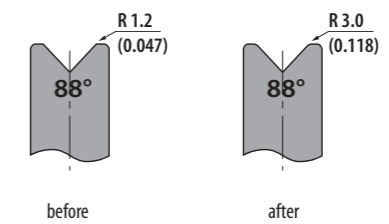
#### Radius Modifications for Punches

Radii modification Punch example production according to your specifications



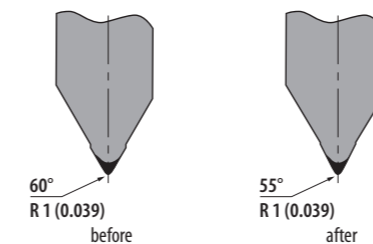
#### Radius Modifications for Dies

Opening Radius modification die example production according to your specifications



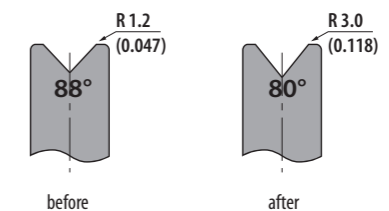
#### Angle Modification Punches

Angle modification punch example production according to your specifications



#### Angle Modification Dies

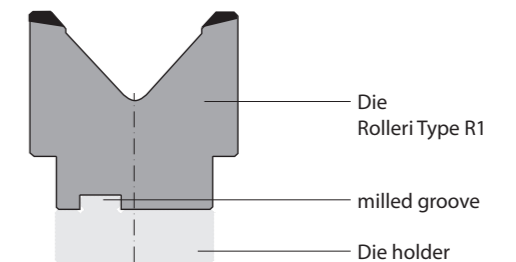
Angle modification die example production according to your specifications



## Grooves for Dies

- Milling of grooves for use on other press brake systems
- fast, economic, percise

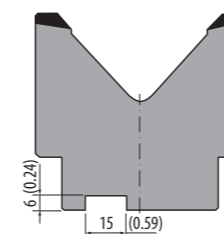
#### Mounting example



Delivery within 3 business days. Upon concordance even faster!

#### A28

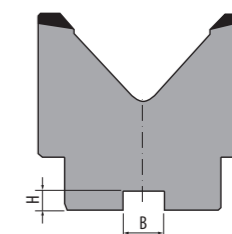
Groove for die holder



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

#### A29

groove production according to your specifications



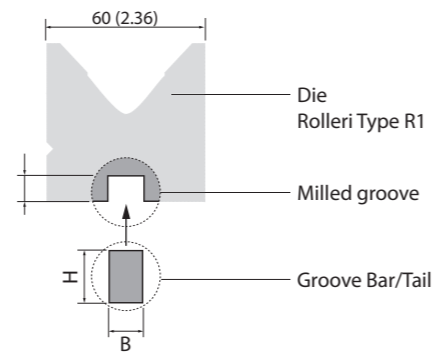
|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |

## ROLLERI MODIFICATIONS

### Grooves und Groove Bars/Tails for Dies

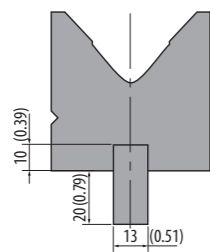
- For milling of the groove and the insert of a ground groove bar/tail the exact measurement is needed to use on other press brake systems
- fast, economic, percise

#### Mounting example



#### A30

Groove Bars/Tails:  
13 x 30 mm (0.51 x 1.18 in) for  
• Roller Type R2  
• Roller Type R3

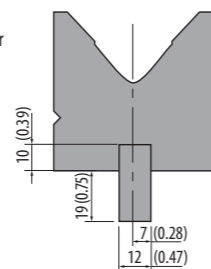


|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |



#### A31

Groove Bars/Tails:  
12 x 29 mm (0.47 x 1.14 in) for  
• Roller Type RX LVD

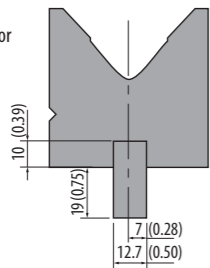


|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |



#### A32

Groove Bars/Tails:  
12.7 x 29 mm (0.50 x 1.14 in) for  
• Roller Type RX LVD

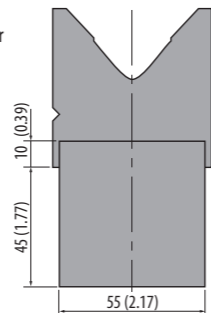


|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |



#### A44

Groove Bars/Tails:  
55 x 55 mm (2.17 x 2.17 in) for  
• Roller Type RX EHT

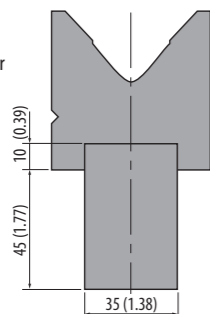


|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |



#### A45

Groove Bars/Tails:  
35 x 55 mm for  
• Roller Type RX Weinbrenner

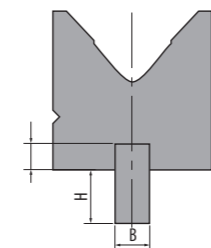


|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |



#### AX

individual Groove Bars/Tails  
for other systems



|                  |                    |
|------------------|--------------------|
| 835 mm           | 32.87 in           |
| 415 mm           | 16.34 in           |
| 805 mm segmented | 31.69 in segmented |



## ROLLERI MODIFICATIONS

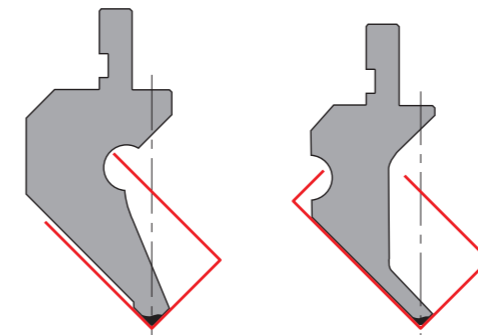
### Gaps and Windows

- The retrofitting of the tool edges of long parts, short U-profiles and similar
- fast, economic, percise



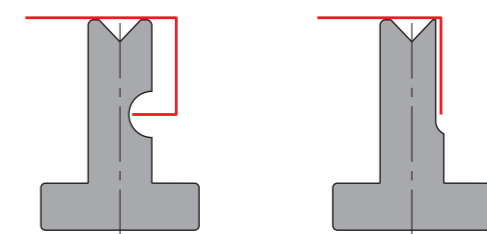
#### Gaps on Punches

Example Punches  
production according to your specifications



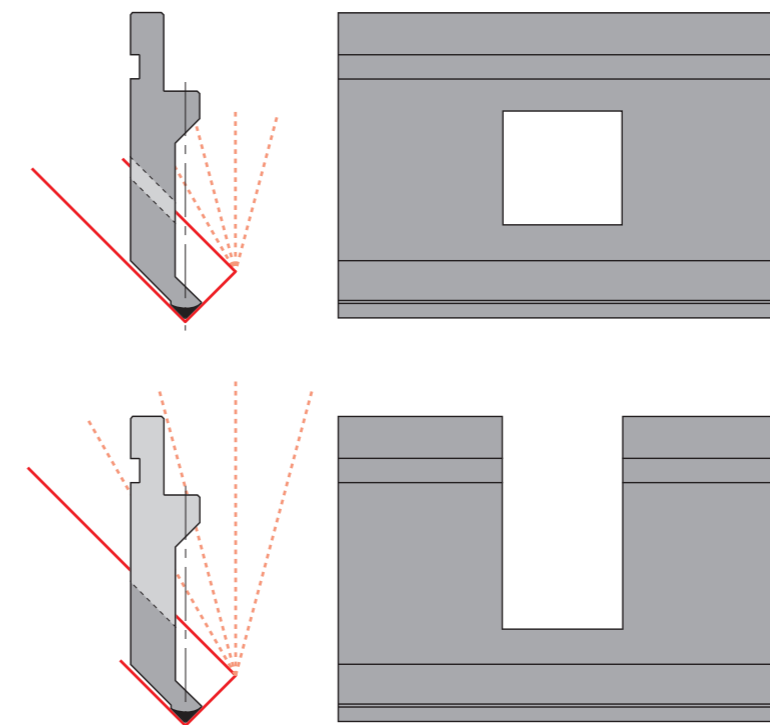
#### Gaps on Dies

Example Dies  
production according to your specifications



#### Windows for Punches

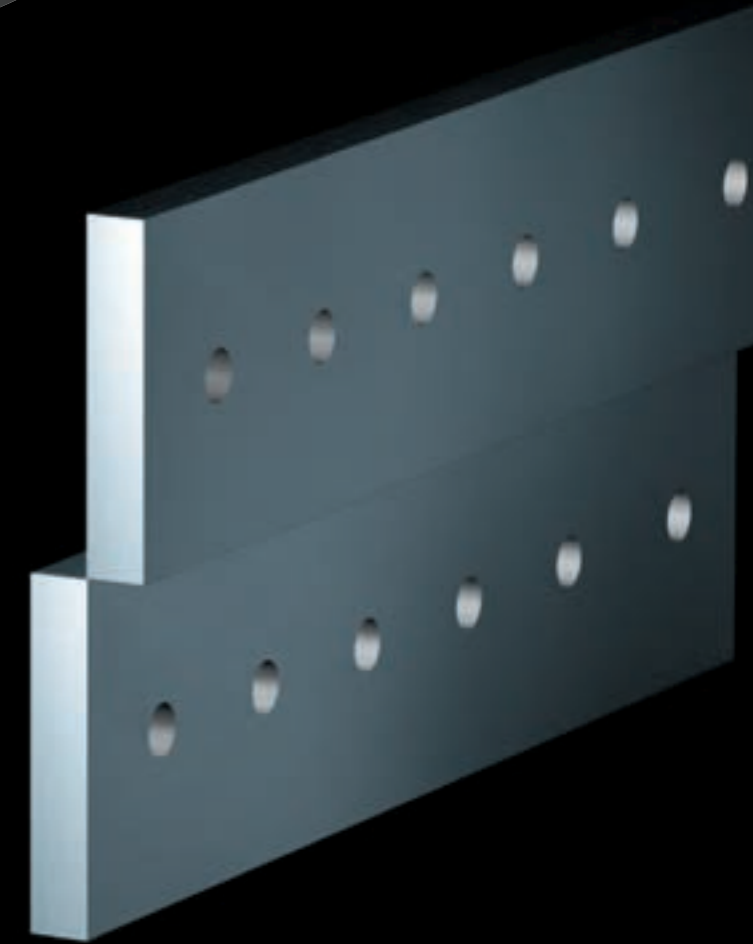
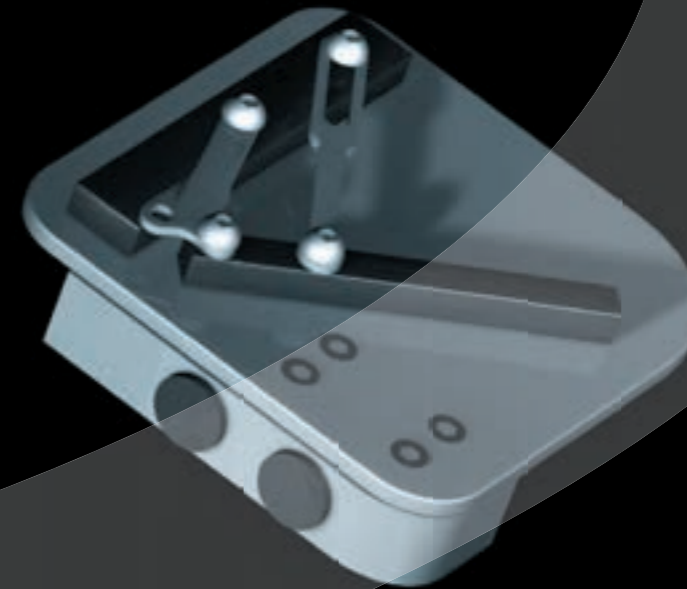
Example Punches  
production according to your specifications



For Roller BLACKFIRE  
see page 243

## ROLLERI SHEAR BLADES AND ACCESSORIES

|                  |           |
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| Tooling Cabinets | 256 - 257 |
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## ROLLERI ACCESSORIES

### Tooling Cabinets

#### Our Advantages – Your Convenience

- Protection against contamination and damage
- Faster access
- Robust construction
- Clear and tidy storage
- Cabinet doors specially designed for lift trucks and truck
- Adjustable height, zinc-plated shelves



#### Rolleri Videos

Tool storage demonstration at:  
[www.rolleritools.com/  
 videos/tooling-cabinets](http://www.rolleritools.com/videos/tooling-cabinets)



#### ARM 835-4 for max. tool length = 835 mm (32.87 in)



850 x 1240 x 1050 (W x H x D)  
 33.46 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1  
 approx. 20 m (787.40 in)  
 Storage capacity



| Equipment  |  |
|------------|--|
| 4 Drawers  | vertical, on wheels (see CS-1)                               |
| 16 Shelves | for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1) |
| 4 Shelves  | for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3) |
| Weight     | 271.0 kg   |

#### ARM 835-5 for max. tool length = 835 mm (32.87 in)



1040 x 1240 x 1050 (W x H x D)  
 40.94 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1  
 approx. 25 m (984.25 in)  
 Storage capacity



| Equipment  |  |
|------------|--|
| 5 Drawers  | vertical, on wheels (see CS-1)                               |
| 20 Shelves | for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1) |
| 5 Shelves  | for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3) |
| Weight     | 350.0 kg   |

#### ARM 1060-4 / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)  
 33.46 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3  
 approx. 26 m / 39 m (1023.62 in /  
 1535.43 in) Storage capacity



| Equipment ARM 1060-4 |   |
|----------------------|---|
| 4 Drawers            | vertical, on wheels (see CS-2)                                  |
| 16 Shelves           | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2) |
| 4 Shelves            | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4) |
| Weight               | 340.0 kg  |

| Equipment ARM 1060-4-CV |  |
|-------------------------|--|
| 4 Drawers               | vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV) |
| 20 Shelves              | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)          |
| 10 Shelves              | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)          |
| Weight                  | 351.0 kg   |

#### ARM 1060-5 / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)  
 40.94 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3  
 approx. 32.5 m / 52 m (1279.52 in /  
 2047.24 in) Storage capacity



| Equipment ARM 1060-5 |   |
|----------------------|---|
| 5 Drawers            | vertical, on wheels (see CS-2)                                  |
| 20 Shelves           | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2) |
| 5 Shelves            | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4) |
| Weight               | 400.0 kg  |

| Equipment ARM 1060-5-CV |  |
|-------------------------|--|
| 5 Drawers               | vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV) |
| 30 Shelves              | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)          |
| 10 Shelves              | for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)          |
| Weight                  | 490.0 kg   |

## ROLLERI ACCESSORIES

### Tool Cabinets



#### ARM 1060-4-T / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)  
 33.46 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3  
 approx. 20.8 m / 31.2 m (818.89 in /  
 1228.34 in) Storage capacity



| Equipment ARM 1060-4-T |   |
|------------------------|---|
| 4 Drawers              | vertical, on wheels (see CS-2)                                  |
| 8 Shelves              | for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4) |
| 8 Shelves              | for type R2/R3 (see shelves UT-4)                               |
| Weight                 | 383.0 kg  |

| Equipment ARM 1060-4-T-CV |  |
|---------------------------|--|
| 4 Drawers                 | vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV) |
| 16 Shelves                | for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)          |
| 8 Shelves                 | for type R2/R3 (see shelves UT-4)  |
| Weight                    | 360.0 kg   |

#### ARM 1060-5-T / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)  
 40.94 x 48.82 x 53.54 (W x H x D)

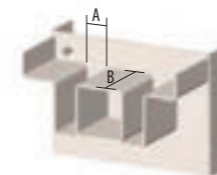
for Tools Roller Type R2/R3  
 approx. 26 m / 41.6 m (1023.62 in /  
 1637.79 in) Storage capacity



| Equipment ARM 1060-5-T |   |
|------------------------|---|
| 5 Drawers              | vertical, on wheels (see CS-2)                                  |
| 10 Shelves             | for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4) |
| 10 Shelves             | for type R2/R3 (see shelves UT-4)                               |
| Weight                 | 447.0 kg  |

| Equipment ARM 1060-5-T-CV |  |
|---------------------------|--|
| 5 Drawers                 | vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV) |
| 24 Shelves                | for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)          |
| 8 Shelves                 | for type R2/R3 (see shelves UT-4)  |
| Weight                    | 500.0 kg   |

#### UC-Shelves



| Model   | L mm (in)  | A mm (in) | B mm (in)  | Weight |
|---------|------------|-----------|------------|--------|
| UC-13-1 | 125 (4.92) | 13 (0.51) | 76 (2.99)  | 0.5 kg |
| UC-13-2 | 250 (9.84) | 13 (0.51) | 232 (9.13) | 1.0 kg |
| UC-20-1 | 125 (4.92) | 20 (0.79) | 76 (2.99)  | 0.5 kg |
| UC-20-2 | 250 (9.84) | 20 (0.79) | 232 (9.13) | 1.0 kg |

2 pieces

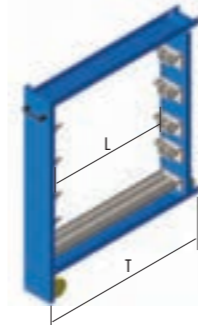
#### UT-Shelves



| Model | L (mm) | L (in) | Weight |
|-------|--------|--------|--------|
| UT-1  | 270    | 10.63  | 1.4 kg |
| UT-2  | 580    | 22.83  | 3.2 kg |
| UT-3  | 1050   | 41.34  | 5.8 kg |
| UT-4  | 1360   | 53.54  | 7.5 kg |

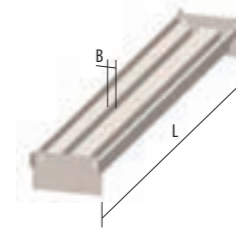
enough room for punches with safety pins

#### CS-Drawers



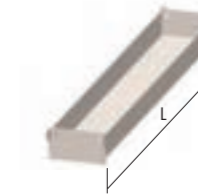
| Model | T mm (in)    | L mm (in)    | Weight  |
|-------|--------------|--------------|---------|
| CS-1  | 1050 (41.34) | 856 (33.70)  | 22.0 kg |
| CS-2  | 1360 (53.54) | 1166 (45.91) | 25.0 kg |

#### UL-Shelves



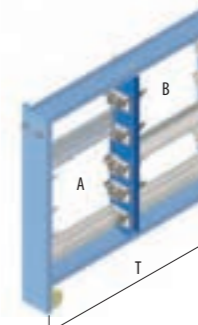
| Model   | L mm (in)    | B mm (in) | Weight |
|---------|--------------|-----------|--------|
| UL-13-1 | 270 (10.63)  | 13 (0.51) | 1.2 kg |
| UL-13-2 | 580 (22.83)  | 13 (0.51) | 2.5 kg |
| UL-13-3 | 1050 (41.34) | 13 (0.51) | 4.6 kg |
| UL-13-4 | 1360 (53.54) | 13 (0.51) | 6.0 kg |
| UL-20-1 | 270 (10.63)  | 20 (0.79) | 1.4 kg |
| UL-20-2 | 580 (22.83)  | 20 (0.79) | 3.2 kg |
| UL-20-3 | 1050 (41.34) | 20 (0.79) | 5.8 kg |
| UL-20-4 | 1360 (53.54) | 20 (0.79) | 7.5 kg |

#### UV-Shelves



| Model | L (mm) | L (in) | Weight |
|-------|--------|--------|--------|
| UV-1  | 270    | 10.63  | 1.0 kg |
| UV-2  | 580    | 22.83  | 2.0 kg |
| UV-3  | 1050   | 41.34  | 4.3 kg |
| UV-4  | 1360   | 53.54  | 5.5 kg |

#### CV-Dividers



| Model | T mm (in)    | A mm (in)   | B mm (in)   | Weight |
|-------|--------------|-------------|-------------|--------|
| CV-1  | 1050 (41.34) | 580 (22.83) | 270 (10.63) | 7.0 kg |
| CV-2  | 1360 (53.54) | 580 (22.83) | 580 (22.83) | 7.0 kg |

## ROLLERI ACCESSORIES

### Tool Trolley

#### Our Advantages – Your Convenience

- faster access
- robust construction
- clear and tidy storage
- visibility of tools

#### Tool Trolleys

| Model     | Content    | Tool System  | Weight   |
|-----------|------------|--------------|----------|
| A Trolley | 30 Shelves | for R1 tools | 108.0 kg |
| T Trolley | 21 Shelves | for R2 tools | 175.0 kg |
| B Trolley | 21 Shelves | for R3 tools | 135.0 kg |



#### Rolleri Videos

Secure storage and mobility:  
[www.rolleritools.com/videos/tool-trolley](http://www.rolleritools.com/videos/tool-trolley)



## Bending Box

### Bending Box

per piece 1.6 kg



## ROLLERI ACCESSORIES

### Squaring Arms

#### Our Advantages – Your Convenience

- easy and fast securing
- precise and flexible adjustability
- adjustable angle stop
- mountable on all dies
- ideal for long, and thin sheet metals



#### Rolleri Videos

Magnetic Squaring Arms :  
[www.rolleritools.com/videos/squaring-arms](http://www.rolleritools.com/videos/squaring-arms)



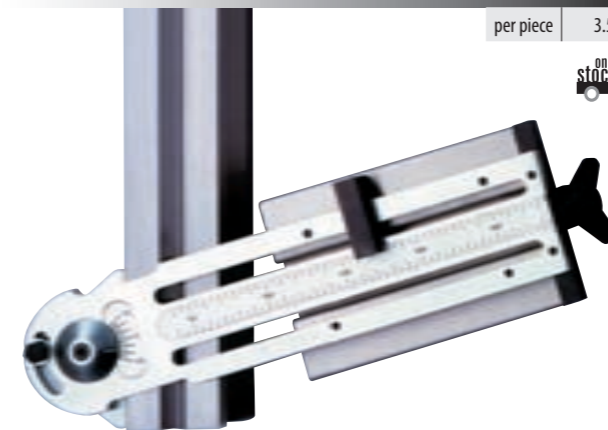
#### MSA – magnetic

|               |           |        |
|---------------|-----------|--------|
| MSA.D (right) | per piece | 1.4 kg |
| MSA.S (left)  | per piece | 1.4 kg |



#### AS

per piece 3.5 kg



Give us a call for  
 more information!

## ROLLERI ACCESSORIES

### Supporting Arms and Back Gauge

#### RIF-Supporting Arm

| Model   | Length mm (in) |         | Weight  |
|---------|----------------|---------|---------|
| RIF500  | 500            | (19.68) | 7.0 kg  |
| RIF1000 | 1000           | (39.37) | 12.0 kg |
| RIF1500 | 1500           | (59.05) | 17.0 kg |



- for secure support for high volume sheet metals
- greater surface guarantees a trouble-free support for sheet metals
- easy handling

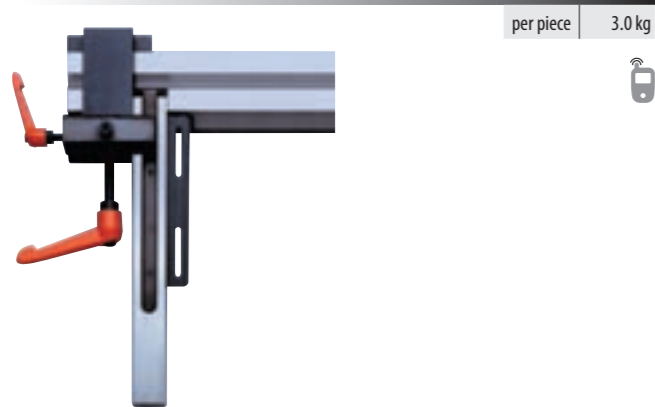
#### RP-Back Gauge

| Model  | Weight |
|--------|--------|
| RP500A | 8.0 kg |
| RP500B | 8.0 kg |



- ensures for the correct positioning of tools on the press brake and secures herewith the exact border distance.
- fast and exact repeatability
- easy handling

#### AS FIX



per piece 3.0 kg

## Shear Blades

We manufacture in our company over more than 20 years shear blades.

High-quality steels are finished according to your specifications.

New production and retrofitting service: fast, economic, precise!

Please provide us with the following information:

- What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.
- How thick is the material in diameter?
- How often to you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

## ROLLERI SHEAR BLADES

### Shear Blades

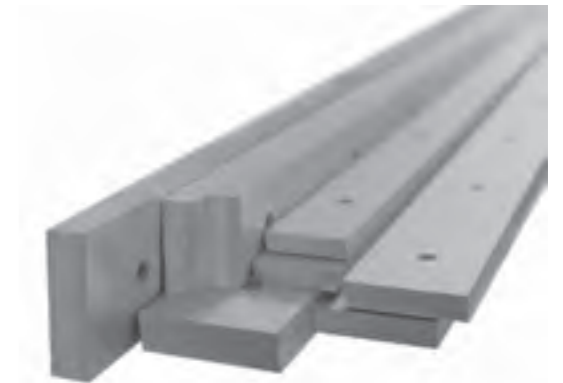


#### Our Advantages – Your Convenience

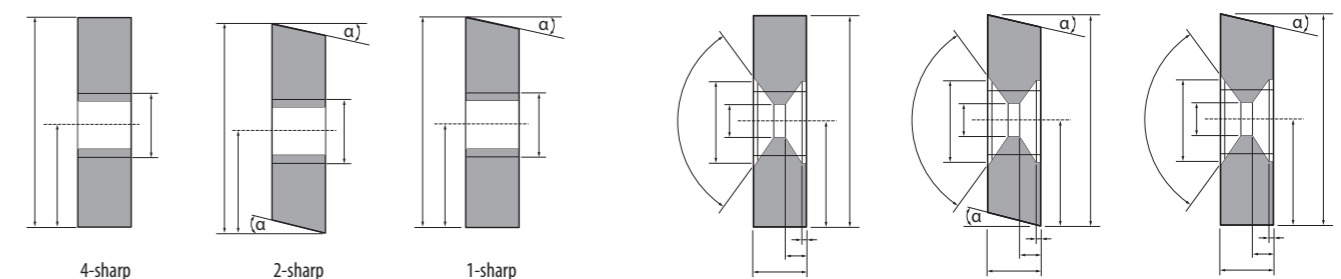
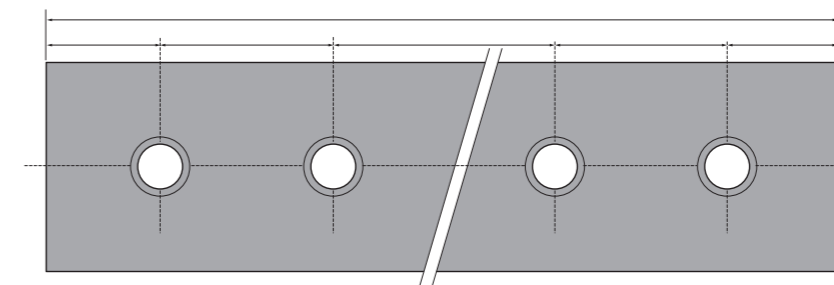
- own production
- custom production
- depending on the cutting material
- high quality Materials
- 4-, 2- or 1-sharp
- with threaded holes or bilateral reduction
- hardened according to your specifications and request



| available sizes mm (in) |                       |                       |                       |                       |
|-------------------------|-----------------------|-----------------------|-----------------------|-----------------------|
| 50 x 10 (1.97 x 0.39)   | 55 x 12 (2.17 x 0.47) | 60 x 12 (2.36 x 0.47) | 65 x 13 (2.56 x 0.51) | 70 x 13 (2.76 x 0.51) |
| 50 x 11 (1.97 x 0.43)   | 55 x 13 (2.17 x 0.51) | 60 x 13 (2.36 x 0.51) | 65 x 14 (2.56 x 0.55) | 70 x 14 (2.76 x 0.55) |
| 50 x 12 (1.97 x 0.47)   | 55 x 14 (2.17 x 0.55) | 60 x 14 (2.36 x 0.55) | 65 x 15 (2.56 x 0.59) | 70 x 15 (2.76 x 0.59) |
| 50 x 13 (1.97 x 0.51)   | 55 x 15 (2.17 x 0.59) | 60 x 15 (2.36 x 0.59) | 65 x 16 (2.56 x 0.63) | 70 x 16 (2.76 x 0.63) |
| 50 x 14 (1.97 x 0.55)   | 55 x 16 (2.17 x 0.63) | 60 x 16 (2.36 x 0.63) | 65 x 17 (2.56 x 0.67) | 70 x 17 (2.76 x 0.67) |
| 50 x 15 (1.97 x 0.59)   | 55 x 17 (2.17 x 0.67) | 60 x 17 (2.36 x 0.67) | 65 x 18 (2.56 x 0.71) | 70 x 18 (2.76 x 0.71) |
|                         | 55 x 18 (2.17 x 0.71) | 60 x 18 (2.36 x 0.71) | 65 x 19 (2.56 x 0.75) | 70 x 19 (2.76 x 0.75) |
|                         | 55 x 19 (2.17 x 0.75) | 60 x 19 (2.36 x 0.75) | 65 x 20 (2.56 x 0.79) | 70 x 20 (2.76 x 0.79) |
|                         | 55 x 20 (2.17 x 0.79) | 60 x 20 (2.36 x 0.79) |                       |                       |



| available sizes mm (in) |                       |                       |                       |                        |
|-------------------------|-----------------------|-----------------------|-----------------------|------------------------|
| 75 x 15 (2.95 x 0.59)   | 80 x 16 (3.15 x 0.63) | 85 x 18 (3.35 x 0.71) | 90 x 20 (3.54 x 0.79) | 100 x 20 (3.94 x 0.79) |
| 75 x 16 (2.95 x 0.63)   | 80 x 18 (3.15 x 0.71) | 85 x 19 (3.35 x 0.75) | 90 x 21 (3.54 x 0.83) | 100 x 22 (3.94 x 0.87) |
| 75 x 17 (2.95 x 0.67)   | 80 x 19 (3.15 x 0.75) | 85 x 20 (3.35 x 0.79) | 90 x 22 (3.54 x 0.87) | 100 x 25 (3.94 x 0.98) |
| 75 x 18 (2.95 x 0.71)   | 80 x 20 (3.15 x 0.79) | 85 x 21 (3.35 x 0.83) | 90 x 23 (3.54 x 0.91) | 100 x 26 (3.94 x 1.02) |
| 75 x 19 (2.95 x 0.75)   | 80 x 21 (3.15 x 0.83) | 85 x 22 (3.35 x 0.87) | 90 x 24 (3.54 x 0.94) | 100 x 27 (3.94 x 1.06) |
| 75 x 20 (2.95 x 0.79)   | 80 x 22 (3.15 x 0.87) | 85 x 23 (3.35 x 0.91) | 90 x 25 (3.54 x 0.98) | 100 x 28 (3.94 x 1.10) |
| 75 x 21 (2.95 x 0.83)   | 80 x 23 (3.15 x 0.91) | 85 x 24 (3.35 x 0.94) |                       | 100 x 29 (3.94 x 1.14) |
| 75 x 22 (2.95 x 0.87)   | 80 x 24 (3.15 x 0.94) | 85 x 25 (3.35 x 0.98) |                       | 100 x 30 (3.94 x 1.18) |
| 75 x 23 (2.95 x 0.91)   | 80 x 25 (3.15 x 0.98) |                       |                       |                        |
| 75 x 24 (2.95 x 0.94)   |                       |                       |                       |                        |
| 75 x 25 (2.95 x 0.98)   |                       |                       |                       |                        |

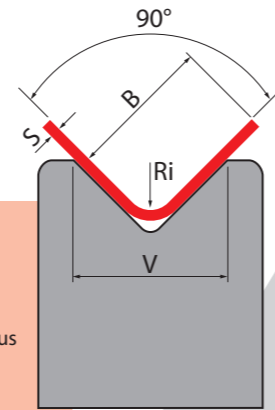


**Press Force Table**

The press force table is based on the press force caliper and is very useful to those who deal with sheet metal profiles. It can assist you from the projection of profiles, to technical construction, to the buying of tools, and to the finished profile from the press brake machine.

In the first left column the thickness of the sheet metal is noted as (S). In the three first lines you can find the die width (V), the minimum boarder (B), and the ideal inner profile radius (Ri).

By crossing the thickness with the die width, you will find the necessary press force per meter. Furthermore, depicted are the span of 5 different die widths. The correction factors are found below in the table.



S = Thickness  
V = Die Width  
B = Min. Boarder  
Ri = Inner Profile Radius

|           |  | 420 N/mm <sup>2</sup> |     |     |     |     |     |      |      |      |      |      |      |      |      |      |      |       |       |       |    |
|-----------|--|-----------------------|-----|-----|-----|-----|-----|------|------|------|------|------|------|------|------|------|------|-------|-------|-------|----|
| S<br>(mm) |  | 4                     | 5   | 6   | 8   | 10  | 12  | 16   | 20   | 25   | 32   | 40   | 50   | 63   | 80   | 100  | 125  | 160   | 200   | 250   | V  |
|           |  | 3.0                   | 3.5 | 4.0 | 5.5 | 6.5 | 8.0 | 10.5 | 13.0 | 16.5 | 21.0 | 26.0 | 32.5 | 41.0 | 52.0 | 65.0 | 81.5 | 104.0 | 130.0 | 163.0 | B  |
|           |  | 0,5                   | 0,7 | 0,8 | 1,0 | 1,3 | 1,5 | 2,0  | 2,5  | 3,2  | 4,4  | 5,0  | 6,5  | 8,0  | 10,0 | 12,0 | 15,0 | 20,0  | 25,0  | 37,0  | Ri |
| 0.6       |  | 60                    | 50  | 30  | 20  |     |     |      |      |      |      |      |      |      |      |      |      |       |       |       |    |
| 0.8       |  | 120                   | 90  | 70  | 50  | 40  |     |      |      |      |      |      |      |      |      |      |      |       |       |       |    |
| 1.0       |  |                       | 150 | 110 | 80  | 60  | 50  |      |      |      |      |      |      |      |      |      |      |       |       |       |    |
| 1.2       |  |                       |     | 180 | 120 | 90  | 70  | 50   |      |      |      |      |      |      |      |      |      |       |       |       |    |
| 1.5       |  |                       |     |     | 210 | 150 | 120 | 80   | 60   |      |      |      |      |      |      |      |      |       |       |       |    |
| 2.0       |  |                       |     |     |     | 300 | 230 | 160  | 120  | 90   |      |      |      |      |      |      |      |       |       |       |    |
| 2.5       |  |                       |     |     |     |     | 390 | 270  | 200  | 140  | 110  |      |      |      |      |      |      |       |       |       |    |
| 3.0       |  |                       |     |     |     |     |     | 430  | 310  | 230  | 160  | 120  |      |      |      |      |      |       |       |       |    |
| 4.0       |  |                       |     |     |     |     |     |      | 600  | 440  | 320  | 230  | 180  |      |      |      |      |       |       |       |    |
| 5.0       |  |                       |     |     |     |     |     |      |      | 760  | 540  | 390  | 290  | 220  |      |      |      |       |       |       |    |
| 6.0       |  |                       |     |     |     |     |     |      |      |      | 850  | 620  | 450  | 330  | 250  |      |      |       |       |       |    |
| 8.0       |  |                       |     |     |     |     |     |      |      |      |      | 1210 | 880  | 700  | 460  | 350  |      |       |       |       |    |
| 10.0      |  |                       |     |     |     |     |     |      |      |      |      |      | 1510 | 1090 | 790  | 580  | 440  |       |       |       |    |
| 12.0      |  |                       |     |     |     |     |     |      |      |      |      |      |      | 1730 | 1240 | 910  | 660  | 500   |       |       |    |
| 15.0      |  |                       |     |     |     |     |     |      |      |      |      |      |      |      | 2130 | 1550 | 1130 | 810   | 620   |       |    |
| 20.0      |  |                       |     |     |     |     |     |      |      |      |      |      |      |      |      | 3020 | 2200 | 1580  | 1150  | 890   |    |
| 25.0      |  |                       |     |     |     |     |     |      |      |      |      |      |      |      |      |      | 3780 | 2690  | 1970  | 1440  |    |

F  
kN/m

|      |         |                         |         |      |
|------|---------|-------------------------|---------|------|
| 30°  | B x 1.6 | R=200 N/mm <sup>2</sup> | r x 0.8 | Al   |
| 60°  | B x 1.1 |                         |         |      |
| 90°  | B x 1.0 | R=420 N/mm <sup>2</sup> | r x 1.0 | Fe   |
| 120° | B x 0.9 |                         |         |      |
| 150° | B x 0.7 | R=700 N/mm <sup>2</sup> | r x 1.4 | INOX |

[www.rolleritools.com](http://www.rolleritools.com)

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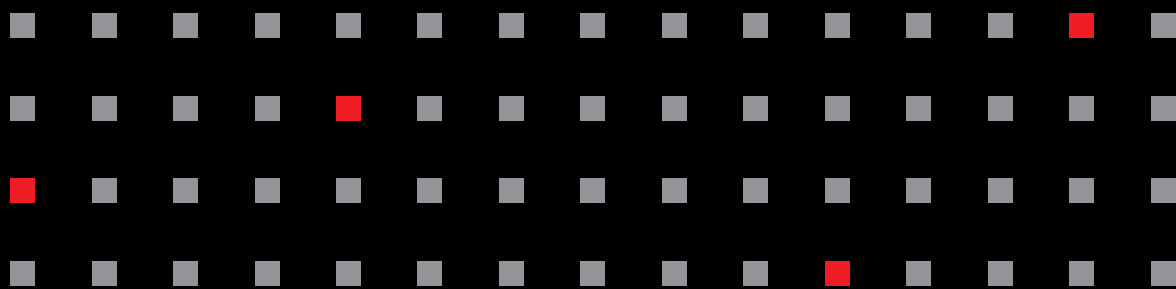
- drawings 1:1 format available
- extra information and tips
- helpful videos and application examples
- easy website browsing



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