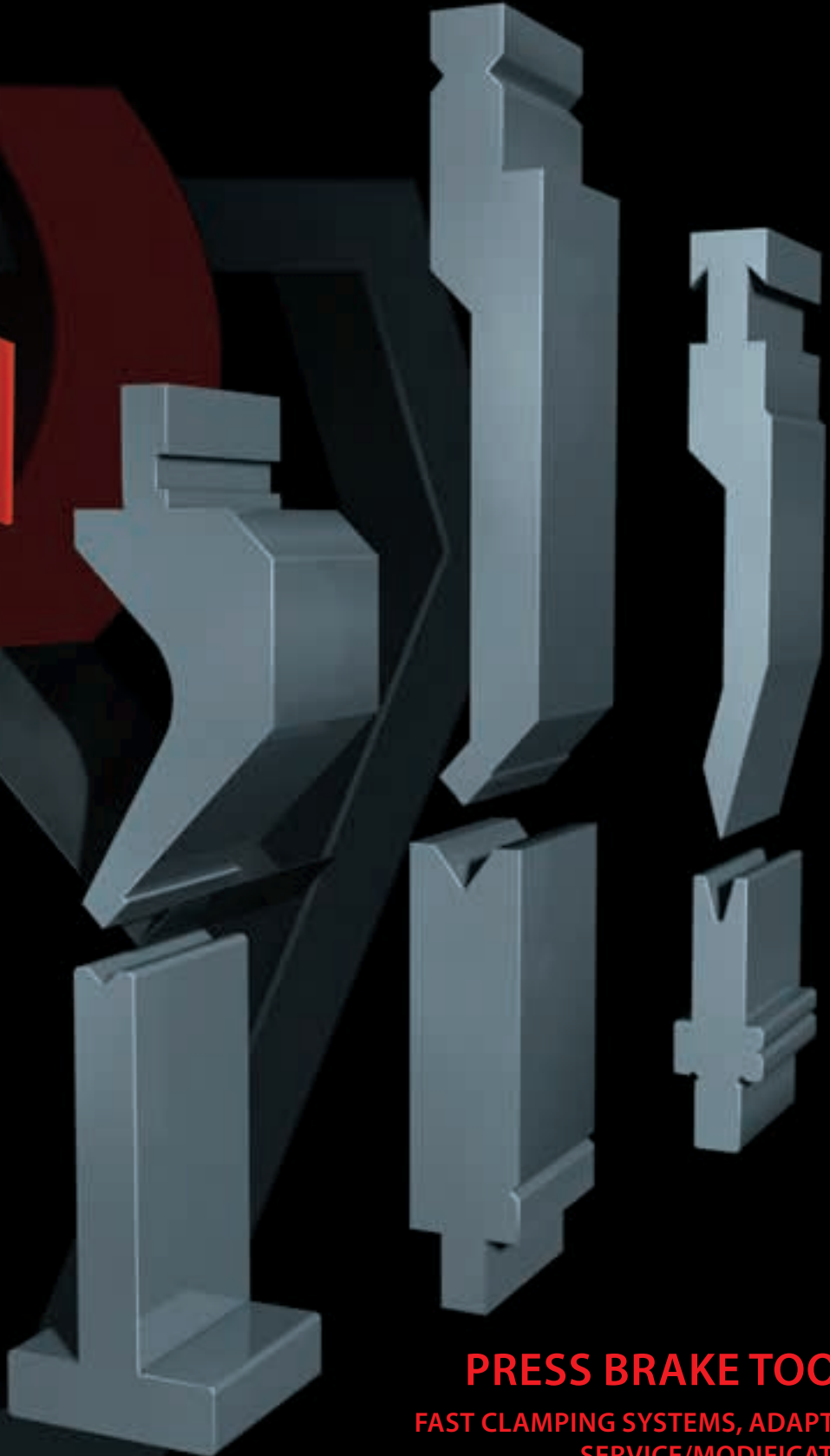




ROLLERI®

**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



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.

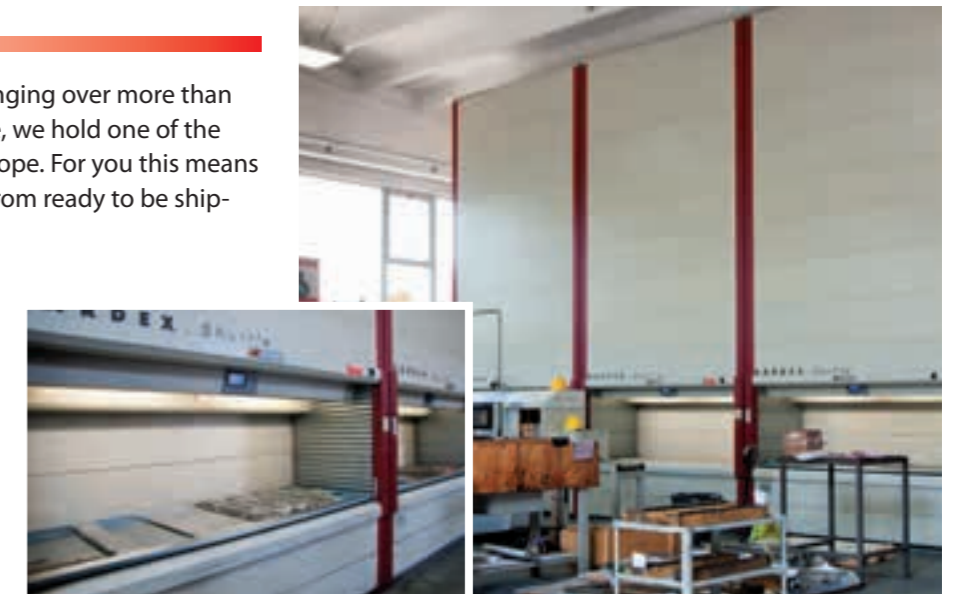


THE WAREHOUSE

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**



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

THE CONSTRUCTION

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

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

Inquire with us today!



THE RAW MATERIAL

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



THE QUALITY

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

THE PRESS BRAKE TOOLS

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



THE QUALITY CONTROL

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

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

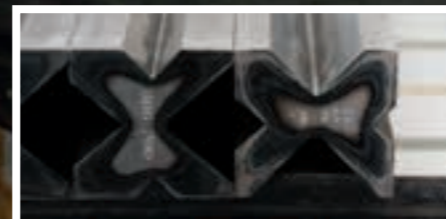
Of course Rolleri also guarantees accurate reproduction, high-quality material, induction hardening, and precision grinding.



INNOVATIONS

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

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



Compatibility

■ Tools Roller Type R1

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

■ Tools Roller Type R2

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

■ Tools Roller Type R3

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

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

■ Tools Roller Type RX

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

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

PUNCHES ROLLERI TYPE R1

DIES ROLLERI TYPE R1

PUNCHES ROLLERI TYPE R2

DIES ROLLERI TYPE R2

PUNCHES ROLLERI TYPE R3

DIES ROLLERI TYPE R3

TOOLS ROLLERI TYPE RX

ROLLERI DIES ROLLA-V

ROLLERI CLAMPING SYSTEMS

ROLLERI ADAPTERS

ROLLERI MARK FREE BENDING

ROLLERI SPECIAL AND HEAVY DUTY TOOLS

ROLLERI SERVICE / MODIFICATIONS

ROLLERI SHEAR BLADES / ACCESSORIES

PUNCHES ROLLERI TYPE 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 ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

All punches 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!

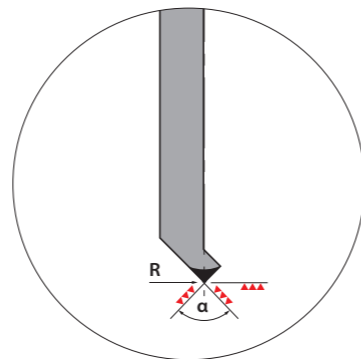
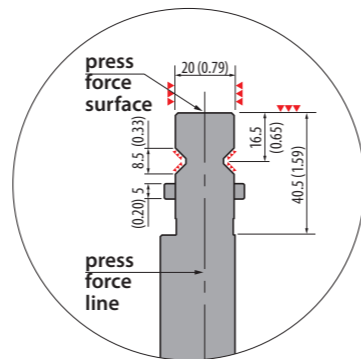
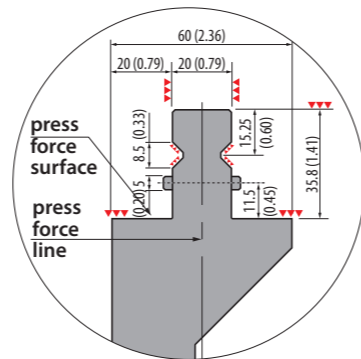
Depending on each type, the punches are either head-bearing or shoulder-bearing.

Indications of precision ground surfaces:



Our Advantages – Your Convenience

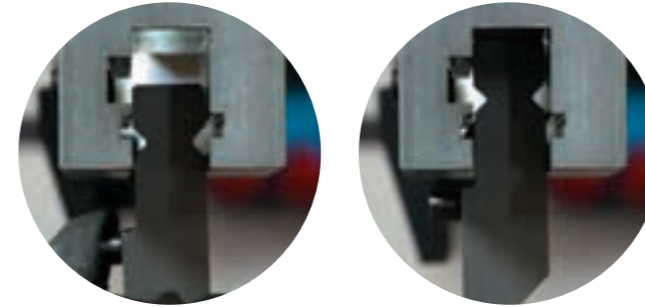
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height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

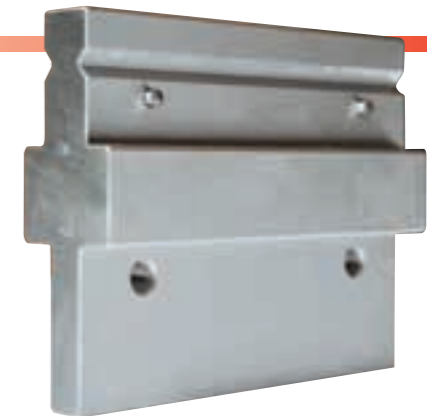


Rolleri Videos

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

Safety Pins (Standard)

- horizontal tool exchange



ROL1-System

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



Tool Lengths and Sectioning

Standard

More lengths and sectionings are possible upon request.

500 mm (19.68 in)

515 mm (20.28 in)

525 mm (20.67 in)

Sectioning FA

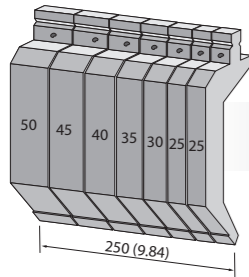
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

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

Sectioning FB

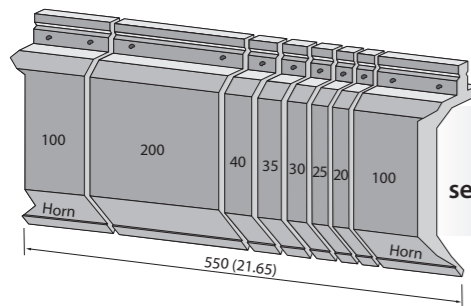
1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

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

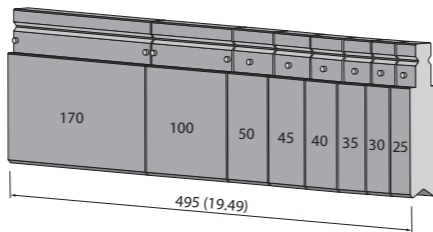


250 mm (9.84 in) segmented / FC (7 segments)

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

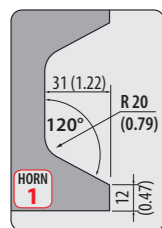


550 mm (21.65 in) segmented / FW (8 segments)

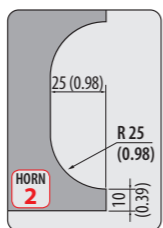


495 mm (19.49 in) segmented / F (8 segments)

Horn Types



Horn 1
Standard for all segmented Punches Rolleri Type R2

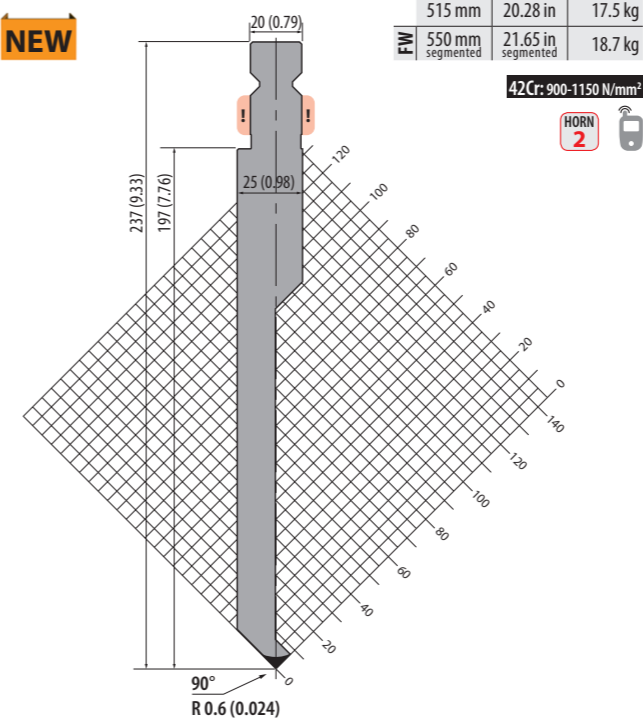


Horn 2
for all segmented Punches Rolleri Type R2 of Length 550 mm (21.65 in)

TPR237.90.R06

600 kN/m max.

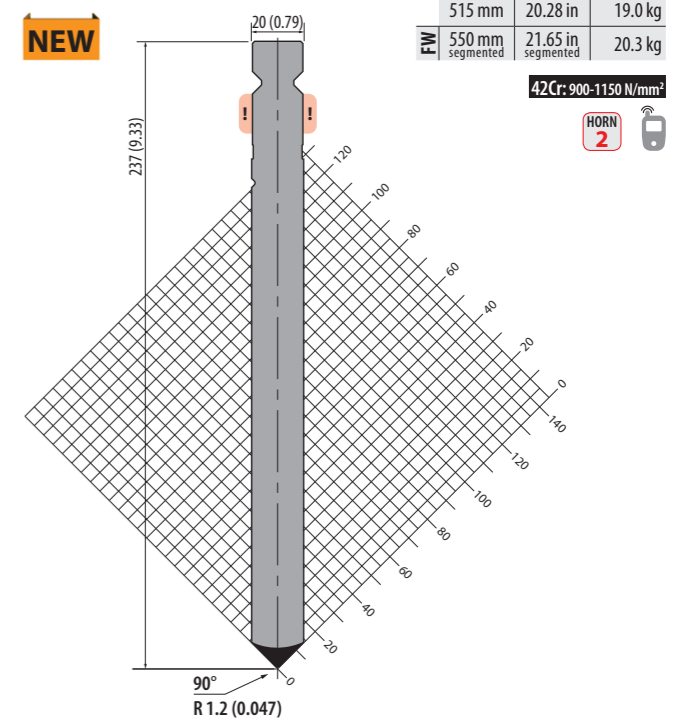
NEW



TPR237.90.R12

1000 kN/m max.

NEW

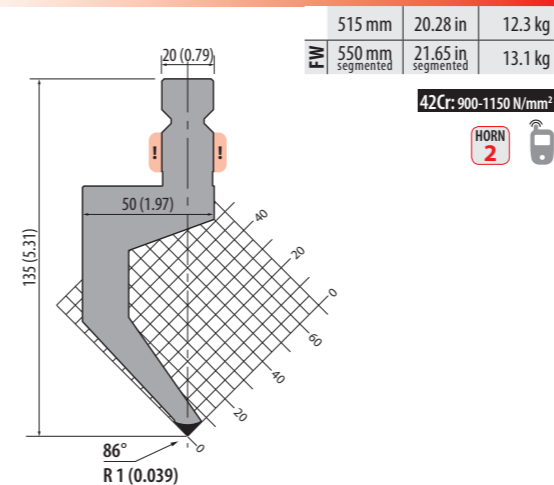


86° Punches

TPR135.86.R1

650 kN/m max.

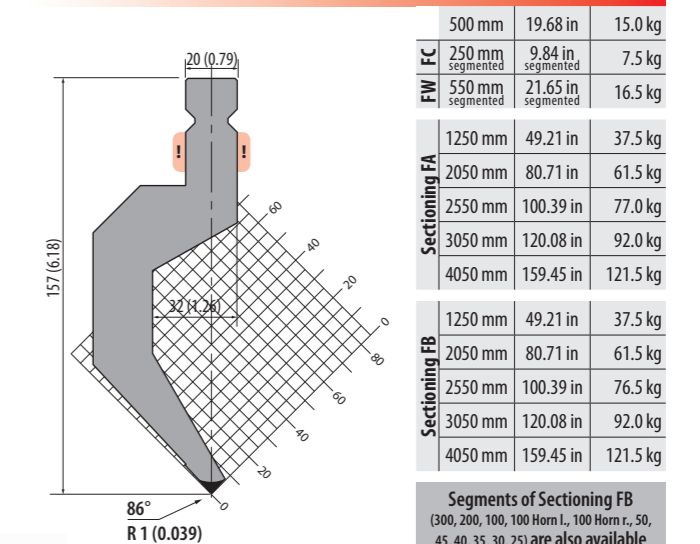
NEW



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.

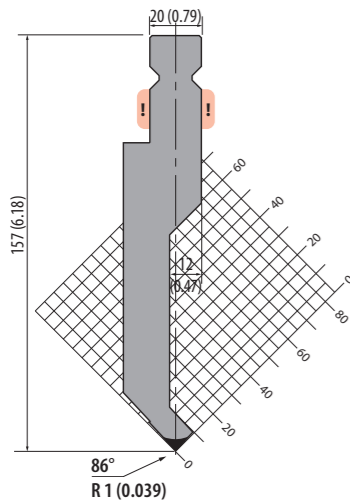
42Cr: 900-1150 N/mm²
HORN 1
HORN 2 only for 550 mm (21.65 in) segm.

R2 ROLLERI TYPE R2

86° Punches

TPR157.86.R1-A

800 kN/m max.



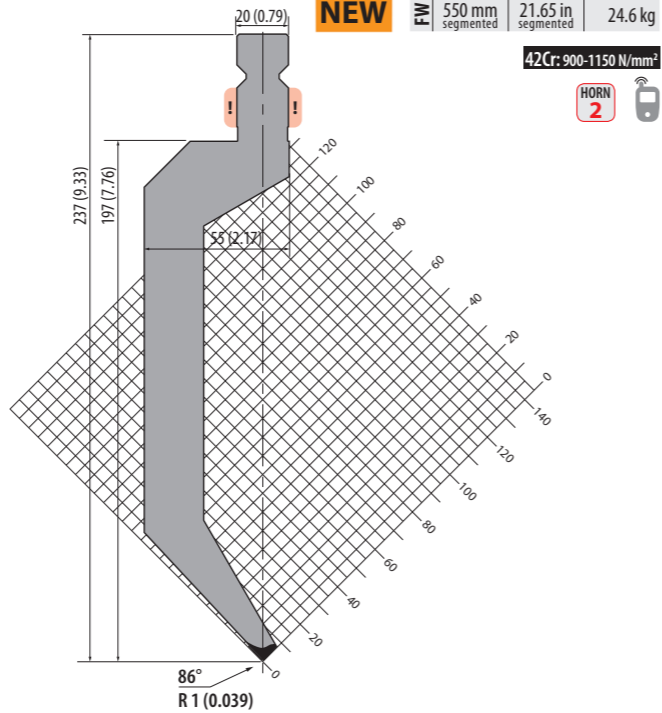
	500 mm	19.68 in	12.5 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
FW	550 mm segmented	21.65 in segmented	13.8 kg
Sectioning FA	1250 mm	49.21 in	31.3 kg
	2050 mm	80.71 in	51.3 kg
	2550 mm	100.39 in	63.8 kg
	3050 mm	120.08 in	76.3 kg
Sectioning FB	1250 mm	49.21 in	31.3 kg
	2050 mm	80.71 in	51.3 kg
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

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

42Cr: 900-1150 N/mm²
HORN 1
HORN 2 only for 550 mm (21.65 in) segm.

TPR237.86.R1

500 kN/m max.



NEW

	515 mm	20.28 in	23.0 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
FW	550 mm segmented	21.65 in segmented	24.6 kg

42Cr: 900-1150 N/mm²
HORN 2

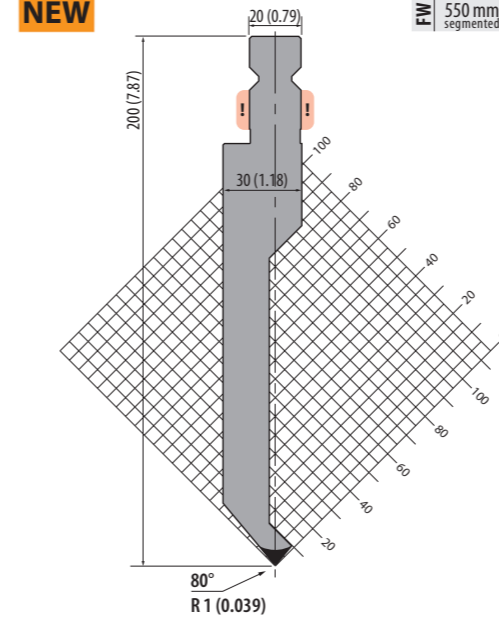
R2 ROLLERI TYPE R2

80° Punches



TPR200.80.R1

800 kN/m max.



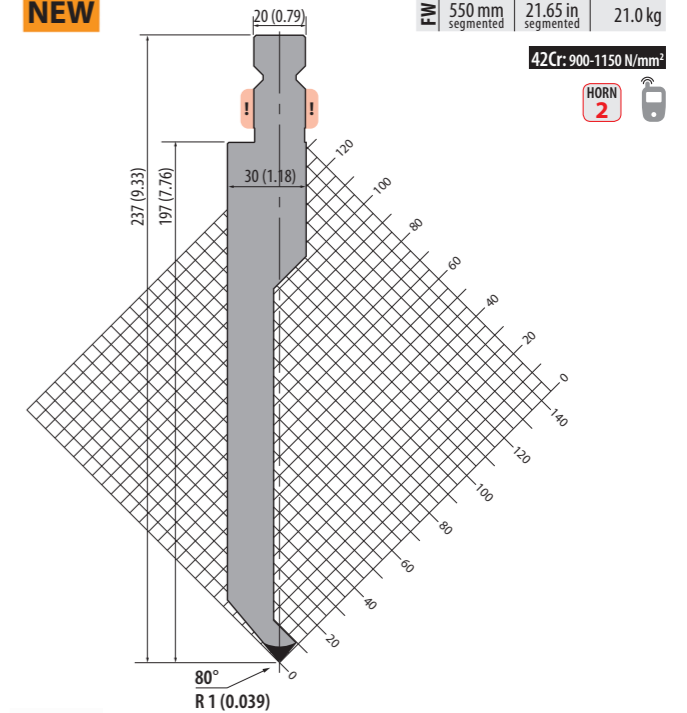
NEW

	515 mm	20.28 in	19.0 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
FW	550 mm segmented	21.65 in segmented	20.3 kg

42Cr: 900-1150 N/mm²
HORN 2

TPR237.80.R1

800 kN/m max.



NEW

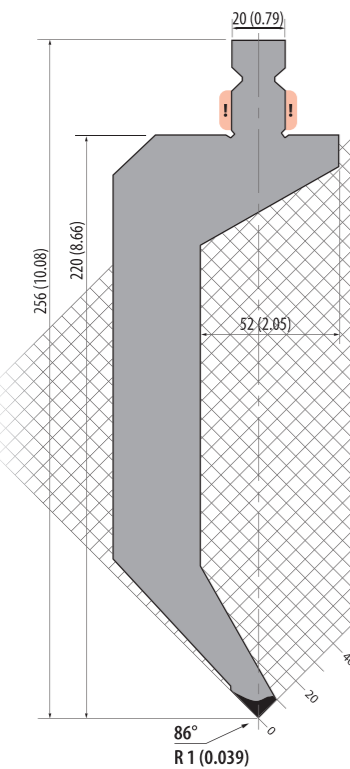
	515 mm	20.28 in	19.7 kg
FC	250 mm segmented	9.84 in segmented	6.3 kg
FW	550 mm segmented	21.65 in segmented	21.0 kg

42Cr: 900-1150 N/mm²
HORN 2

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

TPR256.86.R1

800 kN/m max.



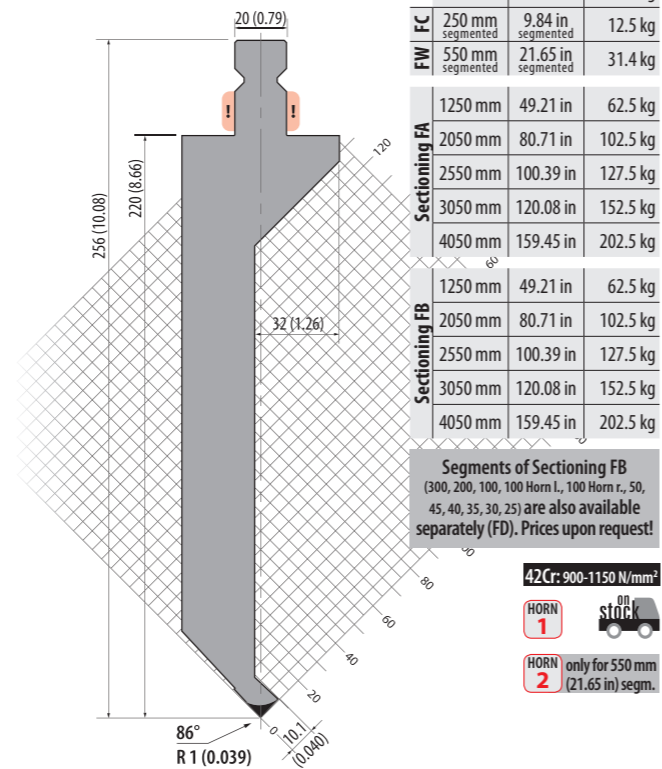
	500 mm	19.68 in	33.0 kg
FC	250 mm segmented	9.84 in segmented	16.5 kg
FW	550 mm segmented	21.65 in segmented	36.3 kg
Sectioning FA	1250 mm	49.21 in	82.5 kg
	2050 mm	80.71 in	136.0 kg
	2550 mm	100.39 in	189.0 kg
	3050 mm	120.08 in	202.0 kg
Sectioning FB	1250 mm	49.21 in	82.5 kg
	2050 mm	80.71 in	136.0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

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

42Cr: 900-1150 N/mm²
HORN 1
HORN 2 only for 550 mm (21.65 in) segm.

TPR256.86.R1-A

800 kN/m max.



	500 mm	19.68 in	28.5 kg
FC	250 mm segmented	9.84 in segmented	12.5 kg
FW	550 mm segmented	21.65 in segmented	31.4 kg

Sectioning FA	1250 mm	49.21 in	62.5 kg
	2050 mm	80.71 in	102.5 kg
	2550 mm	100.39 in	127.5 kg
	3050 mm	120.08 in	152.5 kg
Sectioning FB	1250 mm	49.21 in	62.5 kg
	2050 mm	80.71 in	102.5 kg
	2550 mm	100.39 in	127.5 kg
	3050 mm	120.08 in	152.5 kg
4050 mm	159.45 in	202.5 kg	

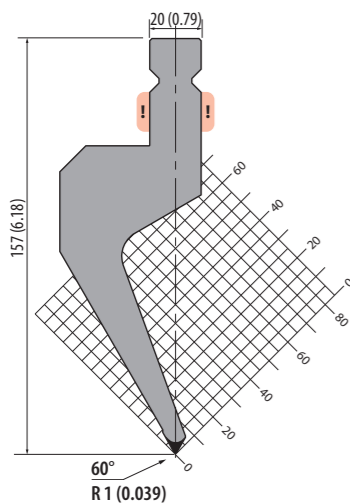
Segments of Sectioning FB (300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²
HORN 1
HORN 2 only for 550 mm (21.65 in) segm.



TPR157.60.R1

700 kN/m max.



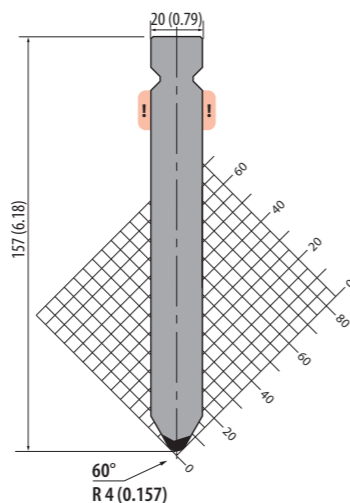
	500 mm	19.68 in	15.0 kg
FW FC	250 mm segmented	9.84 in segmented	7.5 kg
	550 mm segmented	21.65 in segmented	16.5 kg
Sectioning FA	1250 mm	49.21 in	37.5 kg
	2050 mm	80.71 in	61.5 kg
	2550 mm	100.39 in	77.0 kg
	3050 mm	120.08 in	92.0 kg
	4050 mm	159.45 in	121.5 kg
Sectioning FB	1250 mm	49.21 in	37.5 kg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

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

42Cr: 900-1150 N/mm²
 HORN 1
 HORN 2 only for 550 mm (21.65 in) segm.

TPR157.60.R4

1300 kN/m max.



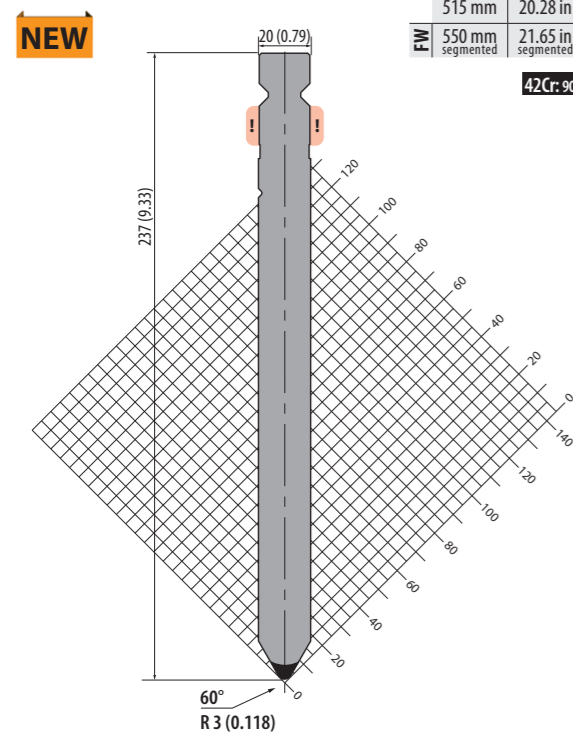
	500 mm	19.68 in	12.0 kg
FW FC	250 mm segmented	9.84 in segmented	6.0 kg
	550 mm segmented	21.65 in segmented	13.2 kg
Sectioning FA	1250 mm	49.21 in	30.0 kg
	2050 mm	80.71 in	49.2 kg
	2550 mm	100.39 in	61.2 kg
	3050 mm	120.08 in	73.2 kg
	4050 mm	159.45 in	97.2 kg
Sectioning FB	1250 mm	49.21 in	30.0 kg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

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

42Cr: 900-1150 N/mm²
 HORN 1
 HORN 2 only for 550 mm (21.65 in) segm.

TPR237.60.R3

1300 kN/m max.

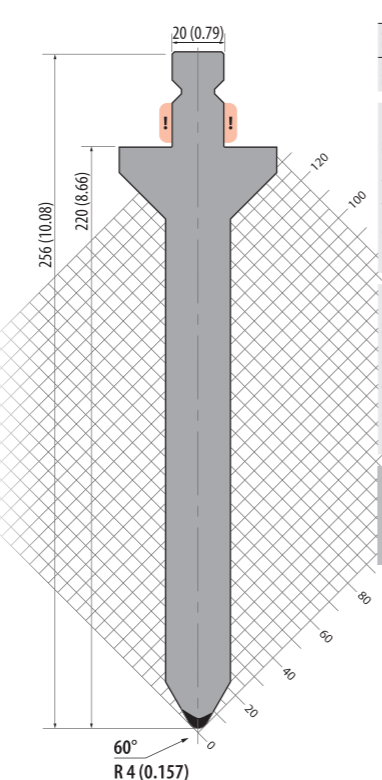


	515 mm	20.28 in	18.8 kg
FW FC	550 mm segmented	21.65 in segmented	20.1 kg

42Cr: 900-1150 N/mm²
 HORN 2

TPR256.60.R4

1300 kN/m max.



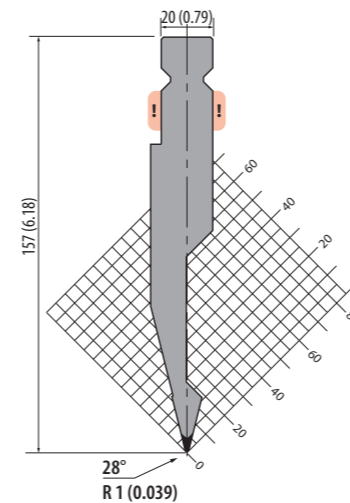
	500 mm	19.68 in	26.1 kg
FW FC	250 mm segmented	9.84 in segmented	13.5 kg
	550 mm segmented	21.65 in segmented	28.7 kg
Sectioning FA	1250 mm	49.21 in	68.0 kg
	2050 mm	80.71 in	111.0 kg
	2550 mm	100.39 in	138.0 kg
	3050 mm	120.08 in	165.0 kg
	4050 mm	159.45 in	219.0 kg
Sectioning FB	1250 mm	49.21 in	68.0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

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

42Cr: 900-1150 N/mm²
 HORN 1
 HORN 2 only for 550 mm (21.65 in) segm.

TPR157.28.R1

600 kN/m max.



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

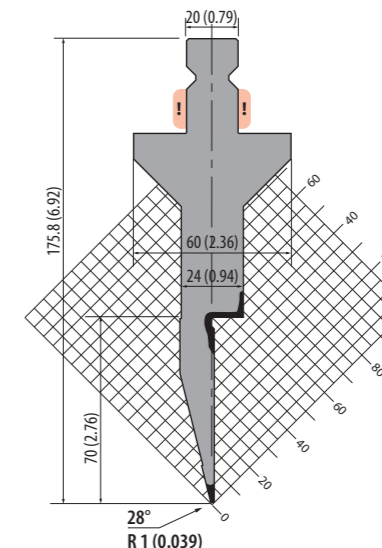
Segments of Sectioning FB
(300, 200, 100, 100 Horn L, 100 Horn r, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²
 HORN 1
 HORN 2 only for 550 mm (21.65 in) segm.

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

TPR176.28.R1

400 kN/m max.



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

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

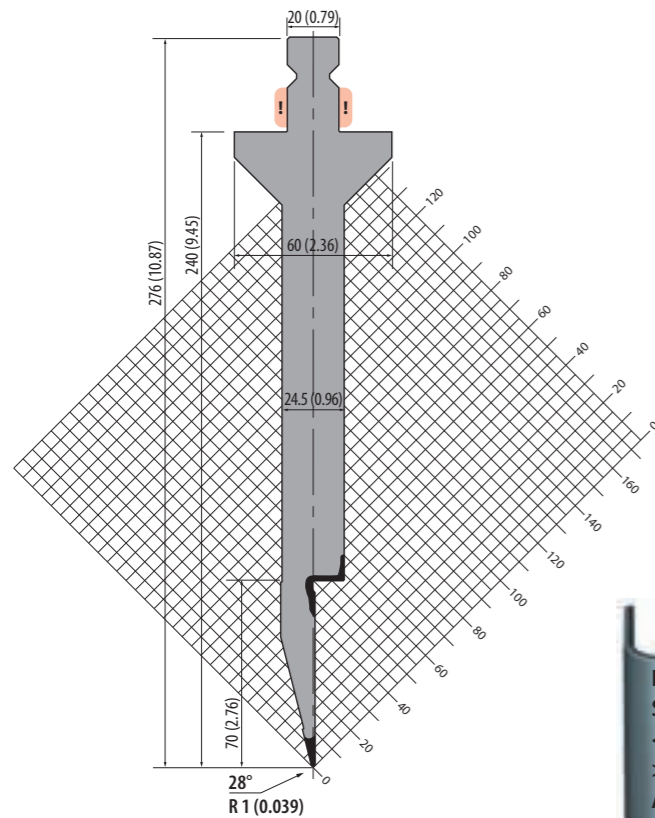
42Cr: 900-1150 N/mm²
 HORN 1
 HORN 2 only for 550 mm (21.65 in) segm.

R2 ROLLERI TYPE R2

28° Punches

TPR276.28.R1

400 kN/m max.



FW FC	mm	in	kg
250 mm segmented	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/mm²

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



R2 ROLLERI TYPE R2

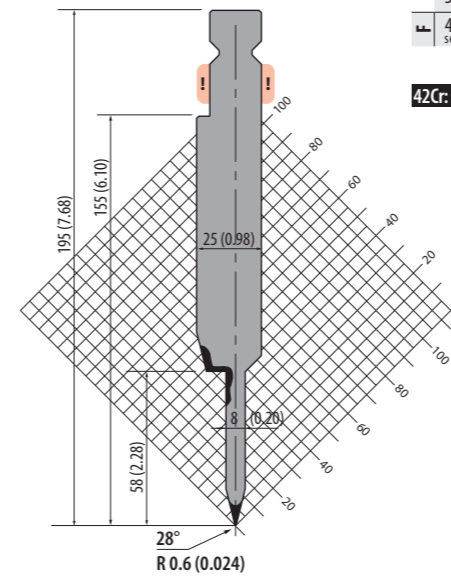
28°/24° Hemming Punches



TPR.SP.195.28.8

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

42Cr: 900-1150 N/mm²

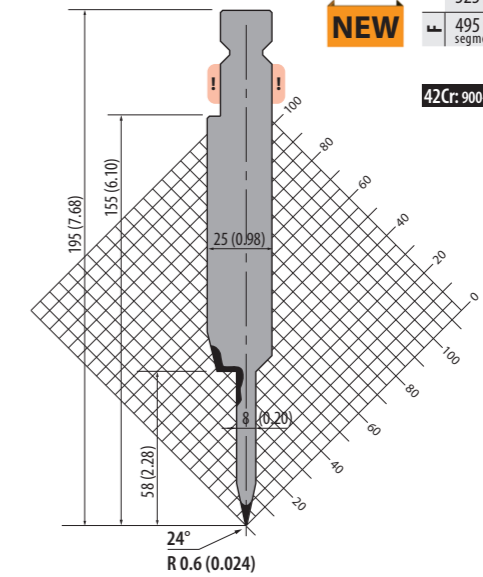


TPR.SP.195.24.8

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

NEW

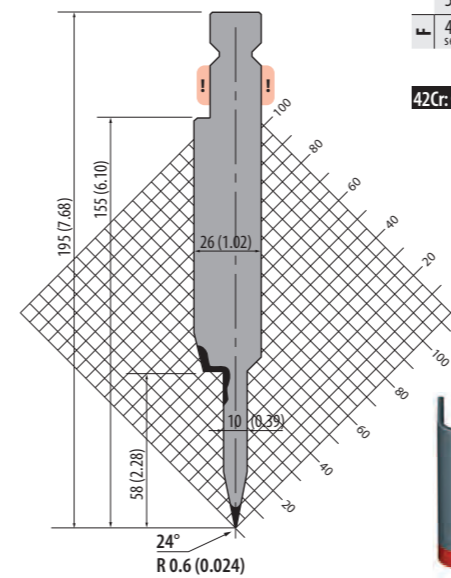
42Cr: 900-1150 N/mm²



TPR.SP.195.24.10

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

42Cr: 900-1150 N/mm²

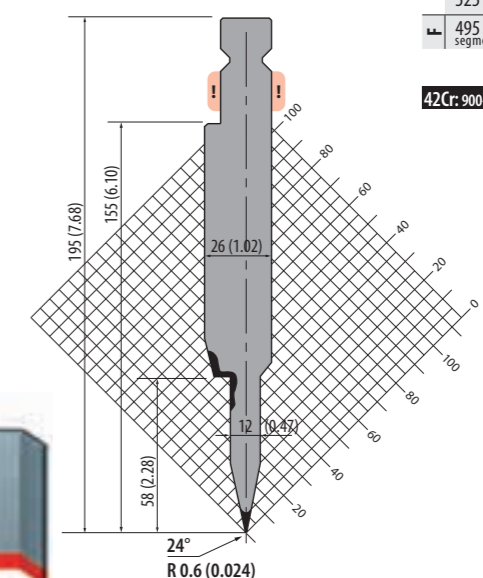


Only for thin material!
 Hemming Dies see page 118

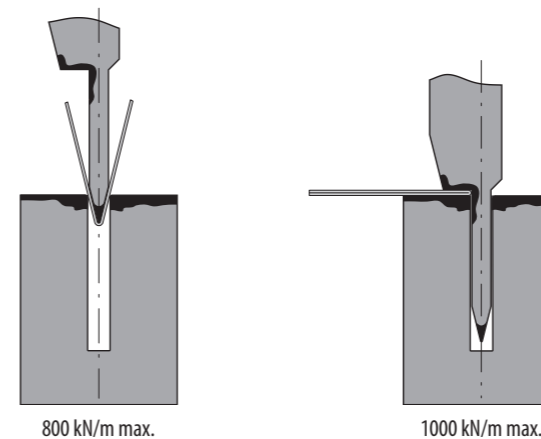
TPR.SP.195.24.12

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

42Cr: 900-1150 N/mm²

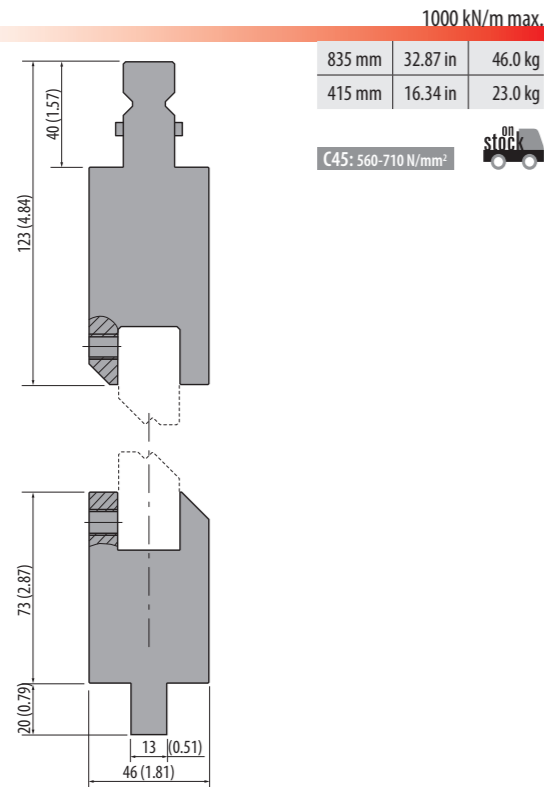


Example of application



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

TPZ

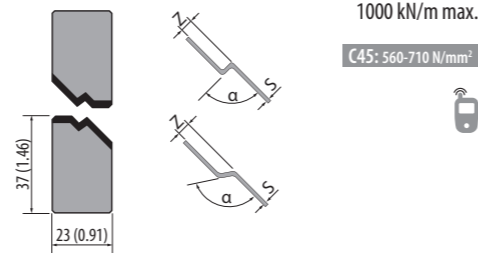


1000 kN/m max.

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

C45: 560-710 N/mm²

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



1000 kN/m max.

C45: 560-710 N/mm²

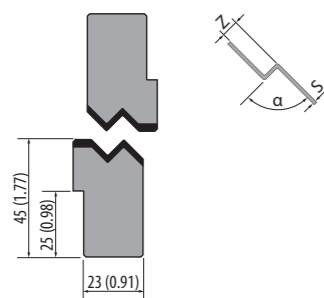
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°	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/mm²

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/mm²

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

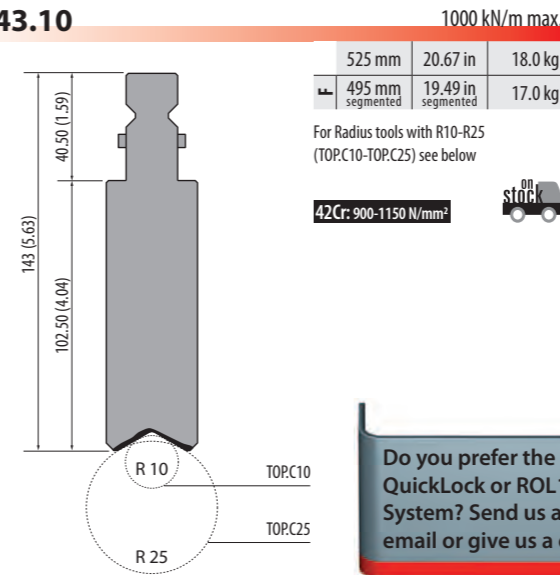
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	6.5 kg
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	6.5 kg
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	6.5 kg
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	6.5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

835 mm / 32.87 in 415 mm / 16.34 in

* Fe Rmax = 42 Kg/mm²



TPR143.10



1000 kN/m max.

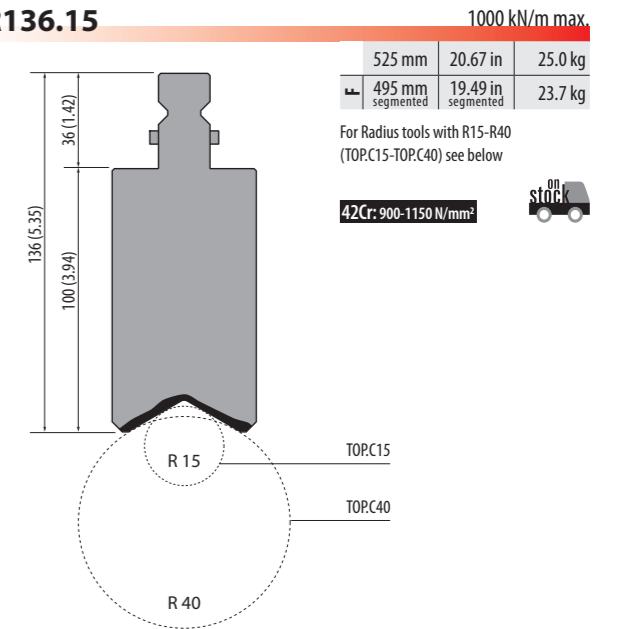
525 mm	20.67 in	18.0 kg
495 mm segmented	19.49 in segmented	17.0 kg

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

42Cr: 900-1150 N/mm²

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

TPR136.15



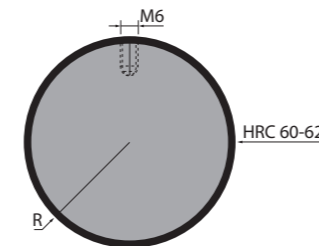
1000 kN/m max.

525 mm	20.67 in	25.0 kg
495 mm segmented	19.49 in segmented	23.7 kg

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

42Cr: 900-1150 N/mm²

Radius punches: R10-40



Material C53 induction hardened 60-62HRC

C53: 610-760 N/mm²

1000 kN/m max.

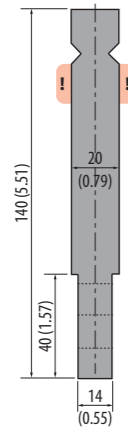
Model	R mm	R in	Weight	Weight
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C40	40	1.57	20.7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

525 mm / 20.67 in 495 mm / 19.49 in segmented

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



TPR140-14 800 kN/m max.

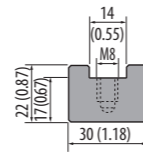


830 mm	32.68 in	17.0 kg
412 mm	16.22 in	9.0 kg

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

C45: 560-710 N/mm²

E30.22 800 kN/m max.

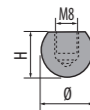


835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

Hemming tool

C45: 560-710 N/mm²

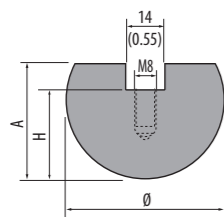
Radius Tool: Ø 16-20 mm (0.63-0.79 in)



C45: 560-710 N/mm²

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

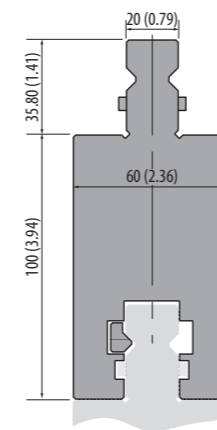
Radius Tool: Ø 25-100 mm (0.98-3.94)



C45: 560-710 N/mm²

Model	Ø mm	Ø in	H mm	H in	A mm	A in	Weight	Weight
C17.12	25	0.98	17	0.67	22	0.87	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.

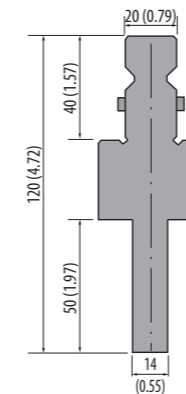


150 mm	5.91 in	7.0 kg
--------	---------	--------

42Cr: 900-1150 N/mm²

Punch Adapters

AD11 1000 kN/m max.



150 mm	5.91 in	3.0 kg
--------	---------	--------

C45: 560-710 N/mm²



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

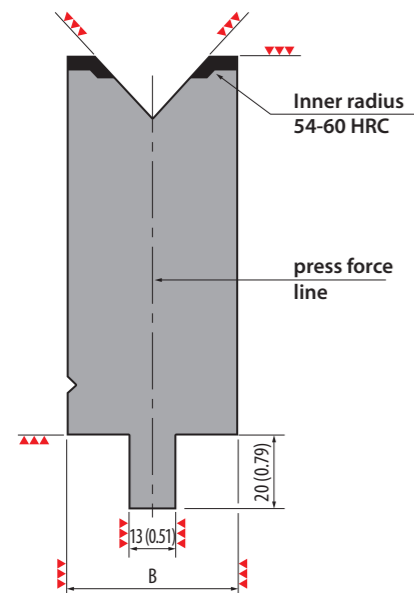
The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

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 ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

Tang

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



Indications of precision ground surfaces:

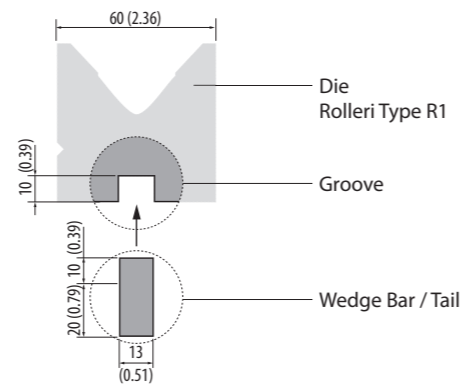


Modification: Wedge Bar / Tail

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

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

A30 (Mounting example)



Tool lengths and sectioning

Standard

More lengths and sectionings are possible upon request.

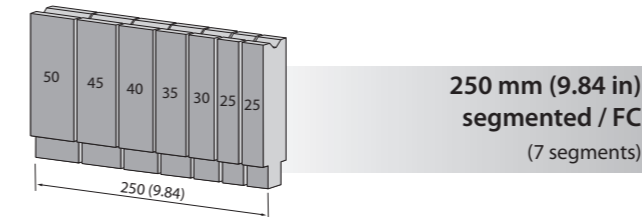
- 500 mm (19.68 in)
- 515 mm (20.28 in)
- 525 mm (20.67 in)
- 1000 mm (39.37 in)

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

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

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

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



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

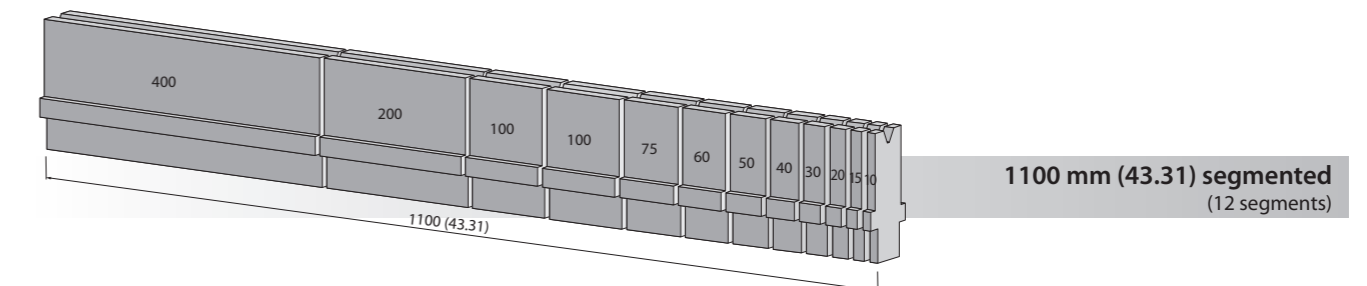
Segmented tools are delivered in complete sets. Single pieces are also available!



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



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



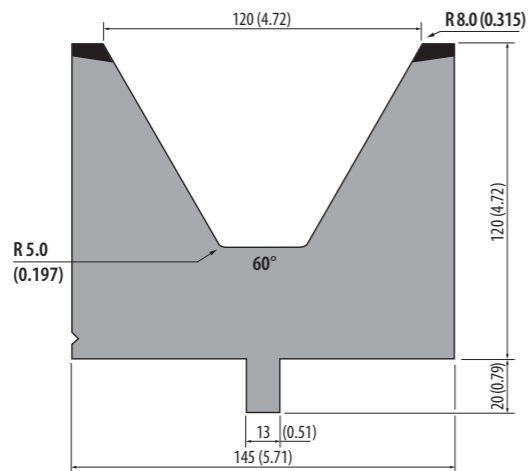
1100 mm (43.31 in) segmented (12 segments)

R2 ROLLERI TYPE R2

Dies 60°, H=120 (4.72)

TMR120.120.60

NEW



1600 kN/m max.

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

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

42Cr: 900-1150 N/mm²



Rolleri Videos

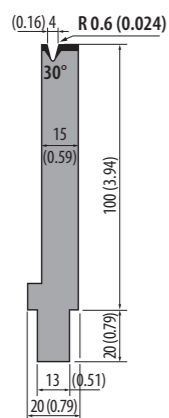
find updated and helpful videos at:
www.rolleritools.com/videos/overview



Dies 30°, H=100 (3.94)

TMR100.04.30

NEW



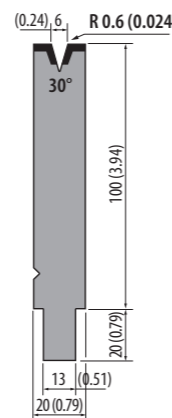
150 kN/m max.

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

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

42Cr: 900-1150 N/mm²

TMR100.06.30



400 kN/m max.

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

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

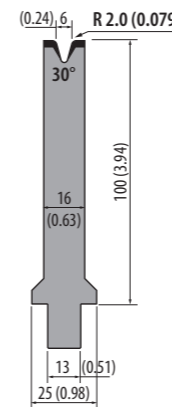
42Cr: 900-1150 N/mm²

R2 ROLLERI TYPE R2

Dies 30°, H=100 (3.94)

WMR100.06.30

NEW

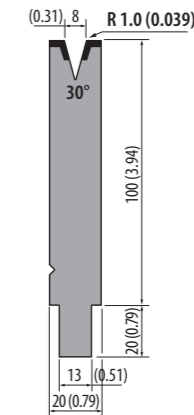


400 kN/m max.

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

42Cr: 900-1150 N/mm²

TMR100.08.30



400 kN/m max.

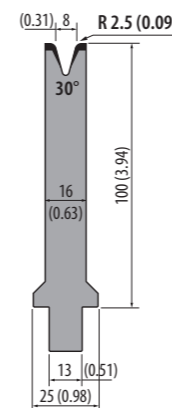
	500 mm	19.68 in	8.5 kg
FW FC	250 mm segmented	9.84 in segmented	4.3 kg
	550 mm segmented	21.65 in segmented	9.4 kg
Sectioning FA	1250 mm	49.21 in	21.3 kg
	2050 mm	80.71 in	34.9 kg
	2550 mm	100.39 in	43.4 kg
	3050 mm	120.08 in	51.9 kg
	4050 mm	159.45 in	68.9 kg
Sectioning FB	1250 mm	49.21 in	21.3 kg
	2050 mm	80.71 in	34.9 kg
	2550 mm	100.39 in	43.4 kg
	3050 mm	120.08 in	51.9 kg
	4050 mm	159.45 in	68.9 kg

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

42Cr: 900-1150 N/mm²

WMR100.08.30

NEW

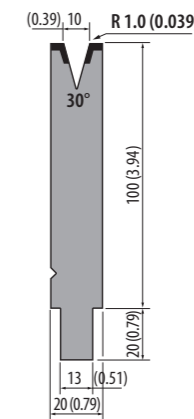


400 kN/m max.

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

42Cr: 900-1150 N/mm²

TMR100.10.30



400 kN/m max.

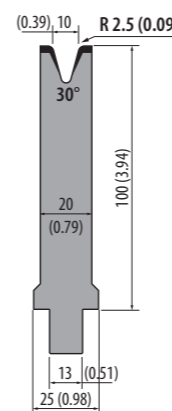
	500 mm	19.68 in	8.5 kg
FW FC	250 mm segmented	9.84 in segmented	3.5 kg
	550 mm segmented	21.65 in segmented	9.4 kg
Sectioning FA	1250 mm	49.21 in	17.5 kg
	2050 mm	80.71 in	28.7 kg
	2550 mm	100.39 in	35.7 kg
	3050 mm	120.08 in	42.7 kg
	4050 mm	159.45 in	56.7 kg
Sectioning FB	1250 mm	49.21 in	17.5 kg
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

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

42Cr: 900-1150 N/mm²

WMR100.10.30

NEW

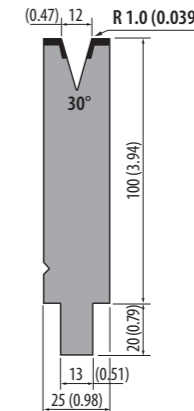


400 kN/m max.

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

42Cr: 900-1150 N/mm²

TMR100.12.30



400 kN/m max.

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

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

42Cr: 900-1150 N/mm²

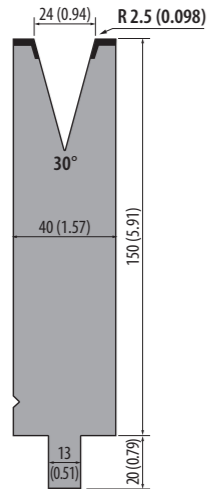
R2 ROLLERI TYPE R2

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
Sectioning FA			
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
Sectioning FB			
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

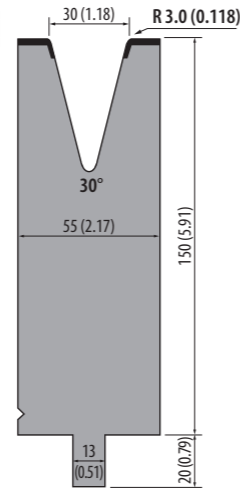
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

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
Sectioning FA			
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
Sectioning FB			
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

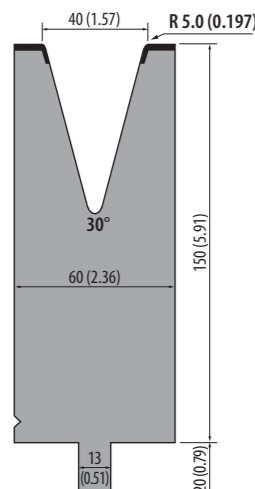
Segments of Sectioning FB (500, 300, 200, 100, 50, 45, 40, 35, 30, 25) are also available separately (FD). Prices upon request!

42Cr: 900-1150 N/mm²

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
Sectioning FA			
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
Sectioning FB			
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/mm²



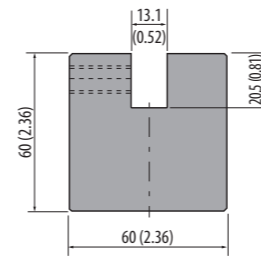
R2 ROLLERI TYPE R2

Die adapters



AD5

1000 kN/m max.



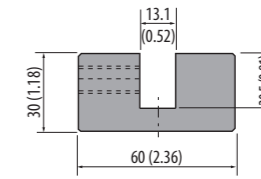
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



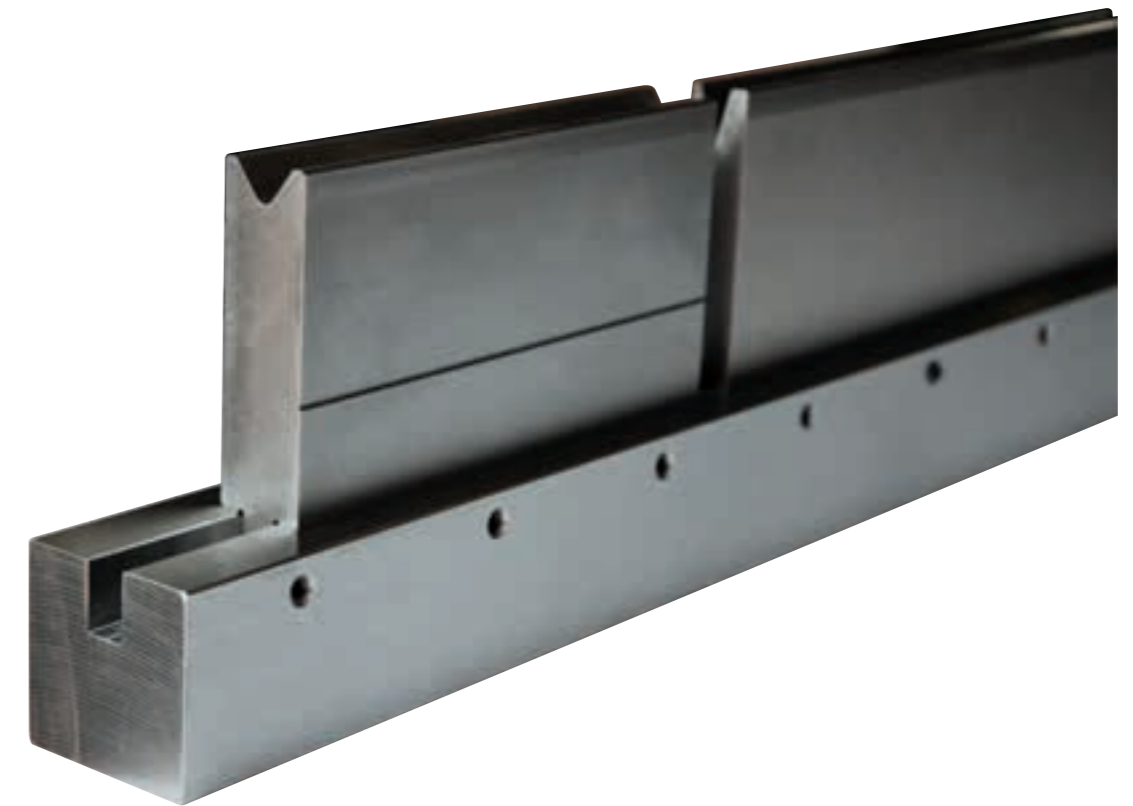
AD6

1000 kN/m max.



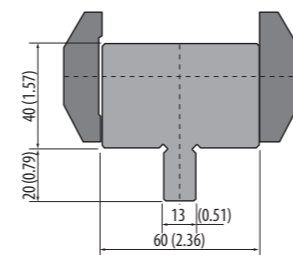
Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD7

1000 kN/m max.



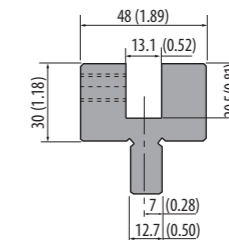
Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²



AD8-12.7

1000 kN/m max.



Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



R2 ROLLERI TYPE R2

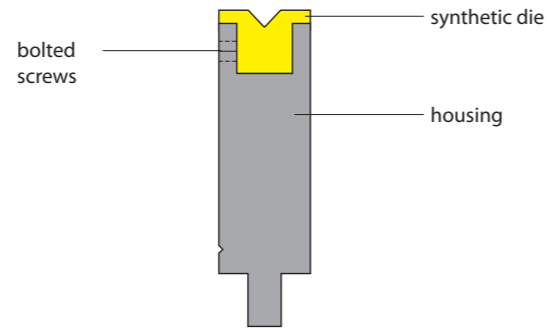
Synthetic dies, H=100 (3.94)

Our Advantages – Your Convenience

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

Mounting example

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

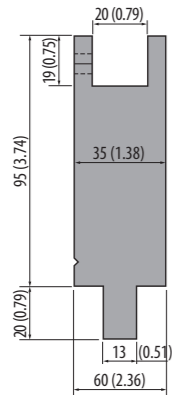


TMN95.20

1000 kN/m max.

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

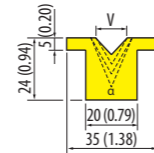
C45: 560-710 N/mm²



INS20...

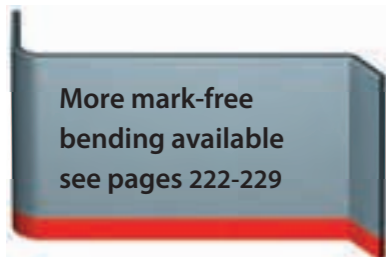
200 kN/m max.

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



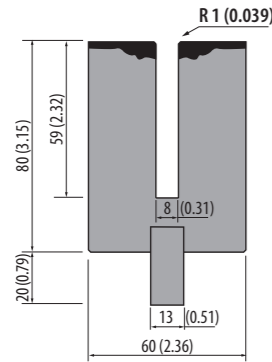
Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

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



4
R2

TPR.SM.195.28.8 / TPR.SM.195.24.8

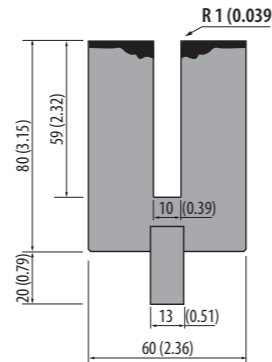


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.4 kg

42Cr: 900-1150 N/mm²



TPR.SM.195.24.10

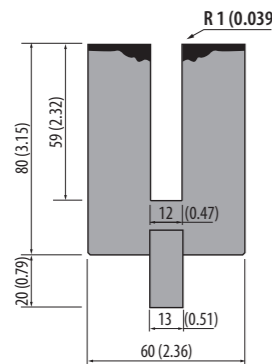


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²



TPR.SM.195.24.12



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

42Cr: 900-1150 N/mm²

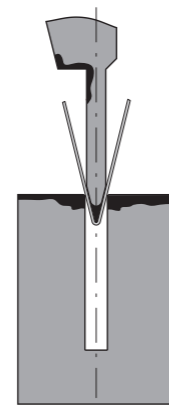


Only for thin material!
Hemming punches
see page 91

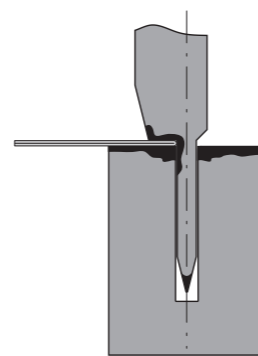
Example of application



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



500 kN/m max.



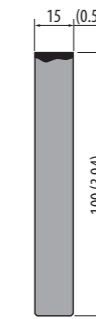
1000 kN/m max.

Application

- movable table necessary
- used flexibly
- easy mounting

Hemming punches
see page 91

TMI100



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

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

C45: 560-710 N/mm²

TML100

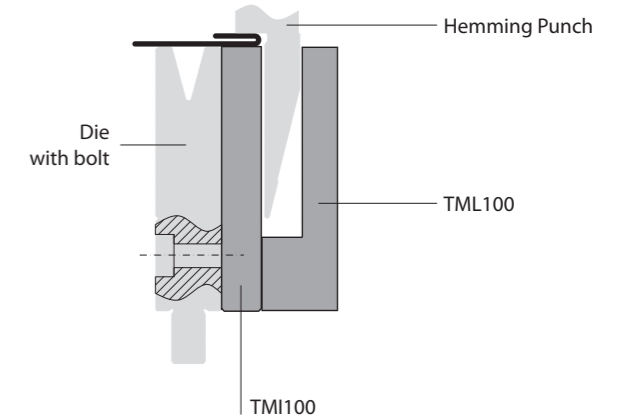


	500 mm	19.68 in	5.0 kg
FW FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg
Sectioning FA	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
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

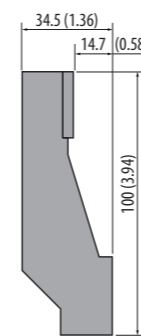
Segments of Sectioning FB
(500, 300, 200, 100, 50, 45, 40, 35, 30, 25)
are also available separately (FD).
Prices upon request!

C45: 560-710 N/mm²

Example of application TMI100 + TML100



TMS100

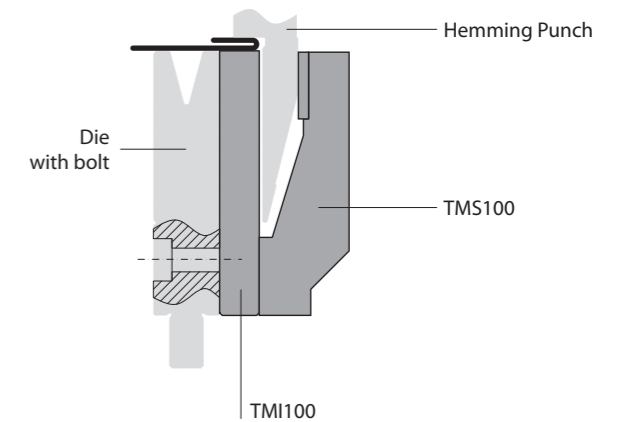


	500 mm	19.68 in	5.0 kg
FW FC	250 mm segmented	9.84 in segmented	2.5 kg
	550 mm segmented	21.65 in segmented	5.5 kg
Sectioning FA	1250 mm	49.21 in	12.5 kg
	2050 mm	80.71 in	20.5 kg
	2550 mm	100.39 in	25.5 kg
	3050 mm	120.08 in	30.5 kg
	4050 mm	159.45 in	40.5 kg
Sectioning FB	1250 mm	49.21 in	12.5 kg
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

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

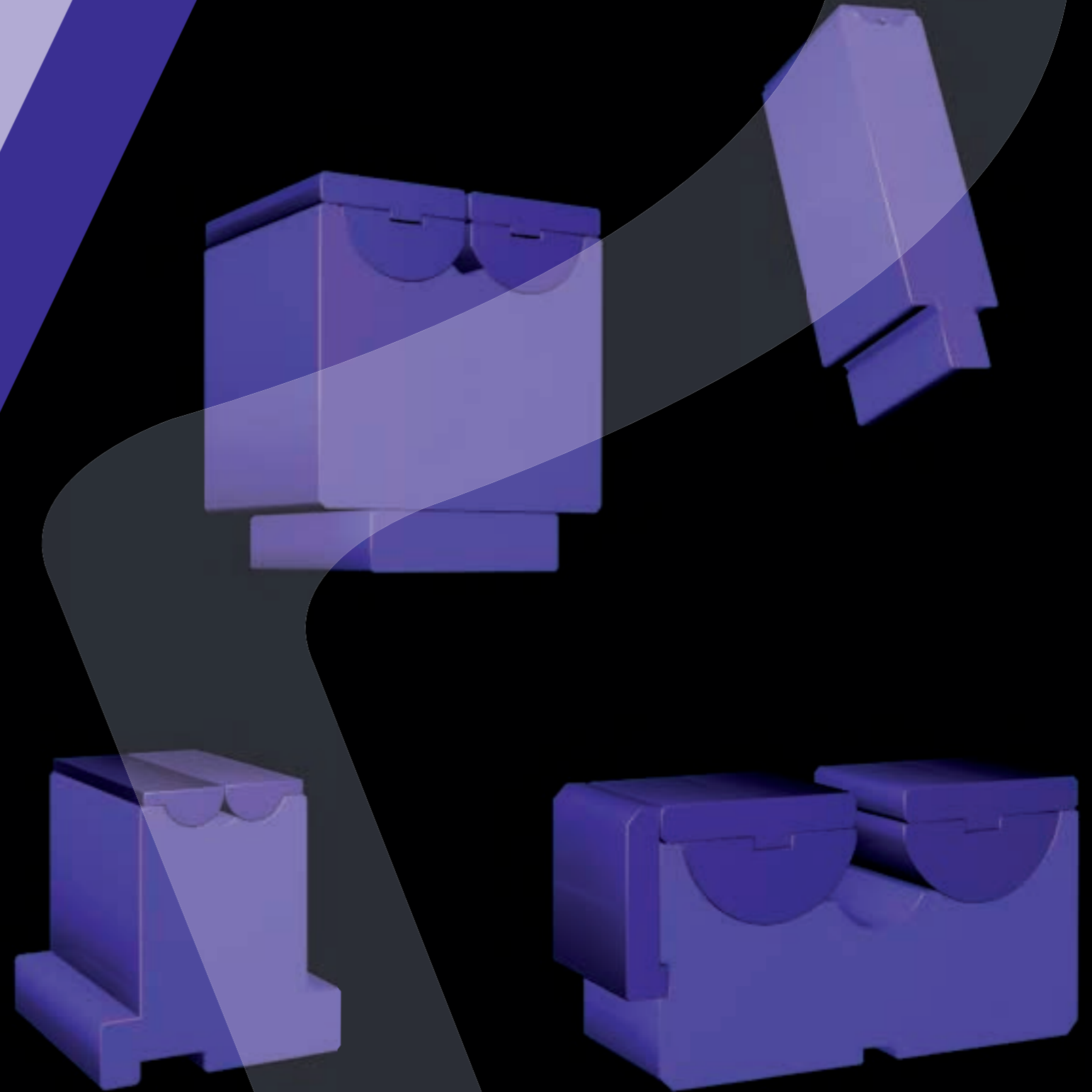
C45: 560-710 N/mm²

Example of application TMI100 + TMS100



ROLLERI DIES ROLLA-V

Content Explanation	190 - 191
Model 1	192
Model 2	193
Model 2.5	193
Model 3	194
Model 4	194
Adjustable Dies	195
Hemming- and Joggle Tools	195

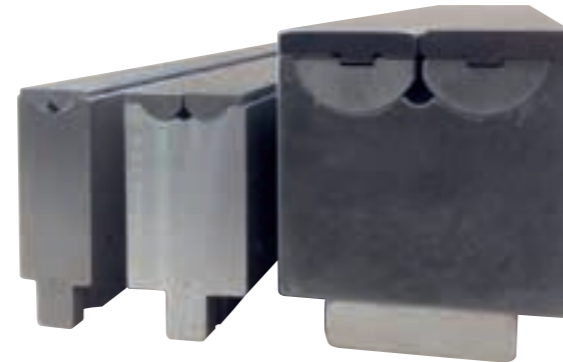


Compatibility

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

Our Advantages – Your Convenience

- high precision grounded
- Interchangability guaranteed
- exact Parallelism
- avoiding bending marks on the sheet metals
- minimum borders bending mark free
- no tool contamination throughout the bending of galvanized sheet metal or aluminum
- extremely short flanges
- less tool exchange
- ideal for diagonal or tapered edges



Material

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

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4	1100-1200 N/mm ²	50 - 55 HRC
Inserts	1	Toolox 44	1450 N/mm ²	through hardened 44 HRC
Inserts	2 / 2.5 / 3 / 4	Toolox 33	1100 N/mm ²	55 - 58 HRC

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

	Equivalent V size mm (in)	Material Thickness mm (in)	min. outside flange mm (in)	needed press force (kN)	max. tool load (kN/m)	min. bending angle
Model 1 Max. recommended thickness = 1.5 mm (0.06 in) (2.0 mm / 0.08 in possible)	8 (0.31)	0.70 (0.03)	3.0 (0.12)	60	1000	40°
		1.10 (0.04)	3.9 (0.15)	110	1000	35°
		1.50 (0.06)	4.2 (0.17)	260	1000	35°
Model 2 Max. recommended thickness = 3.0 mm (0.12 in) (4.0 mm / 0.15 in possible)	15 (0.59)	2.00 (0.08)	8.5 (0.33)	200	1500	59°
		3.00 (0.12)	9.3 (0.37)	460	1500	46°
		3.20 (0.13)	9.3 (0.37)	550	1500	47°
Model 2.5 Max. recommended thickness = 5.0 mm (0.20 in) (6.35 mm / 0.24 in possible)	28 (1.10)	3.00 (0.12)	18.7 (0.74)	230	2000	67°
		4.00 (0.16)	18.7 (0.74)	450	2000	60°
		5.00 (0.20)	18.7 (0.74)	770	2000	57°
		6.00 (0.24)	18.7 (0.74)	1200	2000	51°
Model 3 Max. recommended thickness = 6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)	38 (1.50)	4.00 (0.16)	22.5 (0.89)	270	2500	47°
		6.00 (0.24)	22.5 (0.89)	800	2500	50°

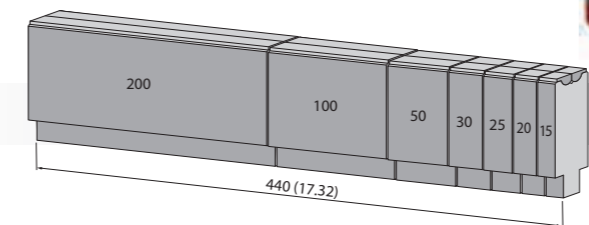
Tool lengths and sectioning

Standard

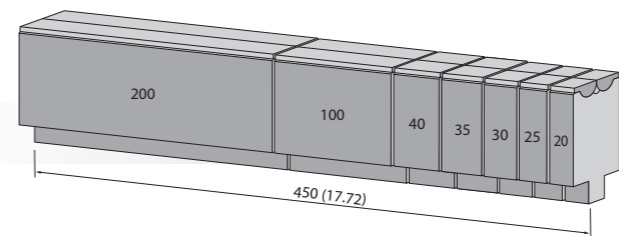


Segmented tools are delivered in complete sets. Single pieces are also available!
More lengths and sectionings are possible upon request.

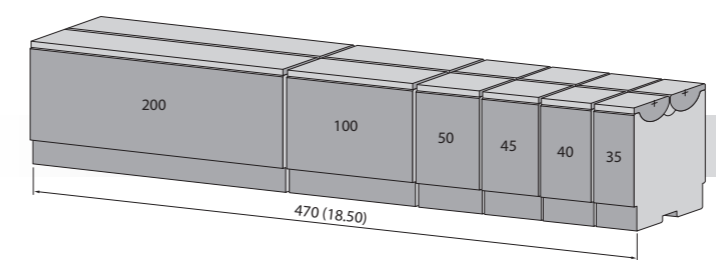
500 mm (19.68 in)
200 mm (7.87 in)



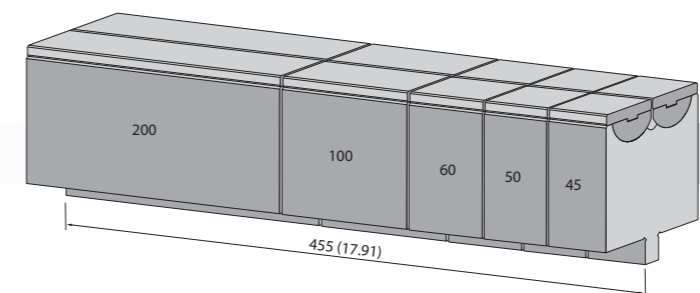
Model 1, 440 mm (17.32 in) segmented (7 segments)



Model 2, 450 mm (17.72 in) segmented (7 segments)



Model 2.5, 470 mm (18.50 in) segmented (6 segments)



Model 3, 455 mm (17.91 in) segmented (5 segments)

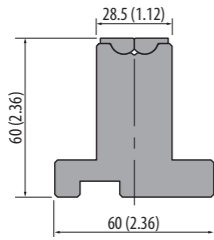


DIES ROLLA-V


Model 1

RVP60-1 1000 kN/m max.

NEW

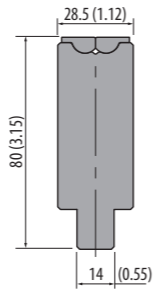


500 mm	16.68 in	6.9 kg
440 mm segmented	17.32 in segmented	6.1 kg


42Cr: 1100-1200 N/mm² 

RVS80-1 1000 kN/m max.

NEW

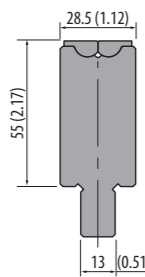


500 mm	16.68 in	6.3 kg
440 mm segmented	17.32 in segmented	5.8 kg


42Cr: 1100-1200 N/mm² 

RVT55-1 1000 kN/m max.

NEW

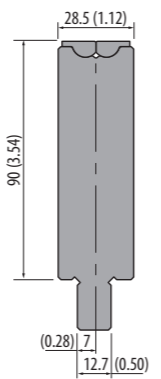


500 mm	16.68 in	5.5 kg
440 mm segmented	17.32 in segmented	5.0 kg


42Cr: 1100-1200 N/mm² 

RVT90-1 1000 kN/m max.

NEW

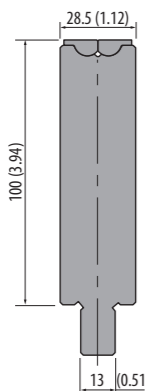


500 mm	16.68 in	8.5 kg
440 mm segmented	17.32 in segmented	7.8 kg


42Cr: 1100-1200 N/mm² 

RVT100-1 1000 kN/m max.

NEW



500 mm	16.68 in	9.4 kg
440 mm segmented	17.32 in segmented	8.6 kg

42Cr: 1100-1200 N/mm² 

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

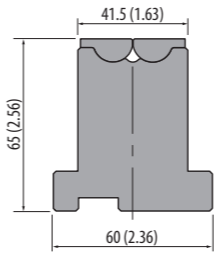


DIES ROLLA-V


Model 2

RVP65-2 1500 kN/m max.

NEW

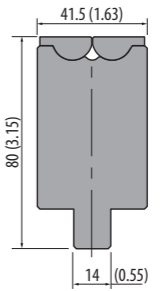


500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg


42Cr: 1100-1200 N/mm² 

RVS80-2 1500 kN/m max.

NEW

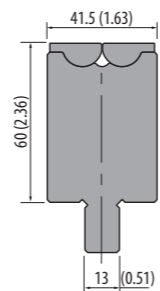


500 mm	16.68 in	8.3 kg
450 mm segmented	17.72 in segmented	7.8 kg


42Cr: 1100-1200 N/mm² 

RVT60-2 1500 kN/m max.

NEW

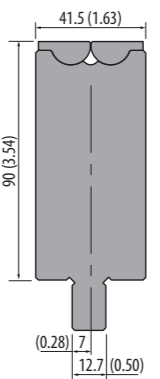


500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg


42Cr: 1100-1200 N/mm² 

RVT90-2 1500 kN/m max.

NEW

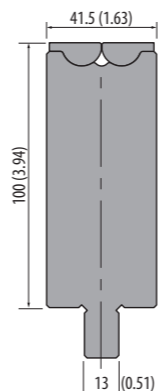


500 mm	16.68 in	11.3 kg
450 mm segmented	17.72 in segmented	10.6 kg


42Cr: 1100-1200 N/mm² 

RVT100-2 1500 kN/m max.

NEW



500 mm	16.68 in	12.4 kg
450 mm segmented	17.72 in segmented	11.7 kg

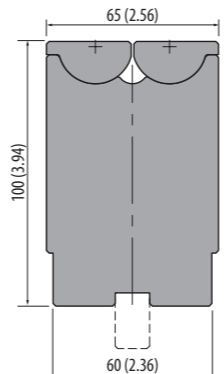
42Cr: 1100-1200 N/mm² 




Model 2.5

RVM2.5 2000 kN/m max.

NEW



500 mm	16.68 in	22.0 kg
470 mm segmented	18.50 in segmented	21.0 kg

42Cr: 1100-1200 N/mm² 

Rolleri Videos



Use and application of Rolla-V dies
www.rolleritools.com/videos/rolla-v



DIES ROLLA-V

Model 3

RVP100-3 2500 kN/m max.

NEW

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

42Cr: 1100-1200 N/mm²

RVM70-3 2500 kN/m max.

NEW

500 mm	16.68 in	20.6 kg
455 mm segmented	17.91 in segmented	18.7 kg

42Cr: 1100-1200 N/mm²

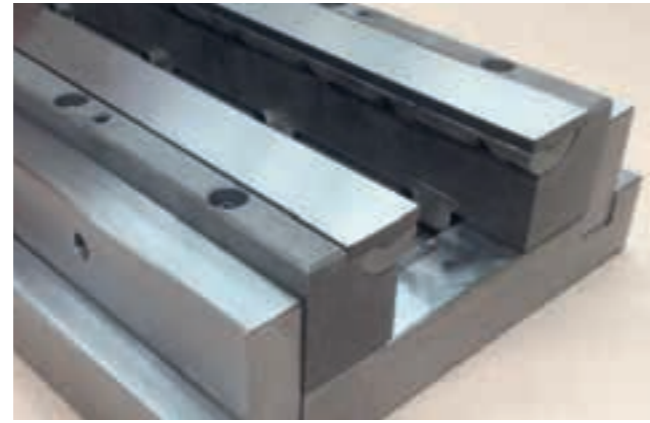
Possible Die Holders:
 - 60 mm (2.36 in)
 - 13 mm (0.51 in) pin
 - 12.7 mm (0.50 in) pin
 - 12.8 mm (0.50 in) offset pin

RVT100-3 2500 kN/m max.

NEW

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

42Cr: 1100-1200 N/mm²



Model 4

Our Advantages – Your Convenience

The **model 4 tools** and the **adjustable dies** are for bending thick material and large radii. Material specifications vary greatly, therefore no specific data can be given.

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

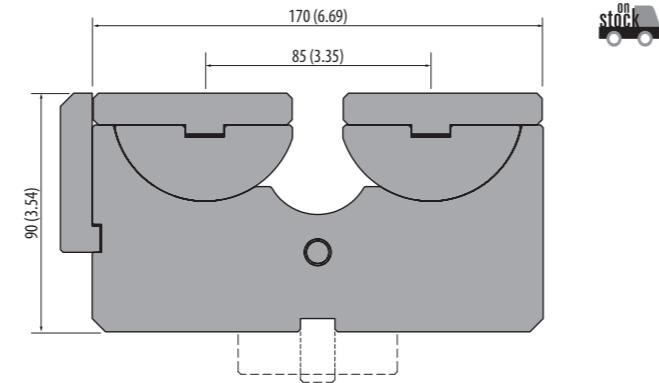
For advice please contact us!

RVM90-4 3000 kN/m max.

NEW

500 mm	16.68 in	56.6 kg
200 mm	7.87 in	22.7 kg

42Cr: 1100-1200 N/mm²



Possible Die Holders:
 - 60 mm (2.36 in)
 - 13 mm (0.51 in) pin
 - 12.7 mm (0.50 in) pin
 - 12.8 mm (0.50 in) offset pin

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

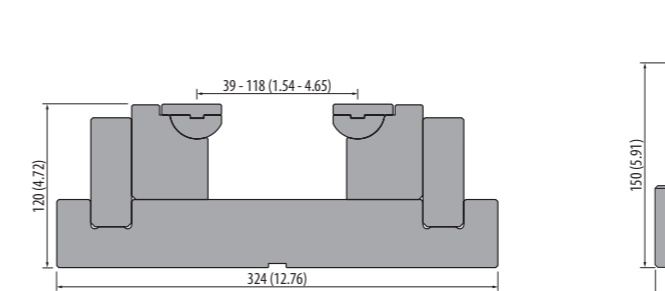
500 mm	16.68 in	50.0 kg
200 mm	7.87 in	20.0 kg

42Cr: 1100-1200 N/mm²

RVHD3 3500 kN/m max.

NEW

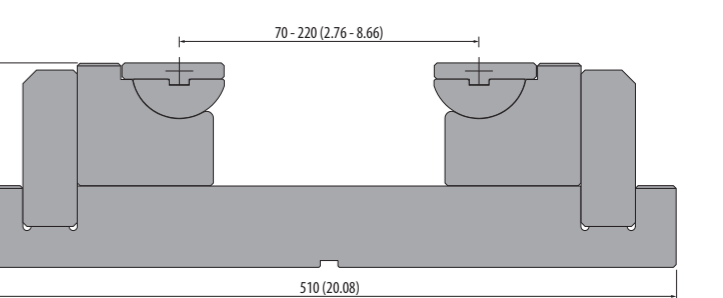
500 mm	16.68 in	98.0 kg
200 mm	7.87 in	38.1 kg



RVHD4 4000 kN/m max.

NEW

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



- V-Bending
- Radius-Bending
- Conical Bending
- Radius-Overbending
- U-Bending
- flat inserts
- flat inserts
- flat inserts
- concave inserts
- V-inserts

Hemming- and Z-Tools

Hemming Tool

NEW

per piece	Price upon request
-----------	--------------------

Production according to your specifications

42Cr: 1100-1200 N/mm²

Joggle Tool

NEW

per piece	Price upon request
-----------	--------------------

Production according to your specifications

42Cr: 1100-1200 N/mm²

ROLLERI CLAMPING SYSTEMS

Content Explanation	198
Intermediates	199
Clamps	200 - 201
ROL100-System for Punches Roller Type R1	202 - 203
ROL1-System for Punches Roller Type R1	204 - 205
ROL4-System for Punches Roller Type R1	205
W-ROL PN-System for Punches Roller Type R2	206
ROL3-System for Punches Roller Type R3 and RX	207
ROL2-System for Dies Roller Type R1	208 - 209
Movable Die Clamps for Dies Roller Type R1	209



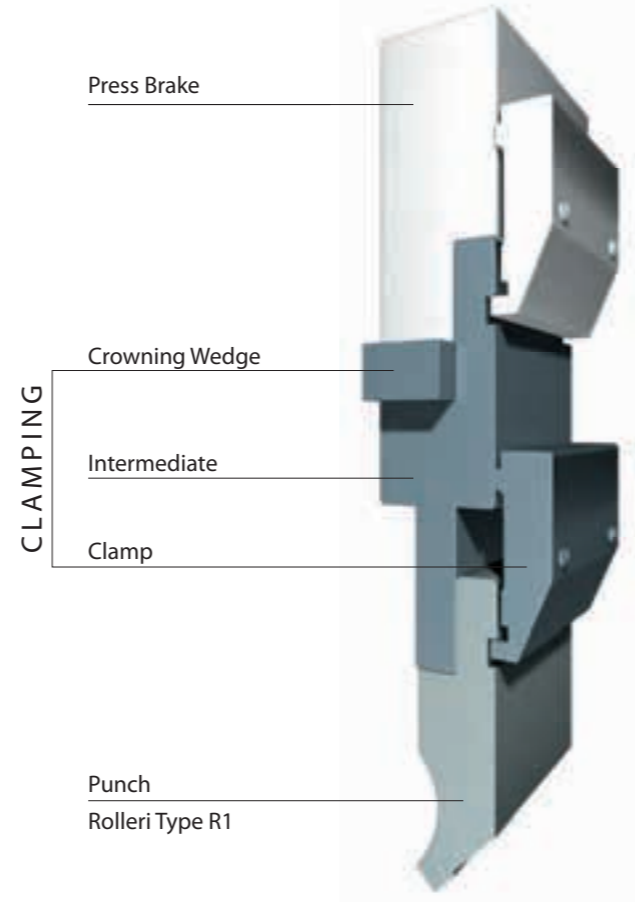
Content Explanation

Standard-Clamping

- for Punches Rollerri Type R1
- made of: Tensioning device + intermediate
- dual sided clamping (KDS-System)
- **horizontal tool exchange**
- see pages 199-201



horizontal



ROL100 Clamping

- for Punches Rollerri Type R1
- **vertical tool exchange**
- can be used **without modifying** Punches Rollerri Type R1
- safety guard
- including selectable intermediates
- manual and pneumatic models available
- see pages 202-203

NEW

vertical

ROL1 Clamping

- for Punches Rollerri Type R1
- **vertical tool exchange**
- **modification necessary:** Punches Rollerri Type R1 are equipped with spring-loaded balls
- safety guard
- including selectable intermediates
- manual, pneumatic and hydraulic models available
- dual sided clamping (KDS-System)
- see pages 204-205

vertical

ROL4 Clamping

- for Punches Rollerri Type R1
- **horizontal tool exchange**
- can be used **without modifying** Punches Rollerri Type R1
- safety guard
- including selectable intermediates
- manual and hydraulic models available
- dual sided clamping integrated
- see pages 205

horizontal

W-ROL PN Clamping

- for Punches Rollerri Type R2
- **vertical tool exchange** with ROL1-System and QuickLock-System
- Punches with Safety-Pins are inserted **horizontal**
- safety guard
- pneumatic model available only
- see page 206

vertical horizontal

ROL3 Clamping

- for Punches Rollerri Type R3/RX
- **vertical or horizontal tool exchange**
- custom manufacturing
- safety guard
- hydraulic model available only
- see page 207

vertical horizontal

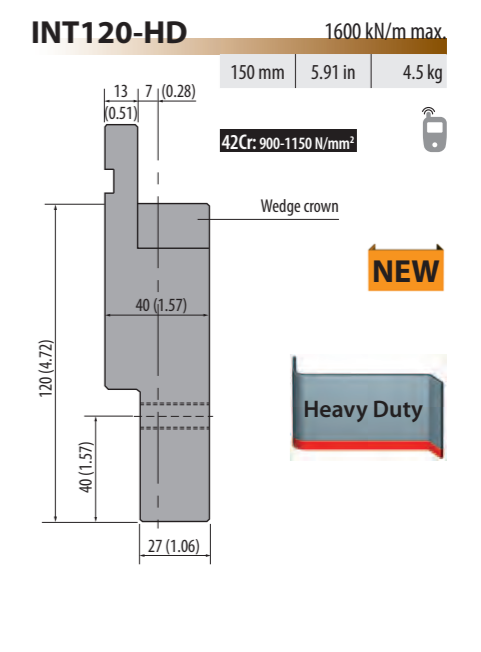
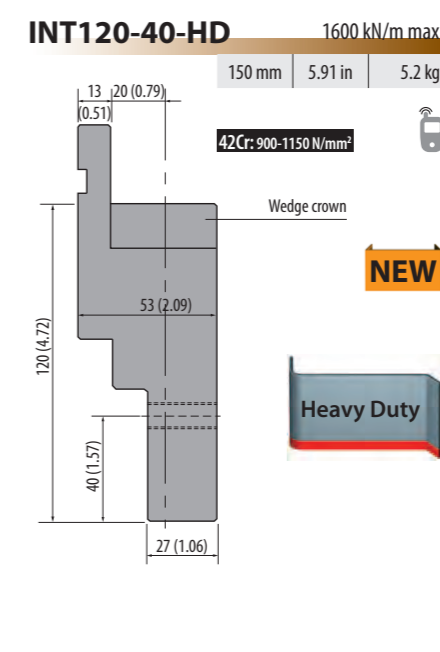
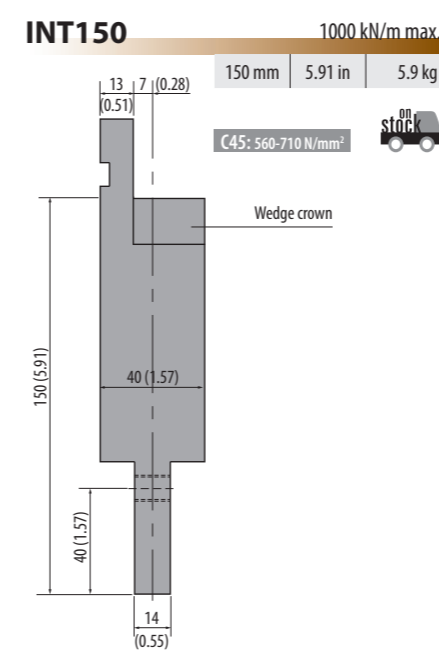
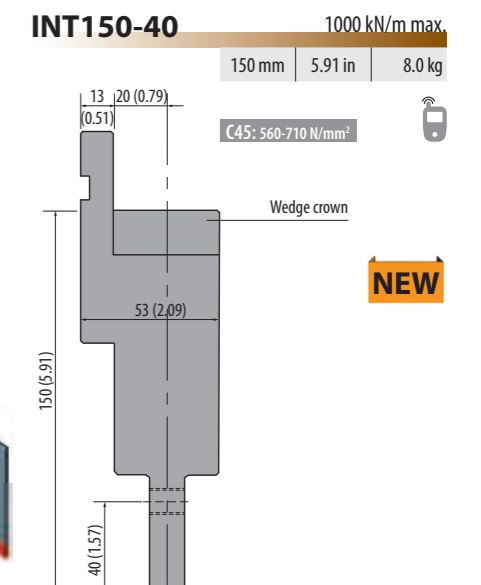
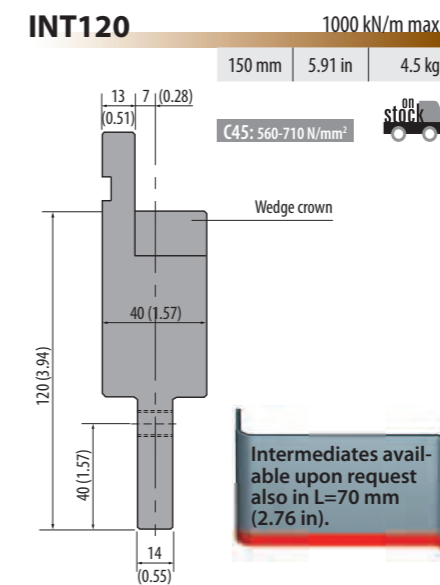
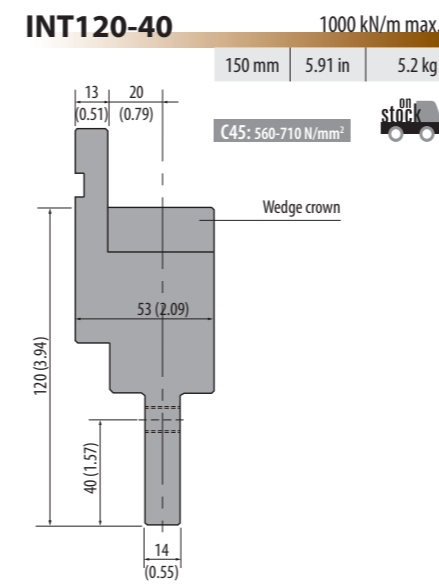
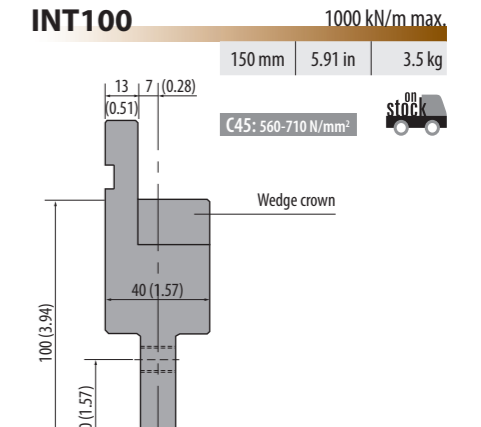
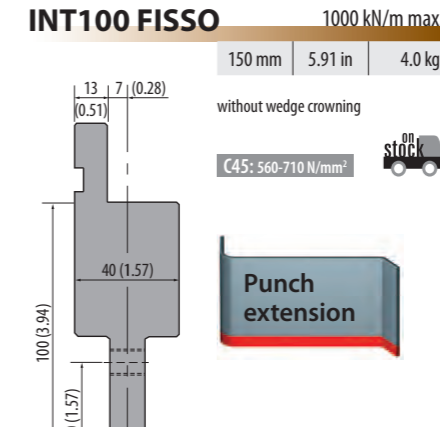
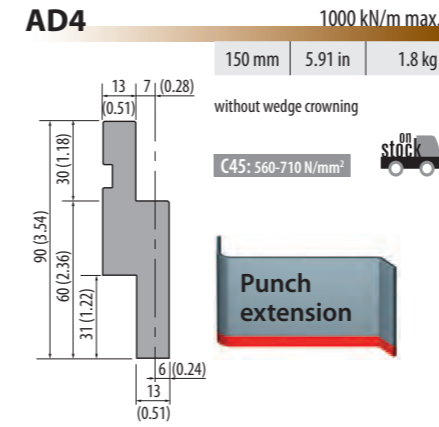
ROL2 Clamping

- for Dies Rollerri Type R1
- manual, pneumatic and hydraulic models available
- see pages 208-209

Movable Die Clamps

- for Dies Rollerri Type R1
- manual model available only
- see page 209

Intermediates



R1 ROLLERI CLAMPING SYSTEMS

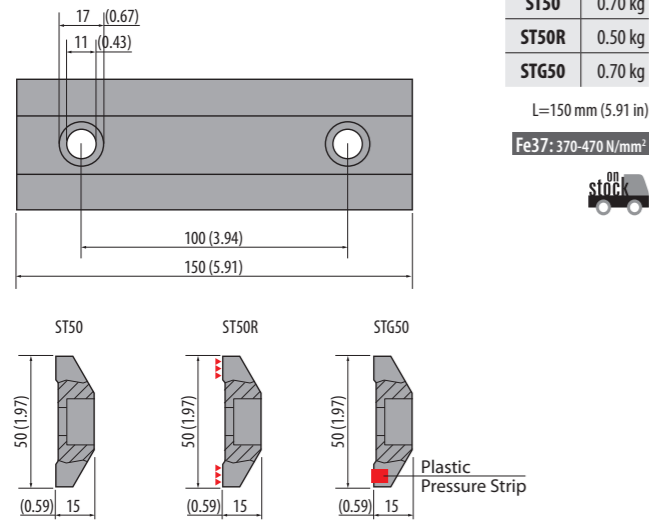
Clamps

Our Advantages – Your Convenience

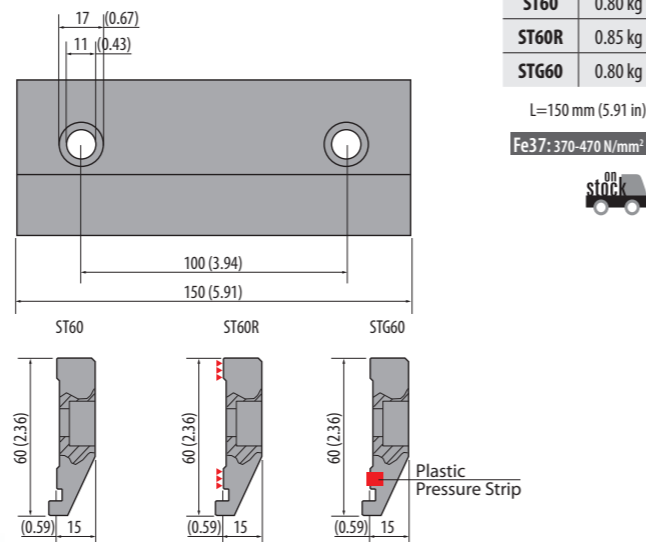
- Rapid Clamping Systems allow a fast horizontal tool exchange
- Plastic Pressure Strip improves the clamping especially with short tool pieces.

needed clamps	Length of press brake
4 pieces	835 mm (32.87 in)
6 pieces	1250 mm (49.21 in)
11 pieces	2100 mm (82.68 in)
14 pieces	2600 mm (102.36 in)
16 pieces	3100 mm (122.05 in)
21 pieces	4100 mm (161.42 in)

ST50 / ST50R / STG50

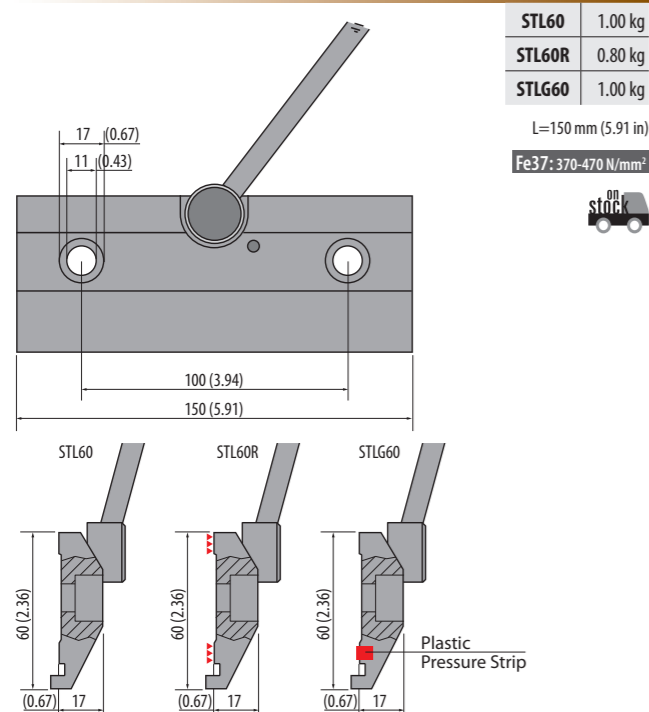


ST60 / ST60R / STG60

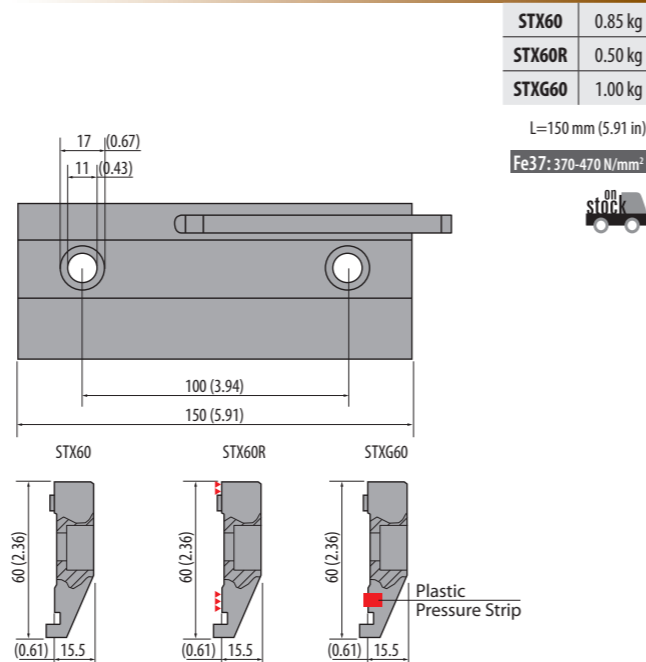


Compatible Intermediates on page 199

STL60 / STL60R / STLG60



STX60 / STX60R / STXG60

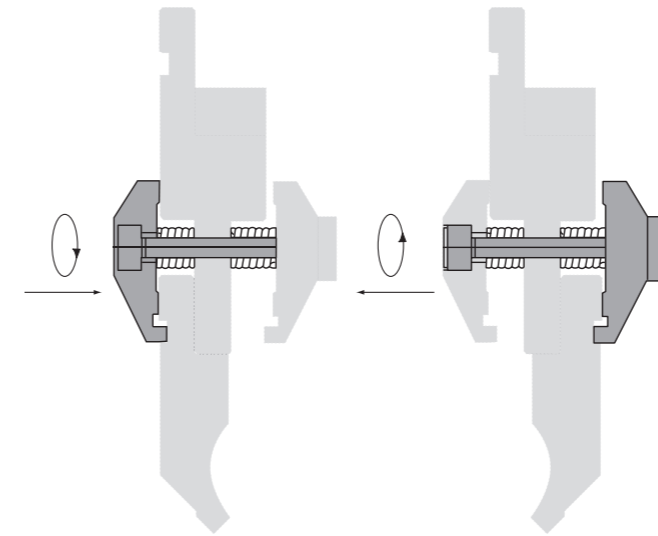
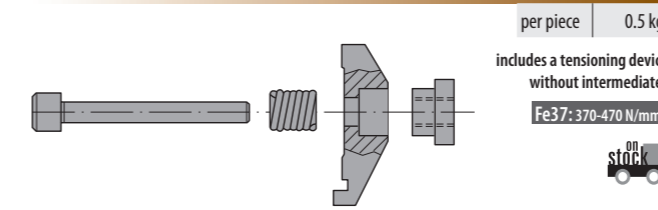


R1 ROLLERI CLAMPING SYSTEMS

Clamps



KDS

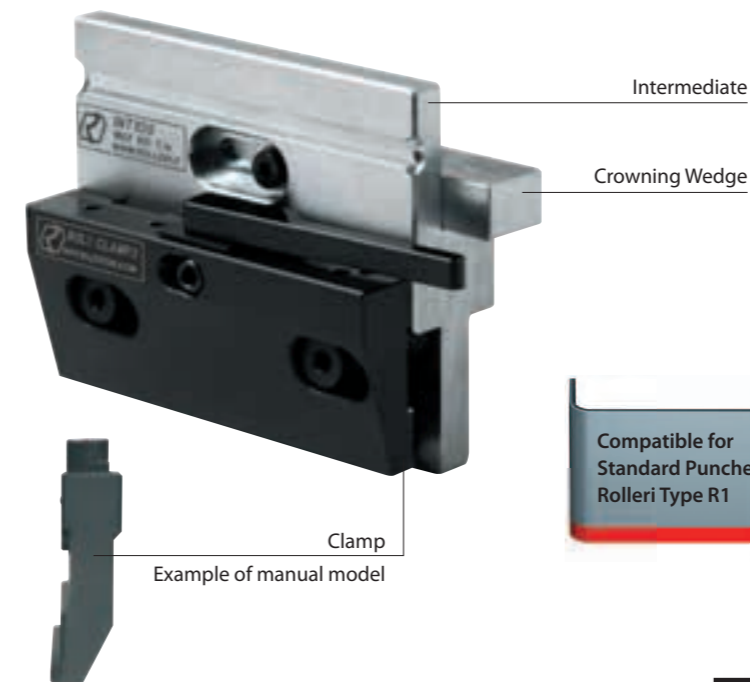


Intermediate

Crowning Wedge

KDS

ROL1 CLAMP3 – manual – hydraulic – pneumatic



Compatible for Standard Punches Roller Type R1

Model	with Intermediate
ROL1 CLAMP3 manual	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

horizontal

ROL1 CLAMP3 manual without Intermediate

Model	with Intermediate
ROL1 CLAMP3 hydraulic	INT100
	INT120
	INT150
	INT100 FISSO
	INT120-40

horizontal

Model	with Intermediate
ROL1 CLAMP3 pneumatic	INT120
	INT150

horizontal

L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates



Rolleri Videos

Application of Clamping System
ROL1 CLAMP3: www.rolleritools.com/videos/rol1-clamp3

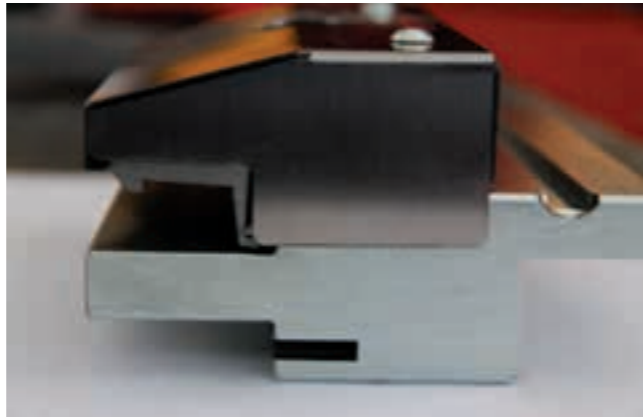


R1 ROLLERI CLAMPING SYSTEMS

ROL100-System for Punches Roller Type R1

... the newest innovation from our Research and Development Department

- fast **vertical** tool exchange for all Punches Roller Type R1
- can be used without modifying Punches Roller Type R1
- safe and fast tool exchange
- significant savings on your setup costs
- no falling out of tools
- available in manual and pneumatic models
- Mounting:
Simply from the bottom into the housing, tighten – DONE!
- Disassembly:
Untighten, gently lift tool and remove downwards.
- Easy to mount on your press brake.
A conversion of the press brake is not necessary.
- For Press Brake Machines and Punches Roller Type R1:
(ACL, Accurpress, AM Machinery, Amada, Atlantic, Adira, Baykal, BL, Boschert, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Darley, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Safan, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.)



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



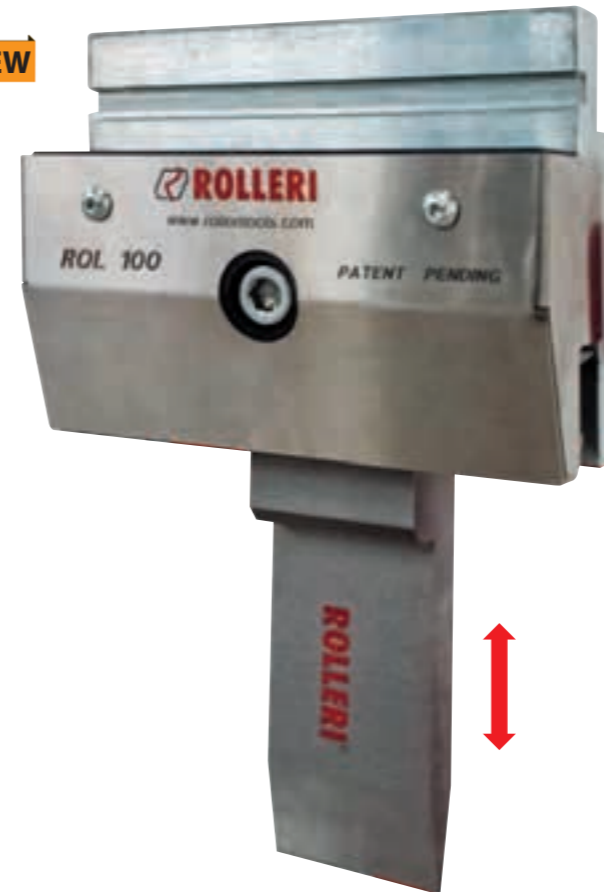
R1 ROLLERI CLAMPING SYSTEMS

ROL100-System for Punches Roller Type R1



ROL100 – manual

NEW



Model	with Intermediate
ROL100 manual	INT100
	INT120
	INT150
	INT100 FISSO



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



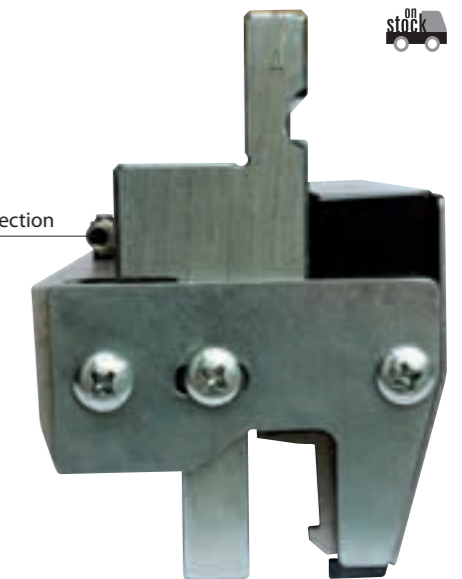
Model	with Intermediate
ROL100 pneumatic	INT100
	INT120
	INT150
	INT100 FISSO



L=150 mm (5.91 in)
vertical tool exchange
including selectable intermediates



Pneumatic connection



R1 ROLLERI CLAMPING SYSTEMS

ROL1-System for Punches Roller Type R1

In order to use the ROL1 System, the punches are modified and equipped with spring-loaded balls.

ROL1 can be used on all press brakes with standard tang intermediates of Roller Type R1.

Our Advantages – Your Convenience

- **vertical clamping** of tools is possible on press brakes thanks to a row of **spring-loaded balls** which are also used as **safety guards** to prevent the falling out of tools.
- complete mechanic functioning fast clamping system for press brake machines.
- Productivity and Versatility of the press brake machines will be increased.
- Significant **reduction in the set-up times** when changing tools



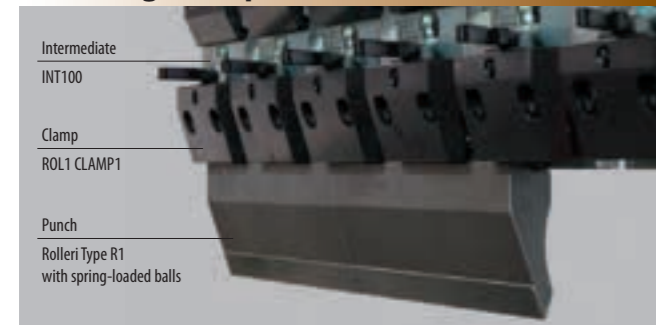
ROL1 CLAMP1 – manual

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 CLAMP1	INT100	vertical
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	

ROL1 CLAMP1 without Intermediate



Mounting example



ROL1 PN CLAMP1 – pneumatic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 PN CLAMP1	INT120	vertical
	INT150	



Rolleri Videos
Application of Clamping Systems
ROL1 CLAMP1: www.rolleritools.com/videos/rol1-clamp1

R1 ROLLERI CLAMPING SYSTEMS

ROL1-System for Punches Roller Type R1



ROL1 HYD CLAMP1 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool exchange including selectable intermediates
ROL1 HYD CLAMP1	INT100	vertical
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



Detailed information about intermediates on page 199

ROL1 KDS

Model	with Intermediate	with Clamp1	with Clamp3	L=150 mm vertical tool exchange including selectable intermediates
ROL1 KDS	INT100	vertical	horizontal	vertical
	INT120			
	INT150			
	INT100 FISSO			
	INT120-40			



ROL4-System for Punches Roller Type R1

ROL4 – manual

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates integrated KDS-System
ROL4 manual	INT100	horizontal
	INT120	
	INT150	
	INT100 FISSO	



ROL4 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool exchange including selectable intermediates integrated KDS-System
ROL4 hydraulic	INT100	horizontal
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



Rolleri Videos
Application of hydraulic clamping ROL4
www.rolleritools.com/videos/rol4-hydraulic-clamping

The ROL4-System is suitable for Standard-Punches Roller Type R1. There are no modifications necessary!

R2 ROLLERI CLAMPING SYSTEMS

W-ROL PN for Punches Roller Type R2

W-ROL PN – pneumatic

515 mm | 20.28 in | 26.8 kg/m

vertical



Our Advantages – Your Convenience

- vertical tool exchange of punches with:
 - ROL1-System
 - QuickLock-System
- Horizontal tool exchange of punches with safety pins
- significantly more efficient bending productivity



R3/RX ROLLERI CLAMPING SYSTEMS

ROL3-System for Punches Roller Type R3 and RX



ROL3 HYD – hydraulic

500 mm | 19.68 in

vertical

horizontal



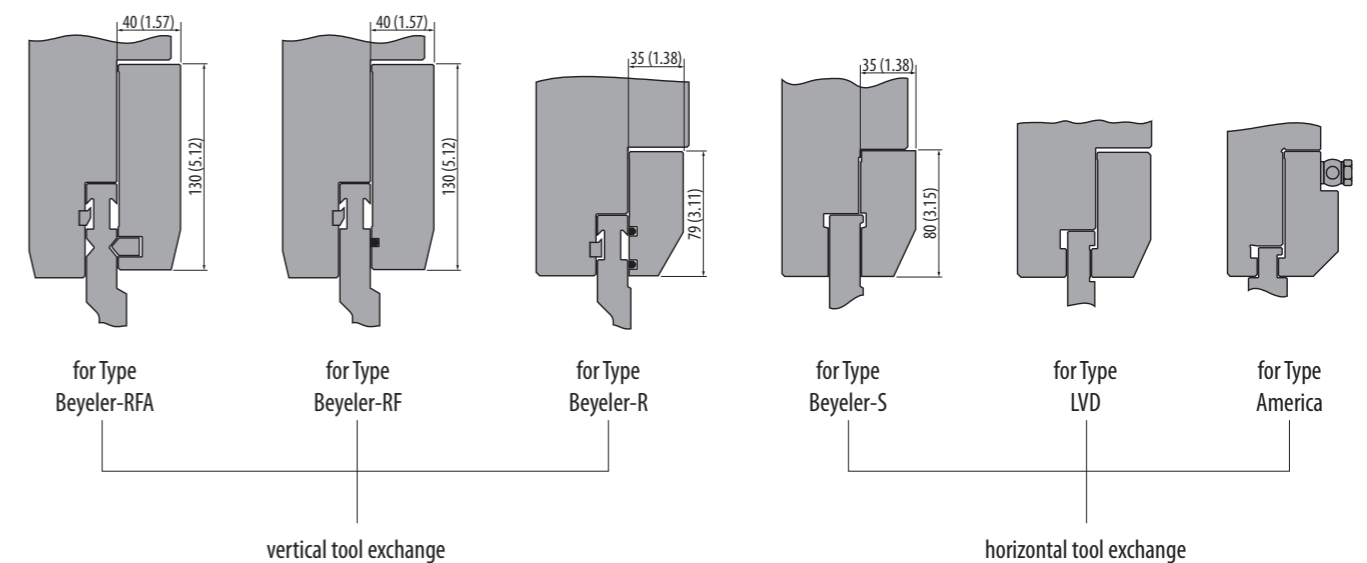
Our Advantages – Your Convenience

- can be used on press brake machines with different tang types
- custom manufacturing possible upon request
- significantly more efficient bending productivity

Equip your press brake with our ROL3 system in order to use the advantages of a hydraulic clamping system!



Examples of ROL3 with various systems



R1 ROLLERI CLAMPING SYSTEMS

ROL2-System for Dies Roller Type R1

■ Explanations

The **ROL2 System** is a system which is used to secure the die into place. It is made up of a special bar (known as **ROL2 CLAMP1**, L=500 mm / 19.68 in), which is operated through a centralized lever.

The **ROL2 System** has a built in spring mechanism and the clamp plates **ROL2 CLAMP1** are positioned in the inner lining of the system, which can be opened or tightened for the die to be perfectly secured.

A special rubber insert inside the clamp plates grants the best positioning for the tools. The press force of the clamp plates is evenly distributed along the complete length. Therefore short tools are also securely fastened.

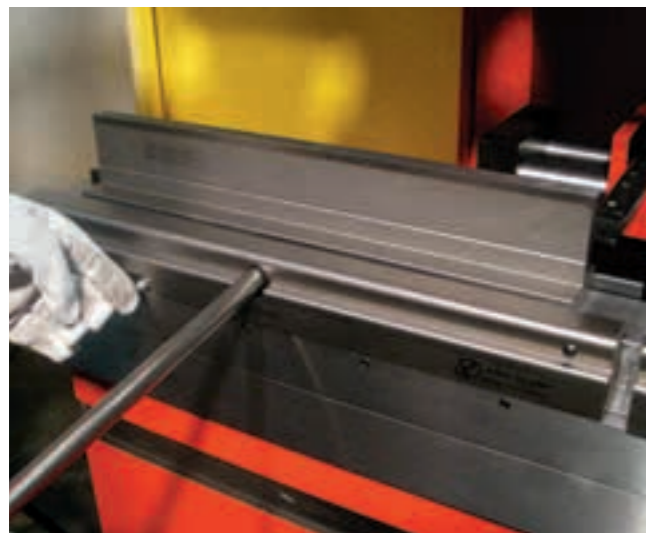
At a press brake of 3 meters (118.11 in), for example; all dies are secured with 6 simple hand movements.

■ Application

- **Directly on the die holder with 60 mm / 2.36 in width**
 - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
 - alternatively modifications of the existing threaded holes necessary
 - system is compatible for press brakes with automatic coving tables
- **Directly on the die holder with 90 mm / 3.54 in width**
 - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
 - alternatively modifications of the existing threaded holes necessary
 - for the use of dies Roller Type R1, two 15 mm / 0.59 in wide inserts are mounted and ground (securing with pins)
 - with rubber corners, the use of short tools is possible and are perfectly secured.
- **With Die Holder on the Die Rail**
 - 60 x 55 mm / 2.36 x 2.167 in die holder, ground and induction hardened.

■ Our Advantages – Your Convenience

- fast exchange of tools
- very time saving
- reduced production costs
- significantly increased profitability
- improved competitiveness



R1 ROLLERI CLAMPING SYSTEMS

ROL2-System for Dies Roller Type R1



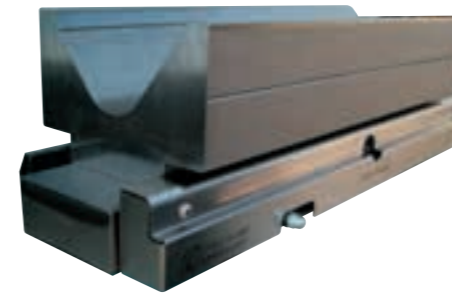
ROL2 – manual

Clamp incl. Die holder		
table: 60 mm	2.36 in	38.0 kg
table: 90 mm	3.54 in	58.0 kg

only Clamp		
table: 60 mm	2.36 in	4.0 kg
table: 90 mm	3.54 in	4.5 kg

L=1075 mm (42.32 in)

L=500 mm (19.68 in)



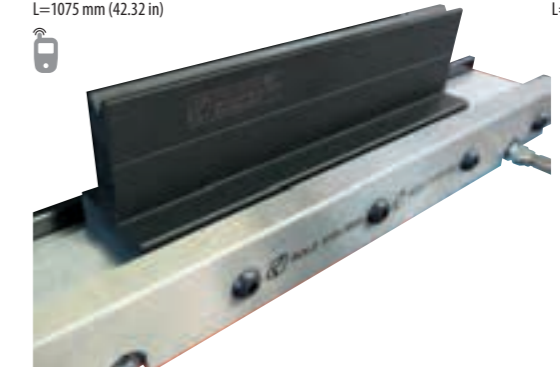
ROL2 – hydraulic

Clamp incl. Die holder		
table: 60 mm	2.36 in	23.0 kg
table: 90 mm	3.54 in	31.7 kg

only Clamp		
table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	5.5 kg

L=1075 mm (42.32 in)

L=500 mm (19.68 in)



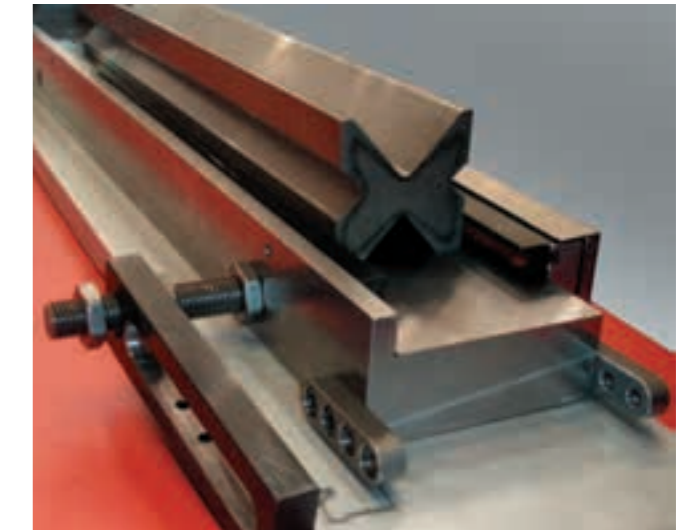
ROL2 – pneumatic

Clamp incl. Die holder		
table: 60 mm	2.36 in	23.0 kg
table: 90 mm	3.54 in	31.7 kg

only Clamp		
table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	5.5 kg

L=1075 mm (42.32 in)

L=500 mm (19.68 in)



Movable Die Clamps for Dies Roller Type R1

■ Our Advantages – Your Convenience

- lowerable clamping plate
- significantly easier exchange of tools, due the possibility of removing the tool by sliding it out and not lifting the tool.



Rolleri Videos

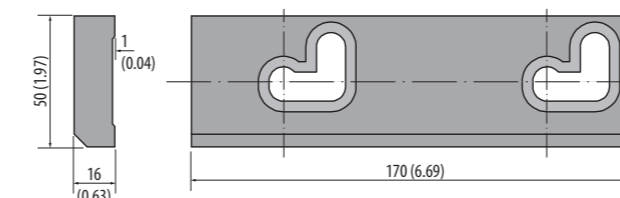
movable die holders ST50-S:
www.rolleritools.com/videos/movable-die-holders



ST50-S

per piece 0.70 kg

Fe37: 370-470 N/mm²



ROLLERI ADAPTERS

Punch Adapters	212 - 215
Bolted Adapters	216 - 217
Die Adapter Rails	218
Die Adapters	219 - 221
Modification: Wedge Bar / Tail	221




ROLLERI ADAPTERS

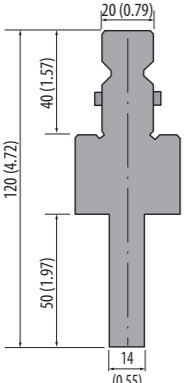
Punch Adapters

AD11 1000 kN/m max.

150 mm	5.91 in	3.0 kg
--------	---------	--------

Rolleri Type R2
→ Rolleri Type R1


C45: 560-710 N/mm² 

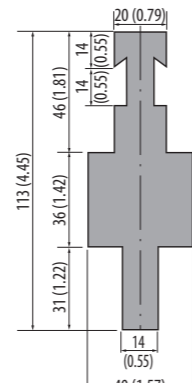


AD22 1000 kN/m max.

150 mm	5.91 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler R
→ Rolleri Type R1


C45: 560-710 N/mm² 

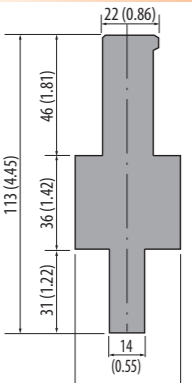


AD3 1000 kN/m max.

150 mm	5.91 in	3.3 kg
--------	---------	--------

Rolleri Type R3 Beyeler S
→ Rolleri Type R1


C45: 560-710 N/mm² 

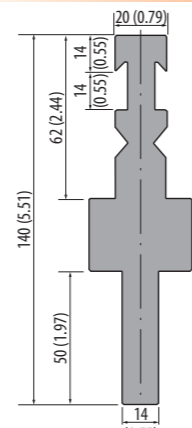


AD10 1000 kN/m max.

150 mm	5.91 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler RFA
→ Rolleri Type R1


C45: 560-710 N/mm² 

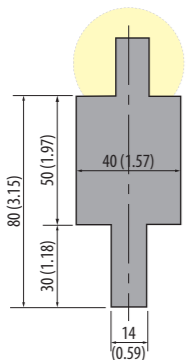


AD1 1000 kN/m max.

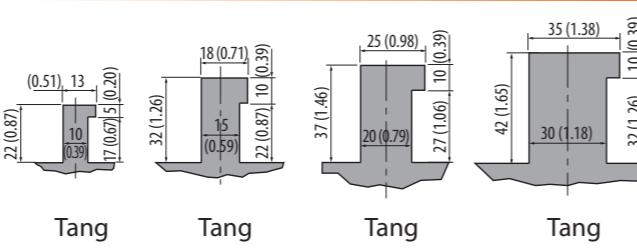
150 mm	5.91 in	3.1 kg
--------	---------	--------

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm² 



Tangs LVD



Tang A Tang B Tang C Tang D

With adapters you can use the vast amount of Punches Rolleri Type R1!




ROLLERI ADAPTERS

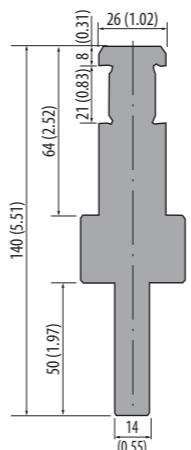
Punch Adapters

AD13 1000 kN/m max.

150 mm	5.91 in	3.0 kg
--------	---------	--------

Rolleri Type RX EHT
→ Rolleri Type R1


C45: 560-710 N/mm² 

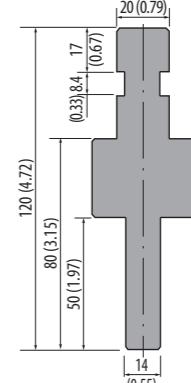


AD14 1000 kN/m max.

150 mm	5.91 in	3.2 kg
--------	---------	--------

Rolleri Type RX Gasparini
→ Rolleri Type R1


C45: 560-710 N/mm² 

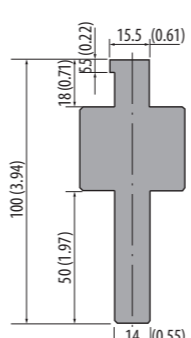


AD15 1000 kN/m max.

150 mm	5.91 in	4.0 kg
--------	---------	--------

Rolleri Type RX Ajial-Axial
→ Rolleri Type R1


C45: 560-710 N/mm² 

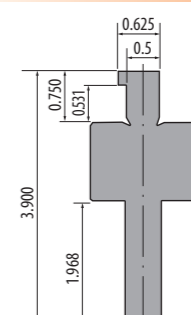


AD16 1000 kN/m max.

5.9 inch	5.91 in	4.0 kg
----------	---------	--------

Rolleri Type American
→ Rolleri Type R1


C45: 560-710 N/mm² 

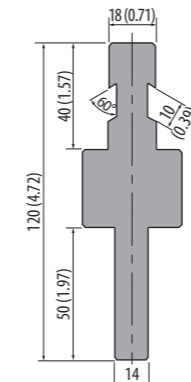


AD12 1000 kN/m max.

150 mm	5.91 in	1.5 kg
--------	---------	--------

Rolleri Type RX Colgar
→ Rolleri Type R1

C45: 560-710 N/mm² 




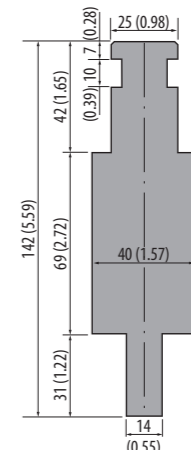
AD23 1000 kN/m max.

NEW

150 mm	5.91 in	5.0 kg
--------	---------	--------

Rolleri Type RX Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm² 

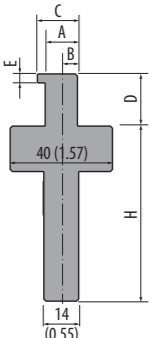


ROLLERI ADAPTERS

Punch Adapters

ADX 1000 kN/m max.

150 mm	5.91 in	3.5 kg
--------	---------	--------



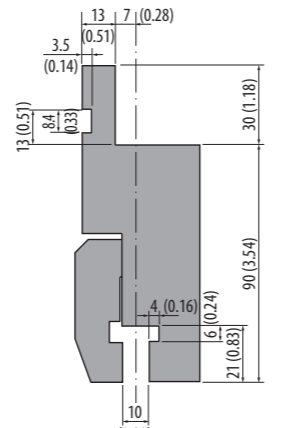
Type X
→ **Rolleri Type R1**

Production according to your specifications

C45: 560-710 N/mm²

AD19-A 1000 kN/m max.

150 mm	5.91 in	6.0 kg
--------	---------	--------



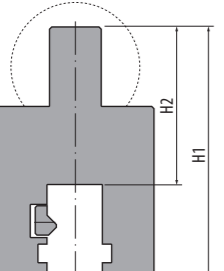
Rolleri Type R1
→ **Rolleri Type RX LVD**

C45: 560-710 N/mm²

ADX2 1000 kN/m max.

NEW

150 mm	5.91 in	4.0 kg
--------	---------	--------



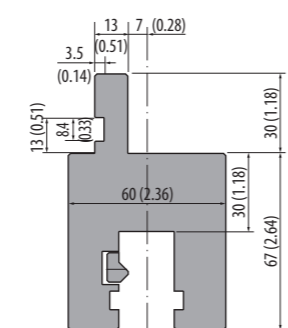
Type X
→ **Rolleri Type R2**

Production according to your specifications

C45: 560-710 N/mm²

AD20 1000 kN/m max.

150 mm	5.91 in	4.0 kg
--------	---------	--------



Rolleri Type R1
→ **Rolleri Type R2**

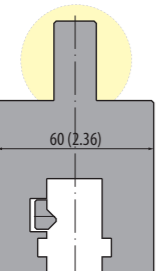
C45: 560-710 N/mm²

Pneumatic Adapters
see page 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



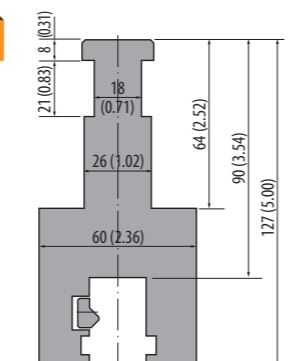
Rolleri Type RX LVD
→ **Rolleri Type R2**

C45: 560-710 N/mm²

AD28 1000 kN/m max.

NEW

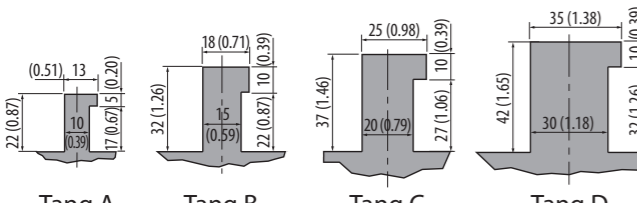
150 mm	5.91 in	5.0 kg
--------	---------	--------



Rolleri Type RX EHT
→ **Rolleri Type R2**

C45: 560-710 N/mm²

Tangs LVD



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)

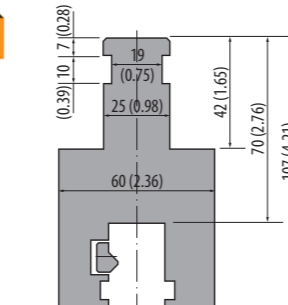
Tang C: 25 (0.98), 37 (1.46), 20 (0.79), 27 (1.06), 10 (0.39)

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/mm²

Rolleri Videos

Bolted Adapters AW, P. 216-217

www.rolleritools.com/videos/bolted-adapters

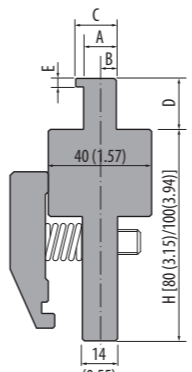


ROLLERI ADAPTERS

Punch Adapters

INT80-100 1000 kN/m max.

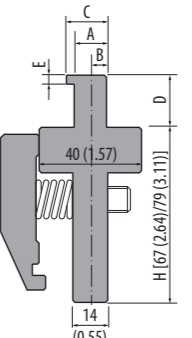
835 mm	32.87 in	25.0 kg
415 mm	16.34 in	12.5 kg



C45: 560-710 N/mm²

INT67-79 1000 kN/m max.

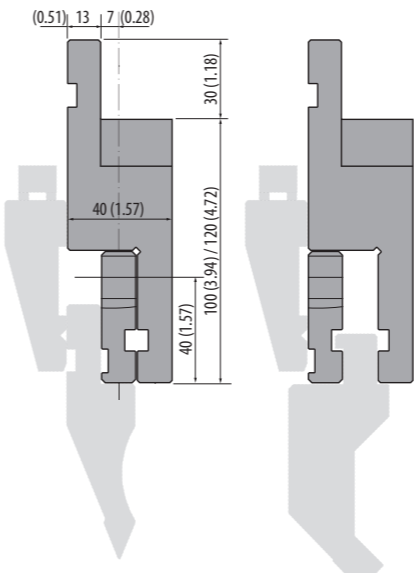
835 mm	32.87 in	20.5 kg
415 mm	16.34 in	10.0 kg



C45: 560-710 N/mm²

INT100-A / INT120-A 1000 kN/m max.

INT100-A	150 mm	5.91 in	3.5 kg
INT120-A	150 mm	5.91 in	5.2 kg



C45: 560-710 N/mm²

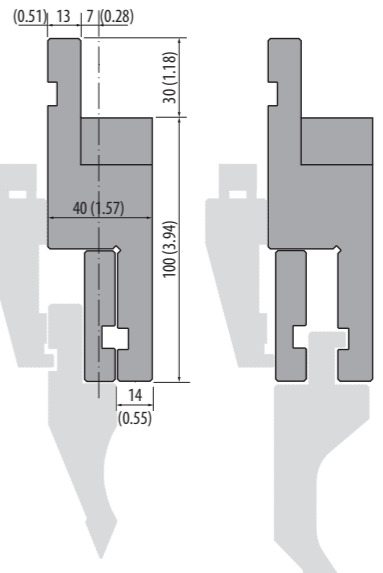
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Pneumatic system only on INT120-A (ROL1 Clamp3 PN), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

horizontal

INT100-N (Newton) 1000 kN/m max.

150 mm	5.91 in	3.5 kg
--------	---------	--------



C45: 560-710 N/mm²

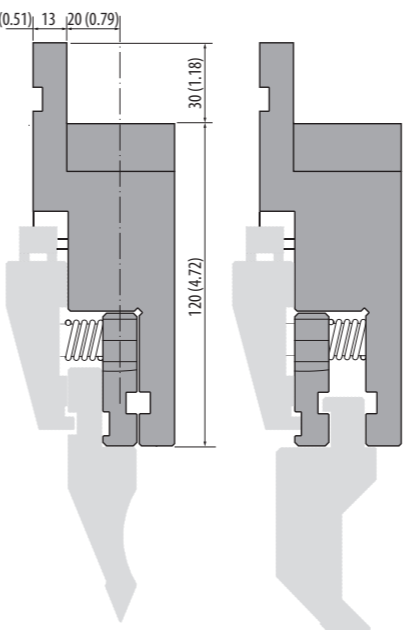
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

horizontal

INT120-40-A 1000 kN/m max.

150 mm	5.91 in	6.0 kg
--------	---------	--------



C45: 560-710 N/mm²

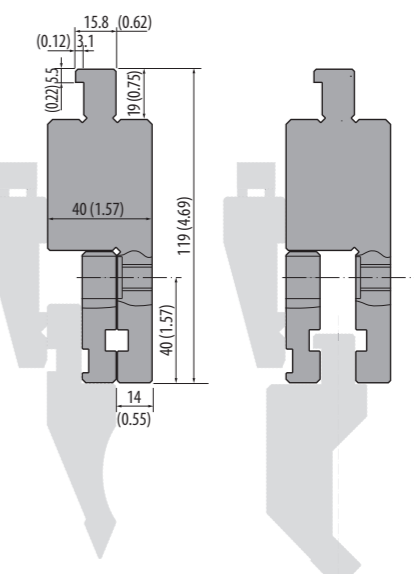
suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201

horizontal

INT100-A (American) 1000 kN/m max.

150 mm	5.91 in	3.5 kg
--------	---------	--------



C45: 560-710 N/mm²

suitable Models:

- Manual system (ST60, STL60, STX60 etc.), see page 200
- Fast Clamping (ROL1 Clamp3), see page 201
- Hydraulic system (ROL1 Clamp3 HYD), see page 201

horizontal

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/mm²

Do you prefer our QuickLock or ROL1-System? Contact us now!

AW3 1000 kN/m max.

NEW

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

Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²

AW10 1000 kN/m max.

NEW

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

Rolleri Type R3 Beyeler RFA
→ Rolleri Type R1

C45: 560-710 N/mm²

AW12 1000 kN/m max.

NEW

835 mm	32.87 in	7.0 kg
415 mm	16.34 in	3.5 kg
805 mm segmented	31.69 in segmented	6.7 kg

Rolleri Type RX Colgar
→ Rolleri Type R1

C45: 560-710 N/mm²

AW1-A 1000 kN/m max.

NEW

835 mm	32.87 in	4.5 kg
415 mm	16.34 in	2.2 kg
805 mm segmented	31.69 in segmented	4.3 kg

Rolleri Type RX LVD A
→ Rolleri Type R1

C45: 560-710 N/mm²

AW1-B 1000 kN/m max.

NEW

835 mm	32.87 in	6.3 kg
415 mm	16.34 in	3.1 kg
805 mm segmented	31.69 in segmented	6.0 kg

Rolleri Type RX LVD B
→ Rolleri Type R1

C45: 560-710 N/mm²

AW1-C 1000 kN/m max.

NEW

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

Rolleri Type RX LVD C
→ Rolleri Type R1

C45: 560-710 N/mm²

AW1-D 1000 kN/m max.

NEW

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

Rolleri Type RX LVD D
→ Rolleri Type R1

C45: 560-710 N/mm²

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/mm²

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/mm²

AW15 1000 kN/m max.

NEW

835 mm	32.87 in	4.6 kg
415 mm	16.34 in	2.3 kg
805 mm segmented	31.69 in segmented	4.4 kg

Rolleri Type RX Ajial-Axial
→ Rolleri Type R1

C45: 560-710 N/mm²

AWC16 1000 kN/m max.

NEW

835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

Rolleri Type RX Colly
→ Rolleri Type R1

C45: 560-710 N/mm²

AWC13.5 1000 kN/m max.

NEW

835 mm	32.87 in	4.8 kg
415 mm	16.34 in	2.4 kg
805 mm segmented	31.69 in segmented	4.6 kg

Rolleri Type RX Colly
→ Rolleri Type R1

C45: 560-710 N/mm²

AWX 1000 kN/m max.

NEW

835 mm	32.87 in	3.0 kg
415 mm	16.34 in	1.5 kg
805 mm segmented	31.69 in segmented	3.0 kg

Individual
→ Rolleri Type R1

C45: 560-710 N/mm²

INT35 1000 kN/m max.

NEW

835 mm	32.87 in	4.0 kg
525 mm	20.67 in	2.5 kg
805 mm segmented	31.69 in segmented	3.9 kg

C45: 560-710 N/mm²

INT35-A 1000 kN/m max.

NEW

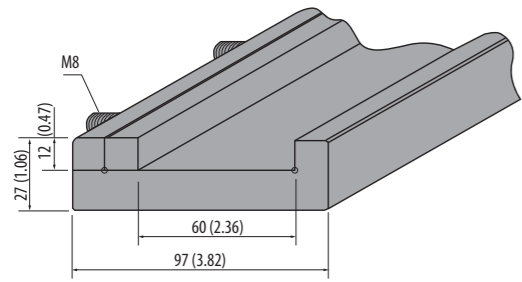
835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

C45: 560-710 N/mm²

ROLLERI ADAPTERS

Die Adapter Rails

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

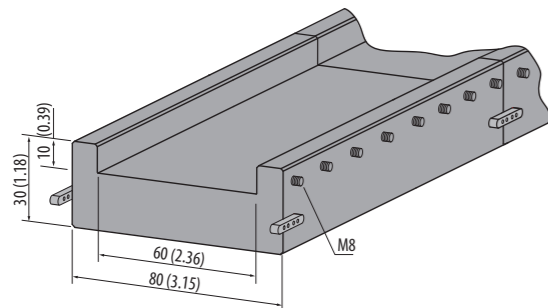


Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm²

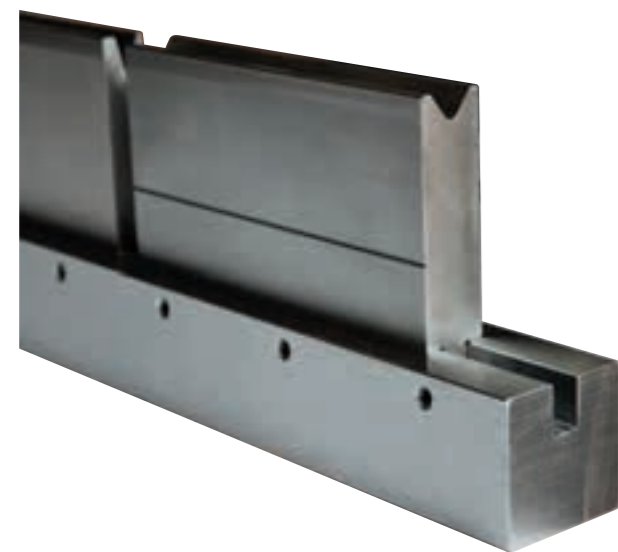
C 1050/R



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

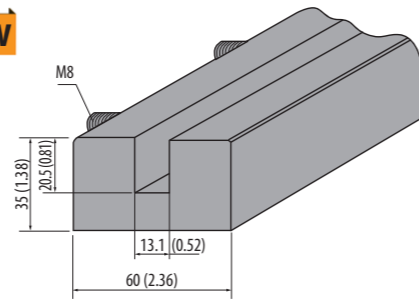


C45: 560-710 N/mm²



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

NEW

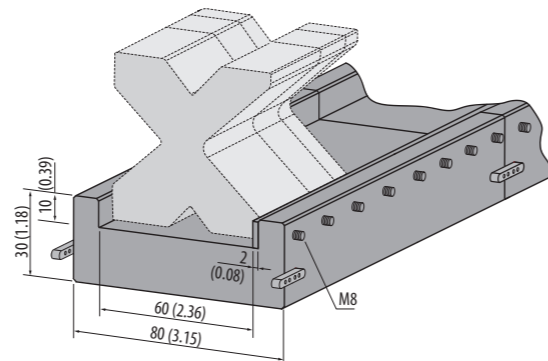


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm²

C 1050/RS

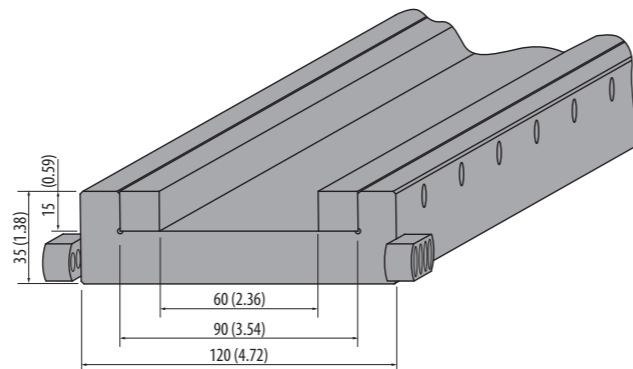


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



C45: 560-710 N/mm²

C 1050-90



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



C45: 560-710 N/mm²

ROLLERI ADAPTERS

Die Adapters



AD6

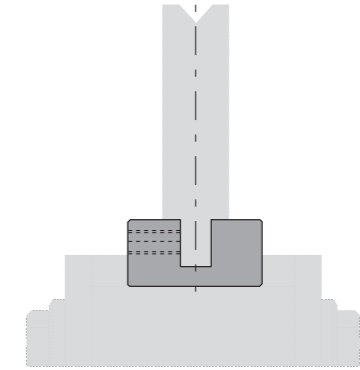
1000 kN/m max.

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/mm²

AD6 Example of Application



AD5

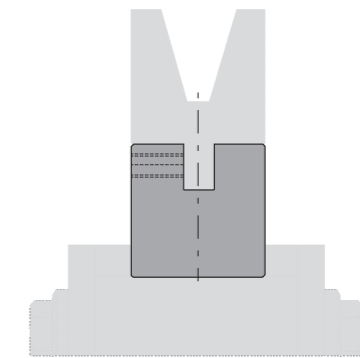
1000 kN/m max.

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

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

AD5 Example of Application



AD7

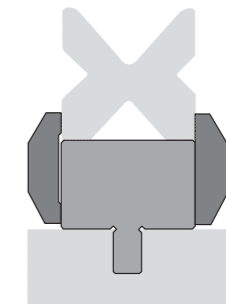
1000 kN/m max.

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

Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²

AD7 Example of Application



AD24

1000 kN/m max.

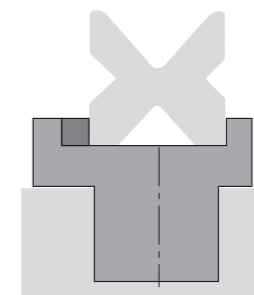
835 mm	32.87 in	28.5 kg
415 mm	16.34 in	14.2 kg

NEW

Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²

AD24 Example of Application

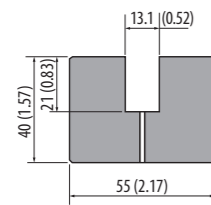


ROLLERI ADAPTERS

Die Adapters

AD25

NEW



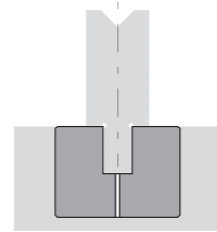
1000 kN/m max.
500 mm 19.68 in 7.5 kg

Rolleri Type RX EHT
→ Rolleri Type R2/R3

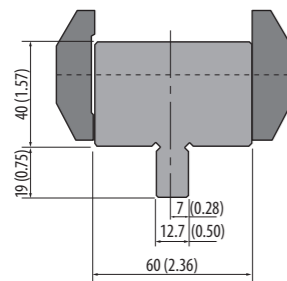
C45: 560-710 N/mm²



AD25 Example of Application



AD9-12.7



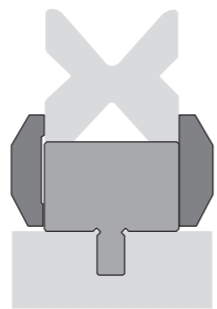
1000 kN/m max.
835 mm 32.87 in 17.0 kg
415 mm 16.34 in 8.5 kg

Rolleri Type RX LVD
→ Rolleri Type R1

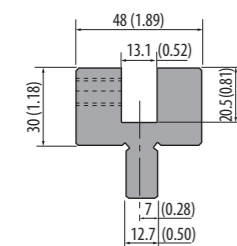
C45: 560-710 N/mm²



AD9-12.7 Example of Application



AD8-12.7



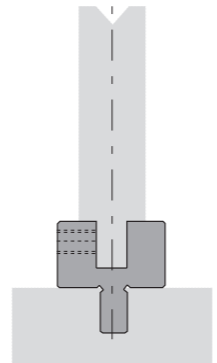
1000 kN/m max.
1000 mm 39.37 in 15.0 kg
500 mm 19.68 in 7.5 kg

Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²

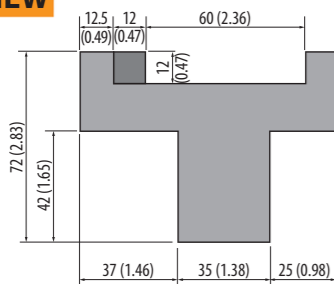


AD8-12.7 Example of Application



AD26

NEW



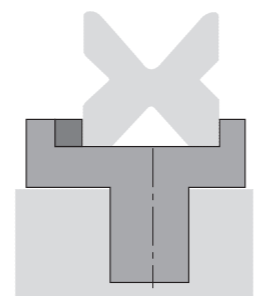
1000 kN/m max.
835 mm 32.87 in 23.0 kg
415 mm 16.34 in 11.4 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm²



AD26 Example of Application



ROLLERI ADAPTERS

Die Adapters



AD27

NEW



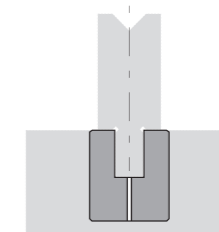
1000 kN/m max.
500 mm 19.68 in 4.5 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R2/R3

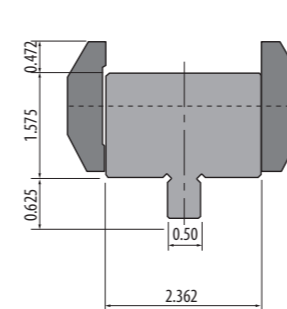
C45: 560-710 N/mm²



AD27 Example of Application



AD17



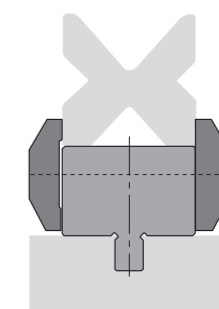
1000 kN/m max.
835 mm 32.87 in 18.0 kg
415 mm 16.34 in 9.0 kg

Type American
→ Rolleri Type R1

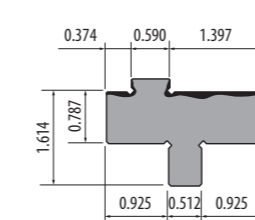
C45: 560-710 N/mm²



AD17 Example of Application



AD18



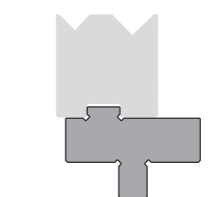
1000 kN/m max.
835 mm 32.87 in 18.0 kg
415 mm 16.34 in 9.0 kg

Type American
→ Rolleri Type R1

C45: 560-710 N/mm²



AD18 Example of Application



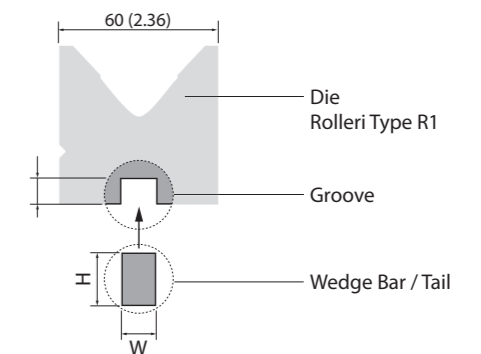
Modification: Wedge Bar / Tail

In order to use the dies Rolleri Type R1 on other press brake machines, a 10 mm (0.39 in) groove is milled to insert a ground wedge bar / tail into the die.

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

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

Mounting example



ROLLERI MARK FREE BENDING

Prevention of Bending Marks	224
Bending Foil Holder/Tensioner	224
Bending Foil	225
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.

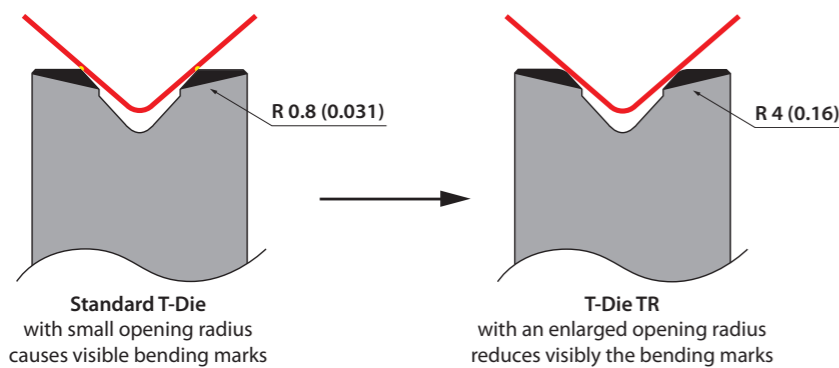
In order to prevent this markings, the following solutions are possible:

- 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

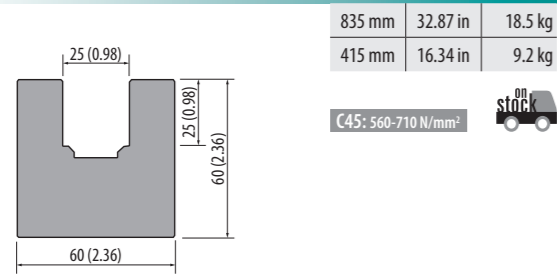
mark free bending:
www.rolleritools.com/videos/mark-free-bending



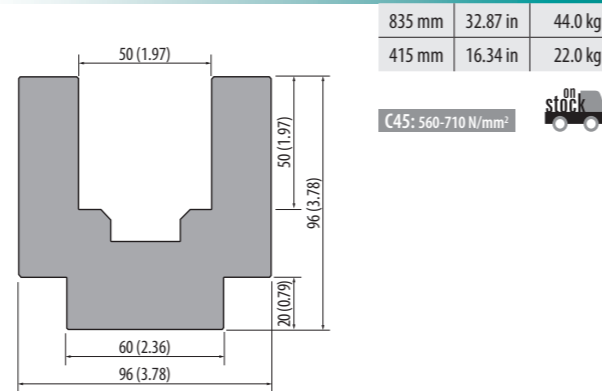
ROLLERI MARK FREE BENDING

PU-Holders and PU-Upholstery

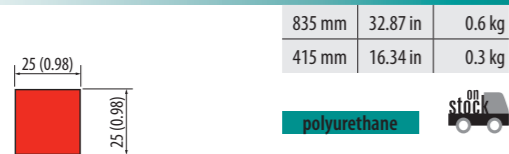
MPG25



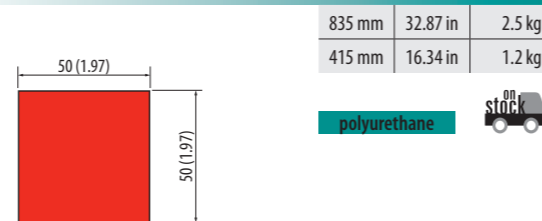
MPG50



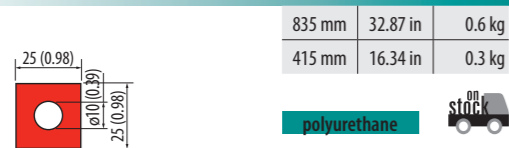
GM 25x25



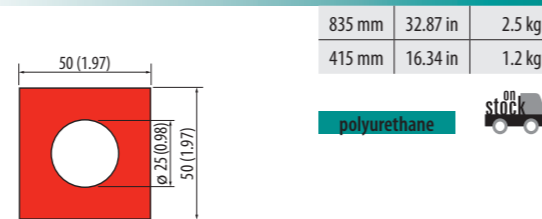
GM 50x50



GMF 25x25x10



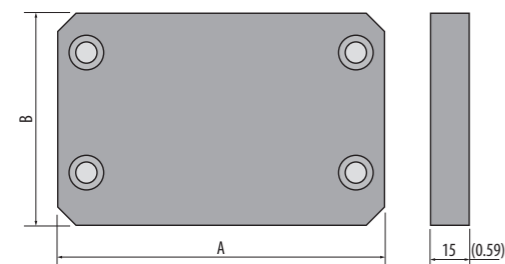
GMF 50x50x25



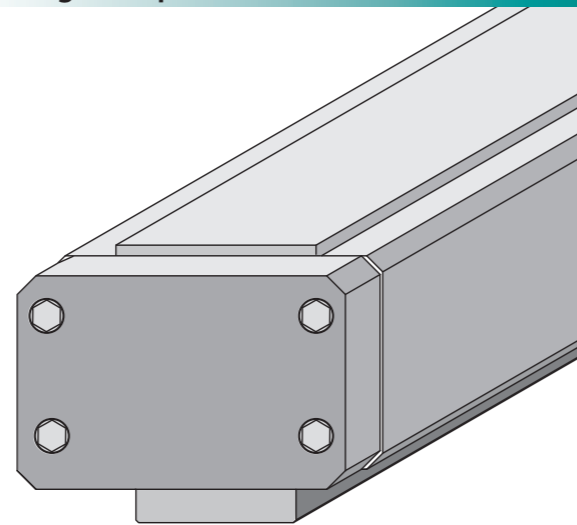
PSTCON

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/mm²



Mounting example

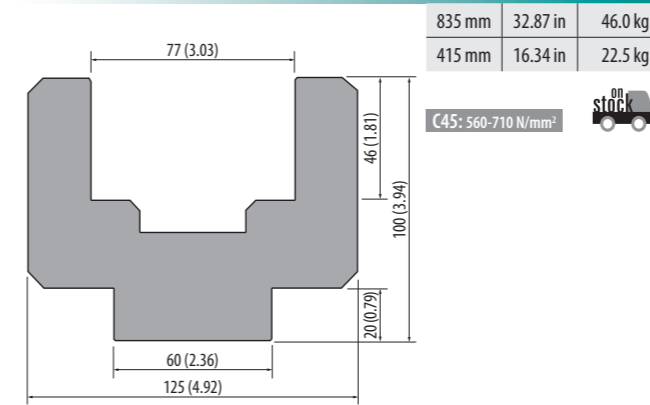


ROLLERI MARK FREE BENDING

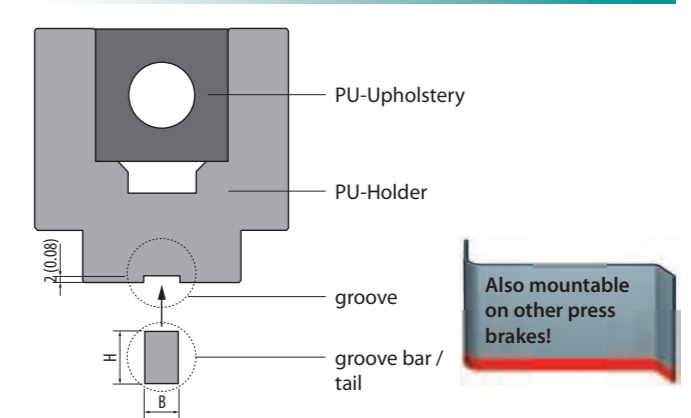
PU-Holders and PU-Upholstery



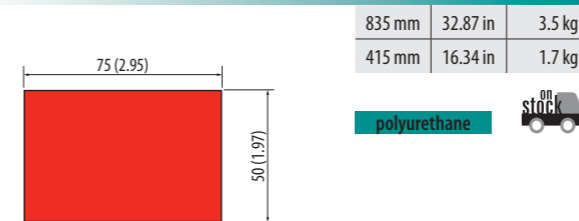
MPG75



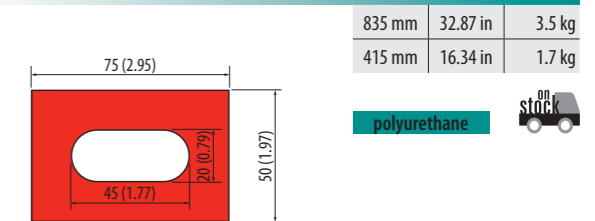
Mounting example



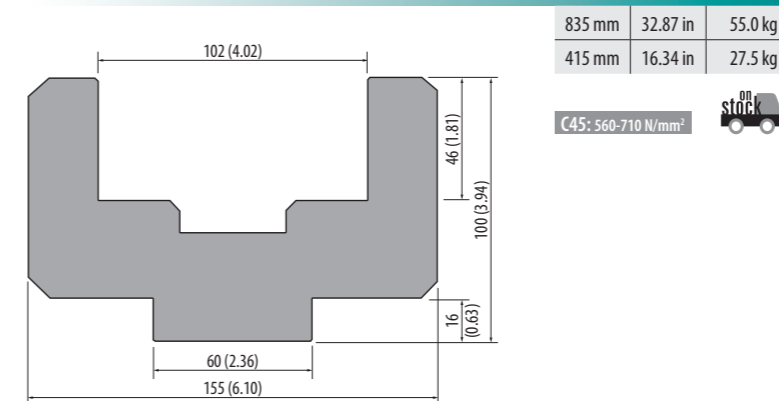
GM 75x50



GMF 75x50x20

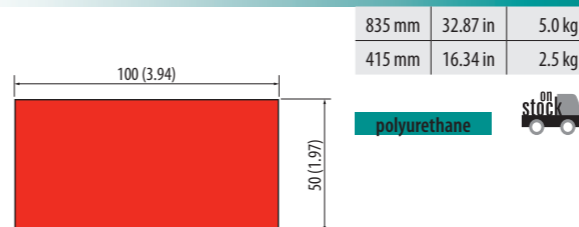


MPG100

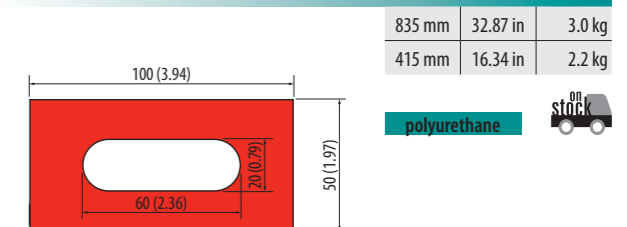


PU-Upholstery are suitable for radius- and U-profile bendings, etc.

GM 100x50



GMF 100x50x20



ROLLERI MARK FREE BENDING

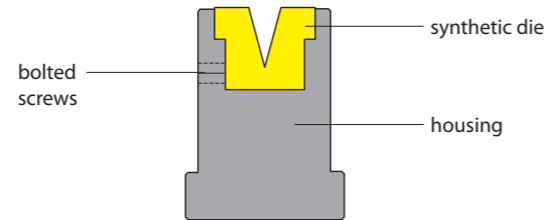
Synthetic Dies

Our Advantages – Your Convenience

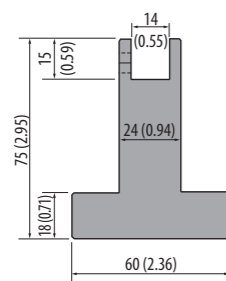
- easy Handling
- faster and easier exchange of plastic dies
- prevention of bending marks
- decrease of post-processing of bent pieces
- no contamination of the materials
- increased product quality

Mounting example

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



TN80.14 1000 kN/m max.



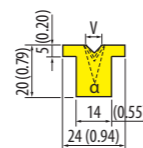
835 mm	32.87 in	15.0 kg
415 mm	16.34 in	7.5 kg

Rolleri Type R1

C45: 560-710 N/mm²



INS14... 200 kN/m max.



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

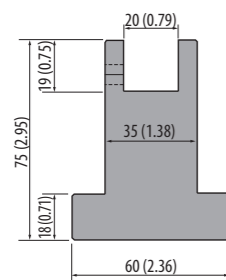
Rolleri Type R1



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

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

TN80.20 1000 kN/m max.



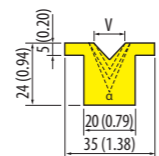
835 mm	32.87 in	19.0 kg
415 mm	16.34 in	9.5 kg

Rolleri Type R1

C45: 560-710 N/mm²



INS20... 200 kN/m max.



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

Rolleri Type R1



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

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

ROLLERI MARK FREE BENDING

Synthetic Dies

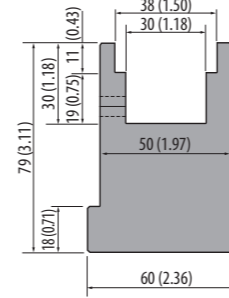


TN80.30 1000 kN/m max.

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

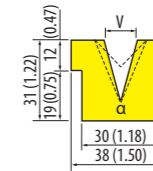
Rolleri Type R1

C45: 560-710 N/mm²



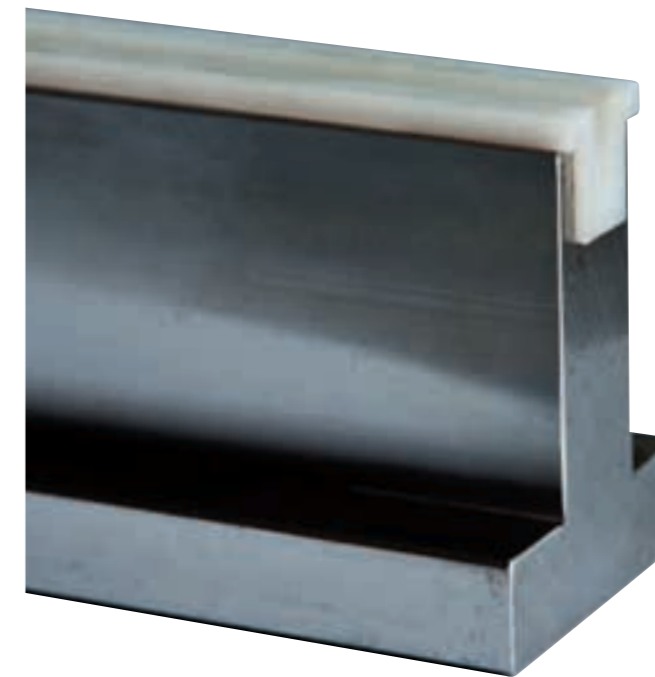
INS30... 200 kN/m max.

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



Model	α	V (mm)	V (in)
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.98
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16	0.63
INS30.20.60	60°	20	0.79

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



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

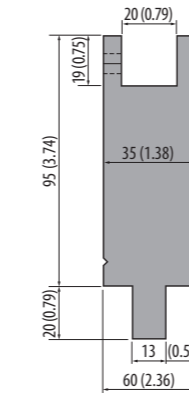


TMN95.20 1000 kN/m max.

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

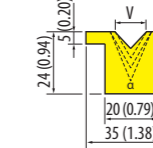
Rolleri Type R2/R3

C45: 560-710 N/mm²



INS20... 200 kN/m max.

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



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

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

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 ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC
1.2767	830 N/mm ²	22 - 25 HRC	54 - 60 HRC

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



Our Advantages – Your Convenience

The bending of materials with extreme high resistance, (Hardox, Weldox, etc.), has developed into an important task.

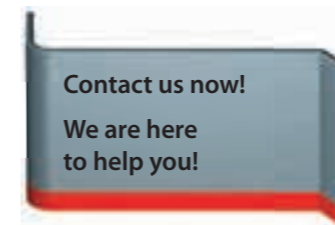
The Heavy Duty tools of Rollerli are built and finished for these challenges.

Tools that have a press force up to 4000 kN/m, offer you many production possibility.

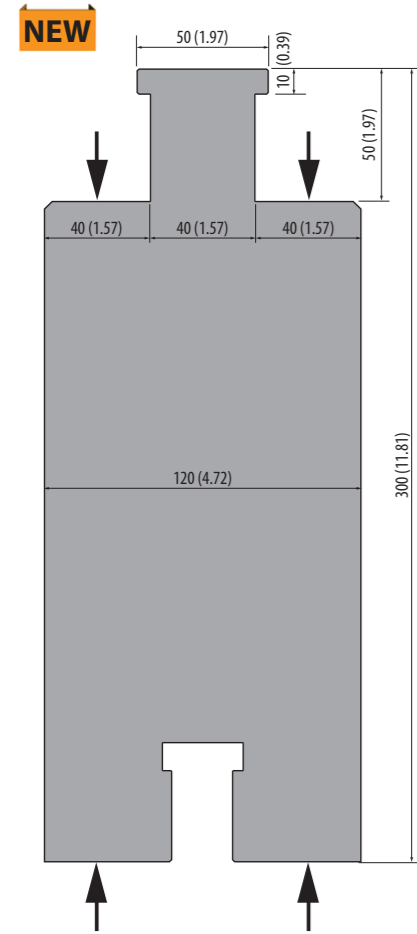
Our many years of experience in the area of special and heavy duty tooling, along with our own developing department, guarantee you functional and economic solutions in the bending sector.

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.



RHD.300



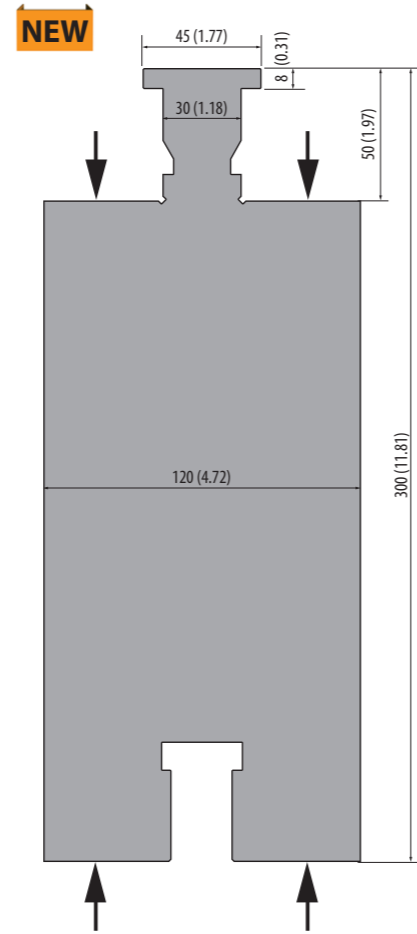
RHD.300-250		
500 mm	19.68 in	122.0 kg

2500 kN/m max.
42Cr: 900-1150 N/mm²

RHD.300-400		
500 mm	19.68 in	122.0 kg

4000 kN/m max.
1.2767: 830 N/mm²

RHD.300 HYD



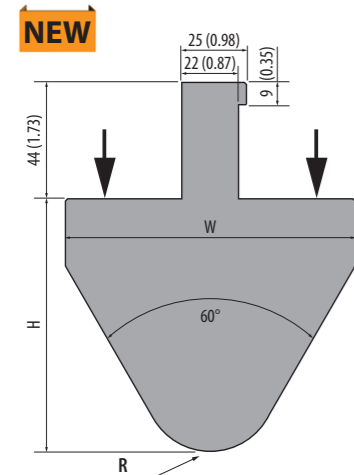
RHD.300-250 HYD		
500 mm	19.68 in	120.0 kg

2500 kN/m max.
42Cr: 900-1150 N/mm²

RHD.300-400 HYD		
500 mm	19.68 in	120.0 kg

4000 kN/m max.
1.2767: 830 N/mm²

RHDP.60



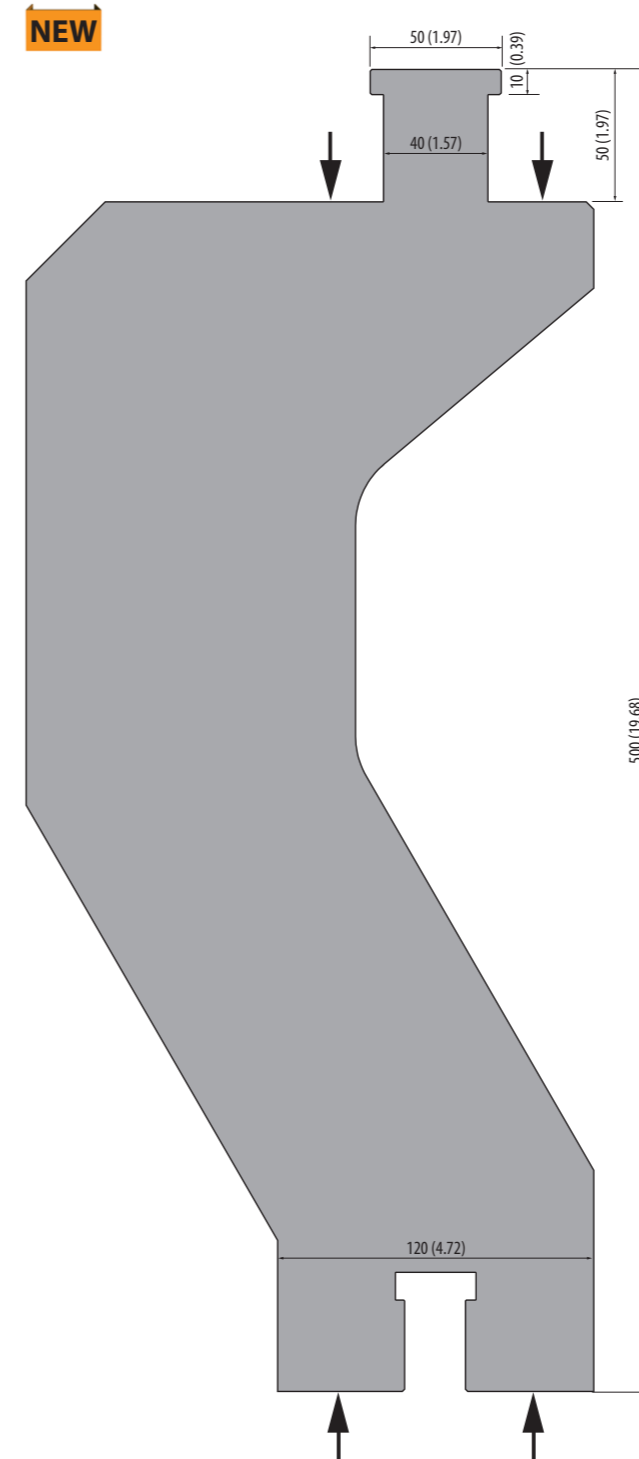
Model	2500 kN/m max.					
	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-250	96	3.78	110	4.33	20	0.79
RHDP.60.25-250	96	3.78	110	4.33	25	0.98
RHDP.60.30-250	96	3.78	110	4.33	30	1.18
RHDP.60.40-250	96	3.78	110	4.33	40	1.57
RHDP.60.50-250	96	3.78	110	4.33	50	1.97
RHDP.60.60-250	96	3.78	110	4.33	60	2.36
RHDP.60.70-250	86	3.39	140	5.51	70	2.76
RHDP.60.80-250	86	3.39	150	5.91	80	3.15
RHDP.60.90-250	86	3.39	165	6.50	90	3.54
RHDP.60.100-250	86	3.39	185	7.28	100	3.94

Model	4000 kN/m max.					
	H (mm)	H (in)	W (mm)	W (in)	R (mm)	R (in)
RHDP.60.20-400	96	3.78	110	4.33	20	0.79
RHDP.60.25-400	96	3.78	110	4.33	25	0.98
RHDP.60.30-400	96	3.78	110	4.33	30	1.18
RHDP.60.40-400	96	3.78	110	4.33	40	1.57
RHDP.60.50-400	96	3.78	110	4.33	50	1.97
RHDP.60.60-400	96	3.78	110	4.33	60	2.36
RHDP.60.70-400	86	3.39	140	5.51	70	2.76
RHDP.60.80-400	86	3.39	150	5.91	80	3.15
RHDP.60.90-400	86	3.39	165	6.50	90	3.54
RHDP.60.100-400	86	3.39	185	7.28	100	3.94

42Cr: 900-1150 N/mm²

1.2767: 830 N/mm²

RHD.500-200



2000 kN/m max.
150 mm 19.68 in 253.0 kg

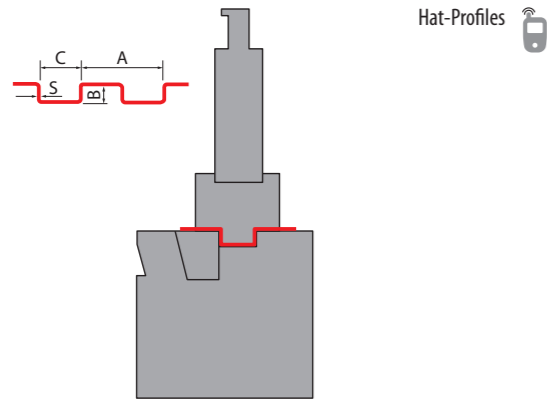
42Cr: 900-1150 N/mm²

More Tools for Heavy Duty operations can be found on pages 156-158

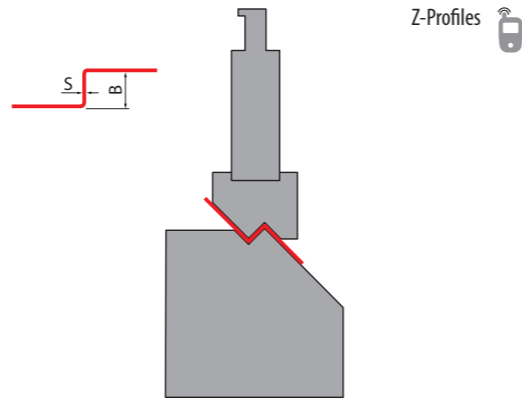


Tool examples

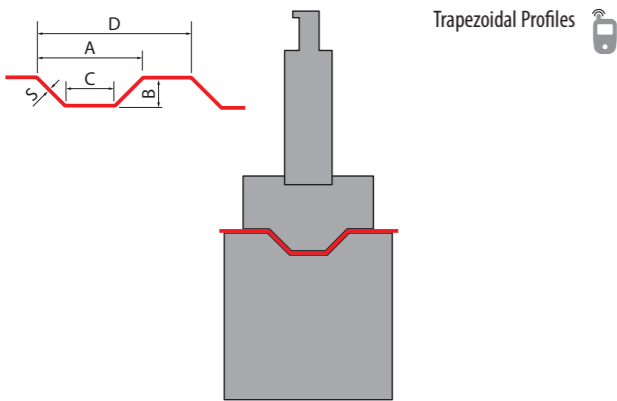
SPE1 Hat-Profiles



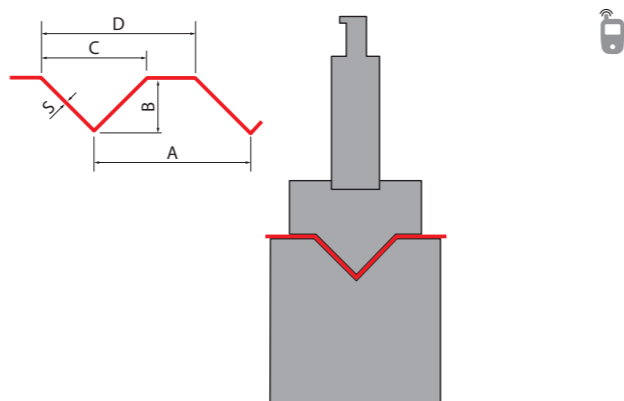
SPE2 Z-Profiles



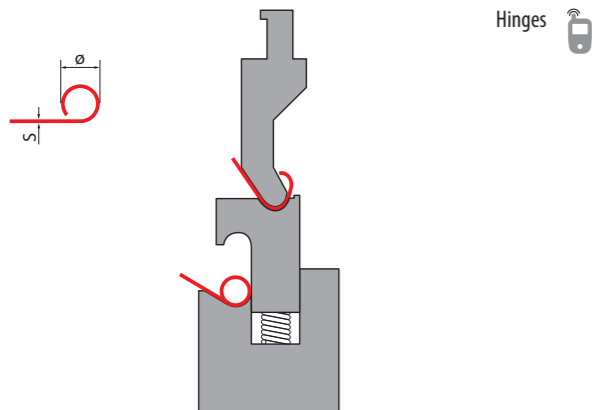
SPE3 Trapezoidal Profiles



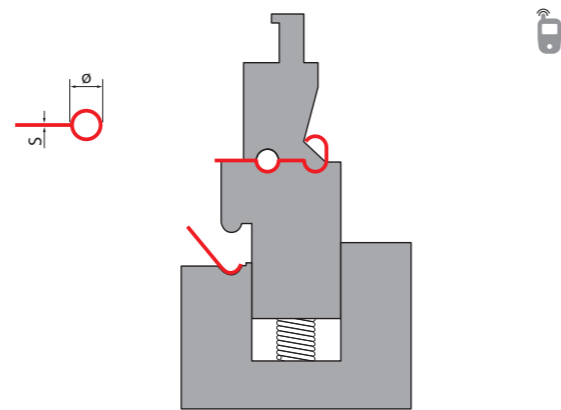
SPE4 Trapezoidal Profiles



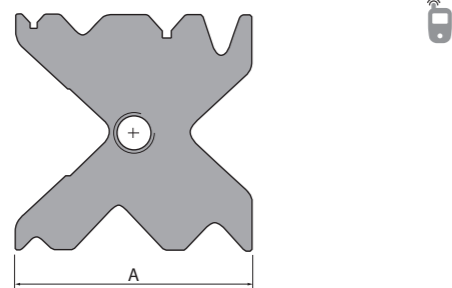
SPE5 Hinges



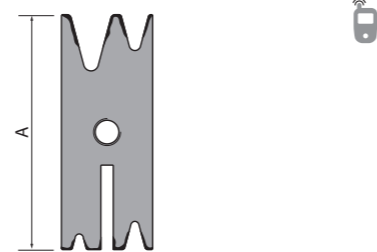
SPE6 Hinges



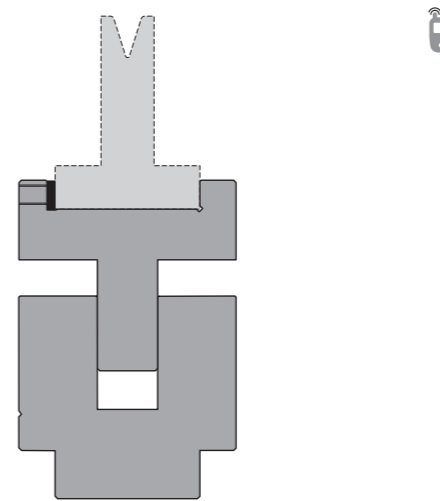
SPE7



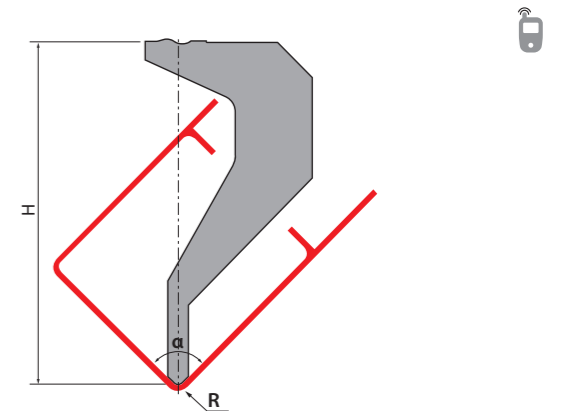
SPE-X



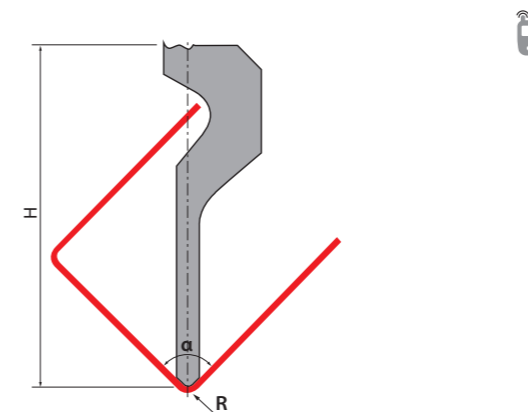
SPE9



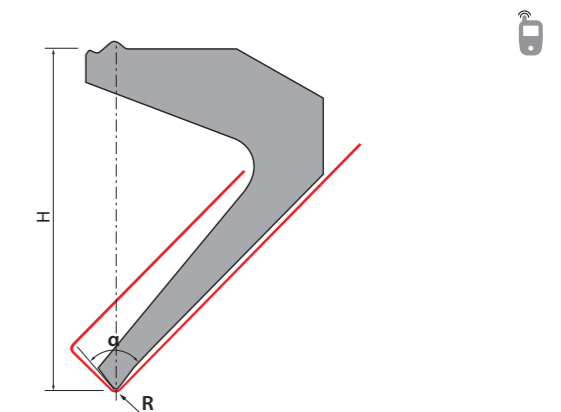
SPE-P1



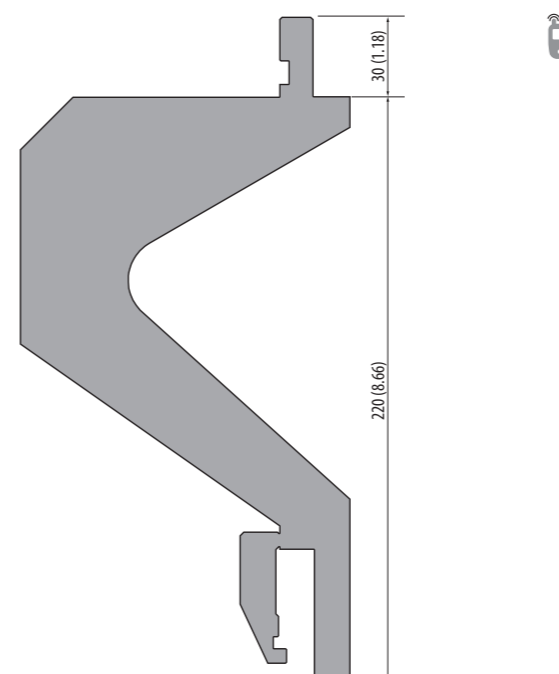
SPE-P2



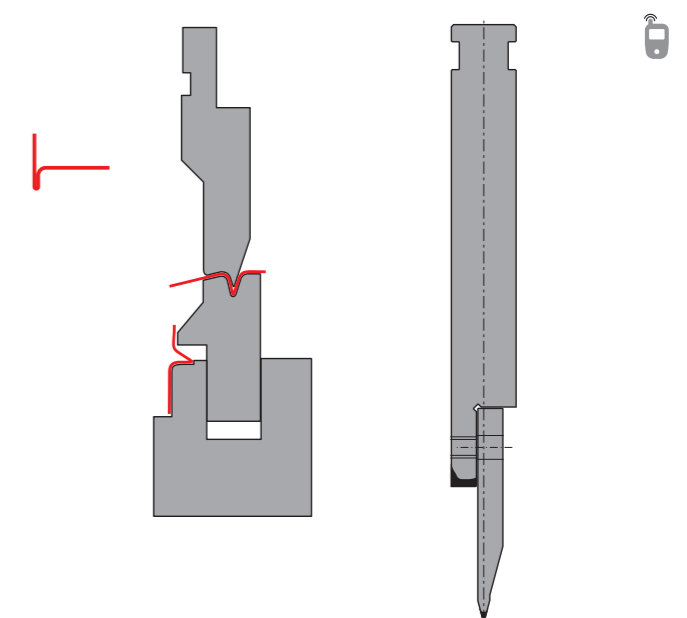
SPE-P3



SPE-P4

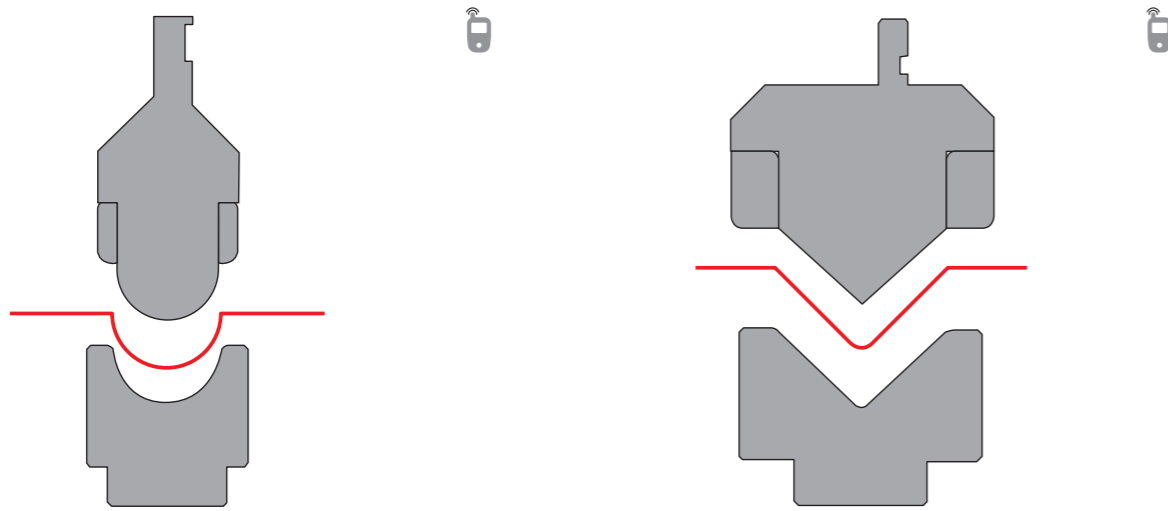


Front- and Hemming Tool (Foldings)

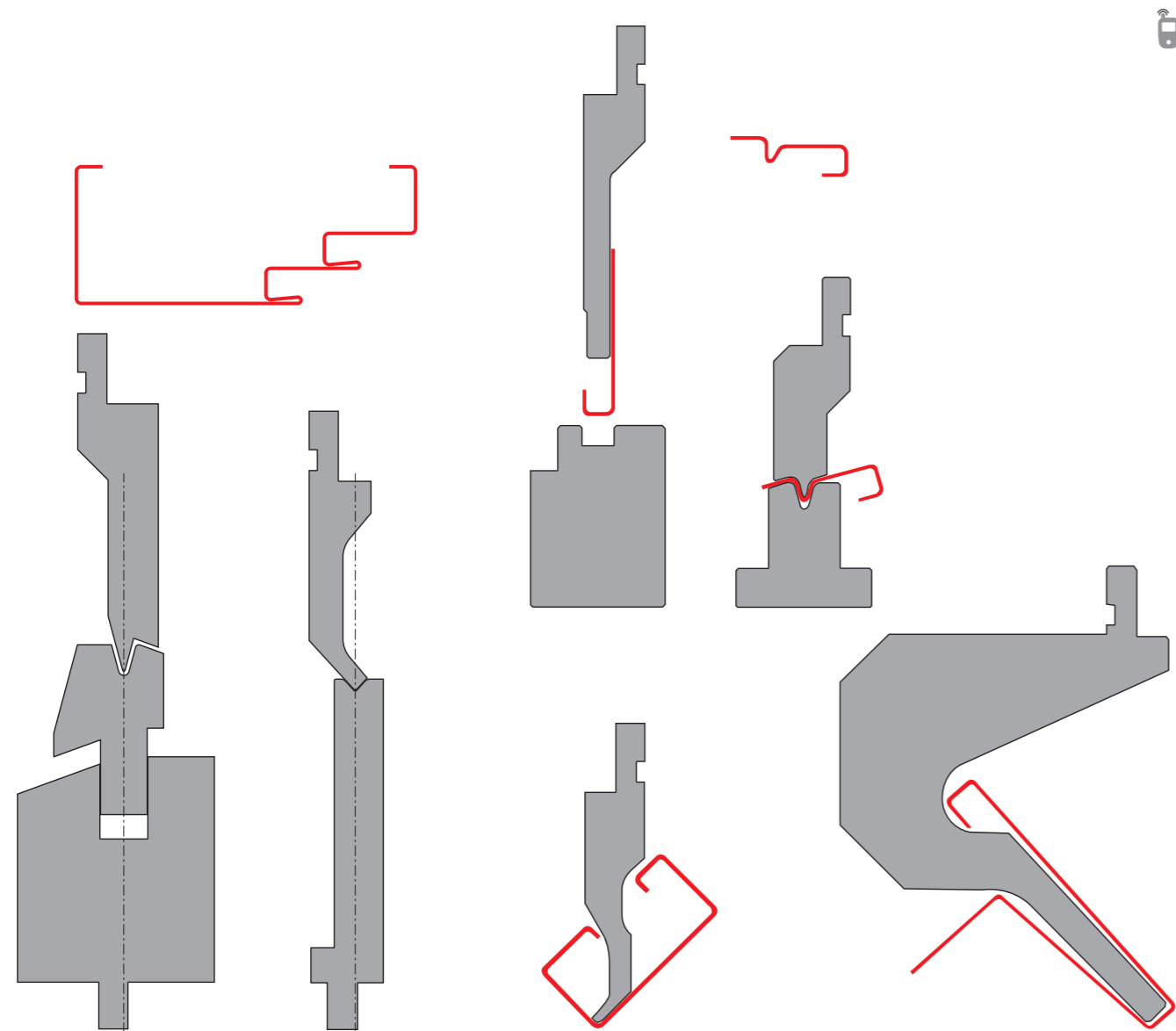


Tool examples

Radii Pressing

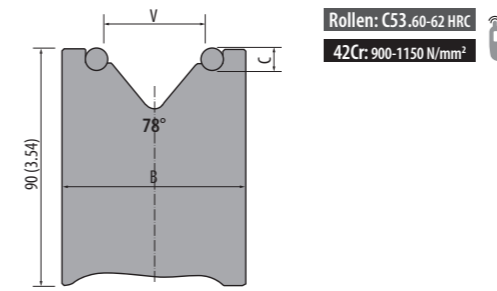


Special Profiles

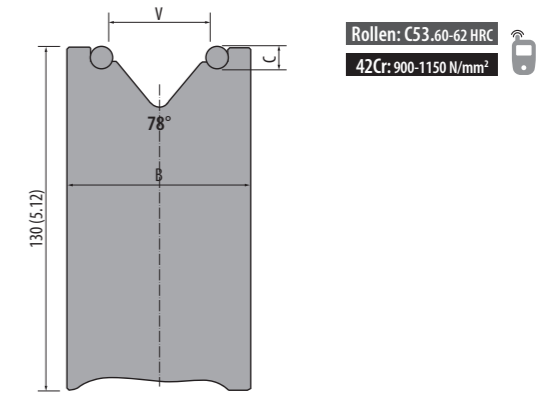


Dies with Rollers

MR90



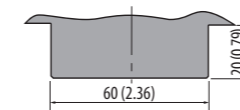
MR130



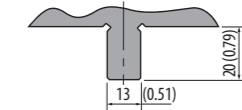
Model	V (mm)	V (in)	B (mm)	B (in)	C (mm)	C (in)	Length (mm)	Length (in)	Weight (kg)
MR90.20.78	20	0.79	45	1.77	6	0.24	835	32.87	15.0
MR90.24.78	24	0.94	49	1.93	6	0.24	835	32.87	17.0
MR90.30.78	30	1.18	60	2.36	8	0.31	835	32.87	21.0
MR90.40.78	40	1.57	70	2.76	8	0.31	835	32.87	24.0
MR90.50.78	50	1.97	84	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

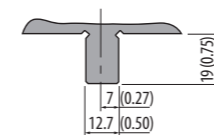
A10



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

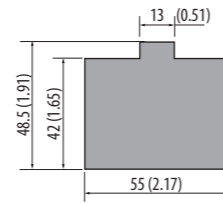
NEW



98 mm 3.86 in
Adapter for Roller Type R2/R3
C45: 560-710 N/mm²

AD MR55

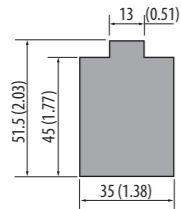
NEW



98 mm 3.86 in
Adapter for Roller Type RX EHT
C45: 560-710 N/mm²

AD MR35

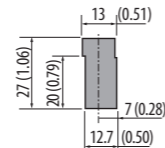
NEW



98 mm 3.86 in
Adapter for Roller Type RX Weinbrenner
C45: 560-710 N/mm²

AD MR12.7

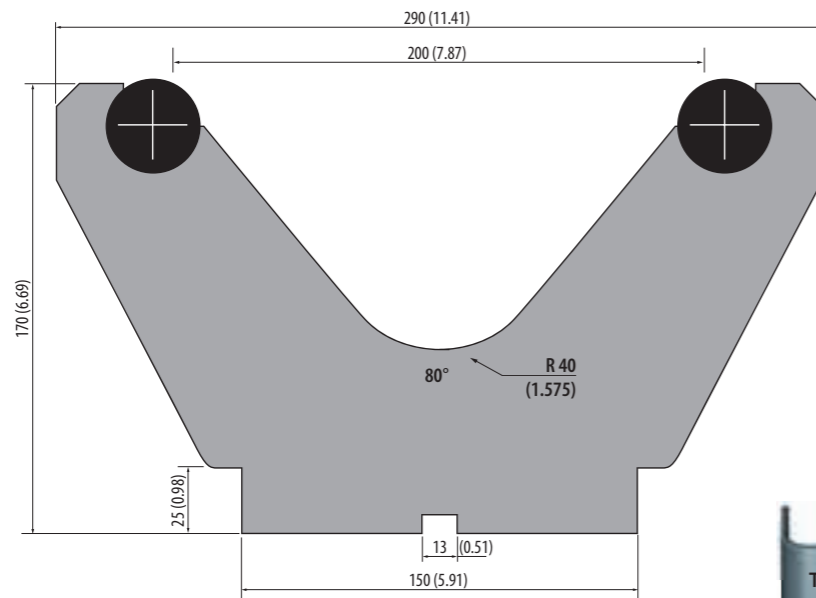
NEW



98 mm 3.86 in
Adapter for Roller Type RX LVD
C45: 560-710 N/mm²

MR170.200.80

NEW

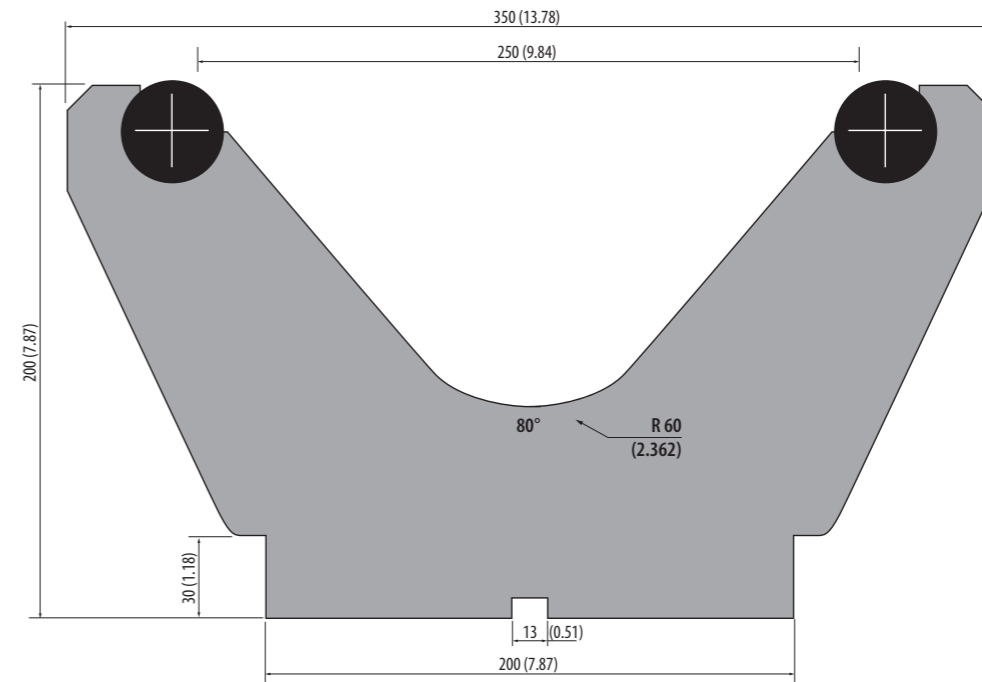


2000 kN/m max.
100 mm 3.94 in 19.0 kg
42Cr: 900-1150 N/mm²

Take advantage of our dies with rollers with means of groove bars/tails to use on other press brake machines.

MR200.250.80

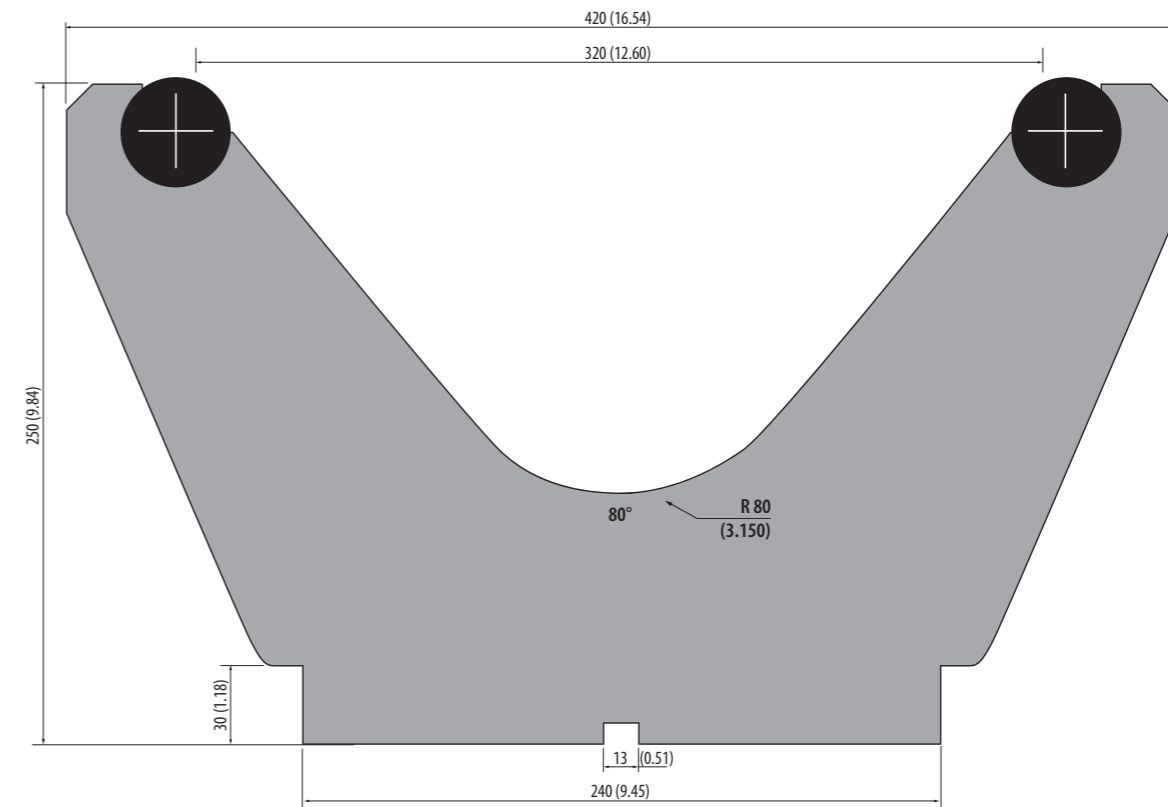
NEW



2000 kN/m max.
100 mm 3.94 in 28.0 kg
42Cr: 900-1150 N/mm²

MR250.320.80

NEW



2000 kN/m max.
100 mm 3.94 in 42.0 kg
42Cr: 900-1150 N/mm²

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

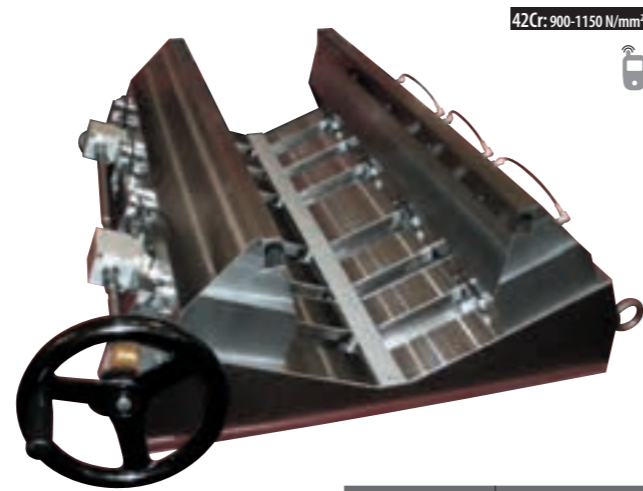
While using the manual version, the opening is set in place by a turn of the steering wheel, or with a gear reduction which is attached to the die.

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/mm²

bending angle	kN/m max.
0°	6000
90°	6000
60°	4000



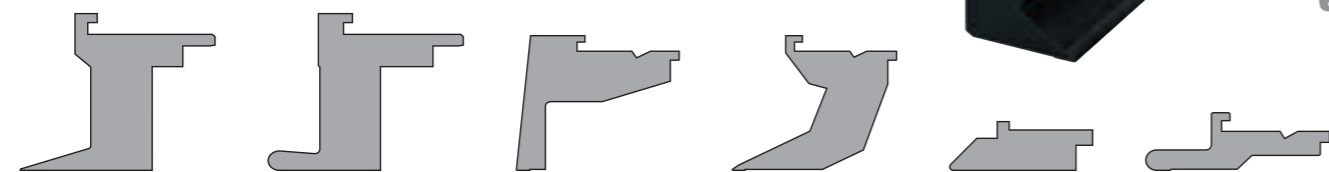
Rolleri Videos

Application of various dies ROL6:
www.rolleritools.com/videos/rol6

Panelling Tools

Our Advantages – Your Convenience

- in-house construction (no reseller or dealer)
- production according to your specifications
- tracking of every tool possible, with a unique serial number on every article after the quality control check.
- precision grinding (tolerance of +/-0.01 mm)
- exact parallelism
- use of the best materials, guaranteed high resistance and tensile strength



BLACKFIRE



The Unique Coating

Rolleri BLACKFIRE is a particular coating of your tools which defines itself by its increased corrosion resistance and special design.

The chemical treatment permanently solves the problem of oxidation.

The top surface of the metals changes through the phosphate process. It builds phosphate-like crystals, that attach themselves chemically on the substance. This improves the durability of the surface against corrosion.

Your equipment will have a long-term lifecycle left unchanged. The glossy black color of BLACKFIRE is compatible with the new technology and that allows a unique and esthetic look which connects well with the advantages of it.

You can have the BLACKFIRE treatment on all standard tools with a surcharge of 30%.

Please note that the delivery times vary by a BLACKFIRE Treatment.

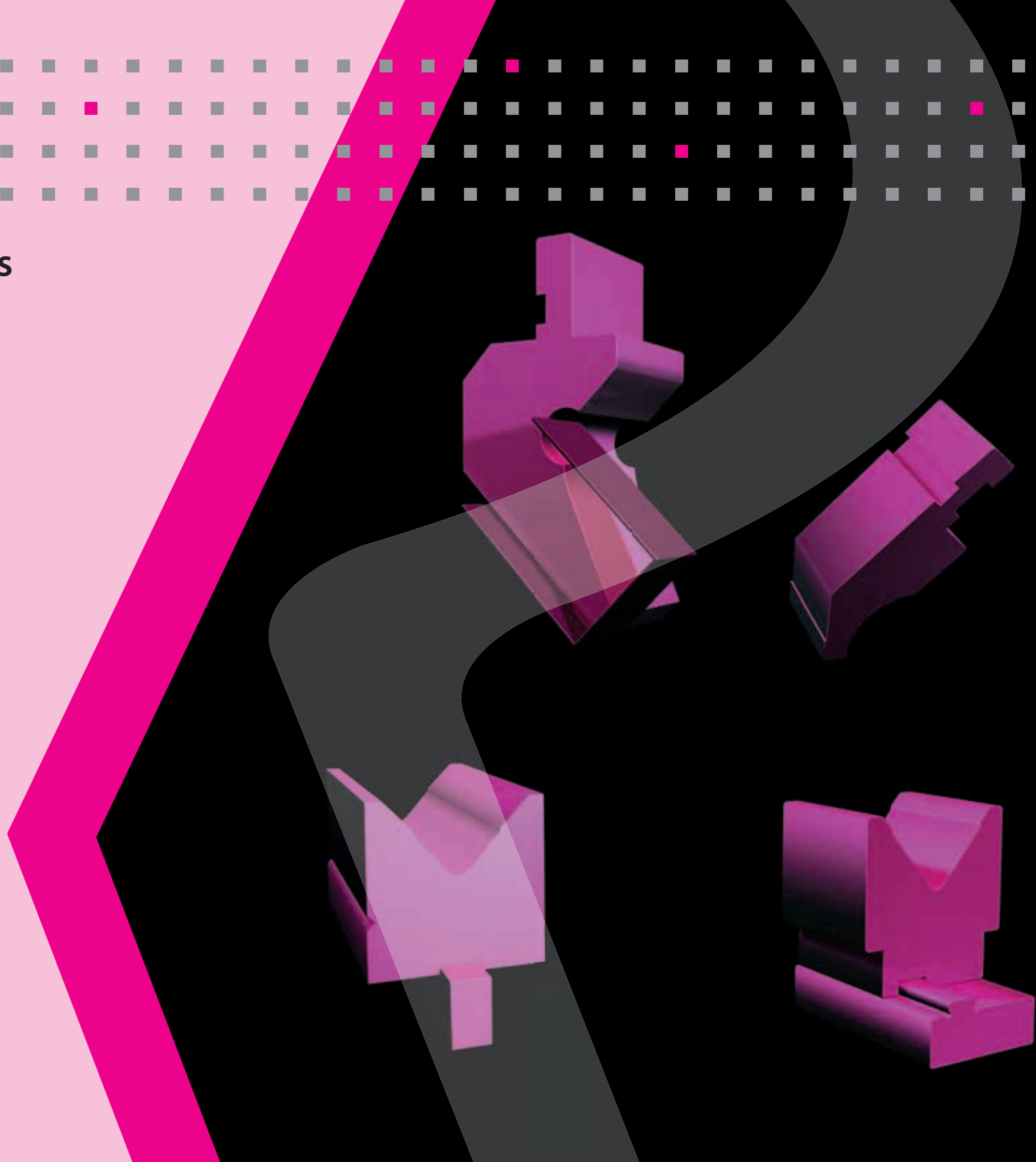
Our Advantages – Your Convenience

- no corrosion
- better gliding by the exchange of tools
- appealing design
- long-life cycle



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

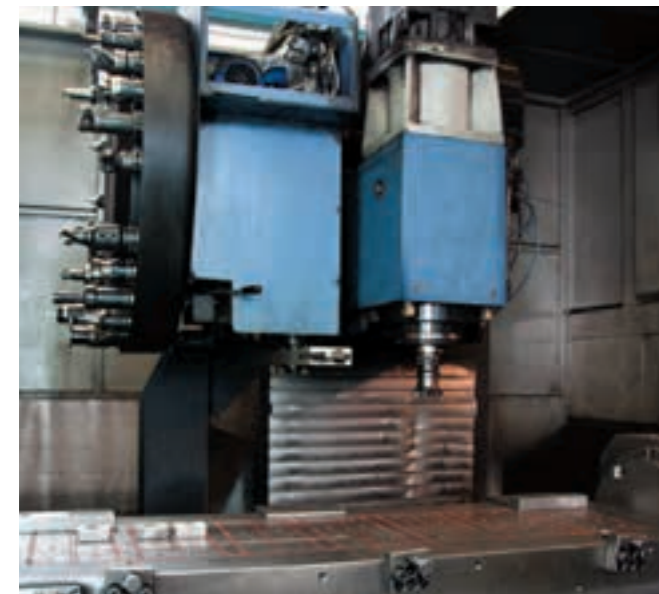


Our Machine Park

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.

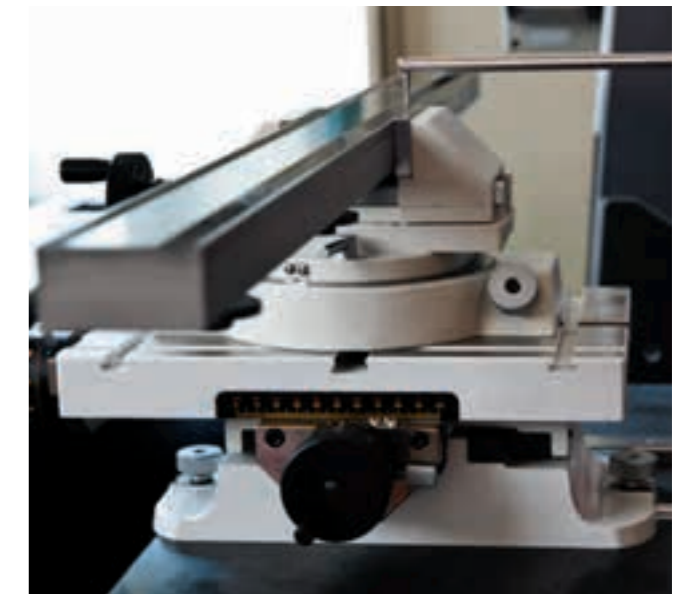
For more resistance strength the hardening of the surfaces can be increased. The depth of the hardening must be at least 3 mm to avoid deformations. We use the electromagnetic technique also known as induction hardening to the best quality for your money's worth.



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 measurements (angle, radius, hardening, etc.) is possible. This step is happens after quality control.

Individual markings are upon request possible.



EDM Wire

By using EDM wire, hardened and very tough material can be retrofitted. The process is operated based on a CAD-system which can also process high dimensions such as special shapes.

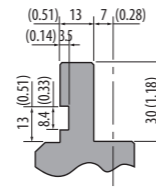
ROLLERI MODIFICATIONS

... 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

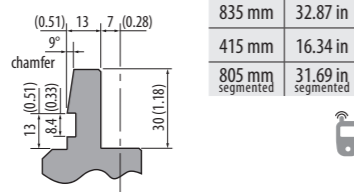
Standard Rolleri Type R1



Fast delivery on these items guaranteed. Please note that delivery terms vary according to your location.

OT

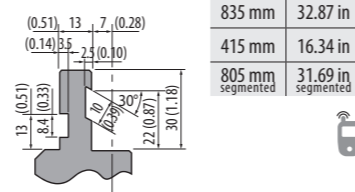
- Modification for:
- for Amada fast clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A1

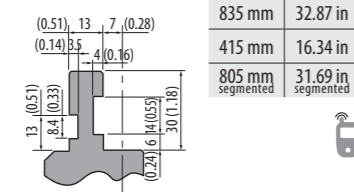
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- pneumatic clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A6

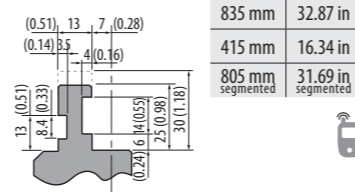
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- Rolleri Type R3
 - Bystronic-Beyeler Euro
 - Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A7

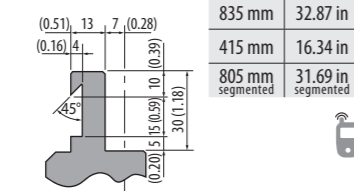
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
- Rolleri Type R3
 - Bystronic-Beyeler Euro
 - Safan



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A8

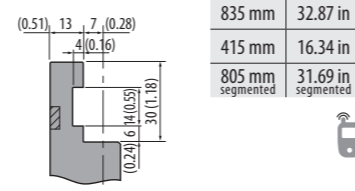
- Groove Bar/Tail for:
- hydraulic clamping system Gasparini



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A41

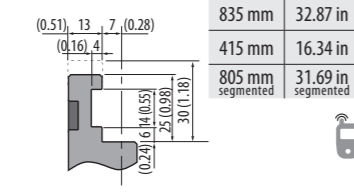
- older clamping system



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A42

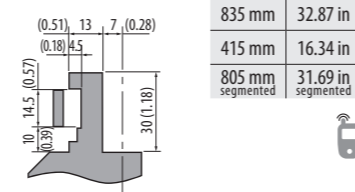
- older clamping system



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



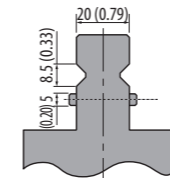
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

ROLLERI MODIFICATIONS

... for standard tangs

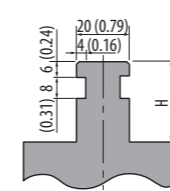


Standard Rolleri Type R2

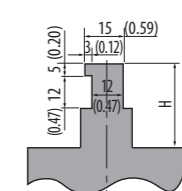


Modification examples Type R2

production according to your specifications

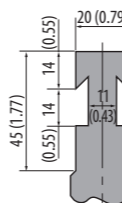


production according to your specifications



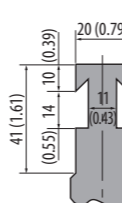
Take advantage of your existing tools with means of modifications.

Standard Rolleri Type R3

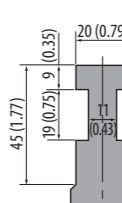


Modification examples Type R3

production according to your specifications



production according to your specifications



ROLLERI MODIFICATIONS

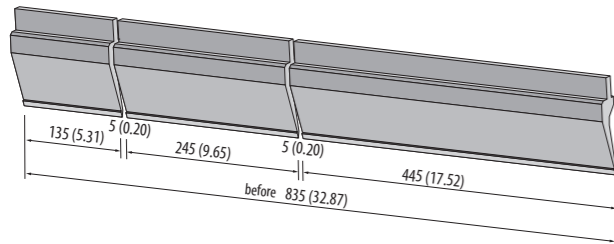
Special Sectioning

- Individual sectioning of your punches and dies
- fast, economic, percise

Pro separation cutting causes a decrease in length of approx. 5 mm

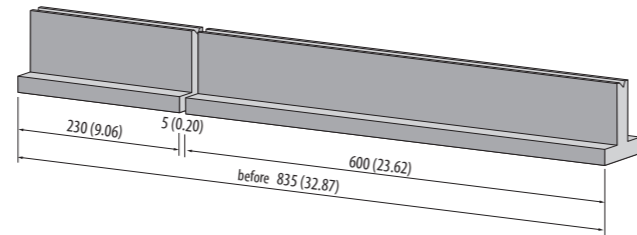
Special Sectioning of Punches

Example of punches production according to your specifications



Special Sectioning of Dies

Example of Dies production according to your specifications

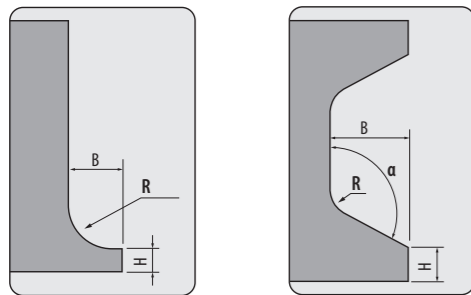


Horn Pieces

- individual horn pieces on punches and dies
- on one or both sides
- fast, economic, percise

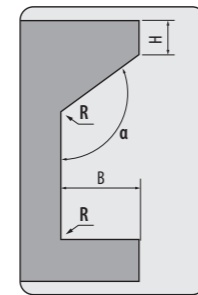
Horn Pieces for Punches

Punch example production according to your specifications



Horn Pieces for Dies

Die example production according to your specifications

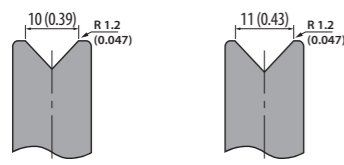


Modifying the V-Opening

- individual modification for dies
- fast, economic, percise

Modifying the V-Opening

Example production according to your specifications



Give us a call for more information!

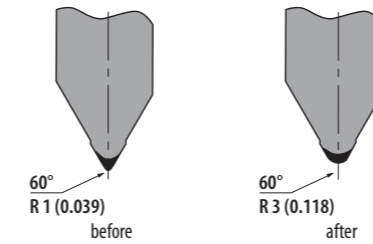
ROLLERI MODIFICATIONS

Radius and Angle Modifications

- Individual modifications of your punches and dies
- fast, economic, percise

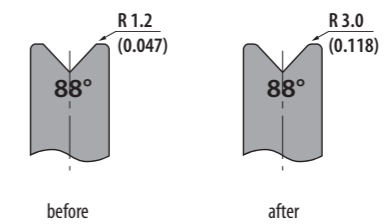
Radius Modifications for Punches

Radii modification Punch example production according to your specifications



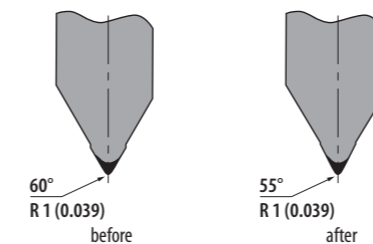
Radius Modifications for Dies

Opening Radius modification die example production according to your specifications



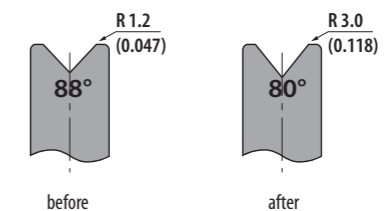
Angle Modification Punches

Angle modification punch example production according to your specifications



Angle Modification Dies

Angle modification die example production according to your specifications

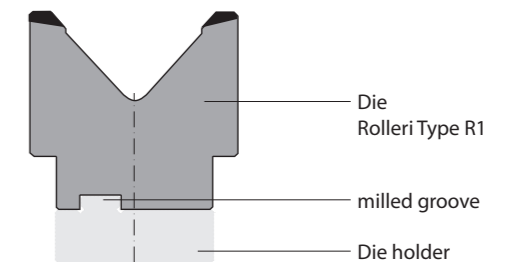


Grooves for Dies

- Milling of grooves for use on other press brake systems
- fast, economic, percise

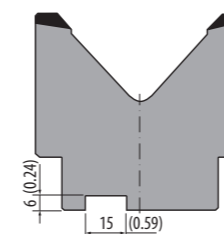
Delivery within 3 business days. Upon concordance even faster!

Mounting example



A28

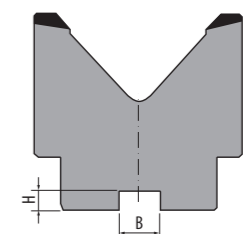
Groove for die holder



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A29

groove production according to your specifications



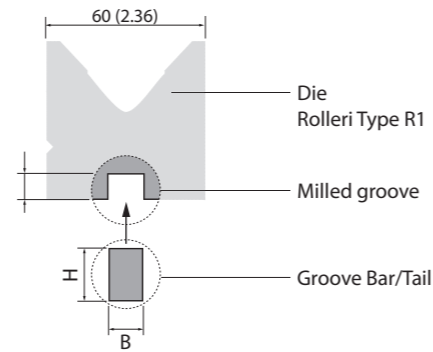
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

ROLLERI MODIFICATIONS

Grooves und Groove Bars/Tails for Dies

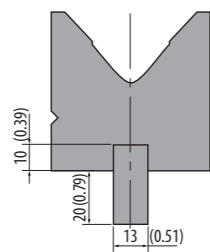
- For milling of the groove and the insert of a ground groove bar/tail the exact measurement is needed to use on other press brake systems
- fast, economic, percise

Mounting example



A30

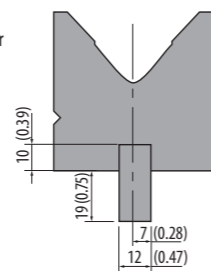
Groove Bars/Tails:
13 x 30 mm (0.51 x 1.18 in) for
• Roller Type R2
• Roller Type R3



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A31

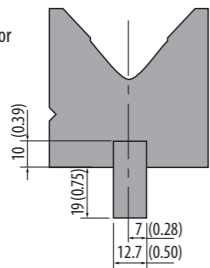
Groove Bars/Tails:
12 x 29 mm (0.47 x 1.14 in) for
• Roller Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A32

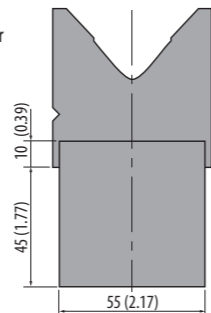
Groove Bars/Tails:
12.7 x 29 mm (0.50 x 1.14 in) for
• Roller Type RX LVD



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A44

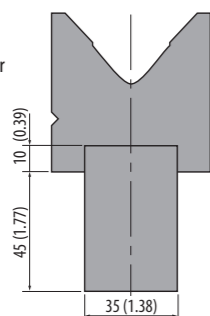
Groove Bars/Tails:
55 x 55 mm (2.17 x 2.17 in) for
• Roller Type RX EHT



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

A45

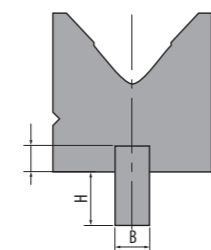
Groove Bars/Tails:
35 x 55 mm (1.38 x 2.17 in) for
• Roller Type RX Weinbrenner



835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

AX

individual Groove Bars/Tails
for other systems

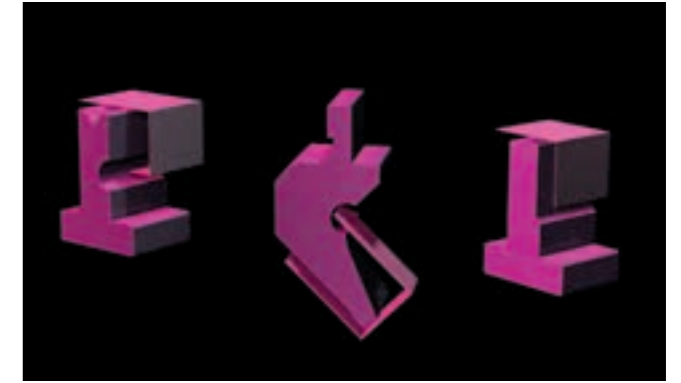


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

ROLLERI MODIFICATIONS

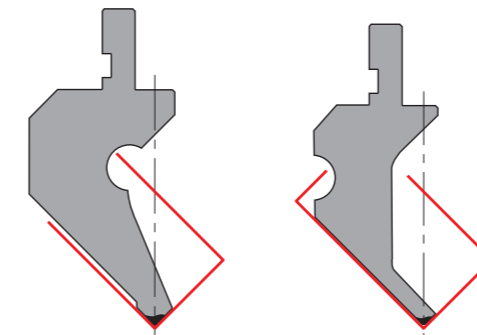
Gaps and Windows

- The retrofitting of the tool edges of long parts, short U-profiles and similar
- fast, economic, percise



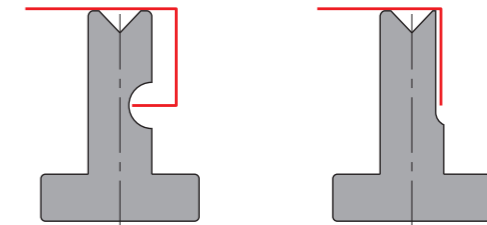
Gaps on Punches

Example Punches
production according to your specifications



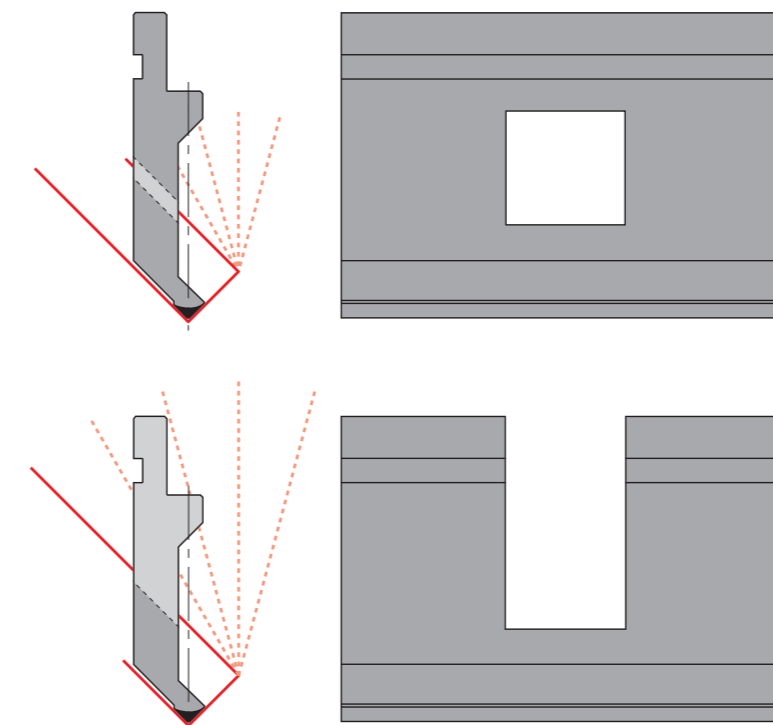
Gaps on Dies

Example Dies
production according to your specifications



Windows for Punches

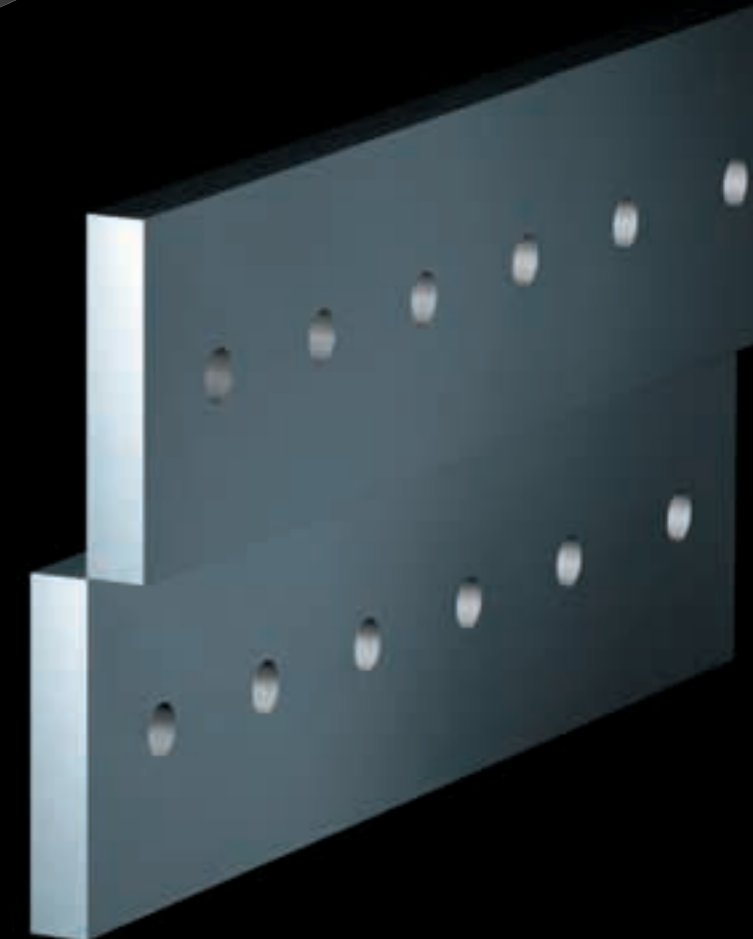
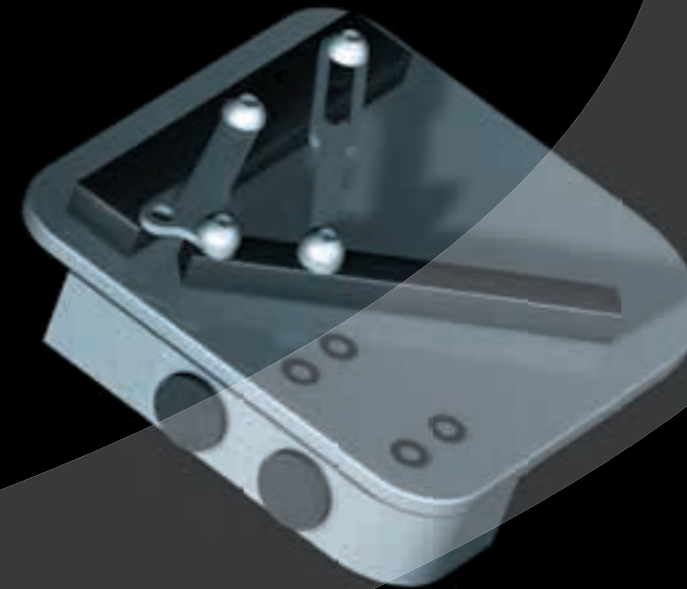
Example Punches
production according to your specifications



For Roller BLACKFIRE
see page 243

ROLLERI SHEAR BLADES AND ACCESSORIES

Tooling Cabinets	256 - 257
Tool Trolley	258
Bending Box	258
Squaring Arms	259
Supporting Arms	260
Back Gauge	260
Shear Blades	260 - 261



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



ARM 835-4 for max. tool length = 835 mm (32.87 in)



850 x 1240 x 1050 (W x H x D)
33.46 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1
approx. 20 m (787.40 in)
Storage capacity



Equipment	
4 Drawers	vertical, on wheels (see CS-1)
16 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
4 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	271.0 kg

ARM 835-5 for max. tool length = 835 mm (32.87 in)



1040 x 1240 x 1050 (W x H x D)
40.94 x 48.82 x 41.34 (W x H x D)

for Tools Roller Type R1
approx. 25 m (984.25 in)
Storage capacity



Equipment	
5 Drawers	vertical, on wheels (see CS-1)
20 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
5 Shelves	for type R1 with 13 mm (0.51 in) tangs (see shelves UL-13-3)
Weight	350.0 kg

ARM 1060-4 / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)
33.46 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3
approx. 26 m / 39 m (1023.62 in /
1535.43 in) Storage capacity



Equipment ARM 1060-4	
4 Drawers	vertical, on wheels (see CS-2)
16 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
4 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	340.0 kg

Equipment ARM 1060-4-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	351.0 kg

ARM 1060-5 / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)
40.94 x 48.82 x 53.54 (W x H x D)

for Tools Roller Type R2/R3
approx. 32.5 m / 52 m (1279.52 in /
2047.24 in) Storage capacity



Equipment ARM 1060-5	
5 Drawers	vertical, on wheels (see CS-2)
20 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-2)
5 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	400.0 kg

Equipment ARM 1060-5-CV	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
30 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UC-20-1)
10 Shelves	for type R2/R3 with 20 mm (0.79 in) tangs (see shelves UL-20-4)
Weight	490.0 kg

ROLLERI ACCESSORIES

Tool Cabinets



ARM 1060-4-T / -CV for max. tool length = 1060 mm (41.73 in)



850 x 1240 x 1360 (W x H x D)
33.46 x 48.82 x 53.54 (W x H x D)

for tools Roller Type R2/R3
approx. 20.8 m / 31.2 m (818.89 in /
1228.34 in) Storage capacity



Equipment ARM 1060-4-T	
4 Drawers	vertical, on wheels (see CS-2)
8 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	383.0 kg

Equipment ARM 1060-4-T-CV	
4 Drawers	vertical, on wheels (see CS-2), incl. 2 Drawers with separators (see CV)
16 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	360.0 kg

ARM 1060-5-T / -CV for max. tool length = 1060 mm (41.73 in)



1040 x 1240 x 1360 (W x H x D)
40.94 x 48.82 x 53.54 (W x H x D)

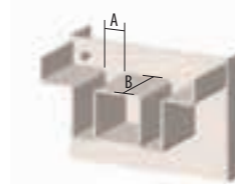
for tools Roller Type R2/R3
approx. 26 m / 41.6 m (1023.62 in /
1637.79 in) Storage capacity



Equipment ARM 1060-5-T	
5 Drawers	vertical, on wheels (see CS-2)
10 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UL-13-4)
10 Shelves	for type R2/R3 (see shelves UT-4)
Weight	447.0 kg

Equipment ARM 1060-5-T-CV	
5 Drawers	vertical, on wheels (see CS-2), incl. 3 Drawers with separators (see CV)
24 Shelves	for type R2/R3 with 13 mm (0.51 in) tangs (see shelves UC-13-1)
8 Shelves	for type R2/R3 (see shelves UT-4)
Weight	500.0 kg

UC-Shelves



Model	L mm (in)	A mm (in)	B mm (in)	Weight
UC-13-1	125 (4.92)	13 (0.51)	76 (2.99)	0.5 kg
UC-13-2	250 (9.84)	13 (0.51)	232 (9.13)	1.0 kg
UC-20-1	125 (4.92)	20 (0.79)	76 (2.99)	0.5 kg
UC-20-2	250 (9.84)	20 (0.79)	232 (9.13)	1.0 kg

2 pieces

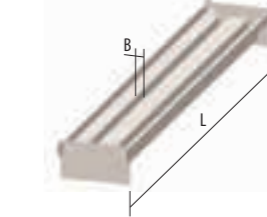
UT-Shelves



Model	L (mm)	L (in)	Weight
UT-1	270	10.63	1.4 kg
UT-2	580	22.83	3.2 kg
UT-3	1050	41.34	5.8 kg
UT-4	1360	53.54	7.5 kg

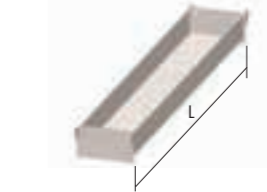
enough room for punches with safety pins

UL-Shelves



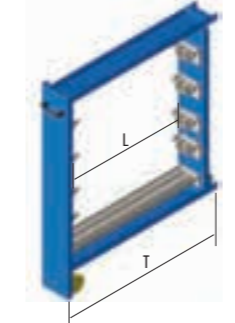
Model	L mm (in)	B mm (in)	Weight
UL-13-1	270 (10.63)	13 (0.51)	1.2 kg
UL-13-2	580 (22.83)	13 (0.51)	2.5 kg
UL-13-3	1050 (41.34)	13 (0.51)	4.6 kg
UL-13-4	1360 (53.54)	13 (0.51)	6.0 kg
UL-20-1	270 (10.63)	20 (0.79)	1.4 kg
UL-20-2	580 (22.83)	20 (0.79)	3.2 kg
UL-20-3	1050 (41.34)	20 (0.79)	5.8 kg
UL-20-4	1360 (53.54)	20 (0.79)	7.5 kg

UV-Shelves



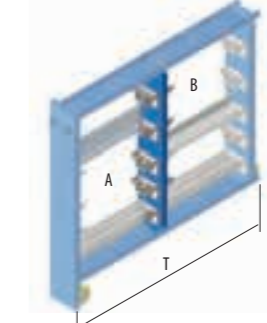
Model	L (mm)	L (in)	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg

CS-Drawers



Model	T mm (in)	L mm (in)	Weight
CS-1	1050 (41.34)	856 (33.70)	22.0 kg
CS-2	1360 (53.54)	1166 (45.91)	25.0 kg

CV-Dividers



Model	T mm (in)	A mm (in)	B mm (in)	Weight
CV-1	1050 (41.34)	580 (22.83)	270 (10.63)	7.0 kg
CV-2	1360 (53.54)	580 (22.83)	580 (22.83)	7.0 kg

ROLLERI ACCESSORIES

Tool Trolley

Our Advantages – Your Convenience

- faster access
- robust construction
- clear and tidy storage
- visibility of tools

Tool Trolleys

Model	Content	Tool System	Weight
A Trolley	30 Shelves	for R1 tools	108.0 kg
T Trolley	21 Shelves	for R2 tools	175.0 kg
B Trolley	21 Shelves	for R3 tools	135.0 kg



Rolleri Videos

Secure storage and mobility:
www.rolleritools.com/videos/tool-trolley



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



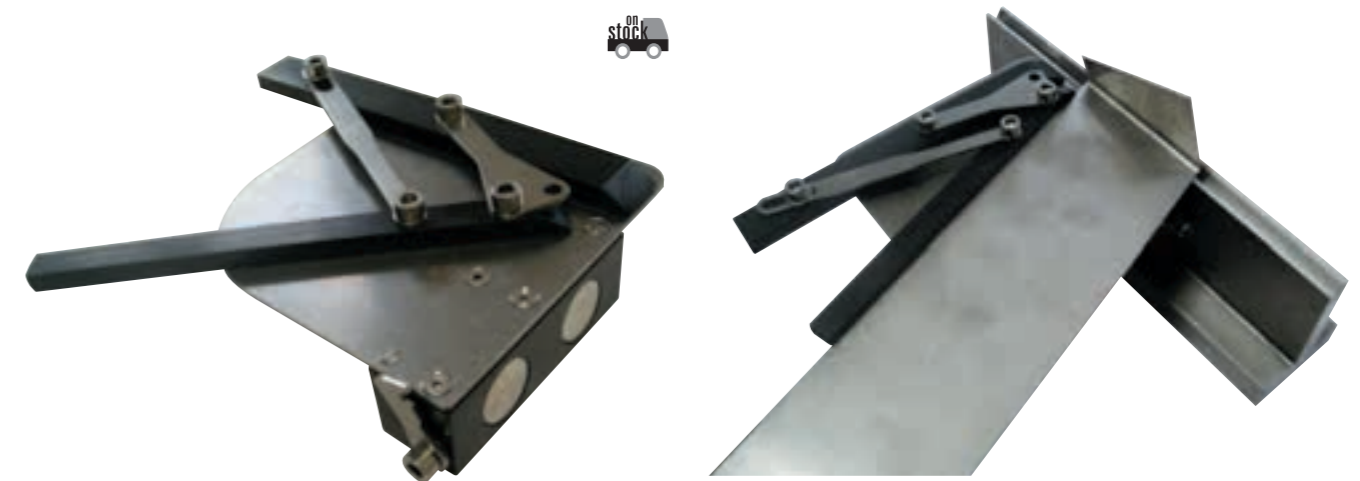
Rolleri Videos

Magnetic Squaring Arms :
www.rolleritools.com/videos/squaring-arms



MSA – magnetic

MSA.D (right)	per piece	1.4 kg
MSA.S (left)	per piece	1.4 kg



Bending Box

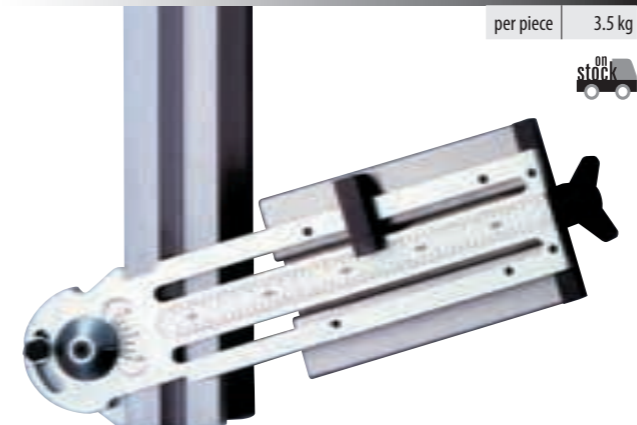
Bending Box



per piece 1.6 kg



AS



per piece 3.5 kg



Give us a call for more information!

ROLLERI ACCESSORIES

Supporting Arms and Back Gauge

RIF-Supporting Arm

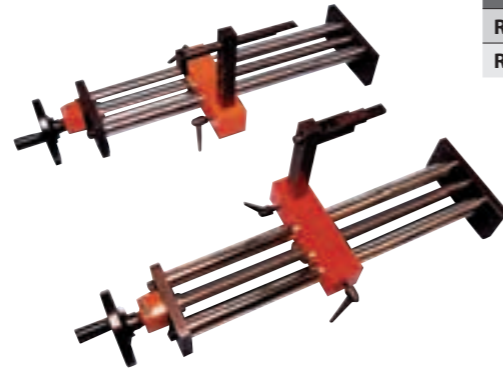
Model	Length mm (in)		Weight
RIF500	500	(19.68)	7.0 kg
RIF1000	1000	(39.37)	12.0 kg
RIF1500	1500	(59.05)	17.0 kg



- for secure support for high volume sheet metals
- greater surface guarantees a trouble-free support for sheet metals
- easy handling

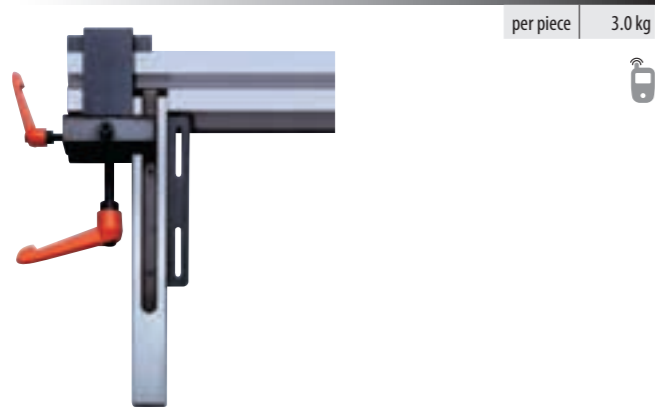
RP-Back Gauge

Model	Weight
RP500A	8.0 kg
RP500B	8.0 kg



- ensures for the correct positioning of tools on the press brake and secures herewith the exact border distance.
- fast and exact repeatability
- easy handling

AS FIX



per piece 3.0 kg

Shear Blades

We manufacture in our company over more than 20 years shear blades.

High-quality steels are finished according to your specifications.

New production and retrofitting service: fast, economic, precise!

Please provide us with the following information:

- What material are you cutting with your machines: Steel, Stainless Steel, Aluminium, etc.
- How thick is the material in diameter?
- How often to you use your cutting machine? (per hour, day, week)
- How many upper and lower shear blades are needed?

ROLLERI SHEAR BLADES

Shear Blades



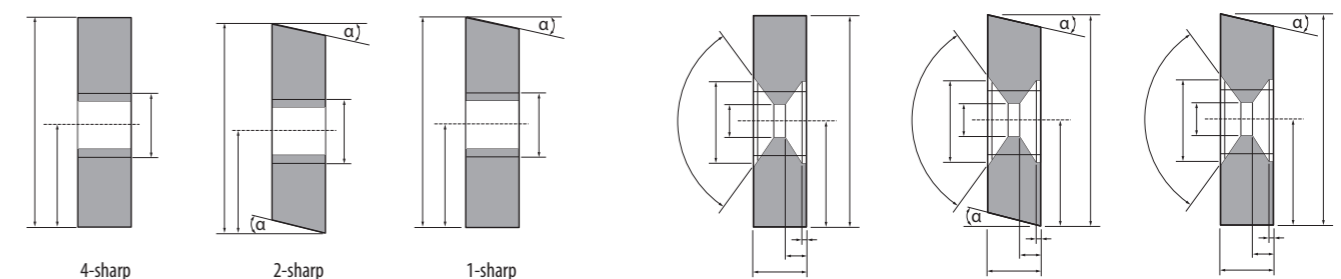
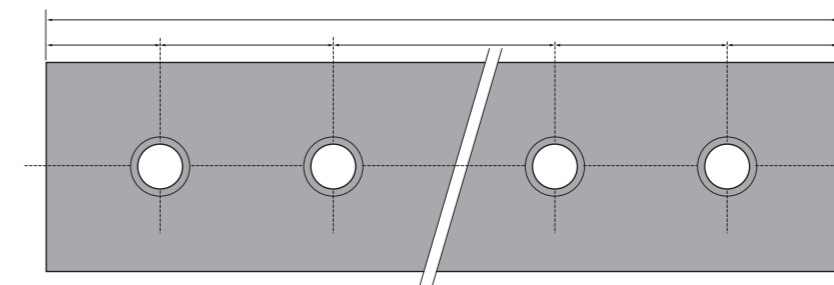
Our Advantages – Your Convenience

- 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)				

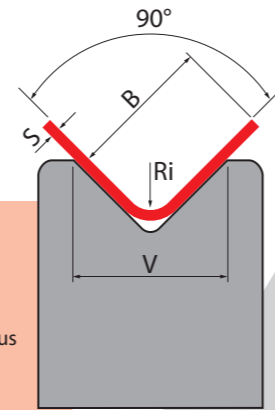


Press Force Table

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 ²																			
S (mm)		4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
		3.0	3.5	4.0	5.5	6.5	8.0	10.5	13.0	16.5	21.0	26.0	32.5	41.0	52.0	65.0	81.5	104.0	130.0	163.0	B
		0,5	0,7	0,8	1,0	1,3	1,5	2,0	2,5	3,2	4,4	5,0	6,5	8,0	10,0	12,0	15,0	20,0	25,0	37,0	Ri
0.6		60	50	30	20																
0.8		120	90	70	50	40															
1.0			150	110	80	60	50														
1.2				180	120	90	70	50													
1.5					210	150	120	80	60												
2.0						300	230	160	120	90											
2.5							390	270	200	140	110										
3.0								430	310	230	160	120									
4.0									600	440	320	230	180								
5.0										760	540	390	290	220							
6.0											850	620	450	330	250						
8.0												1210	880	700	460	350					
10.0													1510	1090	790	580	440				
12.0														1730	1240	910	660	500			
15.0															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 ²	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm ²	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm ²	r x 1.4	INOX

www.rolleritools.com

Visit us on our website and take advantage of:

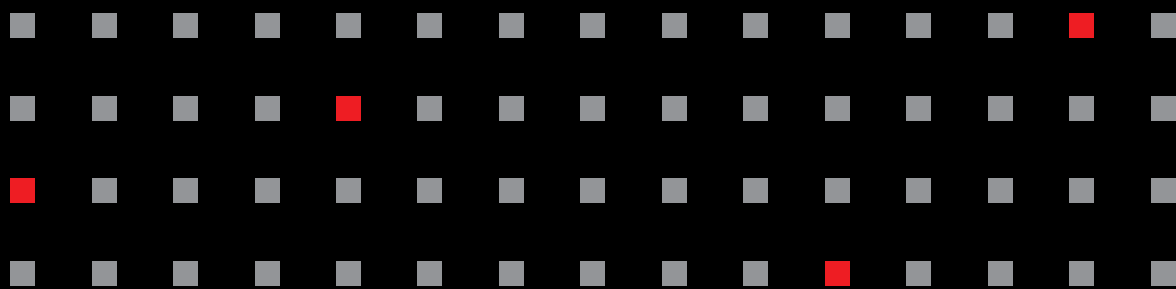
- drawings 1:1 format available
- extra information and tips
- helpful videos and application examples
- easy website browsing



Copyright: The use of Roller Publications and national adoptions of Roller Publications is subject to the user's acceptance of Roller's terms of use and conditions of copyright for Roller publications, as set out below.

All Roller Publications and national adoptions thereof are protected by copyright. Therefore and unless otherwise specified, no part of an Roller Publication or a national adoption thereof may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying, microfilm, and scanning, without permission in writing from the publisher.





www.rolleritools.com



ROLLERI®
PROFESSIONAL
BENDING

Rolleri S.p.A.

Via Artigiani Cabina · 29020 Vigolzone (PC) – Italia

Tel. +39 05 23 87 09 05

Fax +39 05 23 87 90 30

E-Mail sales@rolleri.it

Web www.rolleri.it