



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

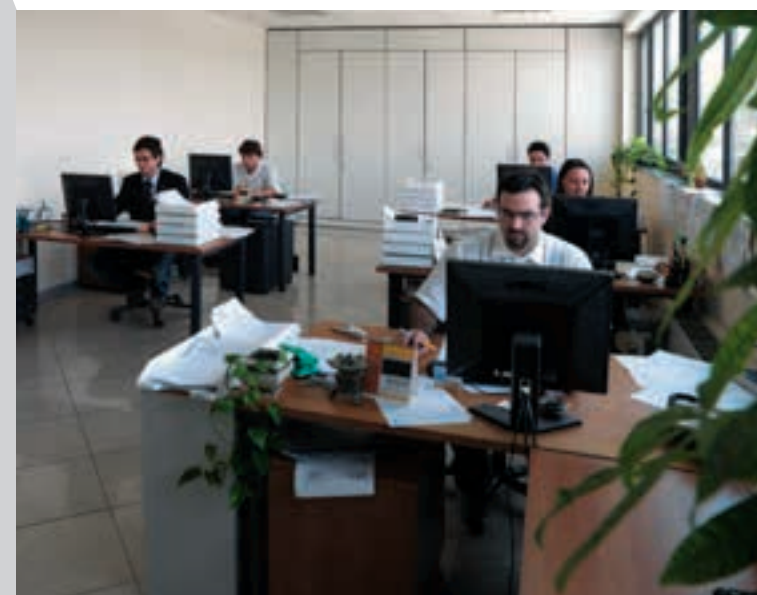
The Rolleri team is made up of all ages. We are innovative, dynamic and experienced, with consistency and harmony. Our mission is to bring you the best results in tool production. At Rolleri teamwork is the key to achieve outstanding customer service, research and development, great warehouse efficiency,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

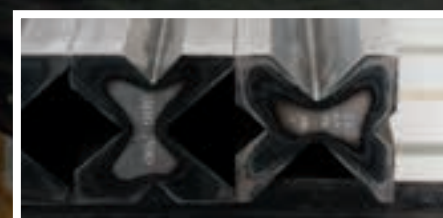
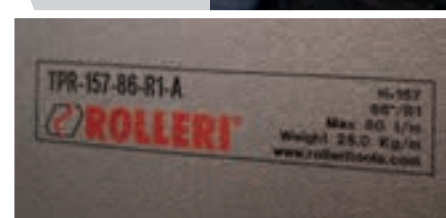


THE QUALITY CONTROL

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.



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 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.



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, Iturrospe, 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 R3

Content Explanation	122 - 123
Punches Bystronic-Beyeler RFA	124 - 125
Punches Bystronic-Beyeler RF	125
Hemming Punches Bystronic-Beyeler RFA	126
Punches Bystronic-Beyeler R	127
Punches Bystronic-Beyeler S	128
Punch adapters	129
Z-Profile Tools	130 - 131
Radius Tools	132 - 133

Compatibility

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

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

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

Compatibility

Punches RollerI Type R3 are:

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

Our Advantages – Your Convenience

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

Material

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

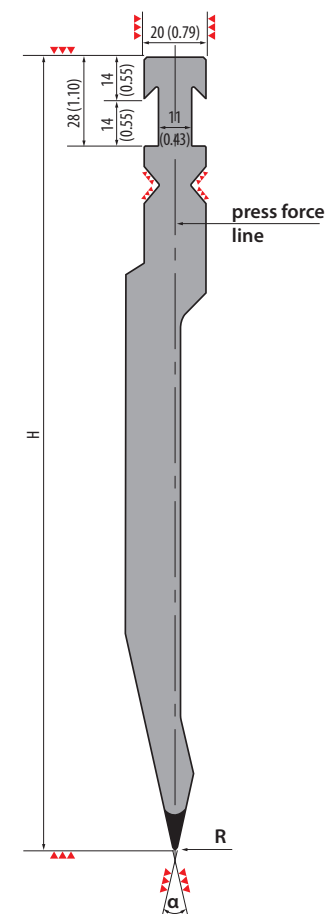
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm ²	12 - 15.5 HRC	54 - 60 HRC

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

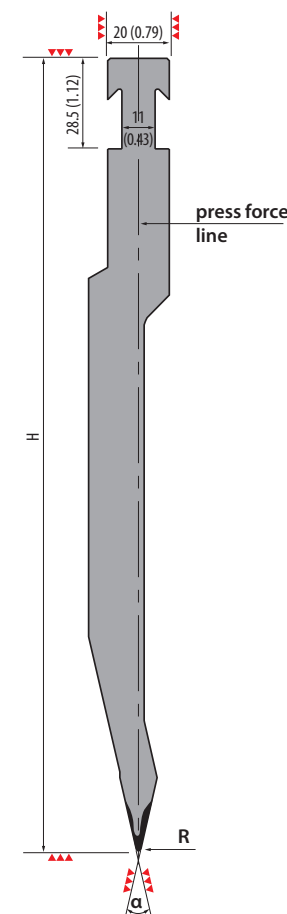
Tang

Punches RollerI Type R3 have the following tangs:

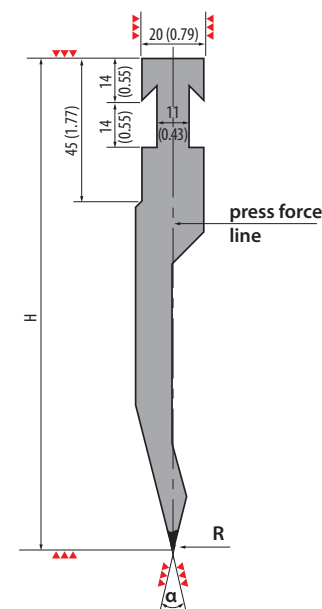
Bystronic-Beyeler RFA



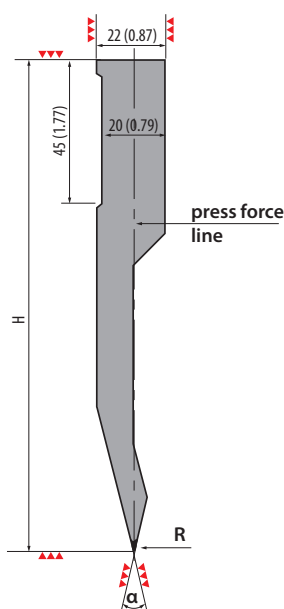
Bystronic-Beyeler RF



Bystronic-Beyeler R



Bystronic-Beyeler S

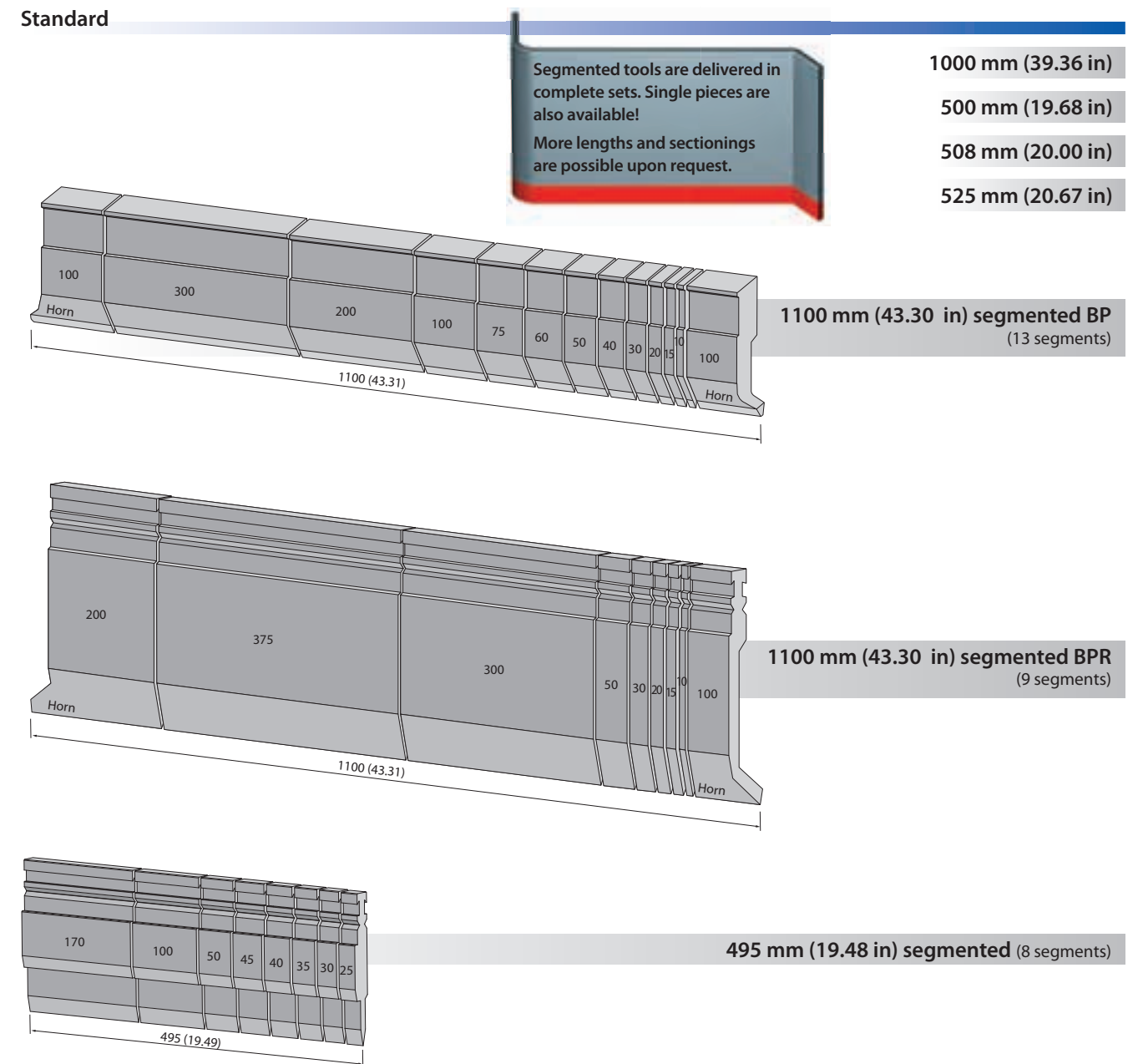


Indications of precision ground surfaces:

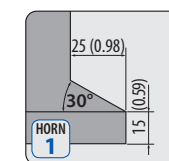


Tool lengths and sectioning

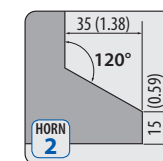
Standard



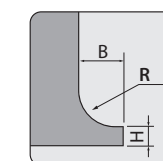
Horn Types



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



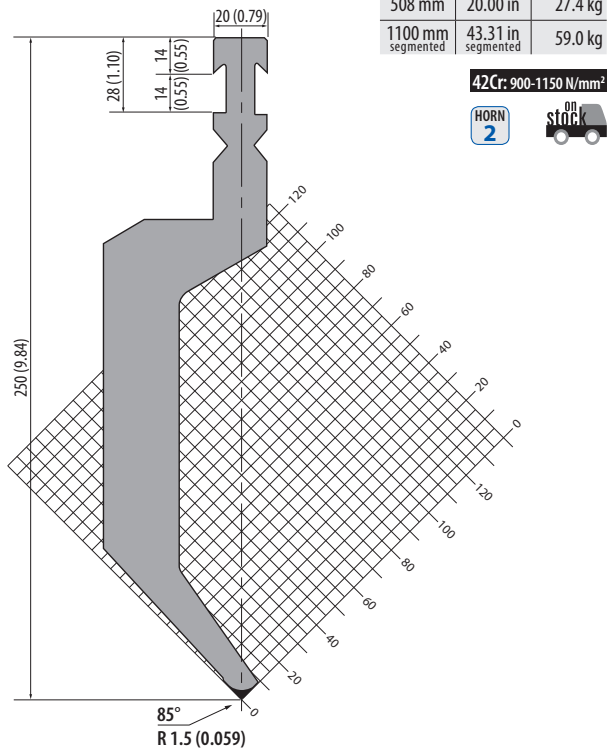
Horn 2
Standard BPR
for all segm.
Punches BPR
Rolleri Type R3



Individual Horn
production
according
to your
specifications

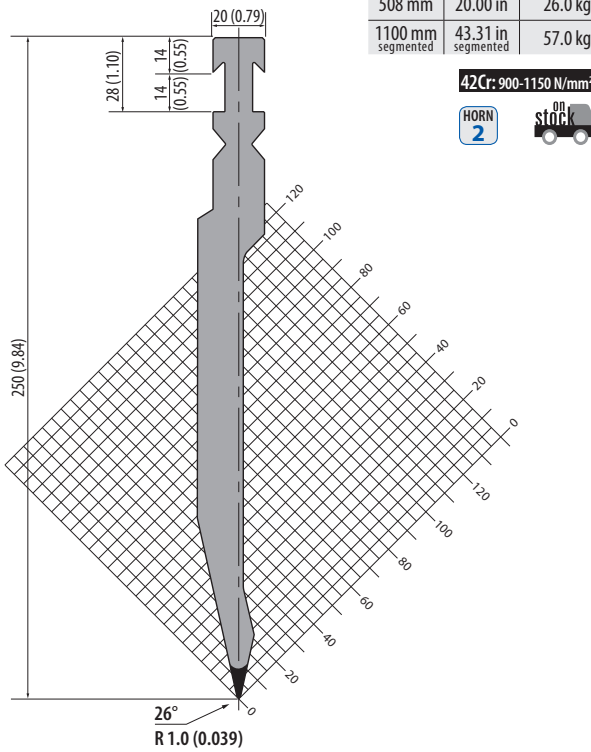
BPR250.P4-RFA

900 kN/m max.



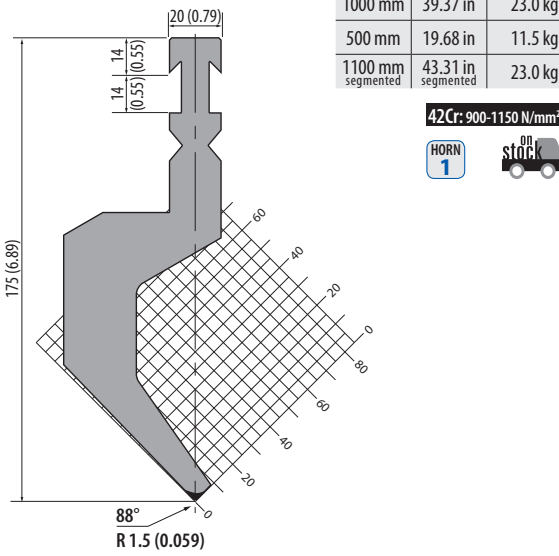
BPR250.P5-RFA

1000 kN/m max.



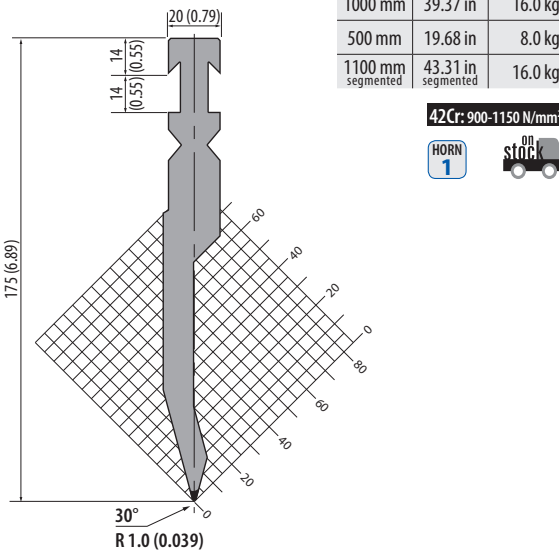
BP175.88.R15-RFA

500 kN/m max.



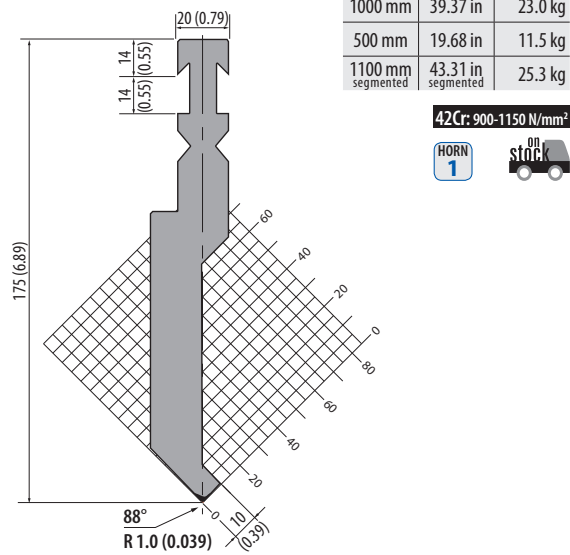
BP175.30.R1-RFA

800 kN/m max.



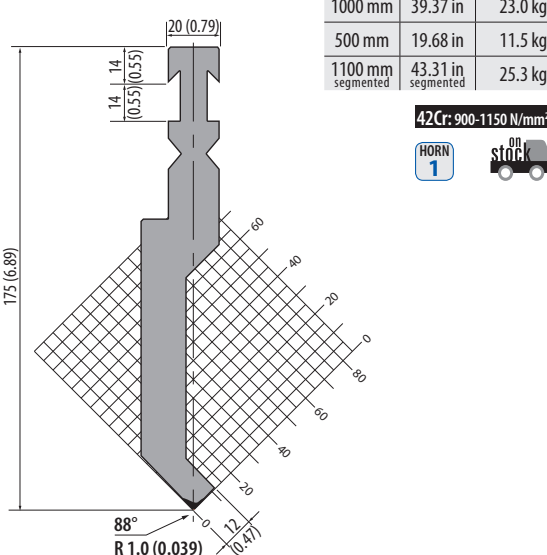
BP175.88.R1-A-RFA

1000 kN/m max.



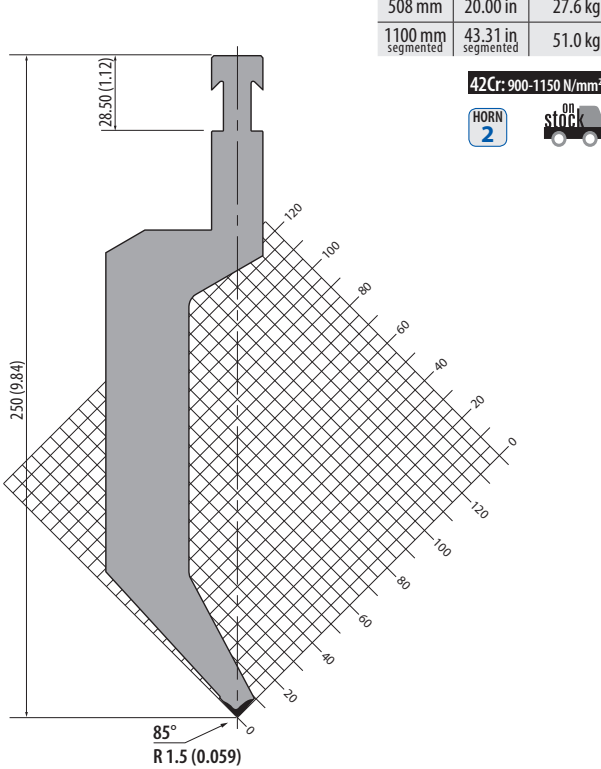
BP175.88.R1-B-RFA

1000 kN/m max.



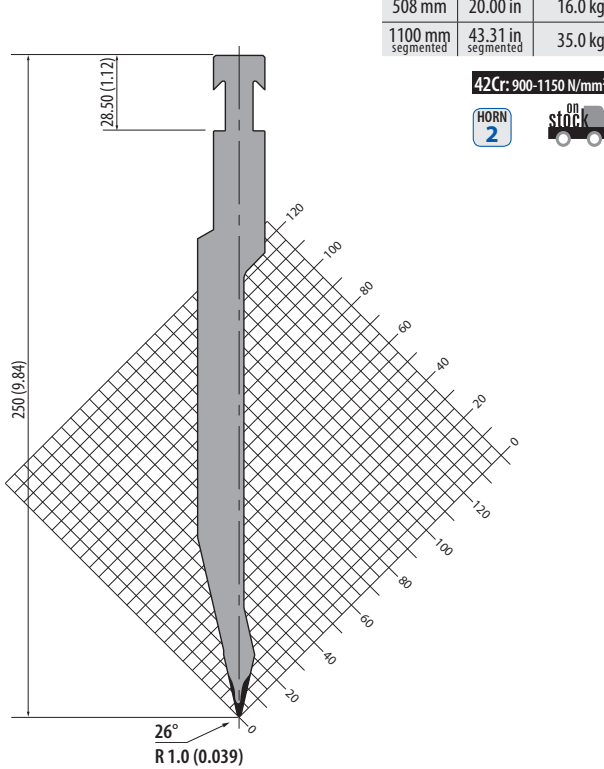
BPR250.P4-RF

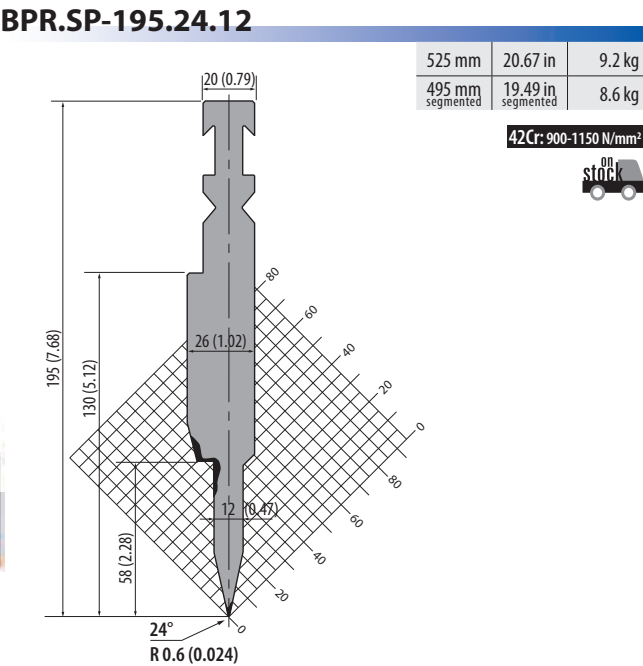
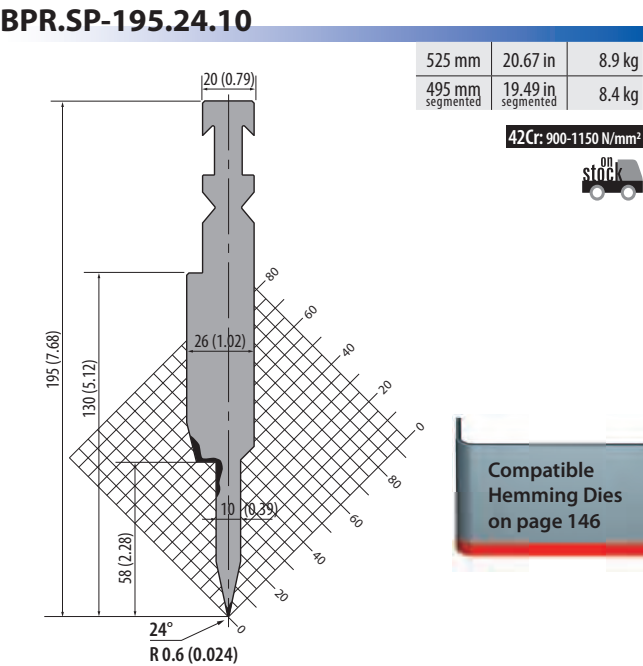
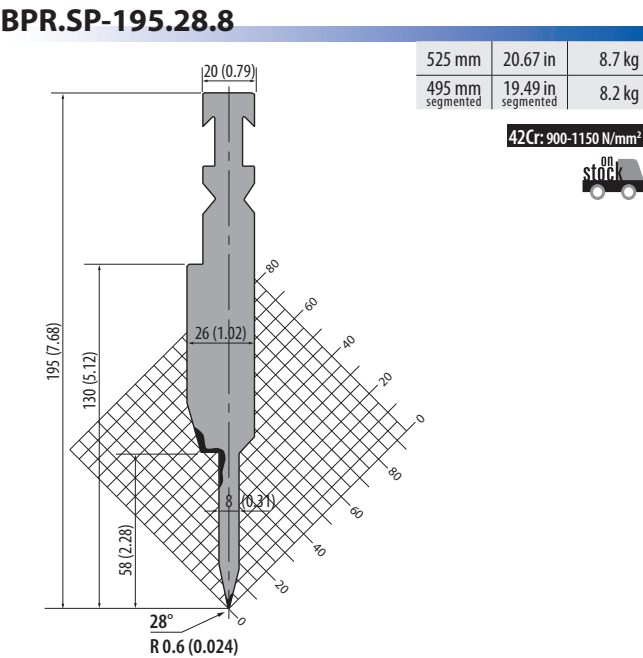
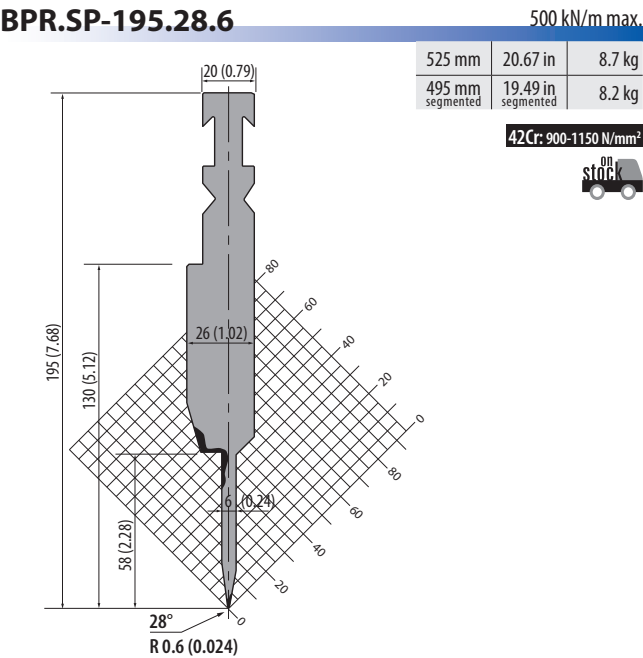
1000 kN/m max.



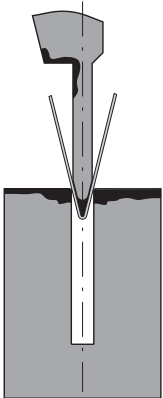
BPR250.P5-RF

900 kN/m max.

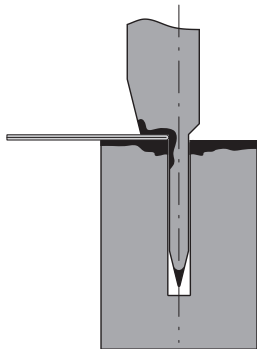




Example of Application

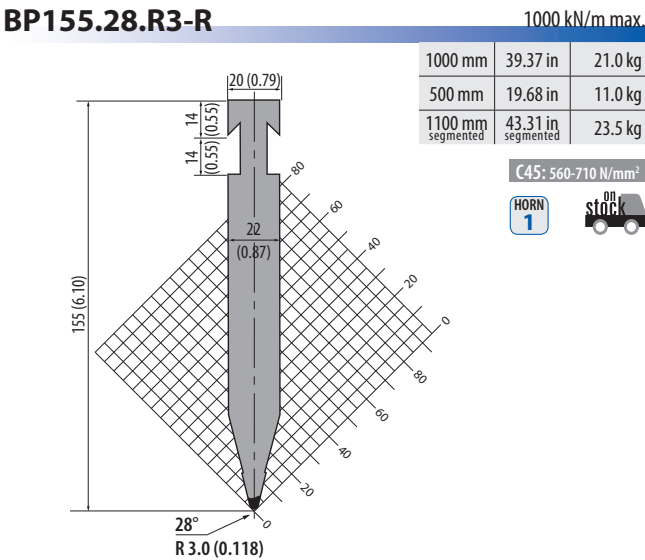
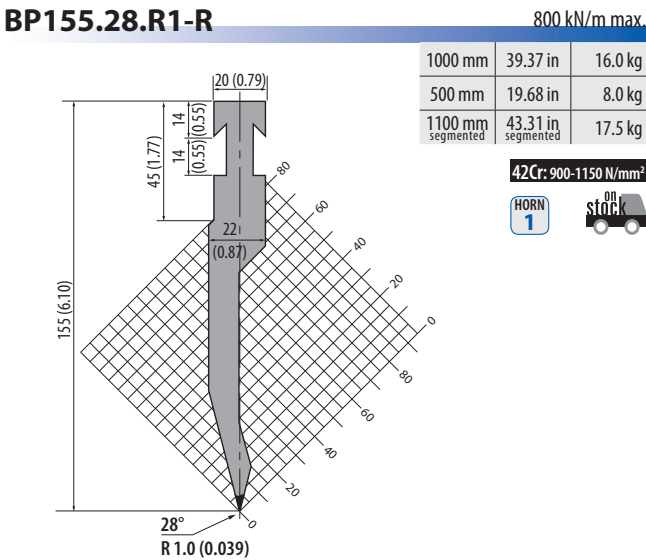
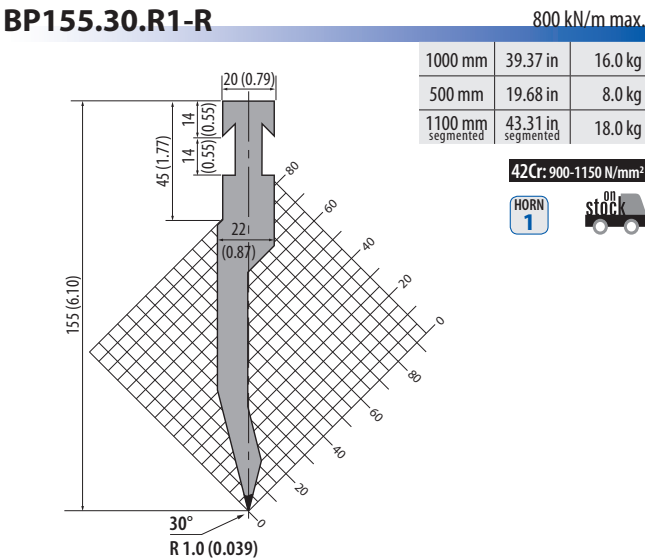
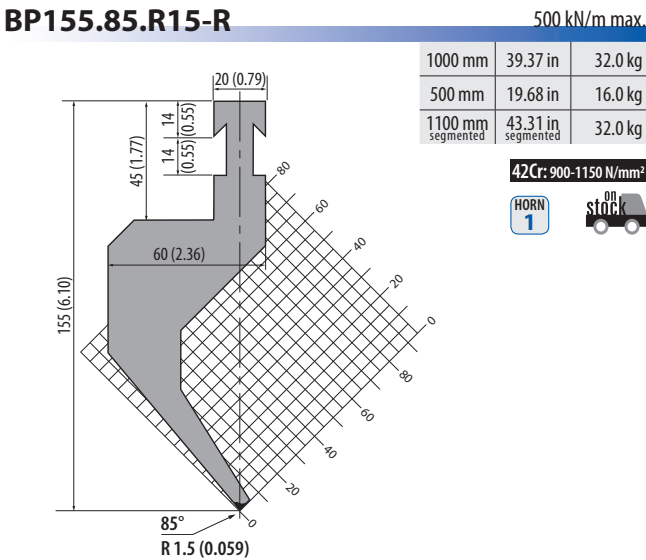
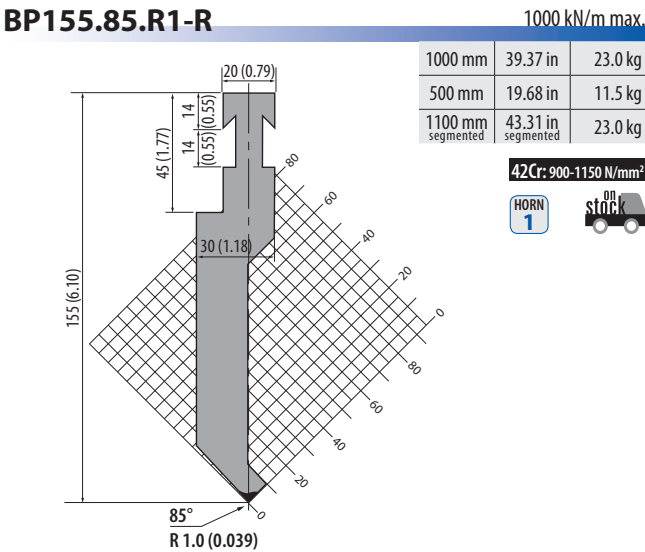
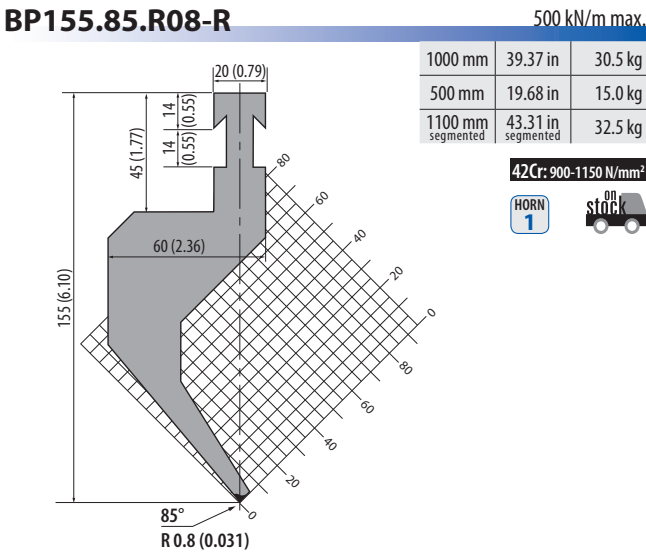


800 kN/m max.



1000 kN/m max.

S	S	A	A	R.45	R.70	S	S	A	A	R.45	R.70
mm	in	mm	in	Kg/mm ²	t/m	mm	in	mm	in	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



BP155.85.R08-S

500 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1

ON STOCK

BP155.85.R1-S

1000 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1

ON STOCK

BP155.85.R15-S

500 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1

ON STOCK

BP155.30.R1-S

800 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1

ON STOCK

BP155.28.R1-S

800 kN/m max.

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

42Cr: 900-1150 N/mm²

HORN 1

ON STOCK

BP155.28.R3-S

1000 kN/m max.

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

C45: 560-710 N/mm²

HORN 1

ON STOCK

AD3

1000 kN/m max.

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

C45: 560-710 N/mm²

ON STOCK

AD10

1000 kN/m max.

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

C45: 560-710 N/mm²

ON STOCK

AD22

1000 kN/m max.

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

C45: 560-710 N/mm²

ON STOCK

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



BPZ-RFA

1000 kN/m max.

835 mm32.87 in37.5 kg

415 mm16.34 in18.7 kg

C45: 560-710 N/mm²

BPZ-R

1000 kN/m max.

835 mm32.87 in24.7 kg

415 mm16.34 in12.3 kg

C45: 560-710 N/mm²

BPZ-S

1000 kN/m max.

835 mm32.87 in37.5 kg

415 mm16.34 in18.5 kg

C45: 560-710 N/mm²

Rolleri Videos

find updated and helpful videos at:

www.rolleritools.com/videos/overview

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

1000 kN/m max.

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

C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

Z-Profile Inserts 90°

1000 kN/m max.

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

C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

BPR150.P10.10-RFA

1000 kN/m max.

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

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

42Cr: 900-1150 N/mm²

BPR150.P10.15-RFA

1000 kN/m max.

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

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

42Cr: 900-1150 N/mm²

BPU-RFA

800 kN/m max.

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

C45: 560-710 N/mm²

BPU-R

800 kN/m max.

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

C45: 560-710 N/mm²

BPU-S

800 kN/m max.

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

C45: 560-710 N/mm²

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

800 kN/m max.

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

C45: 560-710 N/mm²

Radius Tools: R10-40

1000 kN/m max.

Material: C53 induction hardened 60-62HRC

C53: 610-760 N/mm²

Model	R mm	R in	Weight	Weight
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.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 segmented
495 mm / 16.34 in segmented

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

Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.

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

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

C45: 560-710 N/mm²

DIES ROLLERI TYPE R3

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

Compatibility

Dies **Rolleri Type R3** are **compatible** with press brake machines from:

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

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

Compatibility

Dies Roller Type R3 are:

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

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

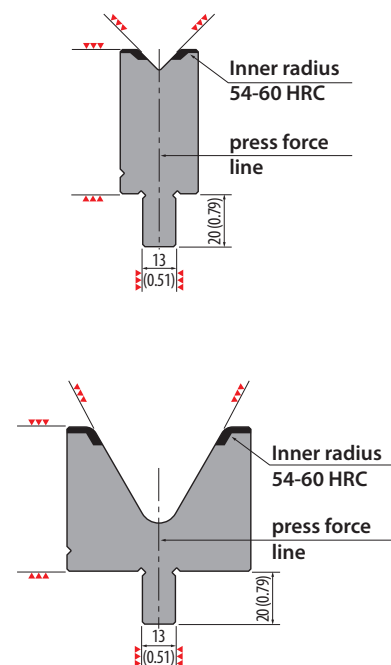
- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

Tang

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

Indications of precision ground surfaces:

▼▼▼



Our Advantages – Your Convenience

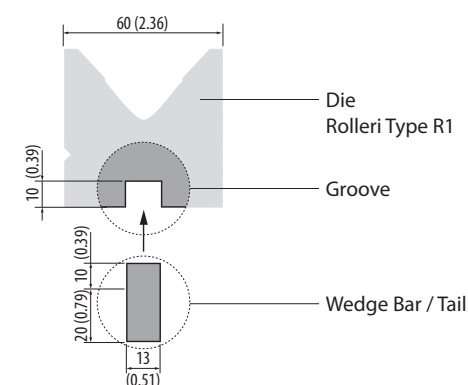
- own production facilities (no reseller or dealer)
- tracking of every tool possible, with a unique **serial number** on every article after the quality control check
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height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

Modification: Wedge Bar / Tail

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

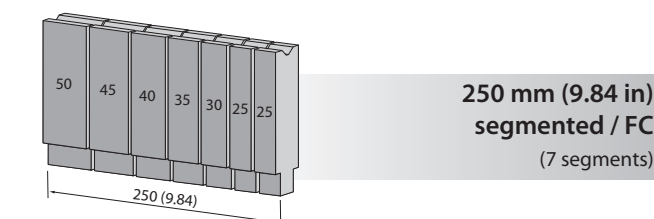
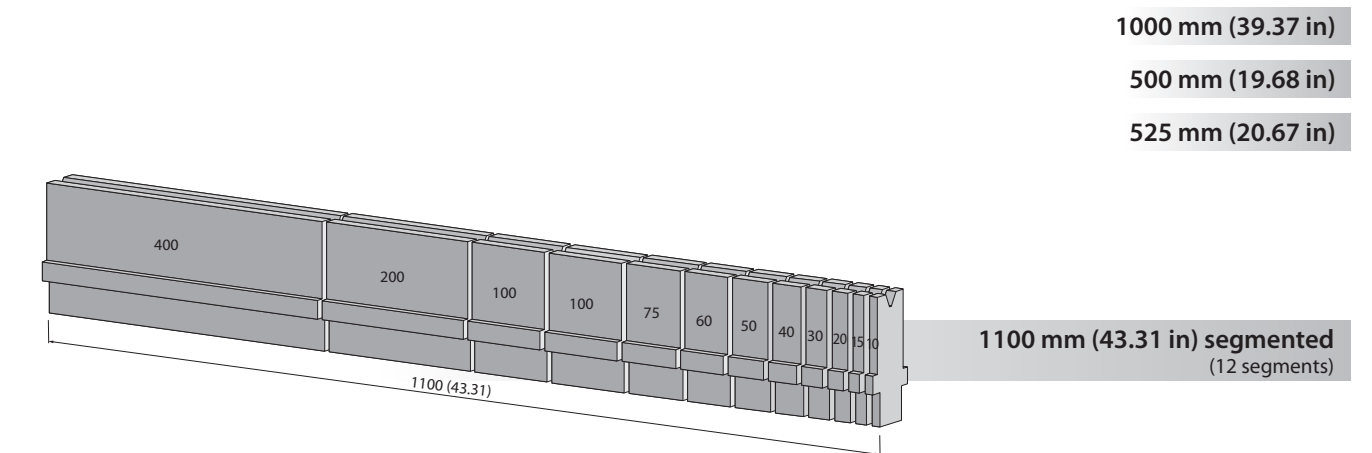
For more specific information and prices go to page 252 in the Service Chapter.

Example of Application

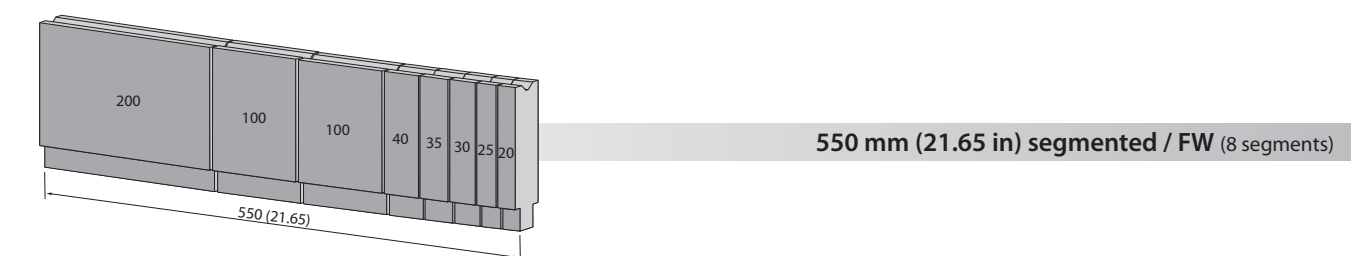


Tool lengths and sectioning

Standard



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



R3 ROLLERI TYPE R3

Dies 80°, H=65 (2.56) / H=85 (3.35)

BMR65.80.80
1700 kN/m max.

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

42Cr: 900-1150 N/mm²

BMR85.100.80
2300 kN/m max.

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

42Cr: 900-1150 N/mm²

R3 ROLLERI TYPE R3

Dies 30°, H=55 (2.17), H=60 (2.36)

BMR55.06.30
350 kN/m max.

1000 mm	39.37 in	8.0 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	9.0 kg

42Cr: 900-1150 N/mm²

BMR55.08.30
200 kN/m max.

1000 mm	39.37 in	9.2 kg
500 mm	19.68 in	4.0 kg
1100 mm segmented	43.31 in segmented	10.1 kg

42Cr: 900-1150 N/mm²

BMR55.10.30
350 kN/m max.

1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

BMR55.12.30
300 kN/m max.

1000 mm	39.37 in	10.0 kg
500 mm	19.68 in	5.0 kg
1100 mm segmented	43.31 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

Dies 60°, H=55 (2.17), H=65 (2.56)

BMR55.40.60
1300 kN/m max.

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

42Cr: 900-1150 N/mm²

BMR55.50.60
1200 kN/m max.

1000 mm	39.37 in	25.0 kg
500 mm	19.68 in	12.0 kg
1100 mm segmented	43.31 in segmented	21.0 kg

42Cr: 900-1150 N/mm²

BMR65.60.60
1100 kN/m max.

1000 mm	39.37 in	31.0 kg
500 mm	19.68 in	15.5 kg
1100 mm segmented	43.31 in segmented	34.1 kg

42Cr: 900-1150 N/mm²

BMR55.16.30
450 kN/m max.

1000 mm	39.37 in	13.5 kg
500 mm	19.68 in	6.7 kg
1100 mm segmented	43.31 in segmented	14.9 kg

42Cr: 900-1150 N/mm²

BMR55.20.30
500 kN/m max.

1000 mm	39.37 in	14.0 kg
500 mm	19.68 in	7.0 kg
1100 mm segmented	43.31 in segmented	13.5 kg

42Cr: 900-1150 N/mm²

BMR55.24.30
550 kN/m max.

1000 mm	39.37 in	15.5 kg
500 mm	19.68 in	7.8 kg
1100 mm segmented	43.31 in segmented	17.0 kg

42Cr: 900-1150 N/mm²

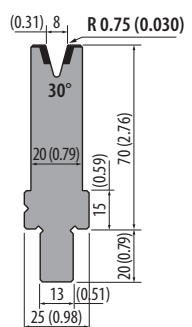
BMR60.32.30
650 kN/m max.

1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	22.5 kg

42Cr: 900-1150 N/mm²

BMR70.08.30

200 kN/m max.

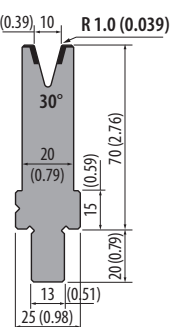


1000 mm	39.37 in	13.1 kg
500 mm	19.68 in	6.5 kg
1100 mm segmented	43.31 in segmented	14.0 kg

42Cr: 900-1150 N/mm²

BMR70.10.30

350 kN/m max.

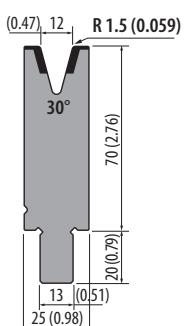


1000 mm	39.37 in	12.8 kg
500 mm	19.68 in	6.4 kg
1100 mm segmented	43.31 in segmented	12.4 kg

42Cr: 900-1150 N/mm²

BMR70.12.30

300 kN/m max.

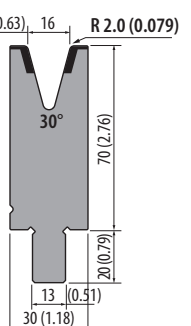


1000 mm	39.37 in	14.7 kg
500 mm	19.68 in	7.3 kg
1100 mm segmented	43.31 in segmented	14.3 kg

42Cr: 900-1150 N/mm²

BMR70.16.30

450 kN/m max.

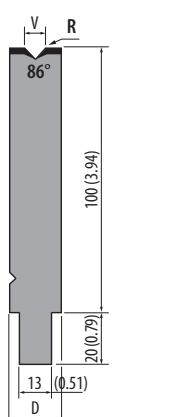


1000 mm	39.37 in	16.7 kg
500 mm	19.68 in	8.3 kg
1100 mm segmented	43.31 in segmented	16.2 kg

42Cr: 900-1150 N/mm²



86° Dies, H=100 (3.94)

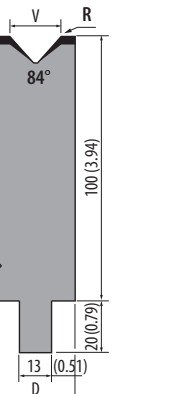


Individual drawings, available lengths and prices see pages 101-103

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.86	4	0.16	0.6	0.02	20	0.79	450
TMR100.06.86	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.86	8	0.31	0.8	0.03	20	0.79	1150
WMR100.08.86	8	0.31	2.5	0.10	25	0.98	400
TMR100.10.86	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.86	12	0.47	1.0	0.04	25	0.98	1200
WMR100.12.86	12	0.47	2.5	0.10	25	0.98	500
TMR100.16.86	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.86	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.86	24	0.94	2.5	0.10	35	1.38	1200
TMR100.30.86	30	1.18	3.0	0.12	45	1.77	1200
TMR100.40.86	40	1.57	3.0	0.12	55	2.17	1200
TMR100.50.86	50	1.97	3.0	0.12	75	2.95	1500

42Cr: 900-1150 N/mm²

84° Dies, H=100 (3.94)

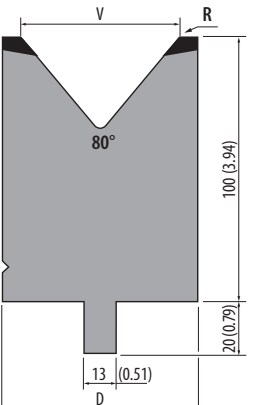


Individual drawings, available lengths and prices see pages 103-104

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.06.84	6	0.24	0.6	0.02	20	0.79	1200
TMR100.08.84	8	0.31	0.8	0.03	20	0.79	1150
TMR100.10.84	10	0.39	1.0	0.04	20	0.79	1100
TMR100.12.84	12	0.47	1.0	0.04	25	0.98	1200
TMR100.16.84	16	0.63	1.6	0.06	30	1.18	1200
TMR100.20.84	20	0.79	2.0	0.08	30	1.18	1150
TMR100.24.84	24	0.94	2.5	0.10	35	1.38	1200

42Cr: 900-1150 N/mm²

80° Dies, H=100 (3.94) / H=120 (4.72)



Individual drawings, available lengths and prices see page 105

Model	V (mm)	V (in)	H (mm)	H (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.60.80	60	2.36	100	3.94	5.0	0.20	75	2.95	1500
TMR100.70.80	70	2.76	100	3.94	5.0	0.20	85	3.35	1500
TMR100.80.80	80	3.15	100	3.94	5.0	0.20	100	3.94	1500
TMR120.90.80	90	3.54	120	4.72	8.0	0.31	110	4.33	1500
TMR120.100.80	100	3.94	120	4.72	8.0	0.31	120	4.72	1500

42Cr: 900-1150 N/mm²

60° Die, H=120 (4.72)

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR120.120.60	120	4.72	8.0	0.31	145	5.71	1000

84° Dies, H=150 (5.91)

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.84	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.84	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.84	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.84	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.84	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.84	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.84	24	0.94	2.5	0.10	35	1.38	700

30° Dies, H=100 (3.94)

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR100.04.30	4	0.16	0.6	0.02	20	0.79	150
TMR100.06.30	6	0.24	0.6	0.02	20	0.79	400
WMR100.06.30	6	0.24	2.0	0.08	20	0.79	400
TMR100.08.30	8	0.31	1.0	0.04	20	0.79	400
WMR100.08.30	8	0.31	2.5	0.10	20	0.79	400
TMR100.10.30	10	0.39	1.0	0.04	20	0.79	400
WMR100.10.30	10	0.39	2.5	0.10	25	0.98	400
TMR100.12.30	12	0.47	1.0	0.04	25	0.98	400
WMR100.12.30	12	0.47	3.0	0.12	25	0.98	400
TMR100.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR100.20.30	20	0.79	2.0	0.08	30	1.18	600
TMR100.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR100.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR100.40.30	40	1.57	5.0	0.20	60	2.36	900

80° Dies, H=150 (5.91)

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.24.80	24	0.94	2.5	0.10	35	1.38	700
TMR150.30.80	30	1.18	5.0	0.20	45	1.77	900
TMR150.40.80	40	1.57	5.0	0.20	55	2.17	1200
TMR150.50.80	50	1.97	5.0	0.20	65	2.56	1500

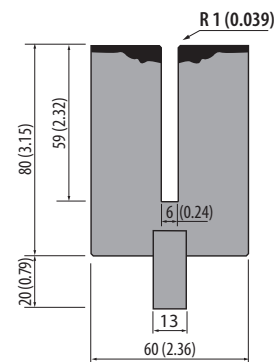
86° Dies, H=150 (5.91)

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.86	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.86	8	0.31	0.8	0.03	20	0.79	400
TMR150.10.86	10	0.39	1.0	0.04	20	0.79	500
TMR150.12.86	12	0.47	1.0	0.04	25	0.98	500
TMR150.16.86	16	0.63	1.6	0.06	30	1.18	700
TMR150.20.86	20	0.79	2.0	0.08	30	1.18	700
TMR150.24.86	24	0.94	2.5	0.10	35	1.38	700

30° Dies, H=150 (5.91)

Model	V (mm)	V (in)	R (mm)	R (in)	D (mm)	D (in)	kN/m max.
TMR150.06.30	6	0.24	0.6	0.02	20	0.79	400
TMR150.08.30	8	0.31	1.0	0.04	20	0.79	400
TMR150.10.30	10	0.39	1.0	0.04	20	0.79	400
TMR150.12.30	12	0.47	1.0	0.04	25	0.98	400
TMR150.16.30	16	0.63	1.6	0.06	30	1.18	500
TMR150.20.30	20	0.79	2.0	0.08	35	1.38	600
TMR150.24.30	24	0.94	2.5	0.10	40	1.57	650
TMR150.30.30	30	1.18	3.0	0.12	55	2.17	900
TMR150.40.30	40	1.57	5.0	0.20	55	2.17	900

BPR.SM.195.28.6



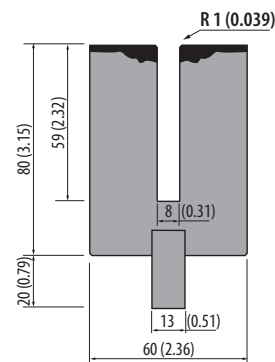
525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



Only for thin material!
Hemming punches
see page 126

BPR.SM.195.28.8

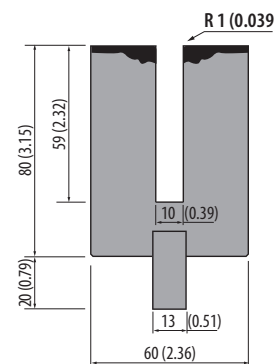


525 mm	20.67 in	12.0 kg
495 mm segmented	19.49 in segmented	11.0 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.10

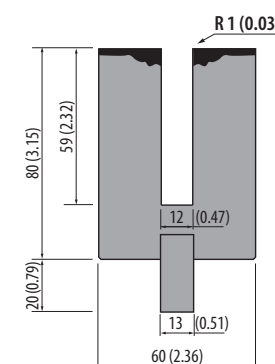


525 mm	20.67 in	11.8 kg
495 mm segmented	19.49 in segmented	11.2 kg

42Cr: 900-1150 N/mm²



BPR.SM.195.24.12

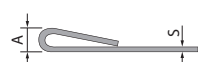


525 mm	20.67 in	11.5 kg
495 mm segmented	19.49 in segmented	10.8 kg

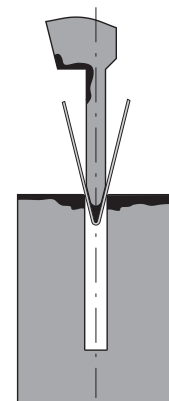
42Cr: 900-1150 N/mm²



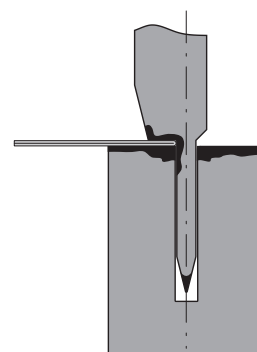
Example of Application



S mm	S in	A mm	A in	R.45 Kgf/mm ² t/m	R.70 Kgf/mm ² t/m	S mm	S in	A mm	A in	R.45 Kgf/mm ² t/m	R.70 Kgf/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



500 kN/m max.



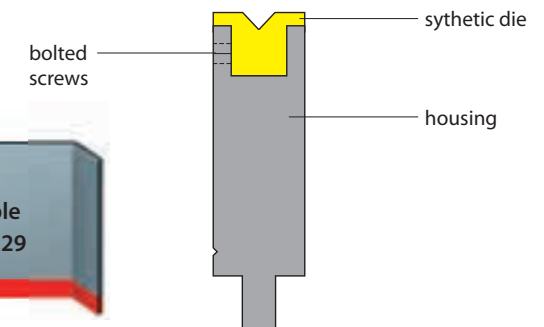
1000 kN/m max.

Our Advantages – Your Convenience

- easy handling
- faster and easier exchange
- preventing bending marks
- decrease of post-processing of bended profiles
- no contact of materials
- higher product quality

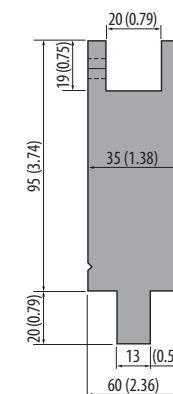
Mounting example

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



More mark-free bending available
see pages 222-229

TMN95.20

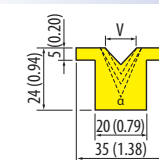


1000 kN/m max.		
835 mm	32.87 in	12.0 kg
415 mm	16.34 in	6.0 kg

C45: 560-710 N/mm²



INS20...



200 kN/m max.		
835 mm	32.87 in	0.40 kg
415 mm	16.34 in	0.20 kg

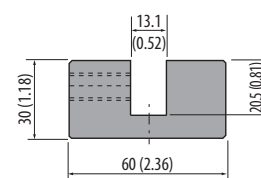


Model	α	V (mm)	V (in)
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63

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

Die Adapters

AD6



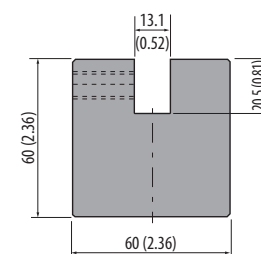
1000 kN/m max.		
1000 mm	39.37 in	12.0 kg
500 mm	19.68 in	6.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD5



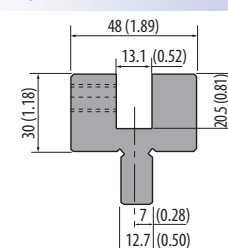
1000 kN/m max.		
1000 mm	39.37 in	26.1 kg
500 mm	19.68 in	13.0 kg

Rolleri Type R1
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD8-12.7



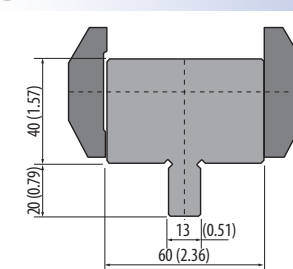
1000 kN/m max.		
1000 mm	39.37 in	15.0 kg
500 mm	19.68 in	7.5 kg

Rolleri Type RX LVD
→ Rolleri Type R2/R3

C45: 560-710 N/mm²



AD7



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

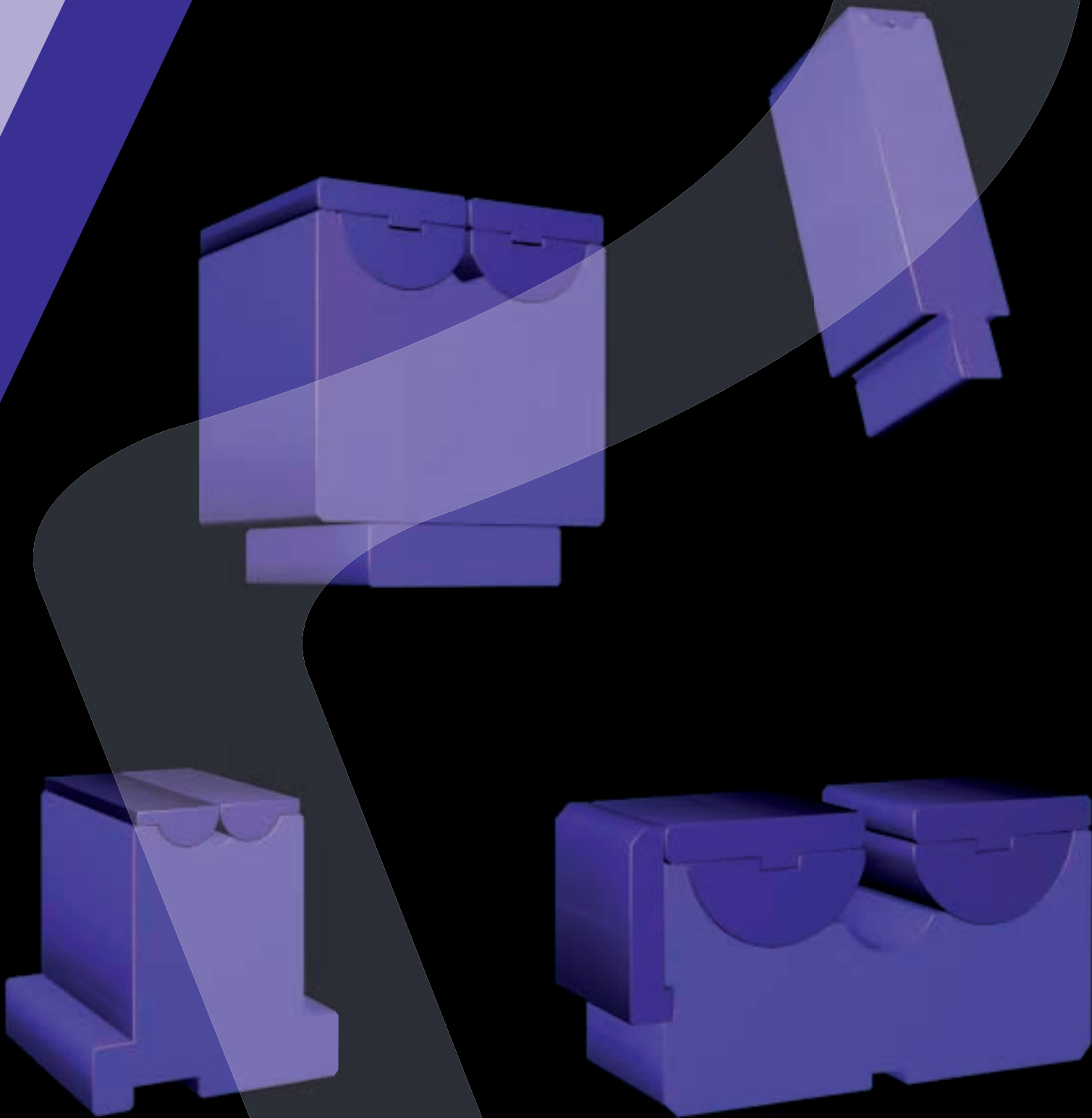
Rolleri Type R2/R3
→ Rolleri Type R1

C45: 560-710 N/mm²



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

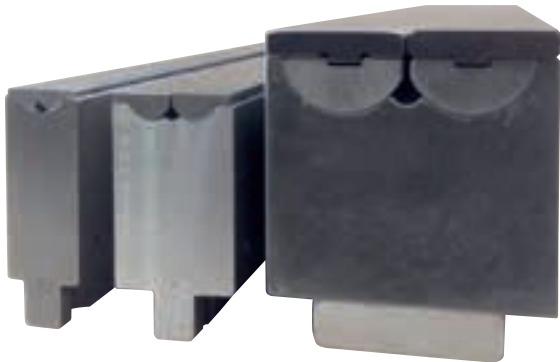


Compatibility

- **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

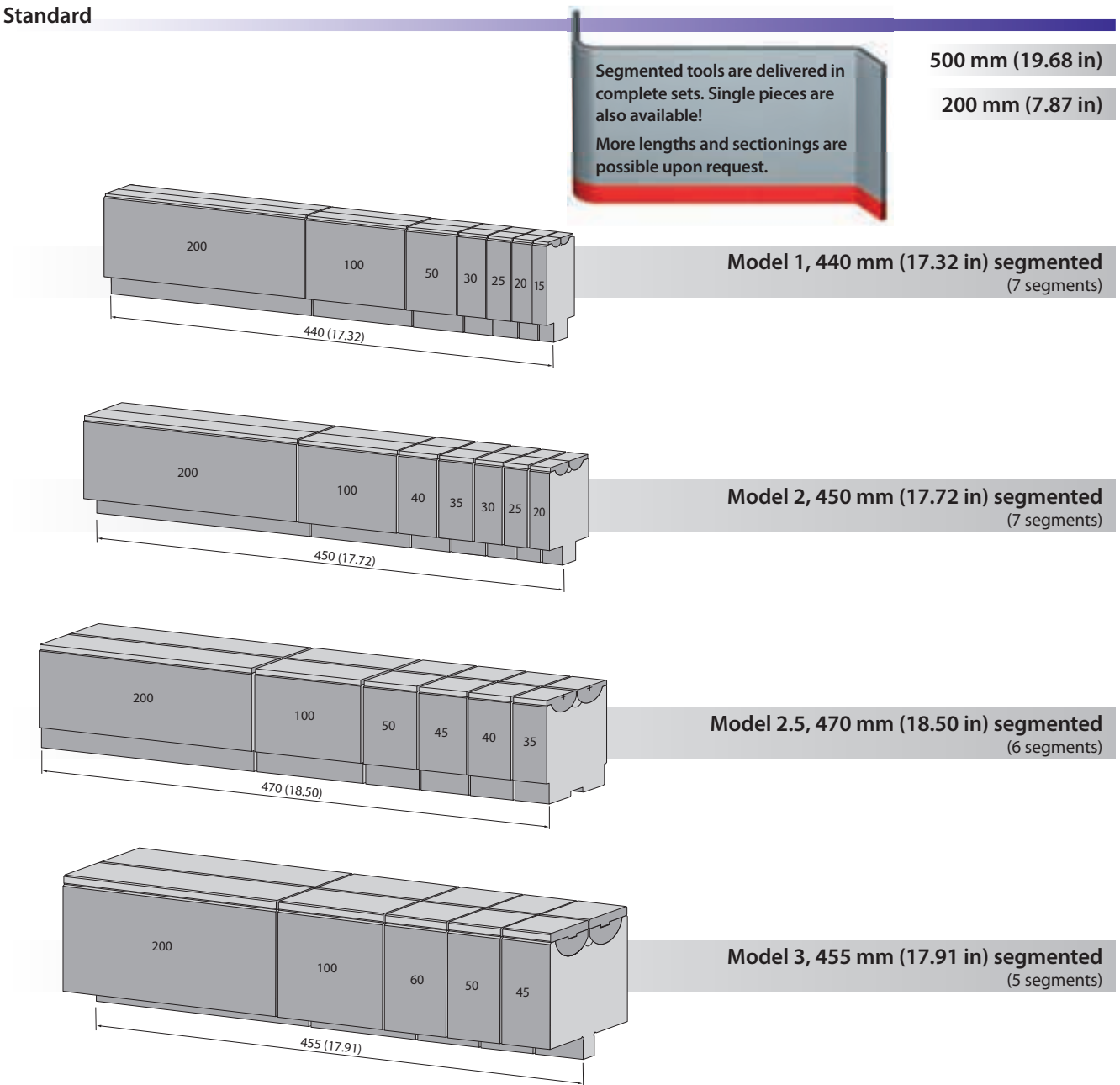
The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

	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/mm²	50 - 55 HRC
Inserts	1	Toolox 44	1450 N/mm²	through hardened 44 HRC
Inserts	2 / 2.5 / 3 / 4	Toolox 33	1100 N/mm²	55 - 58 HRC

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

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



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

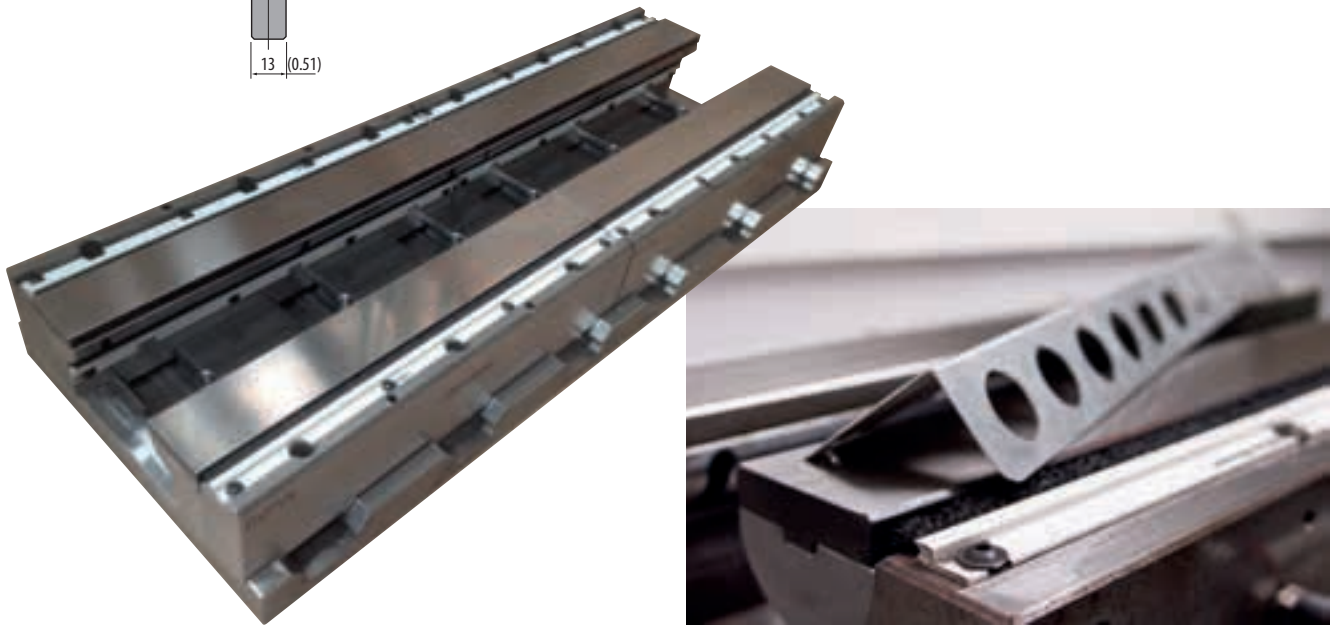
RVT100-1 1000 kN/m max.

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

ON STOCK

RVM70-3 2500 kN/m max.

NEW

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

42Cr: 1100-1200 N/mm²

ON STOCK

Possible Die Holders:

- 60 mm (2.36 in)
- 13 mm (0.51 in) pin
- 12.7 mm (0.50 in) pin
- 12.8 mm (0.50 in) offset pin

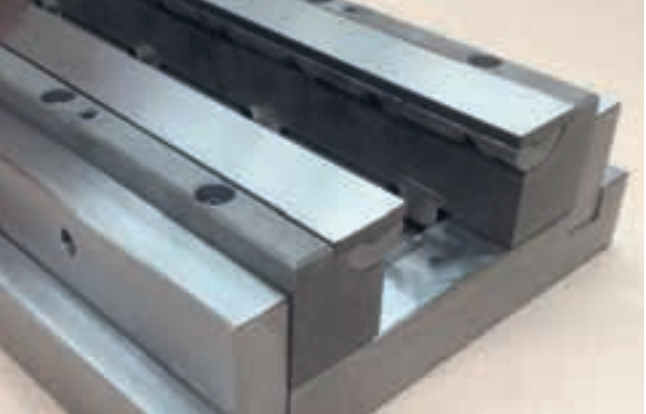
RVT100-3 2500 kN/m max.

NEW

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

42Cr: 1100-1200 N/mm²

ON STOCK



Model 4

Our Advantages – Your Convenience

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

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

For advice please contact us!

RVM90-4 3000 kN/m max.

NEW

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

42Cr: 1100-1200 N/mm²

ON STOCK

Possible Die Holders:

- 60 mm (2.36 in)
- 13 mm (0.51 in) pin
- 12.7 mm (0.50 in) pin
- 12.8 mm (0.50 in) offset pin

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

ON STOCK

RVHD3 3500 kN/m max.

NEW

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

42Cr: 1100-1200 N/mm²

ON STOCK

RVHD4 4000 kN/m max.

NEW

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

42Cr: 1100-1200 N/mm²

ON STOCK

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

Hemming- and Z-Tools

Hemming Tool

NEW

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

Production according to your specifications

42Cr: 1100-1200 N/mm²

ON STOCK

Joggle Tool

NEW

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

Production according to your specifications

42Cr: 1100-1200 N/mm²

ON STOCK

ROLLERI CLAMPING SYSTEMS

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



ROLLERI CLAMPING SYSTEMS

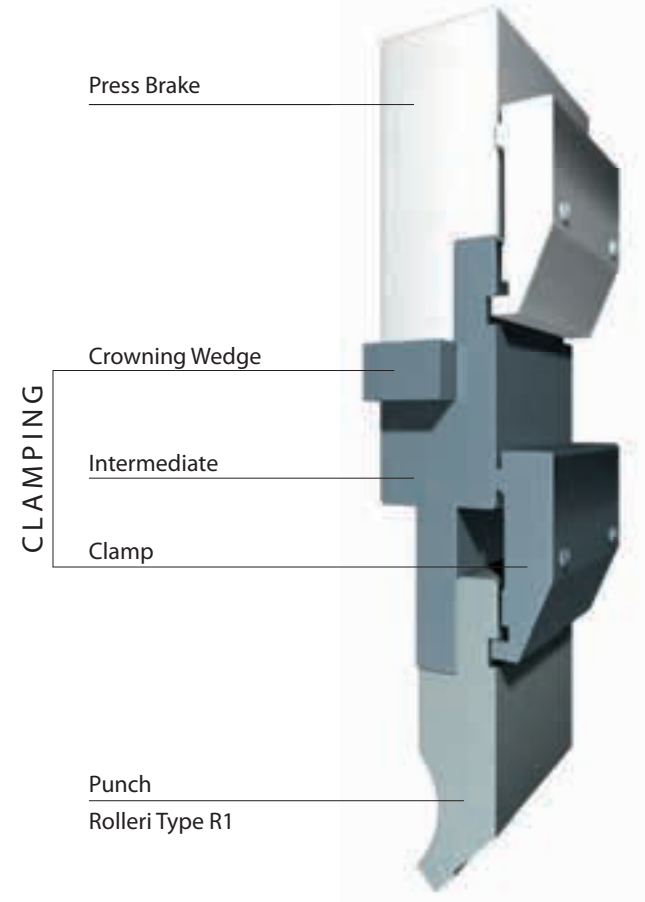
Content Explanation

Standard-Clamping

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



horizontal



ROL100 Clamping

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

NEW
vertical

ROL1 Clamping

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

vertical

ROL4 Clamping

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

horizontal

W-ROL PN Clamping

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

vertical horizontal

ROL3 Clamping

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

vertical horizontal

ROL2 Clamping

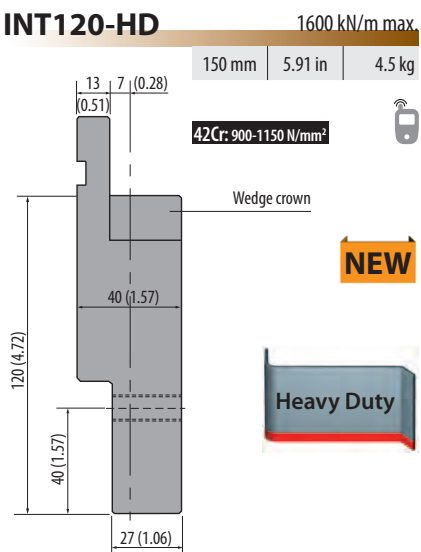
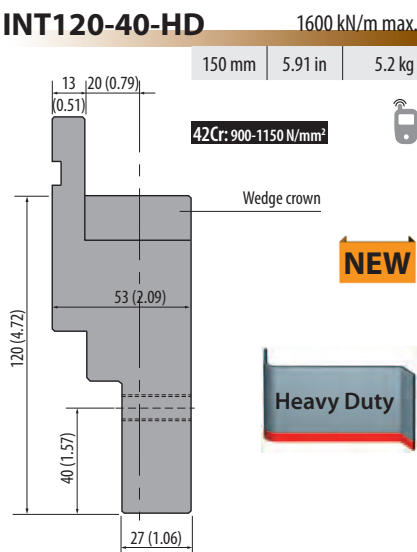
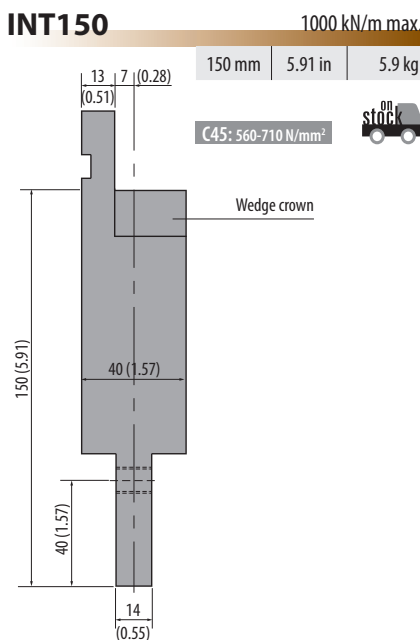
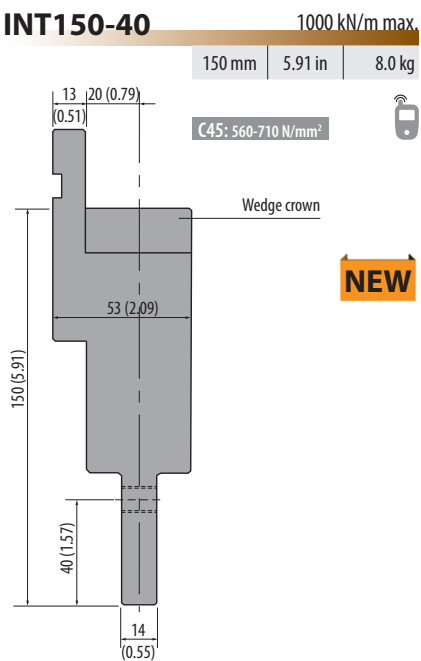
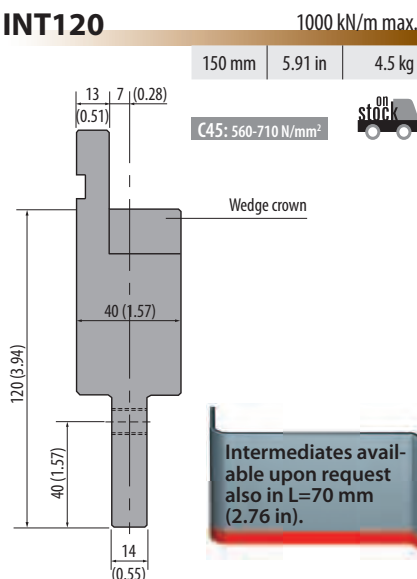
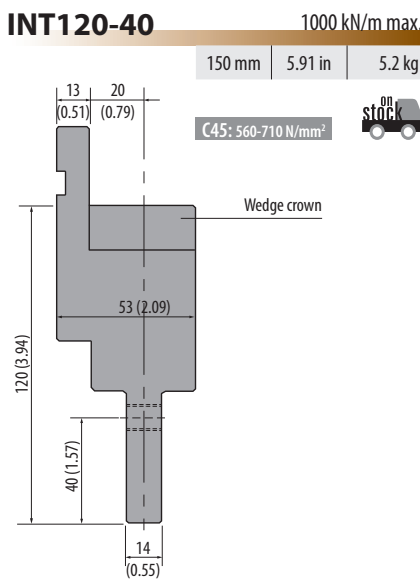
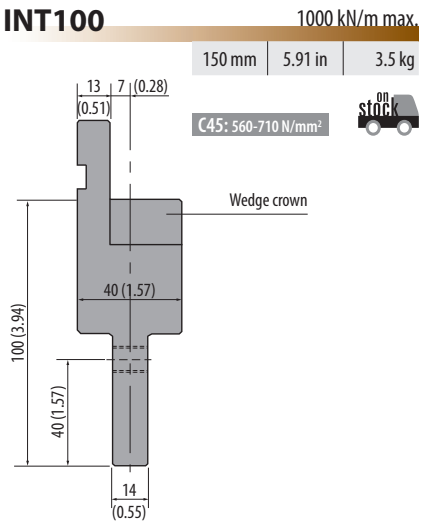
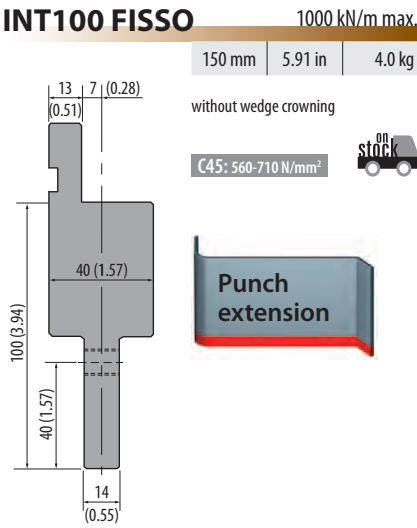
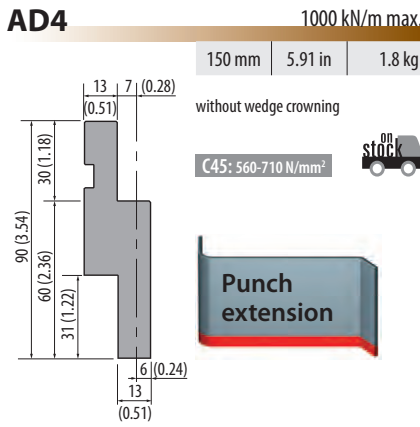
- for Dies Roller Type R1
- manual, pneumatic and hydraulic models available
- see pages 208-209

Movable Die Clamps

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

R1 ROLLER CLAMPING SYSTEMS

Intermediates



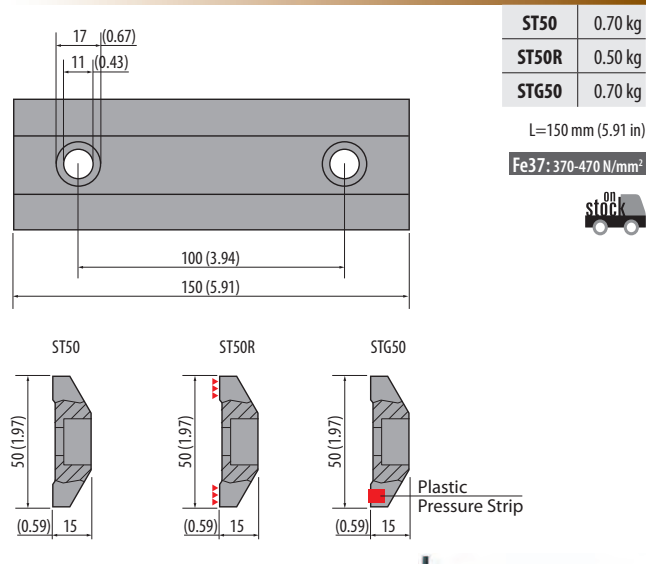
R1 ROLLERI CLAMPING SYSTEMS
Clamps

Our Advantages – Your Convenience

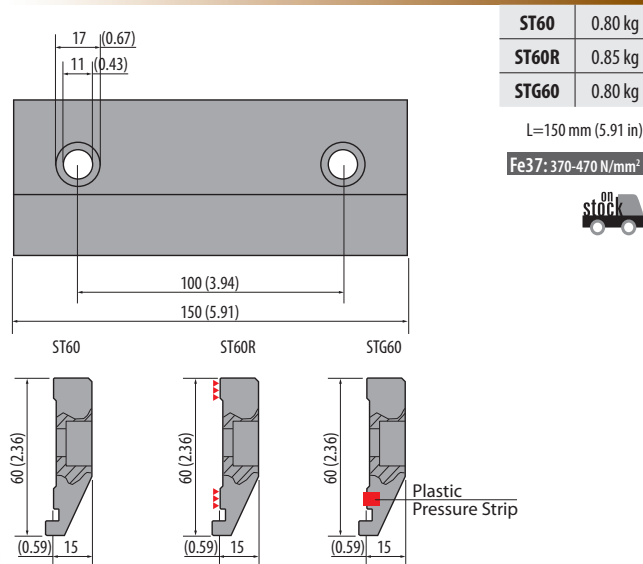
- Rapid Clamping Systems allow a fast horizontal tool exchange
- Plastic Pressure Strip improves the clamping especially with short tool pieces.

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)

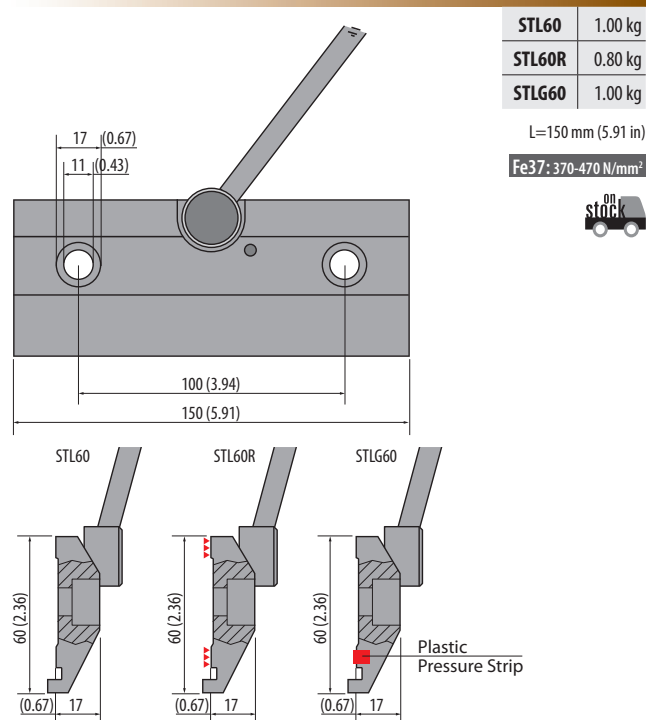
ST50 / ST50R / STG50



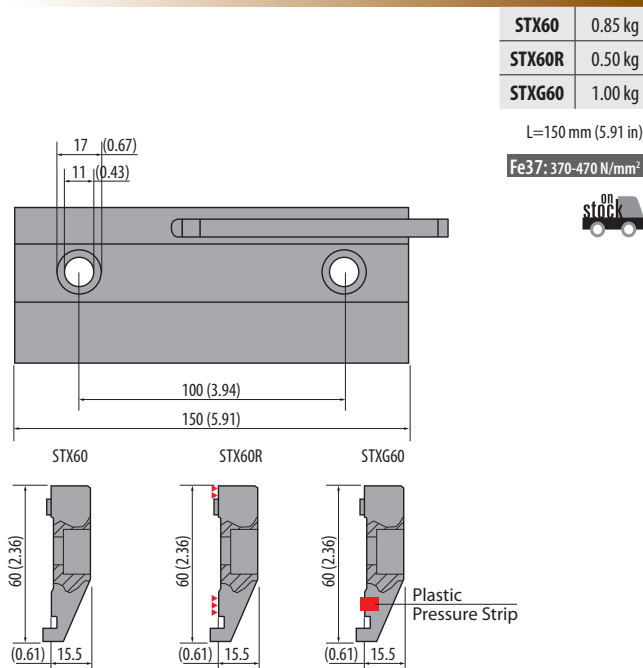
ST60 / ST60R / STG60



STL60 / STL60R / STL60



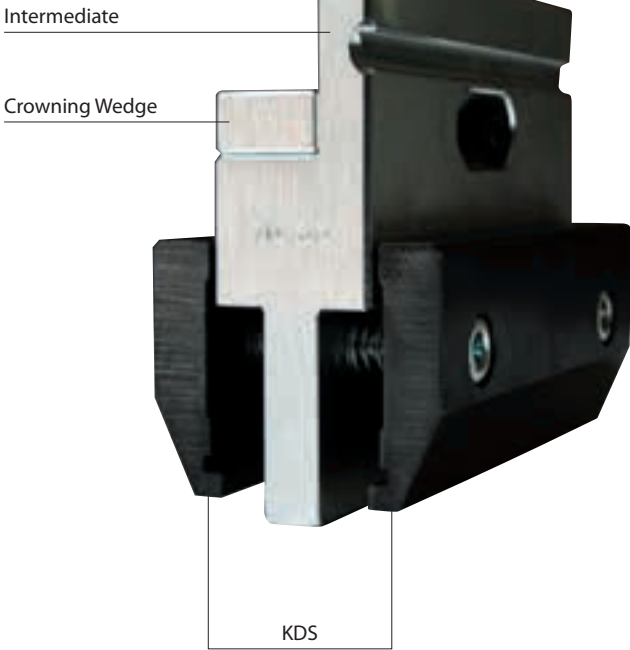
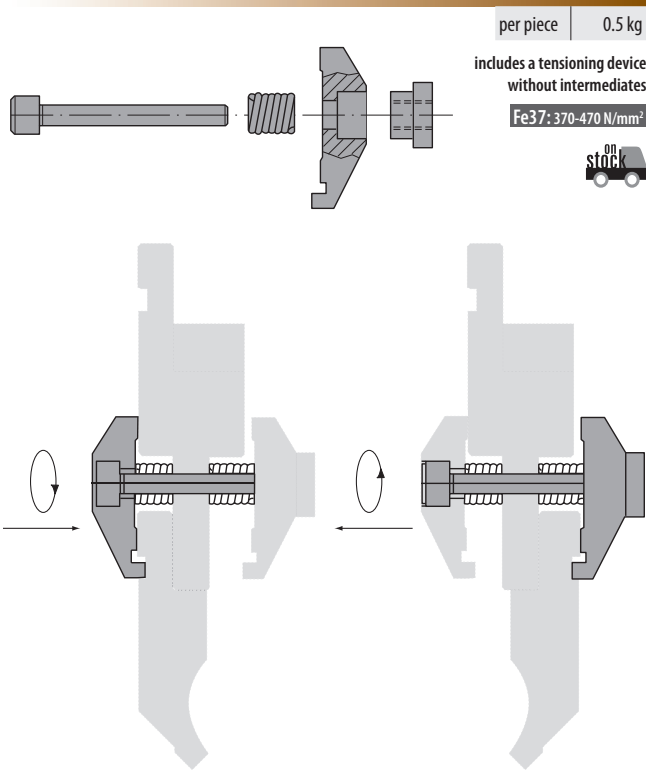
STX60 / STX60R / STXG60



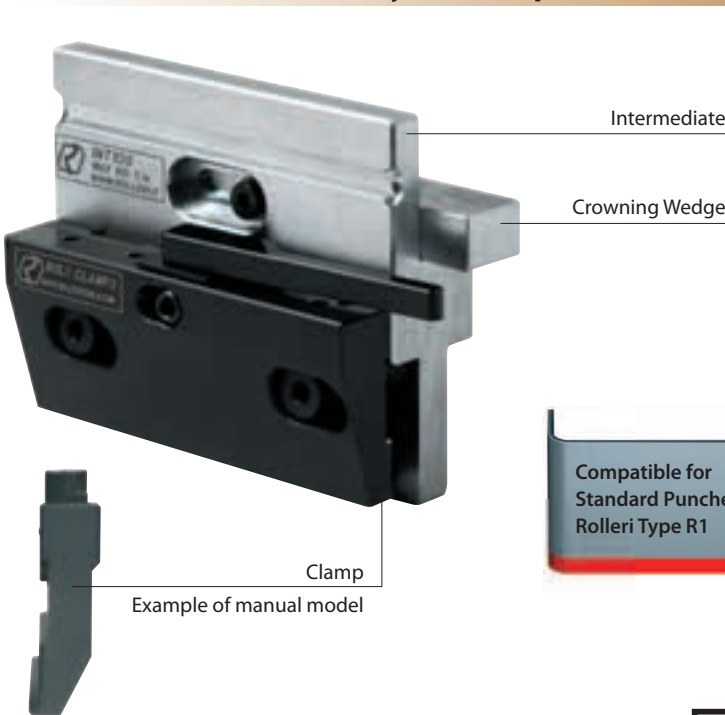
R1 ROLLERI CLAMPING SYSTEMS
Clamps



KDS



ROL1 CLAMP3 – manual – hydraulic – pneumatic



Compatible for
Standard Punches
Rolleri Type R1

Model	with Intermediate
ROL1 CLAMP3 manual	INT100
	INT120
	INT150
	INT100 FISSO
INT120-40	
ROL1 CLAMP3 manual without Intermediate	
Model	with Intermediate
ROL1 CLAMP3 hydraulic	INT100
	INT120
	INT150
	INT100 FISSO
INT120-40	
Model	with Intermediate
ROL1 CLAMP3 pneumatic	INT120
	INT150



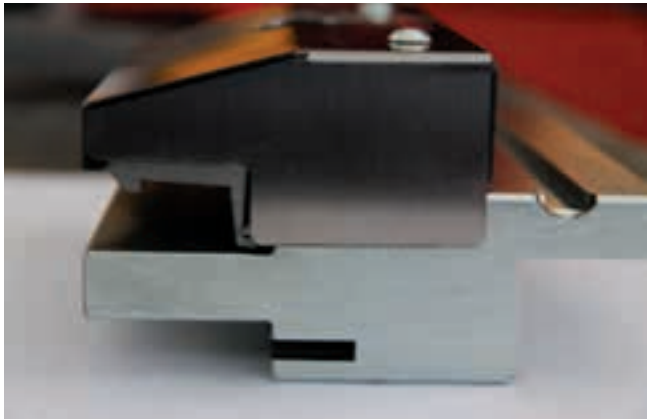
Rolleri Videos

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



... 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, Iturraspe, 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.



ROL100 – manual

NEW



Model	with Intermediate
ROL100 manual	INT100
	INT120
	INT150
	INT100 FISSO

vertical

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



The ROL100-System is suited for Standard-Punches. There are no modifications necessary!

ROL100 – pneumatic

NEW



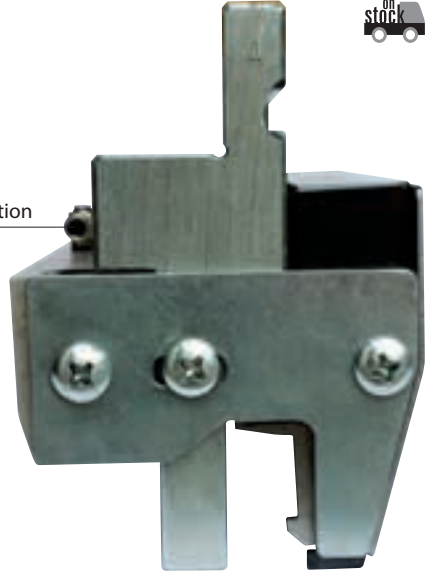
Model	with Intermediate
ROL100 pneumatic	INT100
	INT120
	INT150
	INT100 FISSO

vertical

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



Pneumatic connection



R1 ROLLERI CLAMPING SYSTEMS

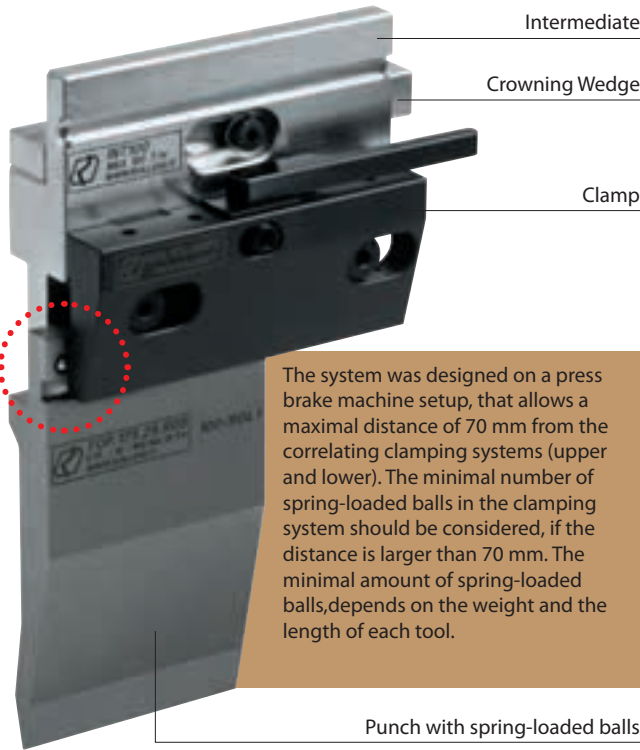
ROL1-System for Punches Roller Type R1

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

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

Our Advantages – Your Convenience

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



ROL1 CLAMP1 – manual

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



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

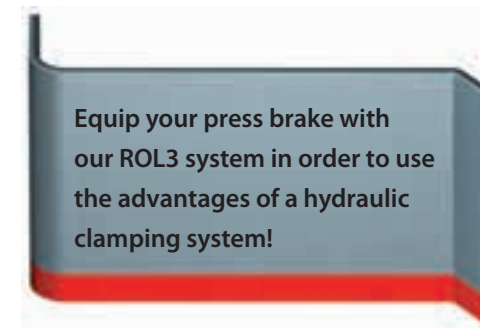
vertical

horizontal

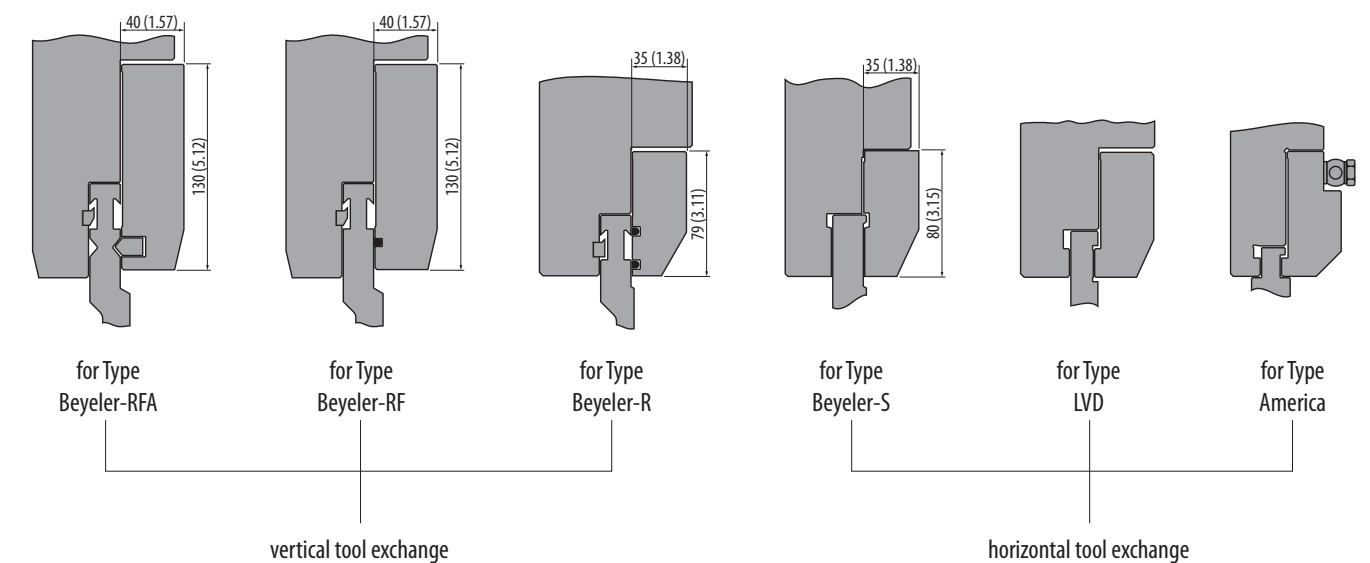


Our Advantages – Your Convenience

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



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			only Clamp		
table: 60 mm	2.36 in	38.0 kg	table: 60 mm	2.36 in	4.0 kg
table: 90 mm	3.54 in	58.0 kg	table: 90 mm	3.54 in	4.5 kg

L=1075 mm (42.32 in)



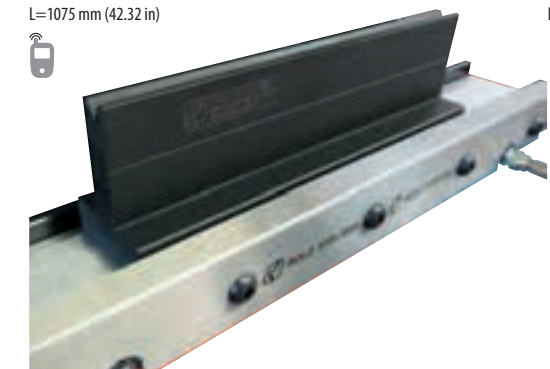
L=500 mm (19.68 in)



ROL2 – hydraulic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

L=1075 mm (42.32 in)



L=500 mm (19.68 in)



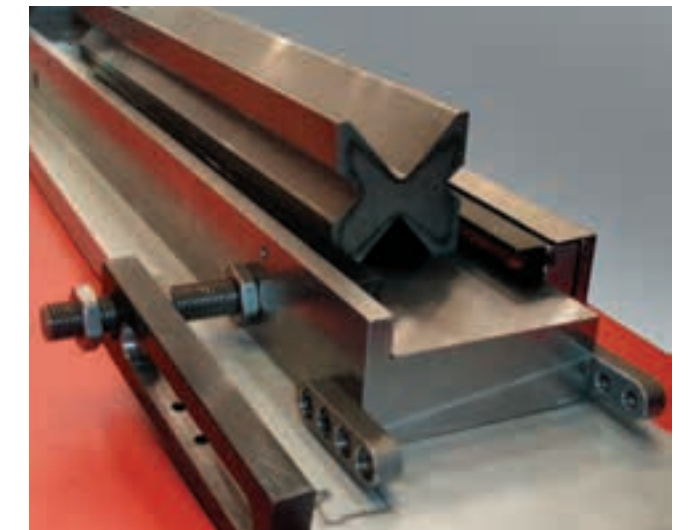
ROL2 – pneumatic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

L=1075 mm (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

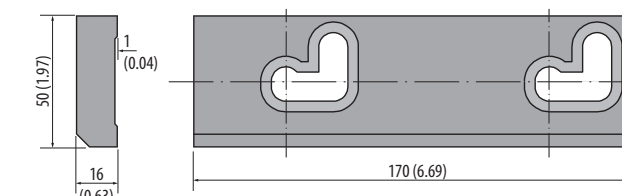
movable die holders ST50-S:
www.rolleritools.com/videos/movable-die-holders



ST50-S

per piece 0.70 kg

Fe37: 370-470 N/mm²



ROLLERI ADAPTERS

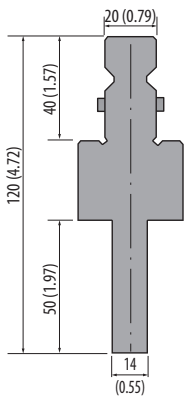
Punch Adapters	212 - 215
Bolted Adapters	216 - 217
Die Adapter Rails	218
Die Adapters	219 - 221
Modification: Wedge Bar / Tail	221



ROLLERI ADAPTERS

Punch Adapters

AD11 1000 kN/m max.



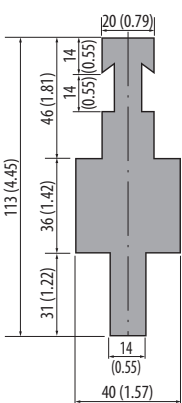
150 mm 5.91 in 3.0 kg

Rolleri Type R2
→ Rolleri Type R1

C45: 560-710 N/mm²



AD22 1000 kN/m max.



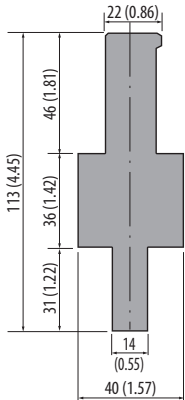
150 mm 5.91 in 3.4 kg

Rolleri Type R3 Beyeler R
→ Rolleri Type R1

C45: 560-710 N/mm²



AD3 1000 kN/m max.



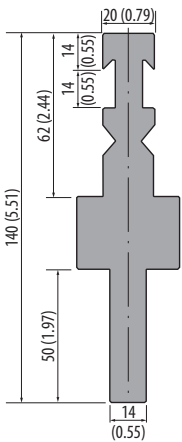
150 mm 5.91 in 3.3 kg

Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



AD10 1000 kN/m max.



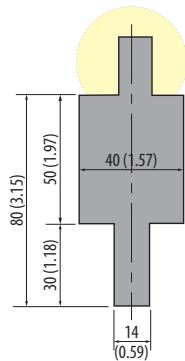
150 mm 5.91 in 3.4 kg

Rolleri Type R3 Beyeler
RFA → Rolleri Type R1

C45: 560-710 N/mm²



AD1 1000 kN/m max.



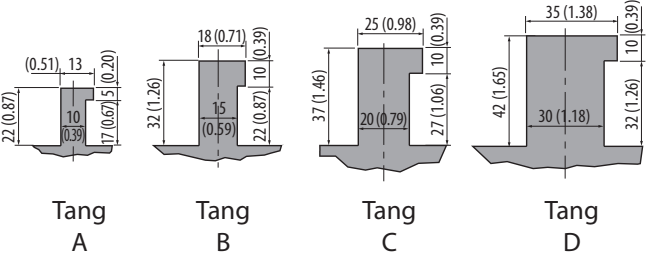
Tang A: AD1-A		
150 mm	5.91 in	3.1 kg
Tang B: AD1-B		
150 mm	5.91 in	3.1 kg
Tang C: AD1-C		
150 mm	5.91 in	3.1 kg
Tang D: AD1-D		
150 mm	5.91 in	3.1 kg

Rolleri Type RX LVD
→ Rolleri Type R1

C45: 560-710 N/mm²



Tangs LVD



Tang A

Tang B

Tang C

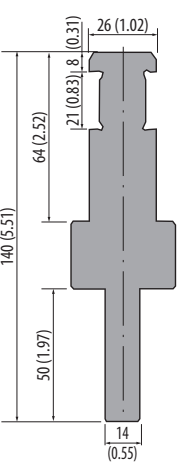
Tang D

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

ROLLERI ADAPTERS

Punch Adapters

AD13 1000 kN/m max.



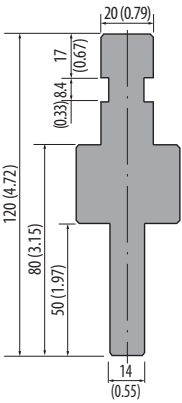
150 mm 5.91 in 3.0 kg

Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²



AD14 1000 kN/m max.



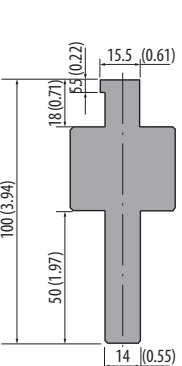
150 mm 5.91 in 3.2 kg

Rolleri Type RX Gas-
parini → Rolleri Type R1

C45: 560-710 N/mm²



AD15 1000 kN/m max.



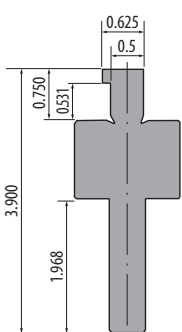
150 mm 5.91 in 4.0 kg

Rolleri Type RX Ajial-
Axial → Rolleri Type R1

C45: 560-710 N/mm²



AD16 1000 kN/m max.



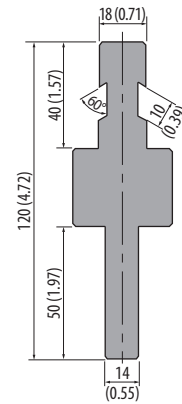
5.9 inch 5.91 in 4.0 kg

Rolleri Type American
→ Rolleri Type R1

C45: 560-710 N/mm²



AD12 1000 kN/m max.



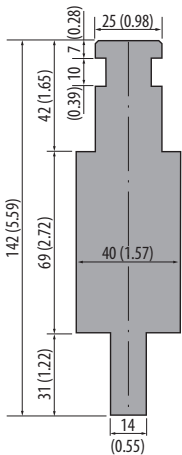
150 mm 5.91 in 1.5 kg

Rolleri Type RX Colgar
→ Rolleri Type R1

C45: 560-710 N/mm²



AD23 1000 kN/m max.



150 mm 5.91 in 5.0 kg

Rolleri Type RX
Weinbrenner
→ Rolleri Type R1

C45: 560-710 N/mm²



Article
on stock



Please ask for
delivery time!

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



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

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), 15 (0.59), 32 (1.26), 18 (0.71), 25 (0.98), 27 (1.06), 10 (0.39), 35 (1.38), 32 (1.26), 10 (0.39).

Tang B: 18 (0.71), 25 (0.98), 27 (1.06), 10 (0.39), 35 (1.38), 32 (1.26), 10 (0.39).

Tang C: 37 (1.46), 20 (0.79), 27 (1.06), 10 (0.39), 35 (1.38), 32 (1.26), 10 (0.39).

Tang D: 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

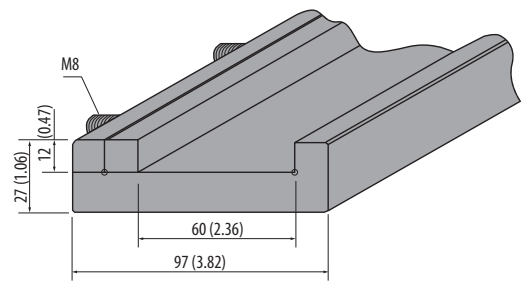
835 mm	32.87 in	5.0 kg
415 mm	16.34 in	2.5 kg
805 mm segmented	31.69 in segmented	4.8 kg

C45: 560-710 N/mm²

ROLLERI ADAPTERS

Die Adapter Rails

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

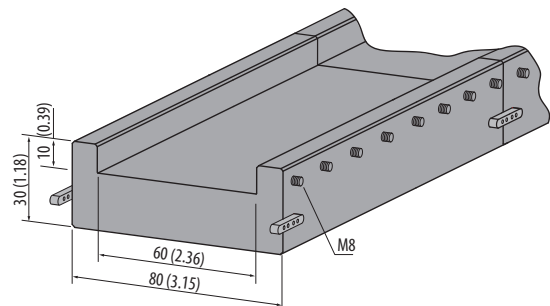


Model	Length (mm)	Length (in)	Weight
C 2000/S	2100	82.68	27.0 kg
C 2500/S	2600	102.36	34.0 kg
C 3000/S	3100	122.05	40.0 kg
C 4000/S	4100	161.42	53.0 kg



C45: 560-710 N/mm²

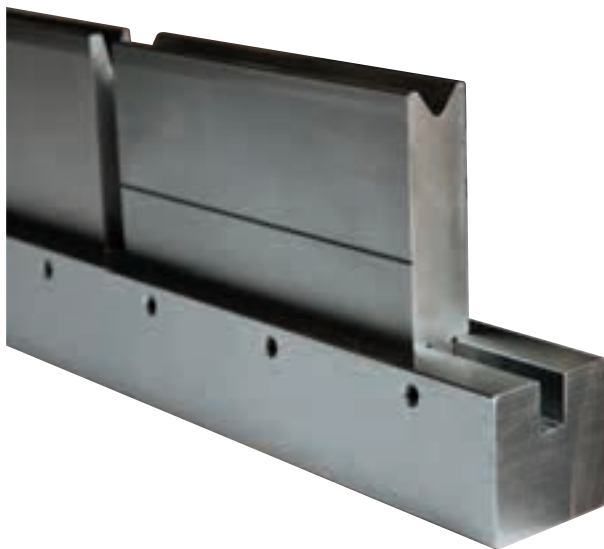
C 1050/R



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

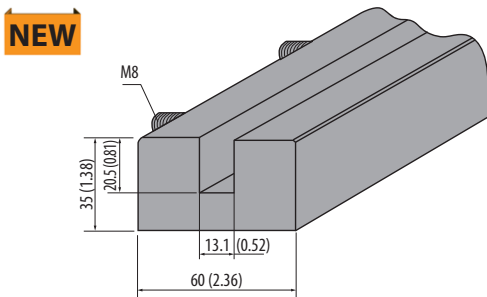


C45: 560-710 N/mm²



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

NEW

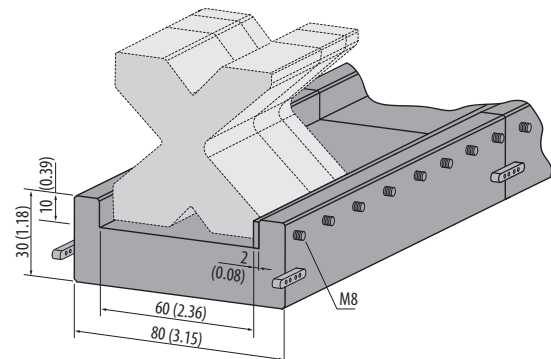


Model	Length (mm)	Length (in)	Weight
TC 2000/S	2100 mm	82.68	30.0 kg
TC 2500/S	2600 mm	102.36	37.0 kg
TC 3000/S	3100 mm	122.05	44.0 kg
TC 4000/S	4100 mm	161.42	59.0 kg



C45: 560-710 N/mm²

C 1050/RS

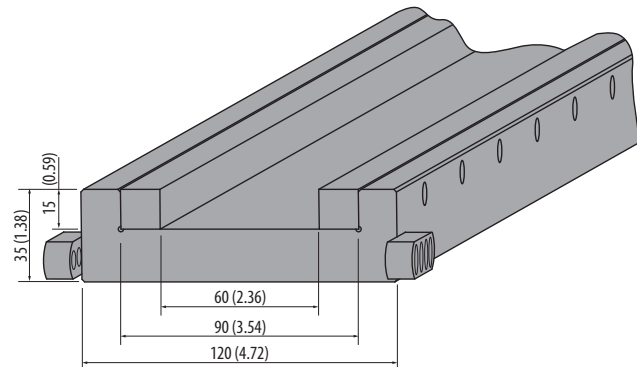


Model	Length (mm)	Length (in)	Weight
C 1050/RS	1050 mm	41.34	15.0 kg
C 1050/RS/C	520 mm	20.47	7.5 kg



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



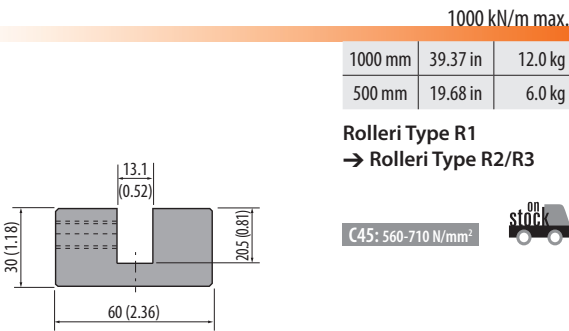
C45: 560-710 N/mm²

ROLLERI ADAPTERS

Die Adapters



AD6

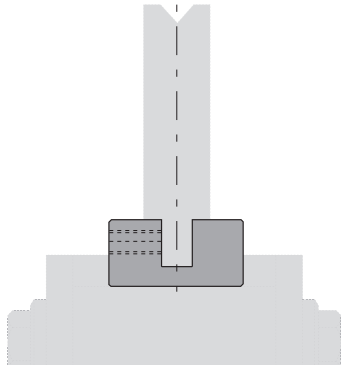


Rolleri Type R1
→ Rolleri Type R2/R3

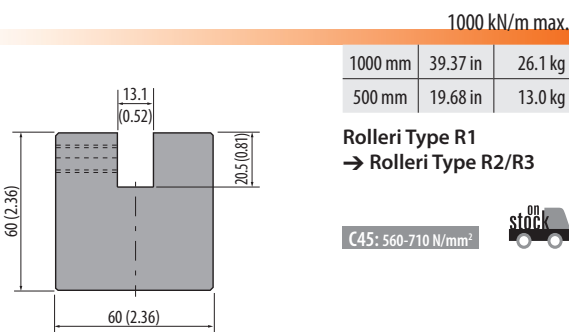
C45: 560-710 N/mm²



AD6 Example of Application



AD5

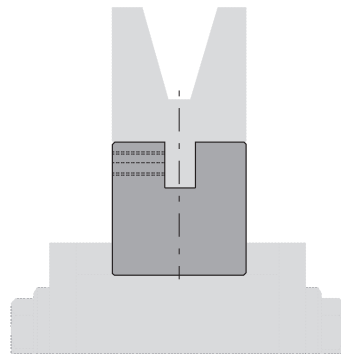


Rolleri Type R1
→ Rolleri Type R2/R3

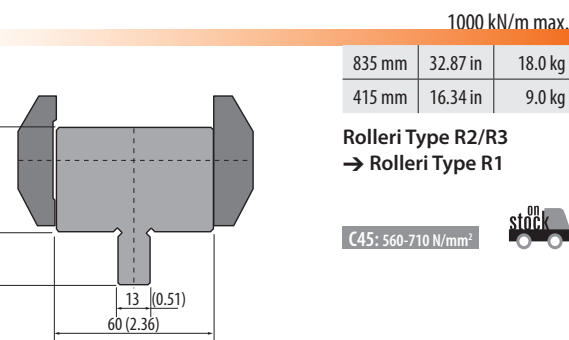
C45: 560-710 N/mm²



AD5 Example of Application



AD7

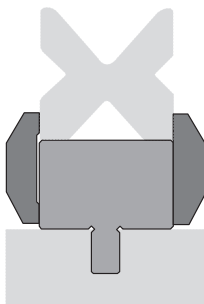


Rolleri Type R2/R3
→ Rolleri Type R1

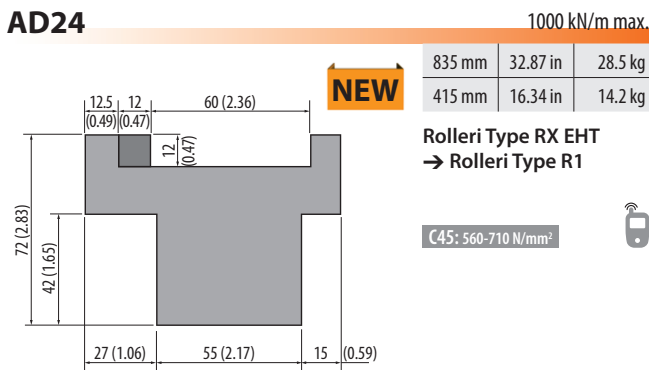
C45: 560-710 N/mm²



AD7 Example of Application



AD24



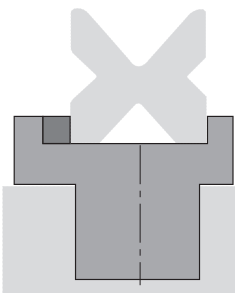
NEW

Rolleri Type RX EHT
→ Rolleri Type R1

C45: 560-710 N/mm²



AD24 Example of Application



Article on stock



Please ask for delivery time!

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



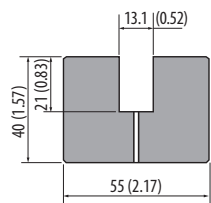
Articles on stock – Please note that delivery time depends on your location.

ROLLERI ADAPTERS

Die Adapters

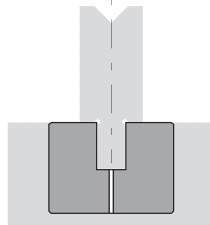
AD25

NEW

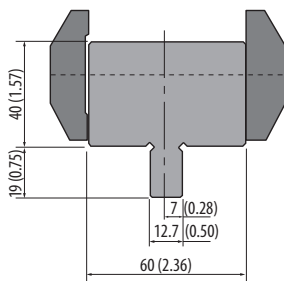


1000 kN/m max.
500 mm 19.68 in 7.5 kg
Rolleri Type RX EHT
→ Rolleri Type R2/R3
C45: 560-710 N/mm²

AD25 Example of Application

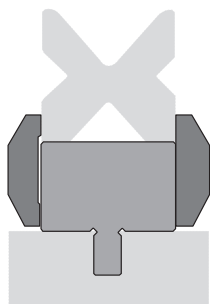


AD9-12.7

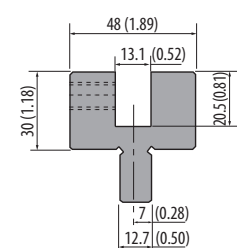


1000 kN/m max.
835 mm 32.87 in 17.0 kg
415 mm 16.34 in 8.5 kg
Rolleri Type RX LVD
→ Rolleri Type R1
C45: 560-710 N/mm²

AD9-12.7 Example of Application

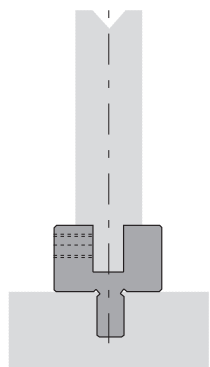


AD8-12.7



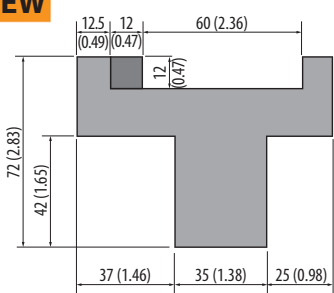
1000 kN/m max.
1000 mm 39.37 in 15.0 kg
500 mm 19.68 in 7.5 kg
Rolleri Type RX LVD
→ Rolleri Type R2/R3
C45: 560-710 N/mm²

AD8-12.7 Example of Application



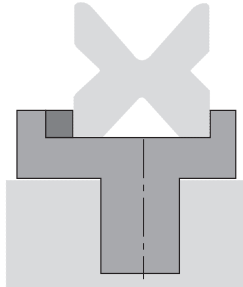
AD26

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



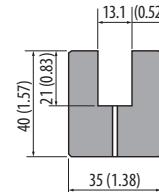
ROLLERI ADAPTERS

Die Adapters



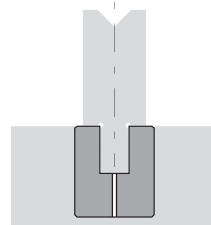
AD27

NEW

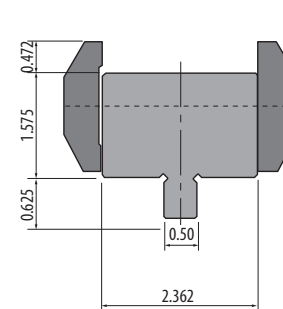


1000 kN/m max.
500 mm 19.68 in 4.5 kg
Rolleri Type RX Weinbrenner
→ Rolleri Type R2/R3
C45: 560-710 N/mm²

AD27 Example of Application

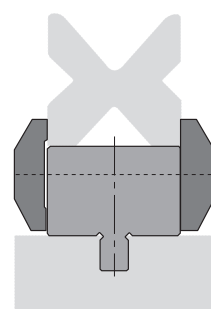


AD17

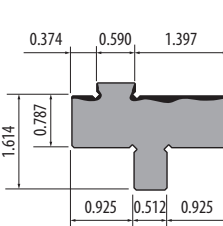


1000 kN/m max.
835 mm 32.87 in 18.0 kg
415 mm 16.34 in 9.0 kg
Type American
→ Rolleri Type R1
C45: 560-710 N/mm²

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

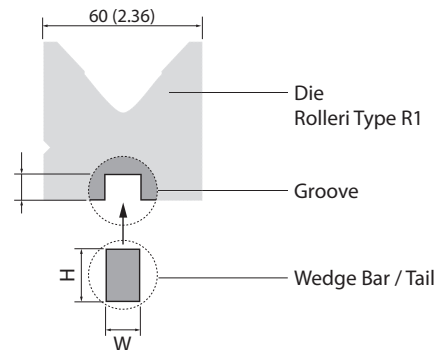


Modification: Wedge Bar / Tail

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.

Mounting example

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



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



Article on stock



Please ask for delivery time!

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



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

ROLLERI MARK FREE BENDING

Prevention of Bending Marks	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.

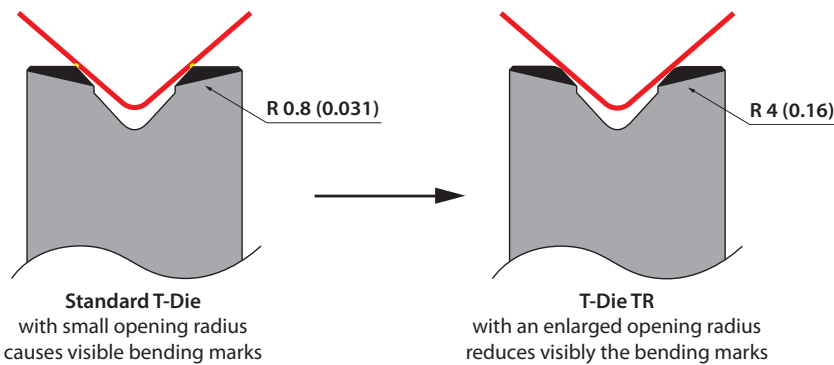
In order to prevent this markings, the following solutions are possible:

- 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

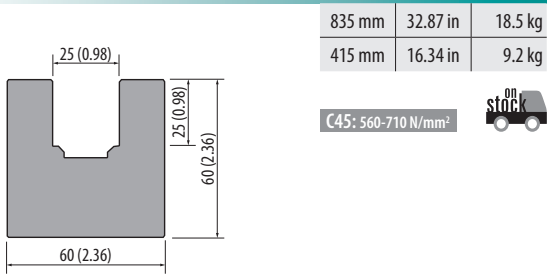
mark free bending:
www.rolleritools.com/videos/mark-free-bending



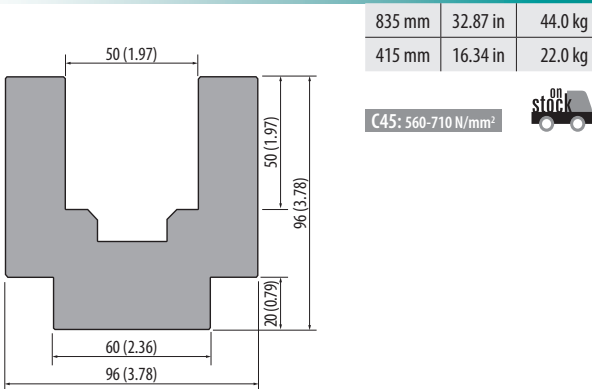
ROLLERI MARK FREE BENDING

PU-Holders and PU-Upholstery

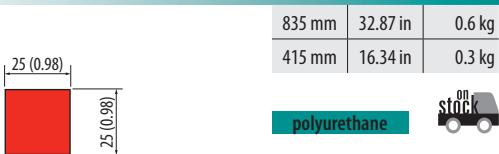
MPG25



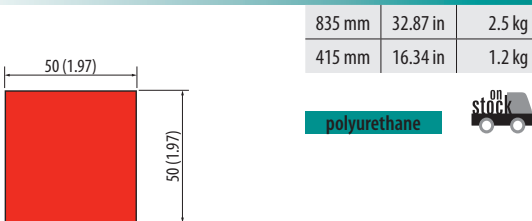
MPG50



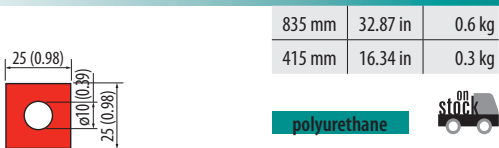
GM 25x25



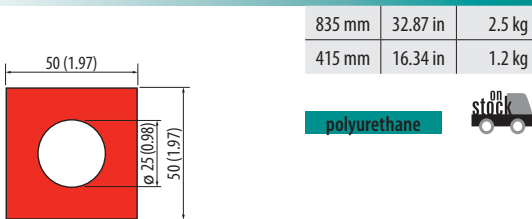
GM 50x50



GMF 25x25x10



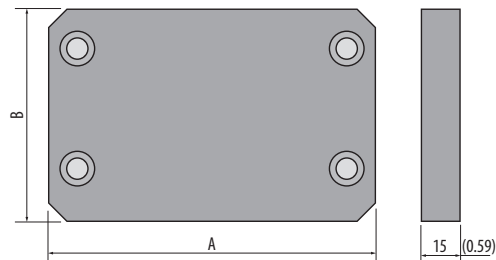
GMF 50x50x25



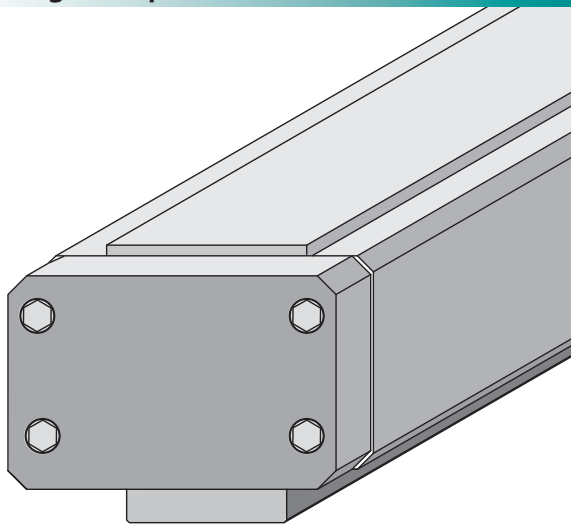
PSTCON

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

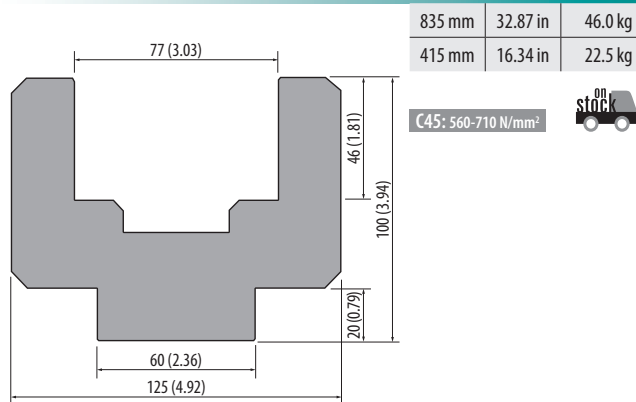


ROLLERI MARK FREE BENDING

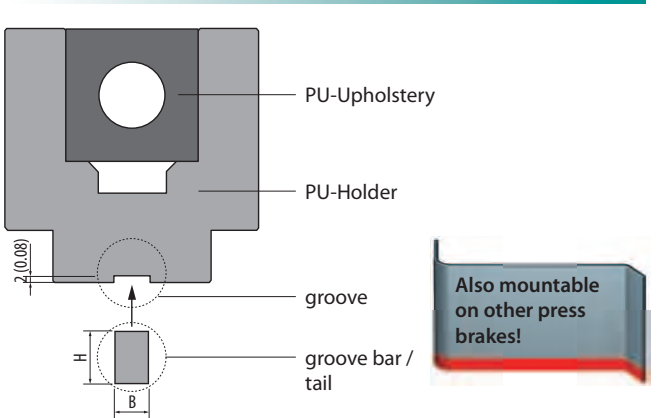
PU-Holders and PU-Upholstery



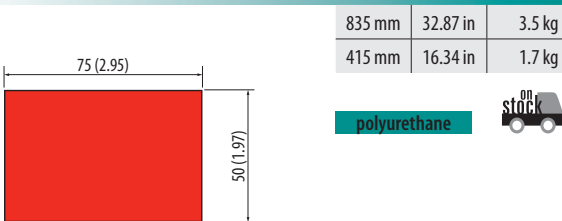
MPG75



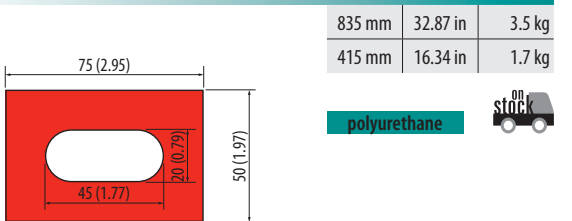
Mounting example



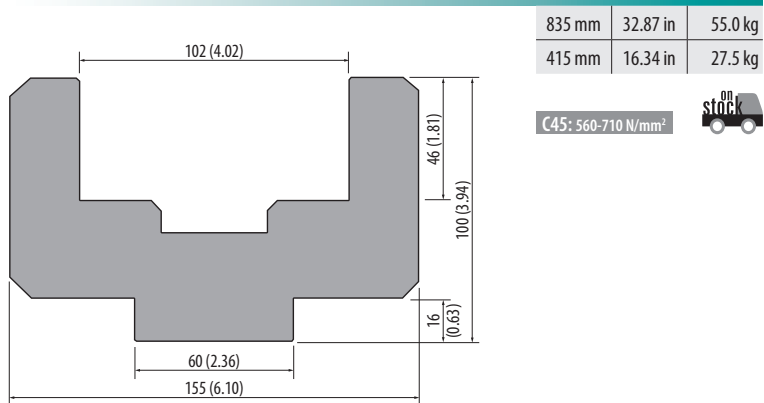
GM 75x50



GMF 75x50x20

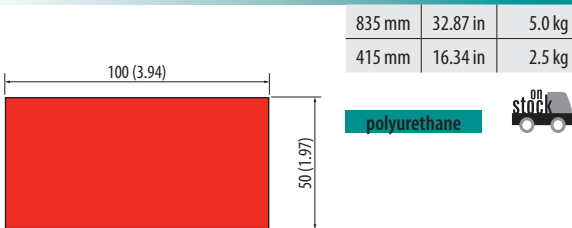


MPG100

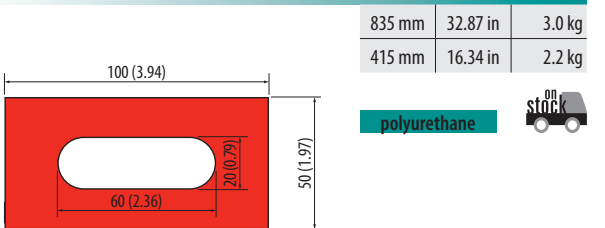


PU-Upholstery are suitable for radius- and U-profile bendings, etc.

GM 100x50



GMF 100x50x20



ROLLERI MARK FREE BENDING

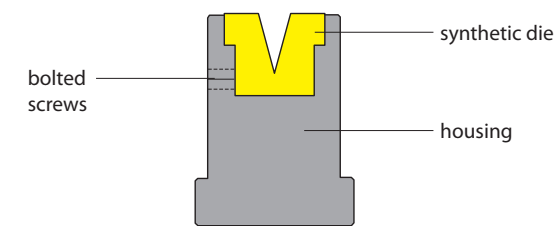
Synthetic Dies

Our Advantages – Your Convenience

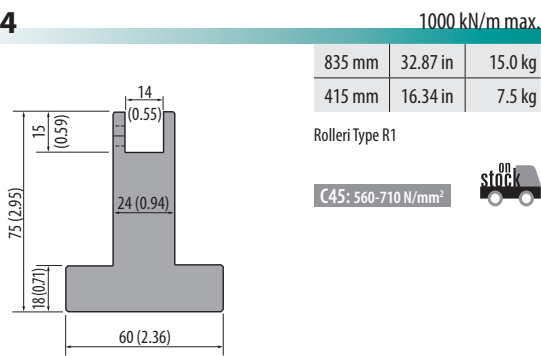
- easy Handling
- faster and easier exchange of plastic dies
- prevention of bending marks
- decrease of post-processing of bent pieces
- no contamination of the materials
- increased product quality

Mounting example

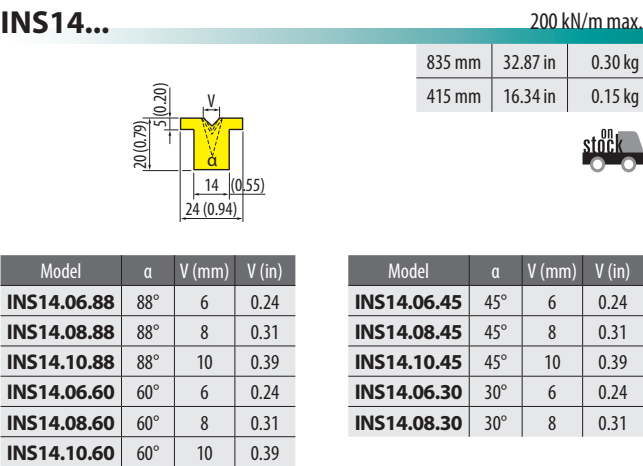
Synthetic dies will be adjusted into the housing and secured with bolted screws.



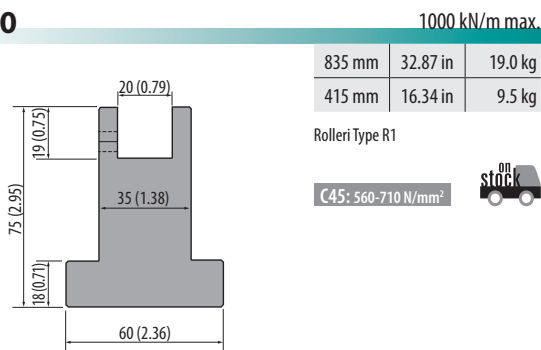
TN80.14



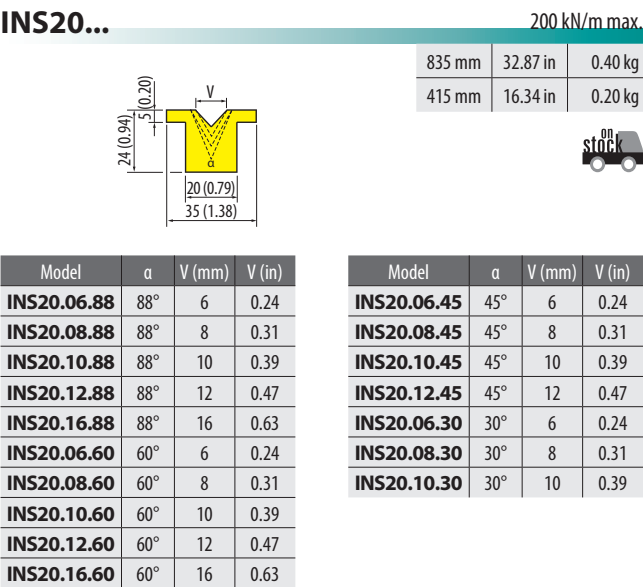
INS14...



TN80.20



INS20...

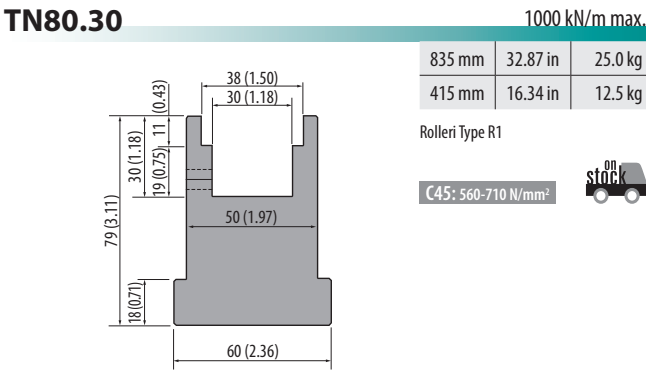


ROLLERI MARK FREE BENDING

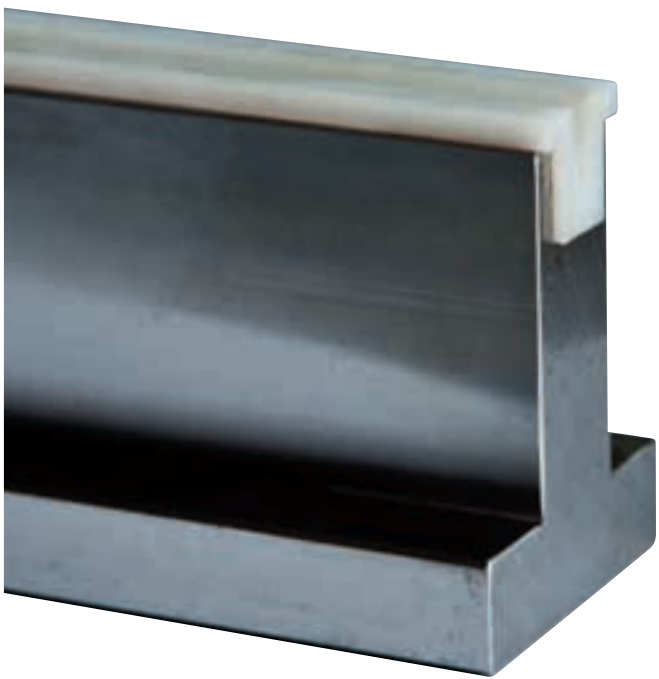
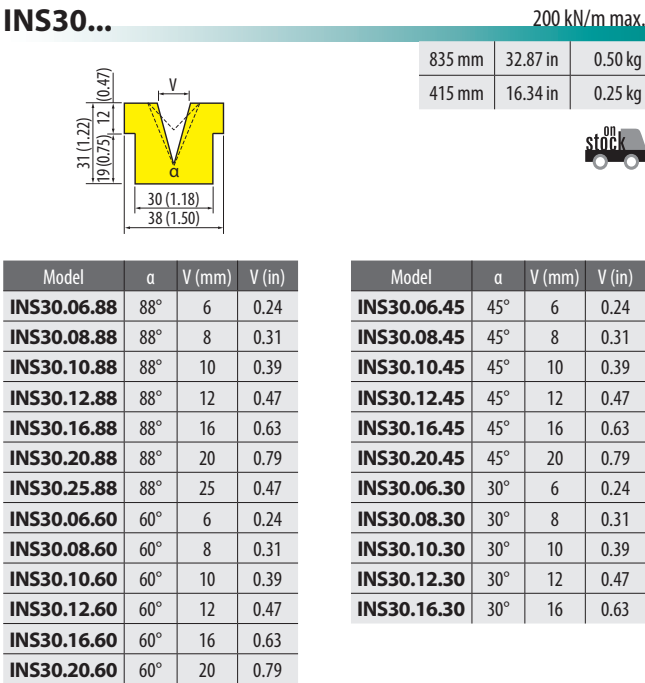
Synthetic Dies



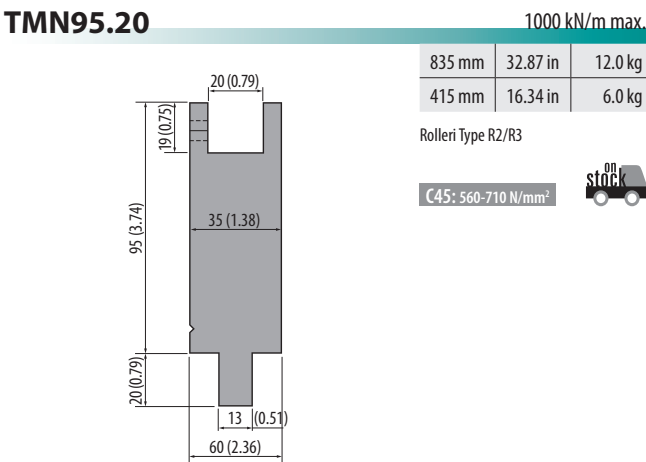
TN80.30



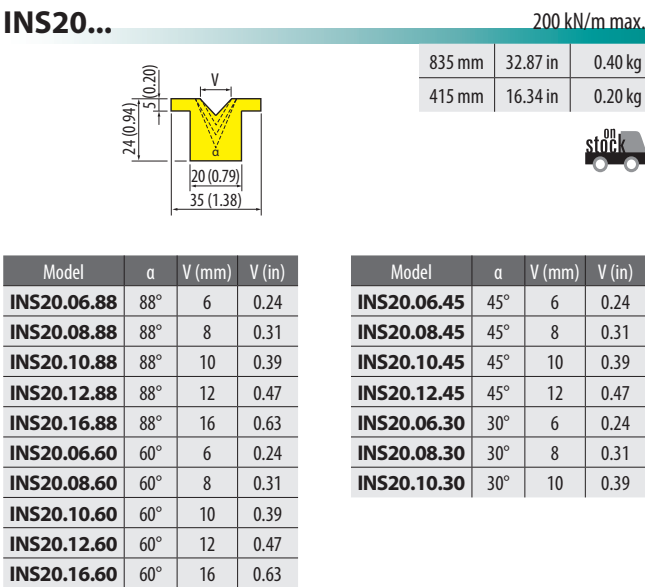
INS30...



TMN95.20



INS20...



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/mm²	29.1 - 36.9 HRC	54 - 60 HRC
C45	560-710 N/mm²	12 - 15.5 HRC	54 - 60 HRC
1.2767	830 N/mm²	22 - 25 HRC	54 - 60 HRC

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



Our Advantages – Your Convenience

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

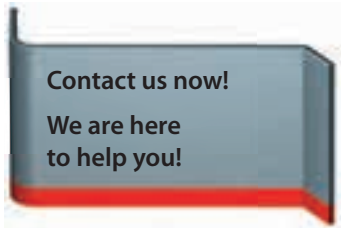
The Heavy Duty tools of Rolleri are built and finished for these challenges.

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

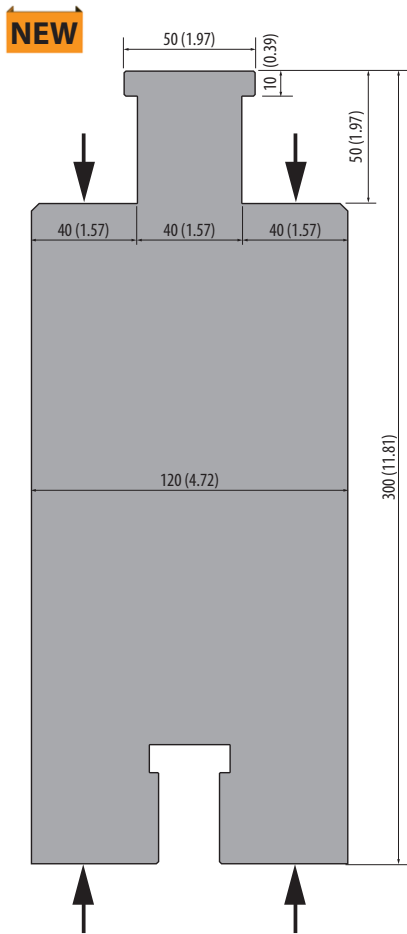
Our many years of experience in the area of special and heavy duty tooling, along with our own developing department, guarantee you functional and economic solutions in the bending sector.

From the compatible tang to the punch onto the compatible die; we manufacture everything in our own production facilities.

Take advantage of the direct contact to the manufacturer and the benefits which come along with it.



RHD.300

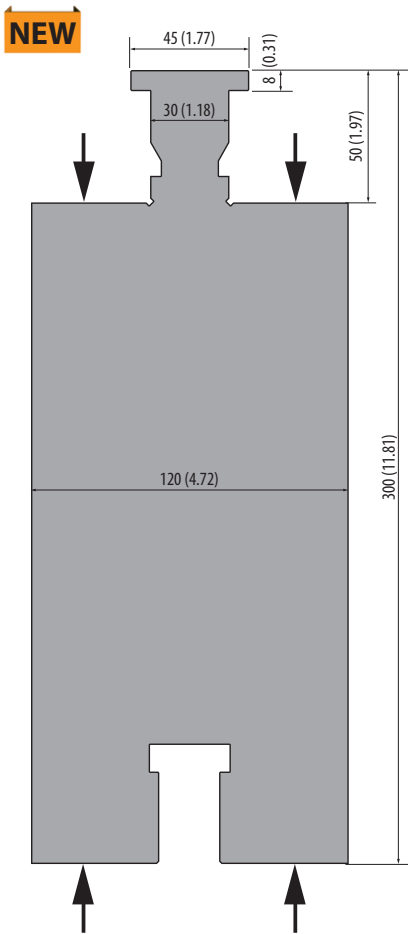


RHD.300-250		
500 mm	19.68 in	122.0 kg

RHD.300-400		
500 mm	19.68 in	122.0 kg

4000 kN/m max.
1.2767: 830 N/mm²

RHD.300 HYD

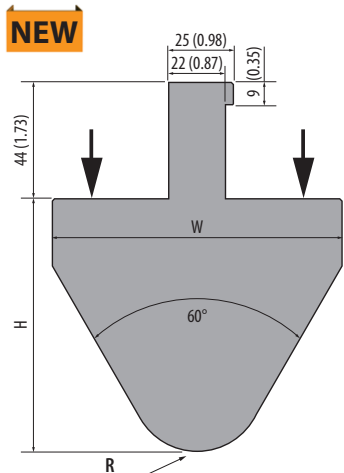


RHD.300-250 HYD		
500 mm	19.68 in	120.0 kg

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

4000 kN/m max.
1.2767: 830 N/mm²

RHDP.60



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

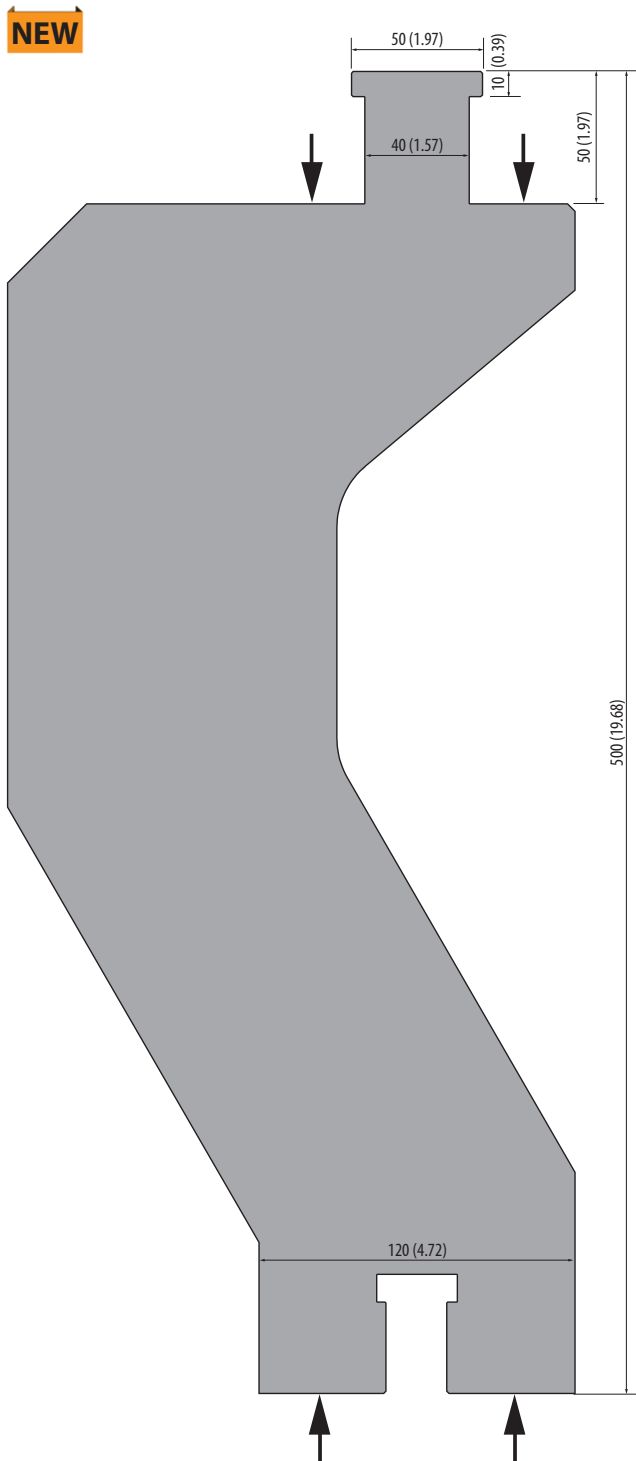
42Cr: 900-1150 N/mm²

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

1.2767: 830 N/mm²



RHD.500-200

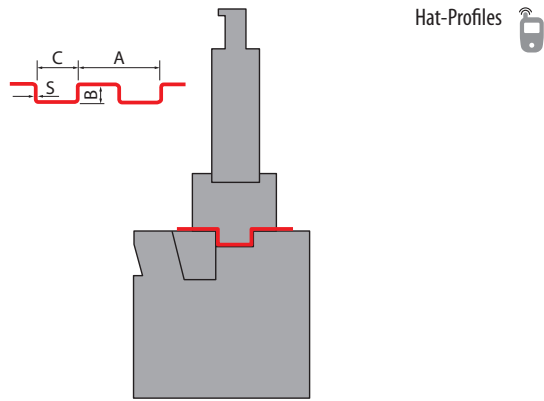


More Tools for Heavy Duty operations can be found on pages 156-158



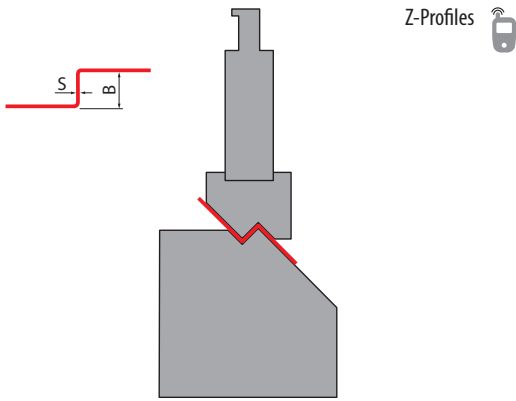
Tool examples

SPE1



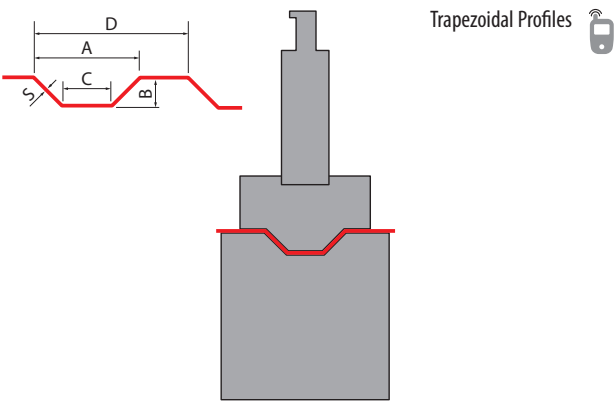
Hat-Profiles

SPE2



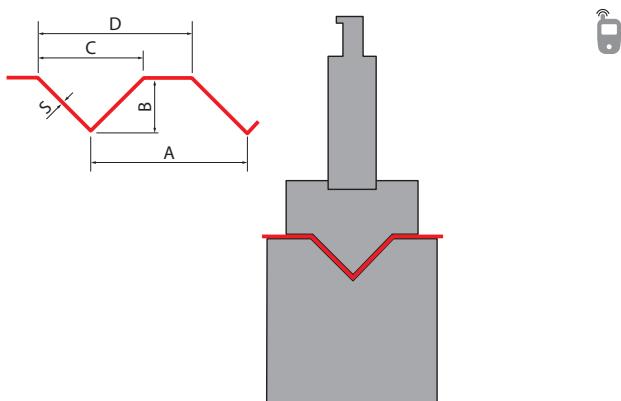
Z-Profiles

SPE3

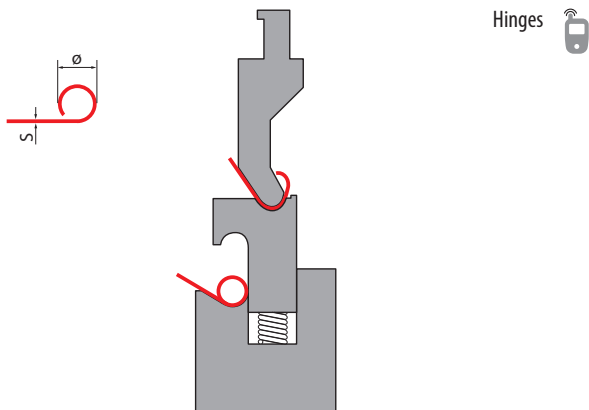


Trapezoidal Profiles

SPE4

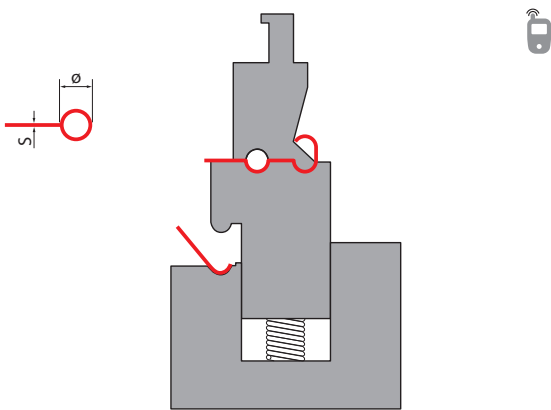


SPE5

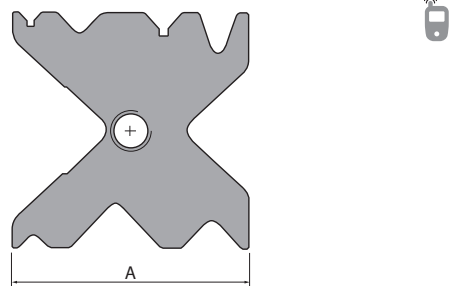


Hinges

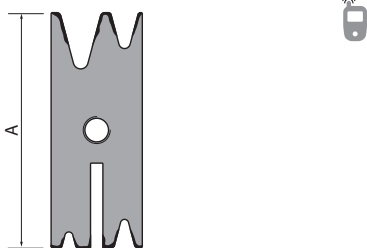
SPE6



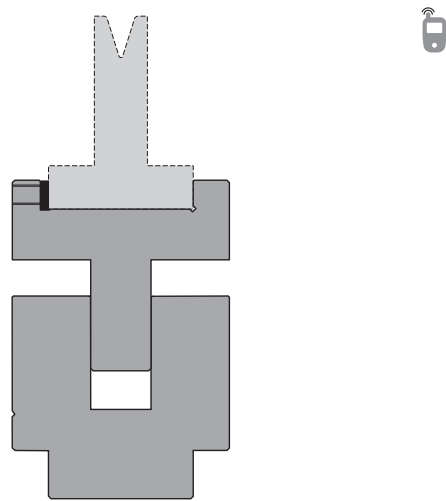
SPE7



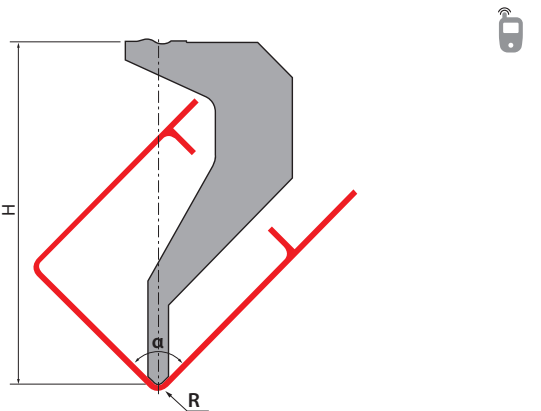
SPE-X



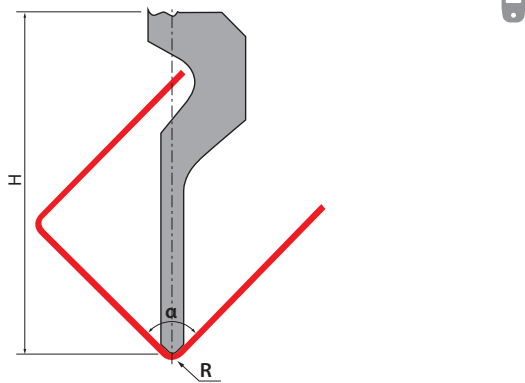
SPE9



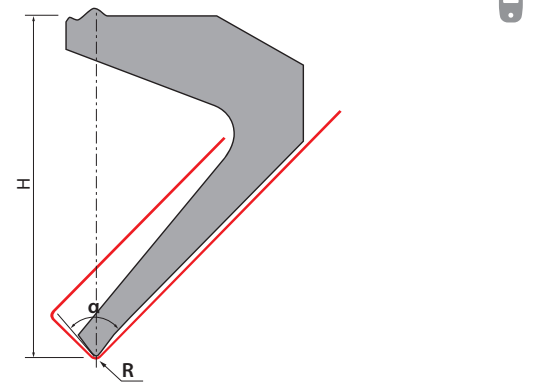
SPE-P1



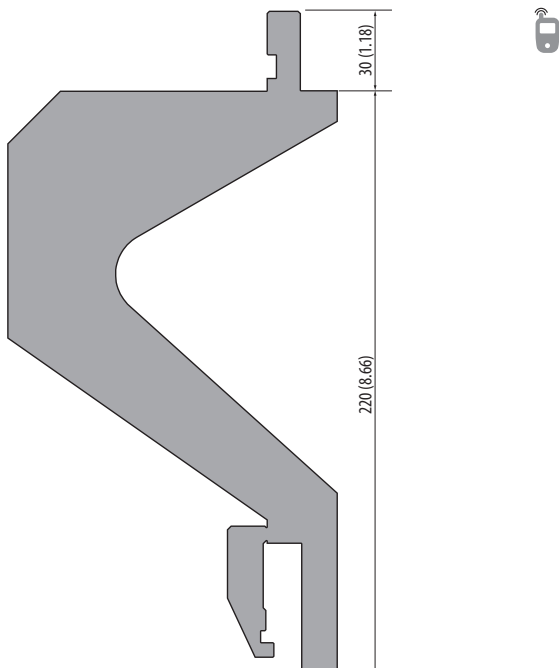
SPE-P2



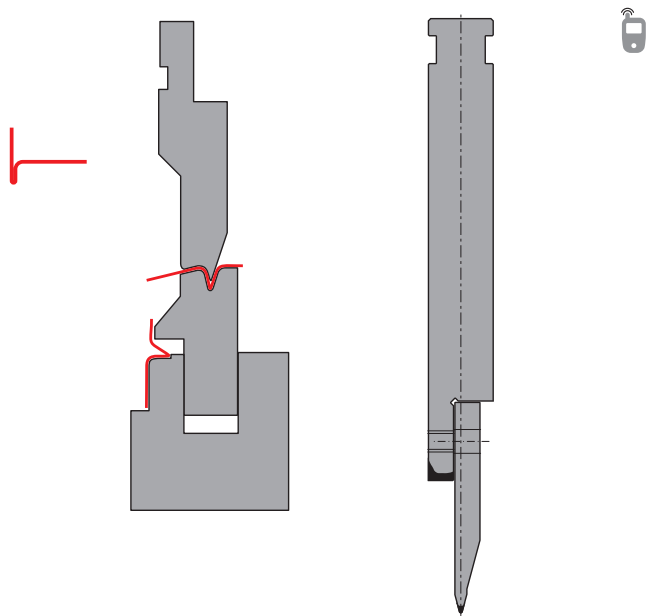
SPE-P3



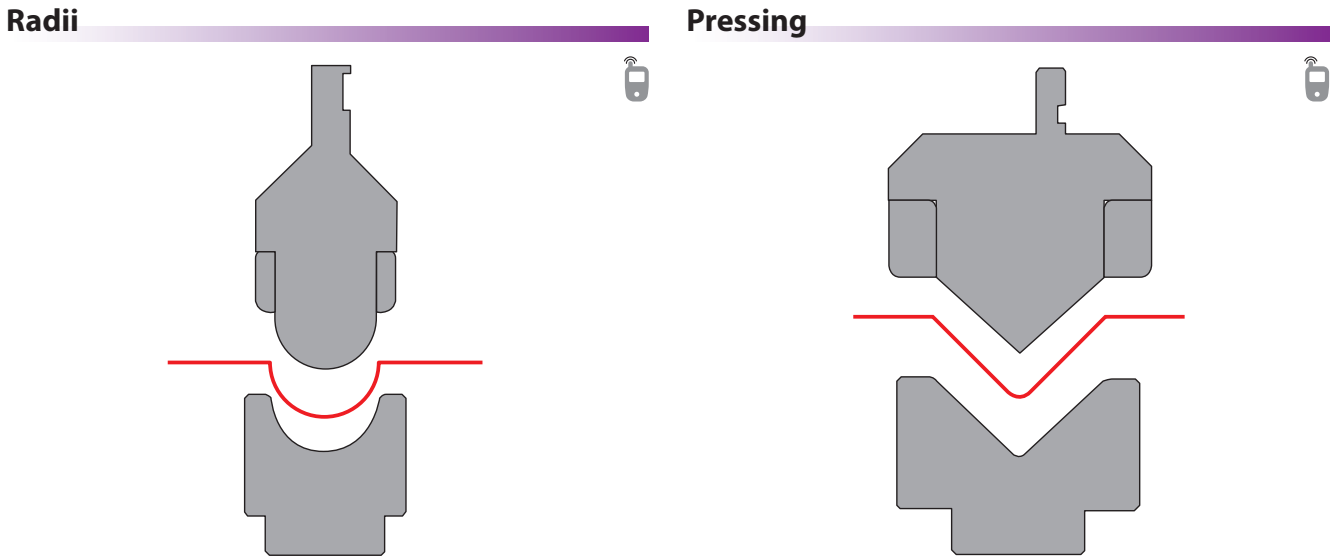
SPE-P4



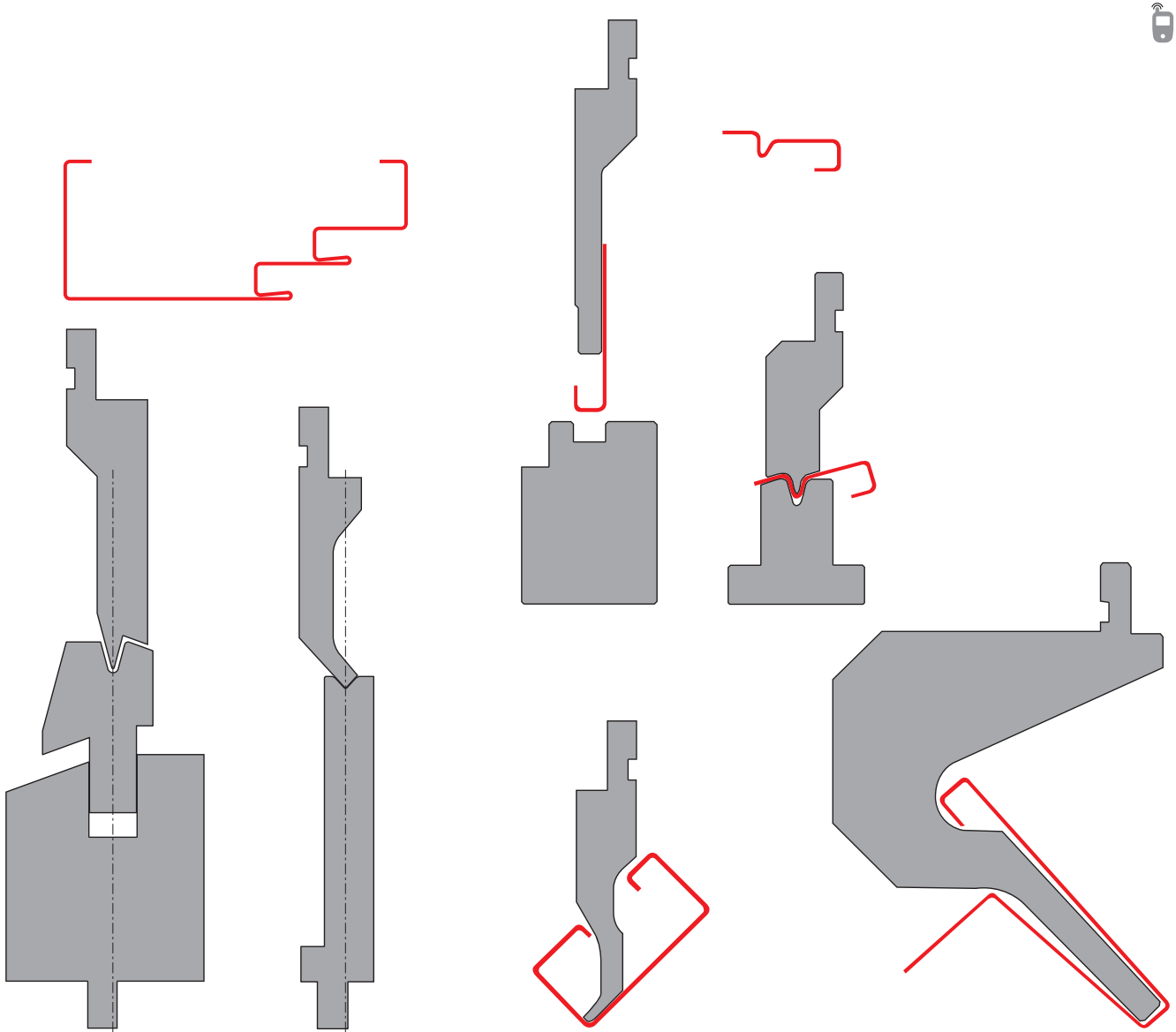
Front- and Hemming Tool (Foldings)



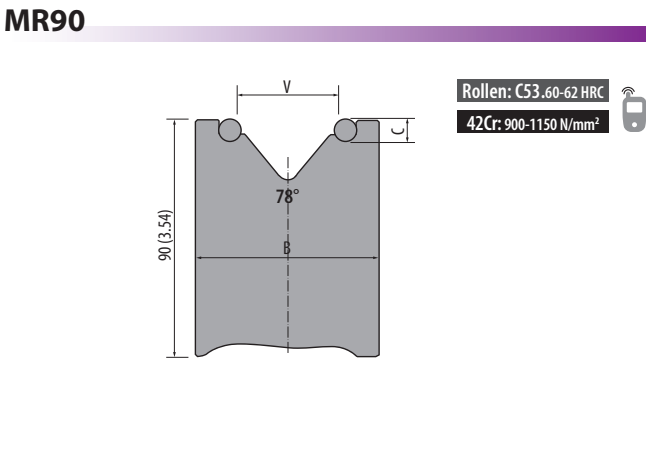
Tool examples



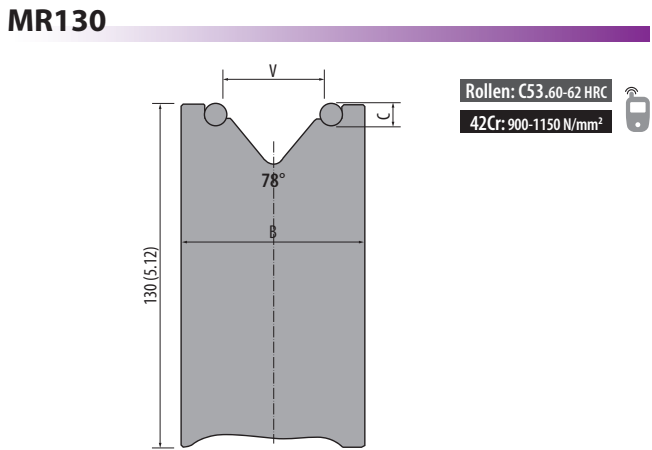
Special Profiles



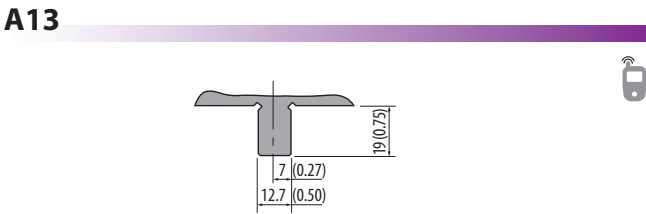
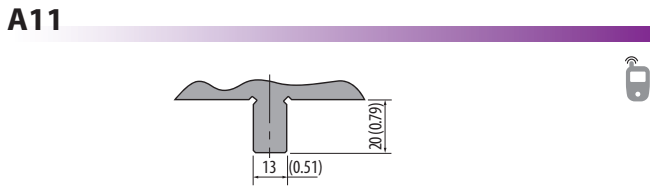
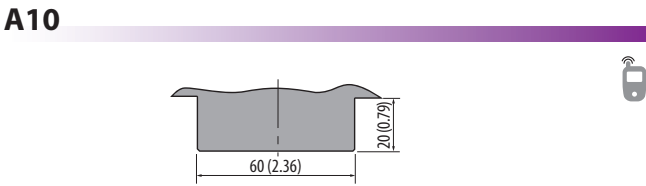
Dies with Rollers



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

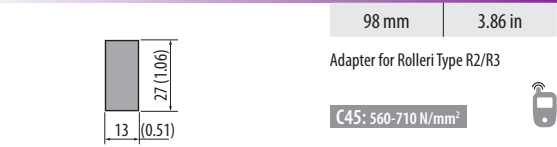


Our Advantages – Your Convenience

- 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

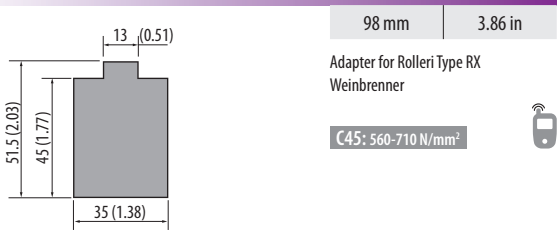
AD MR13

NEW



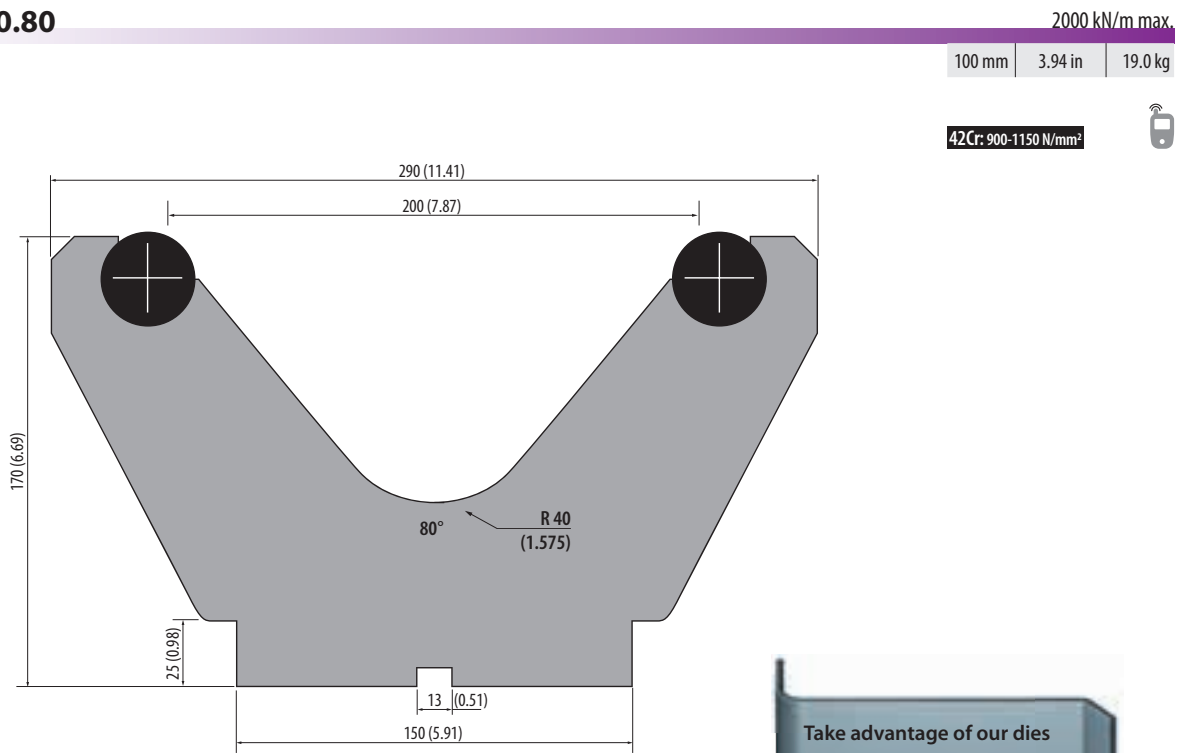
AD MR35

NEW



MR170.200.80

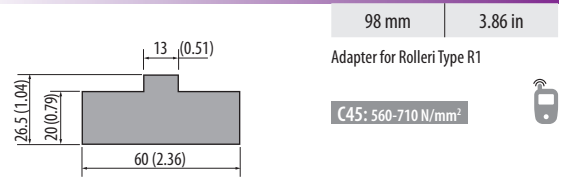
NEW



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

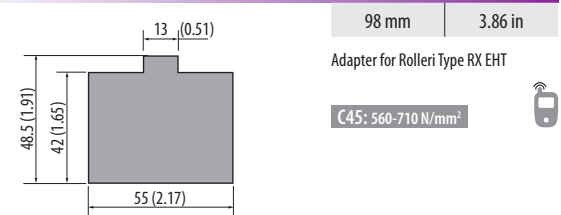
AD MR60

NEW



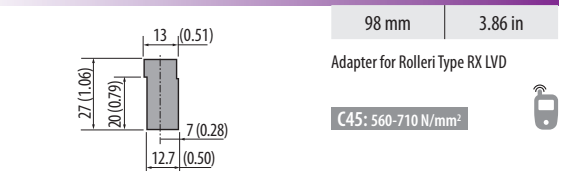
AD MR55

NEW



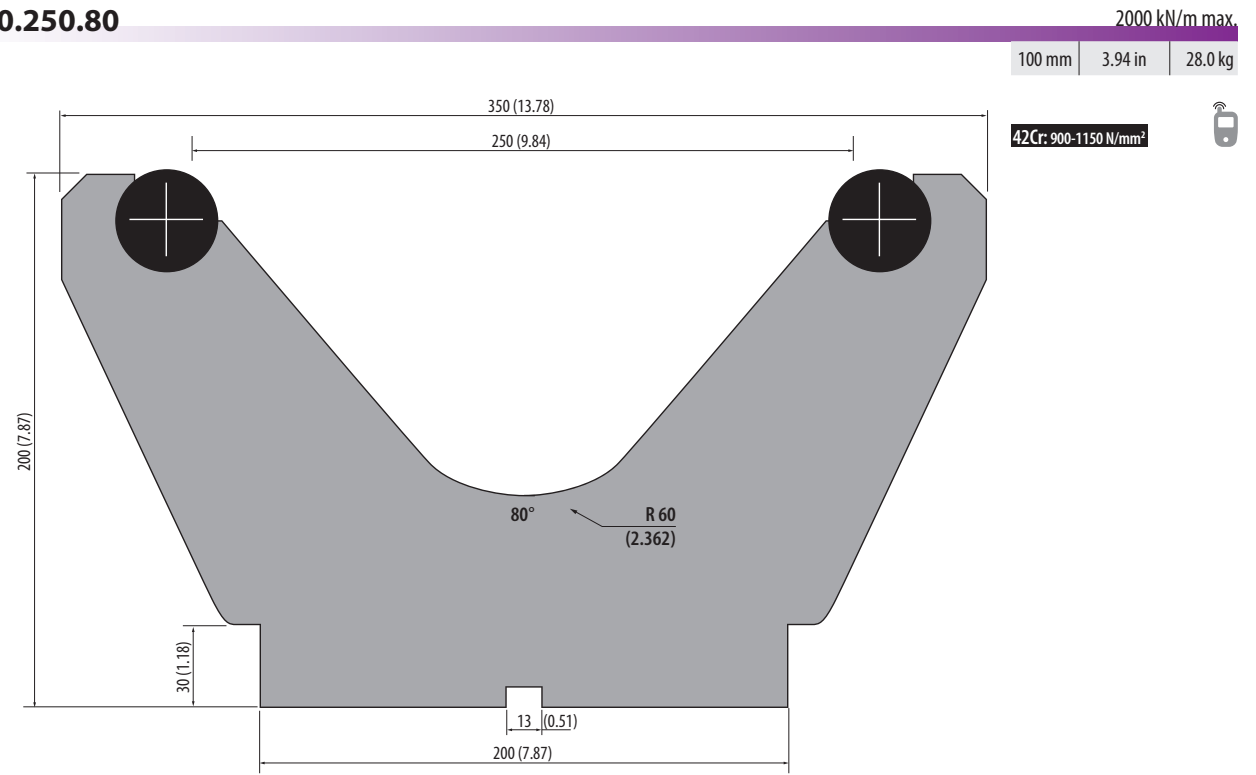
AD MR12.7

NEW



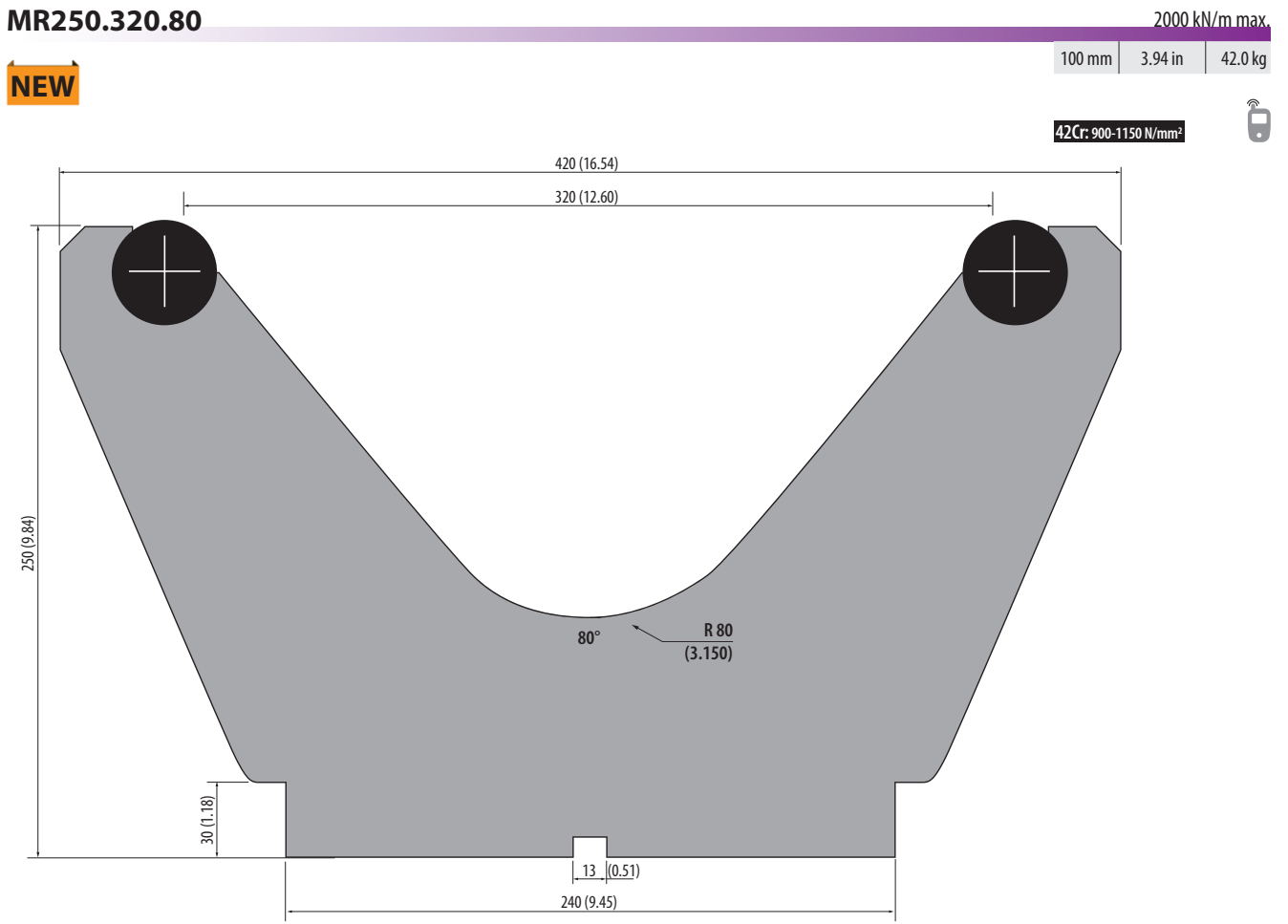
MR200.250.80

NEW



MR250.320.80

NEW



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

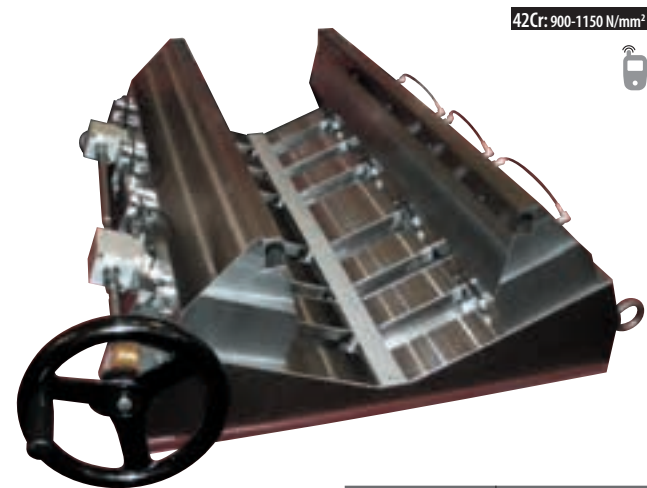
While using the manual version, the opening is set in place by a turn of the steering wheel, or with a gear reduction which is attached to the die.

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

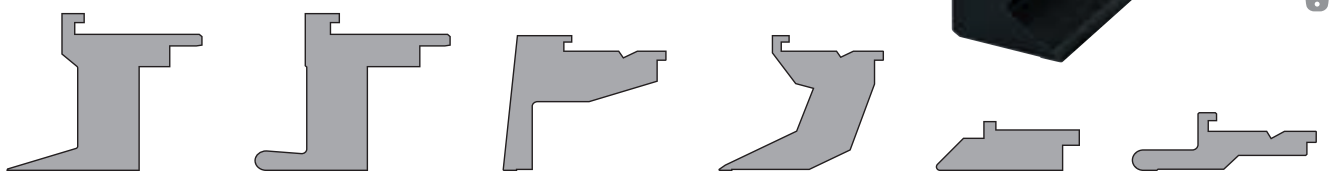
Application of various dies ROL6:
www.rolleritools.com/videos/rol6



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



Article on stock



Please ask for delivery time!

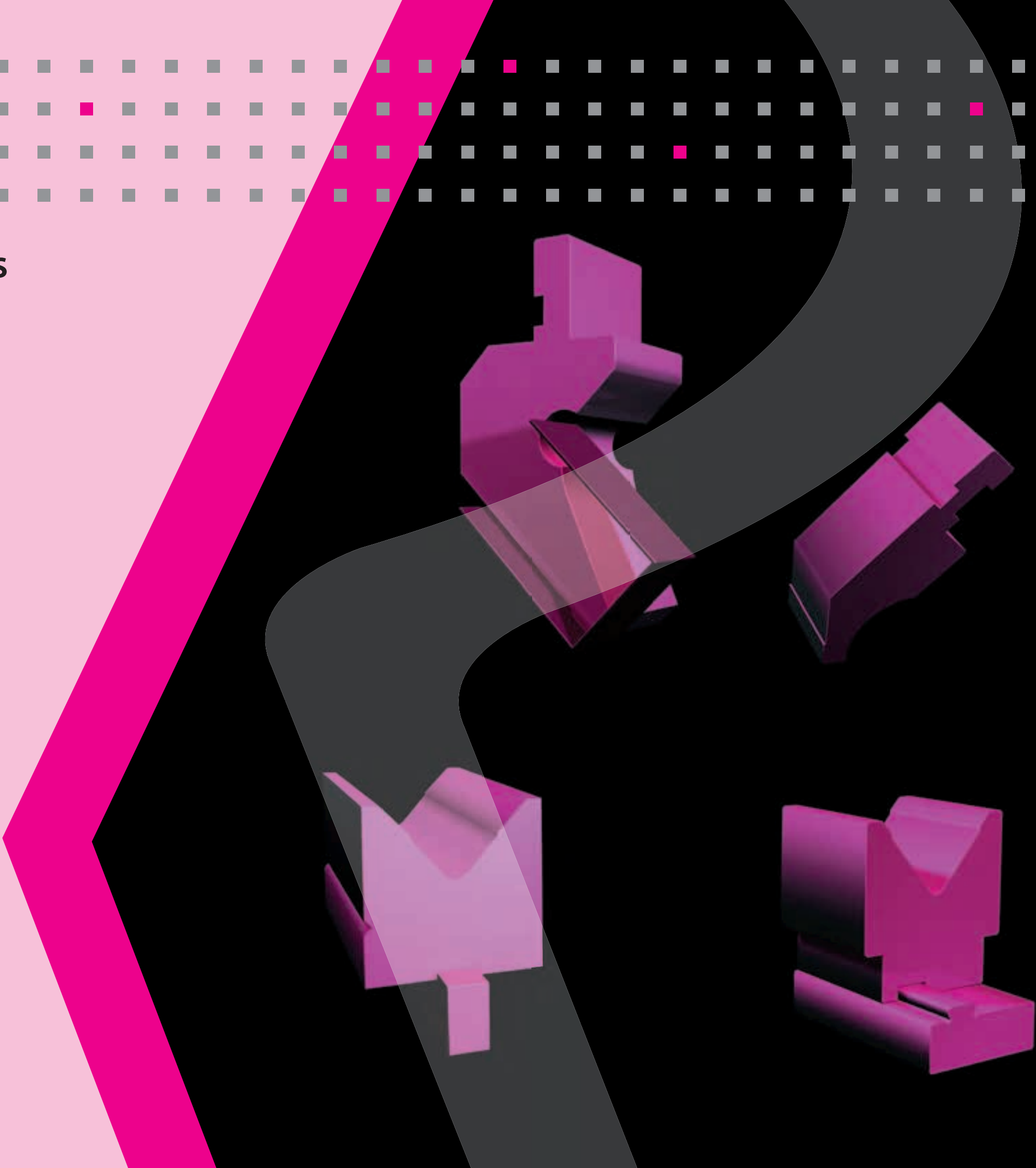
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

ROLLERI 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!

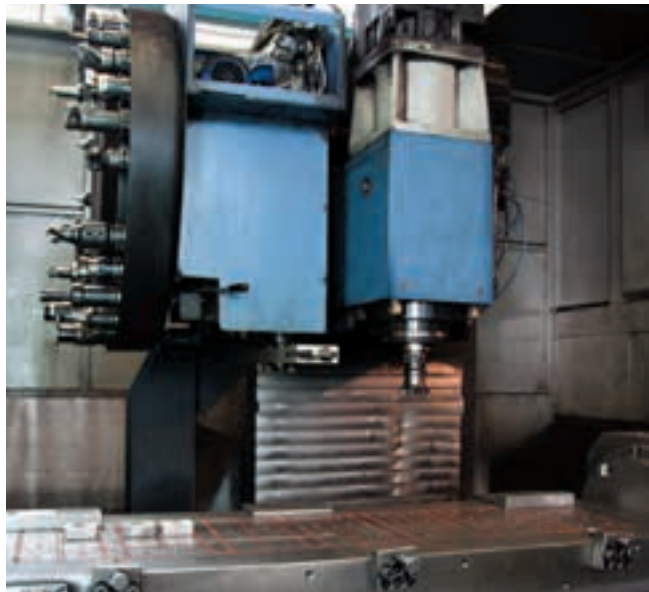


CNC-Milling

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.

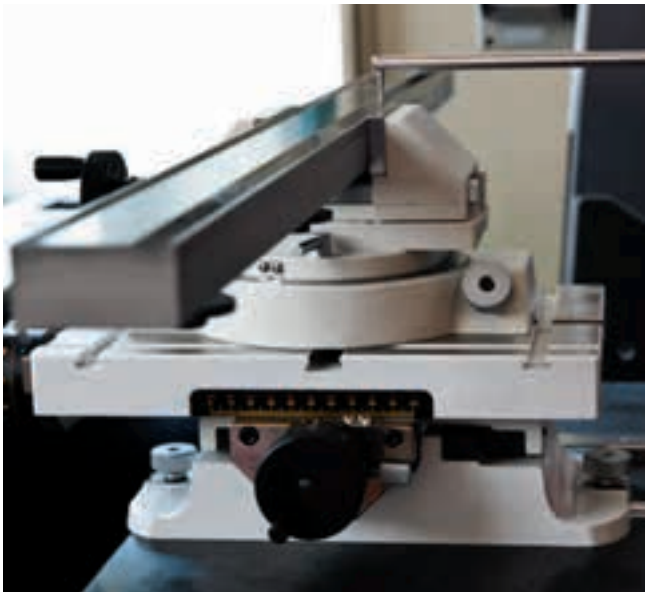
For more resistance strength the hardening of the surfaces can be increased. The depth of the hardening must be at least 3 mm to avoid deformations. We use the electromagnetic technique also known as induction hardening to the best quality for your money's worth.



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 meaasurements (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.



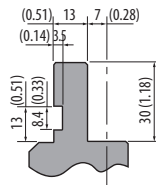
ROLLERI MODIFICATIONS

... 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, percise

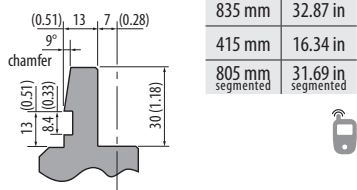
Standard Rolleri Type R1



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

OT

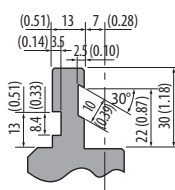
- Modification for:
- for Amada fast clamping system



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

A1

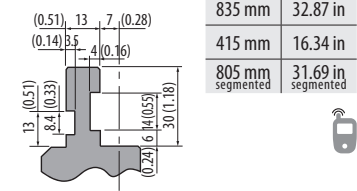
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- pneumatic clamping system



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

A6

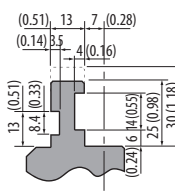
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove for:
- Rolleri Type R3
 - Bystronic-Beyeler Euro
 - Safan



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

A7

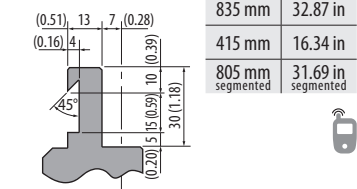
- Groove in addition to 8.4 x 3.5 mm (0.33 x 0.14 in) groove and shortened tang for:
- Rolleri Type R3
 - Bystronic-Beyeler Euro
 - Safan



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

A8

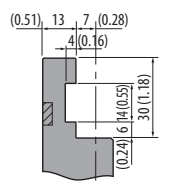
- Groove Bar/Tail for:
- hydraulic clamping system Gasparini



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

A41

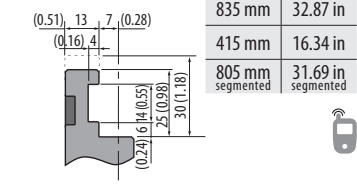
- older clamping system



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

A42

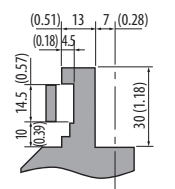
- older clamping system



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



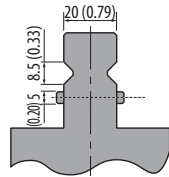
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

ROLLERI MODIFICATIONS

... for standard tangs

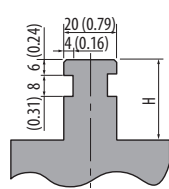


Standard Rolleri Type R2

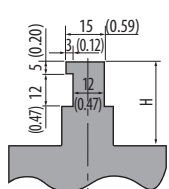


Modification examples Type R2

- production according to your specifications

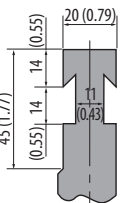


- production according to your specifications



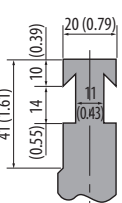
Take advantage of your existing tools with means of modifications.

Standard Rolleri Type R3

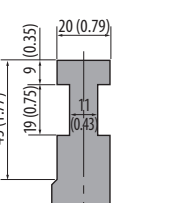


Modification examples Type R3

- production according to your specifications



- production according to your specifications



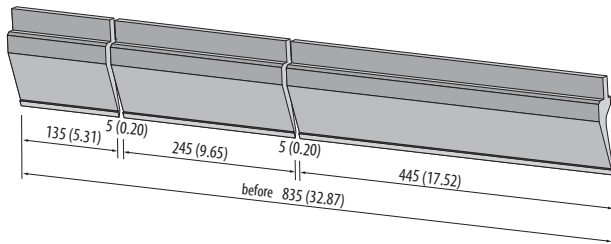
ROLLERI MODIFICATIONS

Special Sectioning

- Individual sectioning of your punches and dies
 - fast, economic, percise
- Pro separation cutting causes a decrease in length of approx. 5 mm

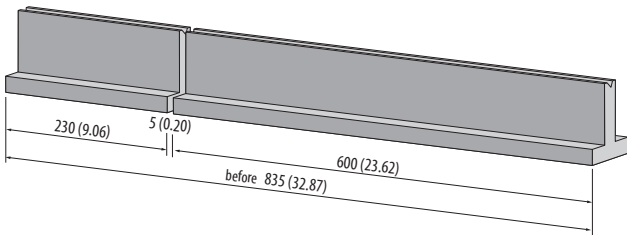
Special Sectioning of Punches

Example of punches production according to your specifications



Special Sectioning of Dies

Example of Dies production according to your specifications

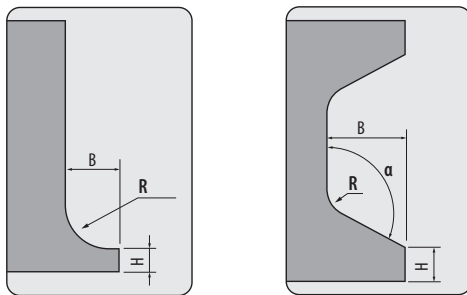


Horn Pieces

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

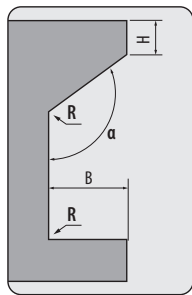
Horn Pieces for Punches

Punch example production according to your specifications



Horn Pieces for Dies

Die example production according to your specifications

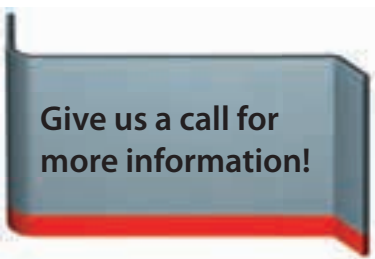
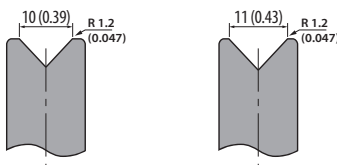


Modifying the V-Opening

- individual modification for dies
- fast, economic, percise

Modifying the V-Opening

Example production according to your specifications



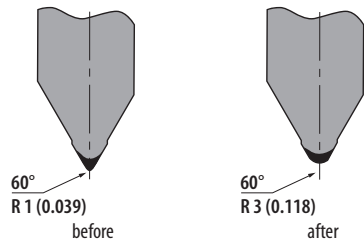
ROLLERI MODIFICATIONS

Radius and Angle Modifications

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

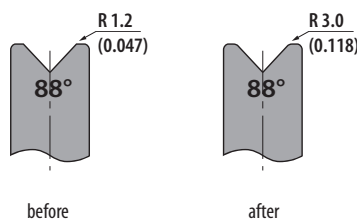
Radius Modifications for Punches

Radii modification Punch example production according to your specifications



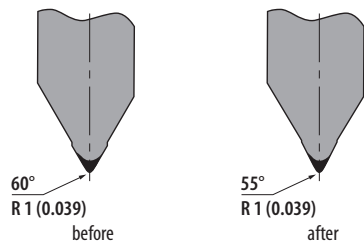
Radius Modifications for Dies

Opening Radius modification die example production according to your specifications



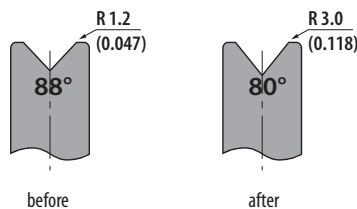
Angle Modification Punches

Angle modification punch example production according to your specifications



Angle Modification Dies

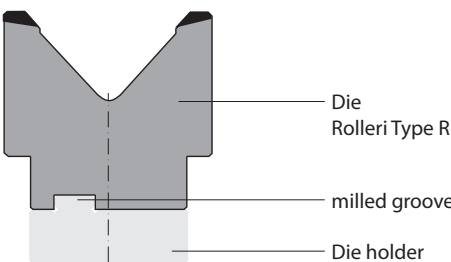
Angle modification die example production according to your specifications



Grooves for Dies

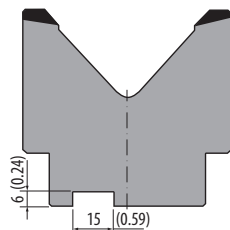
- Milling of grooves for use on other press brake systems
- fast, economic, percise

Mounting example



A28

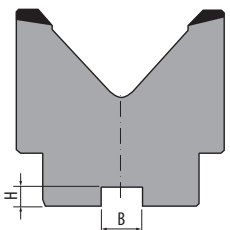
Groove for die holder



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

A29

groove production according to your specifications



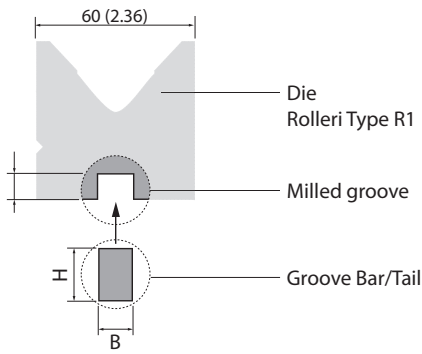
835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

ROLLERI MODIFICATIONS

Grooves und Groove Bars/Tails for Dies

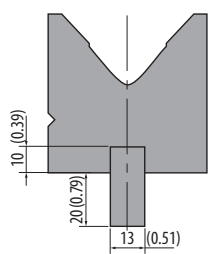
- For milling of the groove and the insert of a ground groove bar/tail the exact measurement is needed to use on other press brake systems
- fast, economic, percise

Mounting example



A30

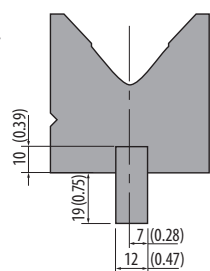
Groove Bars/Tails:
13 x 30 mm (0.51 x 1.18 in) for
• Roller Type R2
• Roller Type R3



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

A31

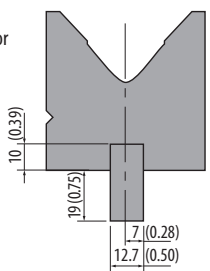
Groove Bars/Tails:
12 x 29 mm (0.47 x 1.14 in) for
• Roller Type RX LVD



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

A32

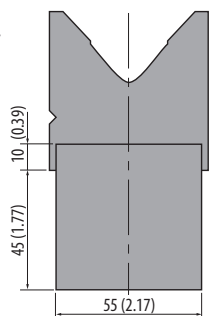
Groove Bars/Tails:
12.7 x 29 mm (0.50 x 1.14 in) for
• Roller Type RX LVD



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

A44

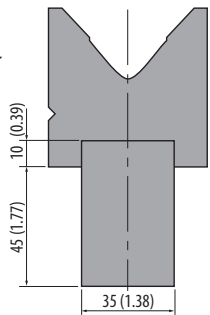
Groove Bars/Tails:
55 x 55 mm (2.17 x 2.17 in) for
• Roller Type RX EHT



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

A45

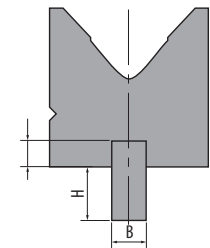
Groove Bars/Tails:
35 x 55 mm (1.38 x 2.17 in) for
• Roller Type RX Weinbrenner



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

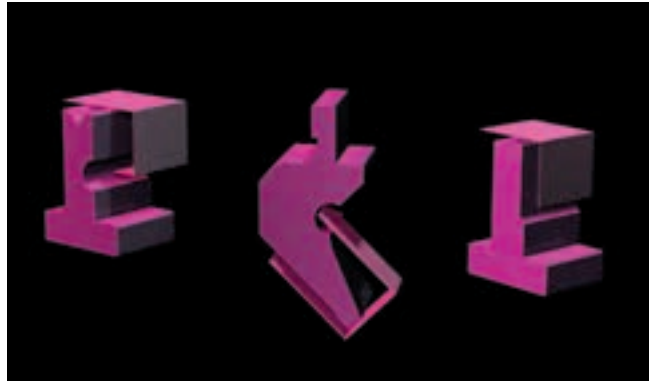


835 mm	32.87 in
415 mm	16.34 in
805 mm segmented	31.69 in segmented

ROLLERI MODIFICATIONS

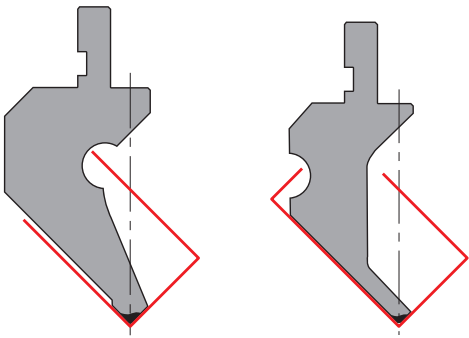
Gaps and Windows

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



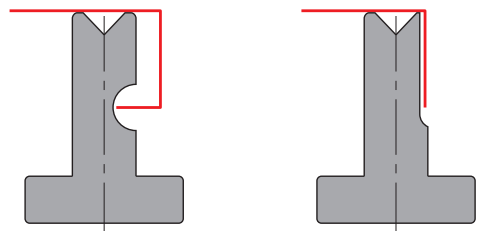
Gaps on Punches

Example Punches
production according to your specifications



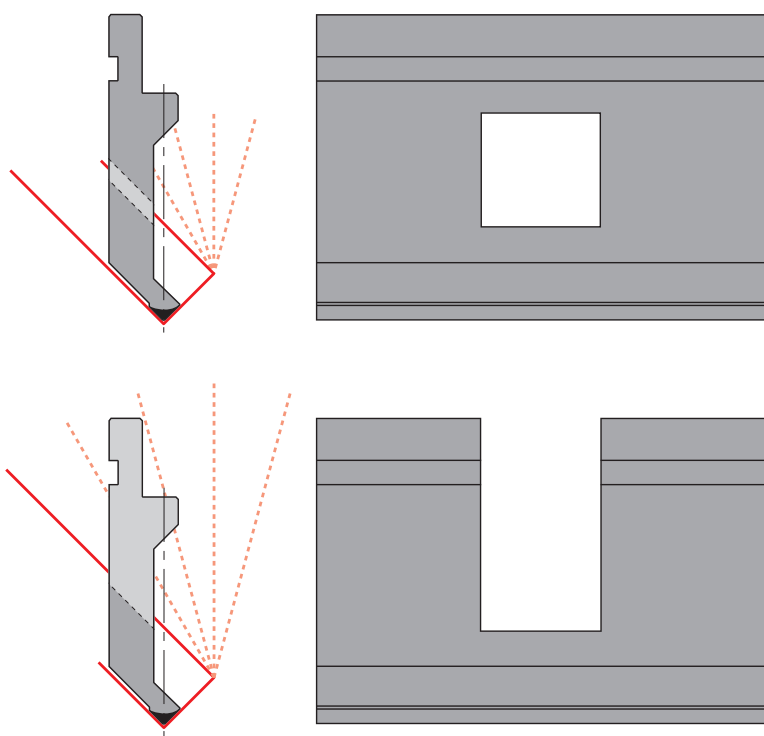
Gaps on Dies

Example Dies
production according to your specifications



Windows for Punches

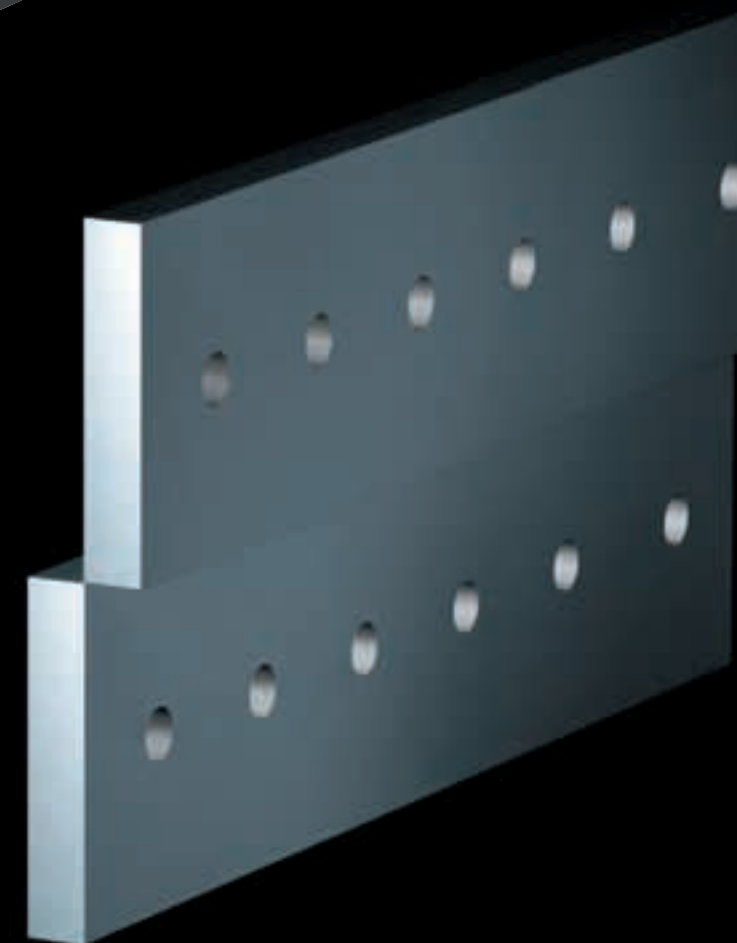
Example Punches
production according to your specifications



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 Rolleri Type R1
approx. 20 m (787.40 in)
Storage capacity



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

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



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

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



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

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



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

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



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

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

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



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

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



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

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

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



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

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

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



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

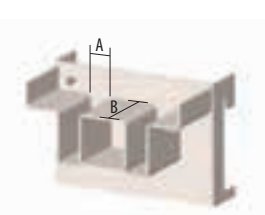
for tools Rolleri Type R2/R3
approx. 26 m / 41.6 m (1023.62 in / 1637.79 in) Storage capacity



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

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

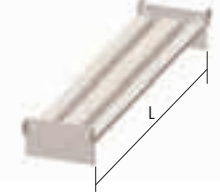
UC-Shelves



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

2 pieces

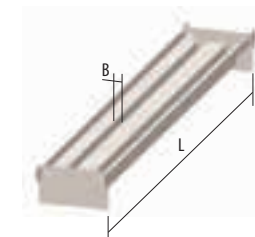
UT-Shelves



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

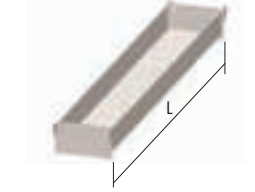
enough room for punches with safety pins

UL-Shelves



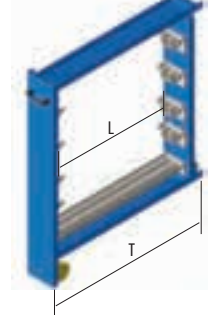
Model	L mm (in)	B mm (in)	Weight
UL-13-1	270 (10.63)	13 (0.51)	1.2 kg
UL-13-2	580 (22.83)	13 (0.51)	2.5 kg
UL-13-3	1050 (41.34)	13 (0.51)	4.6 kg
UL-13-4	1360 (53.54)	13 (0.51)	6.0 kg
UL-20-1	270 (10.63)	20 (0.79)	1.4 kg
UL-20-2	580 (22.83)	20 (0.79)	3.2 kg
UL-20-3	1050 (41.34)	20 (0.79)	5.8 kg
UL-20-4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

UV-Shelves



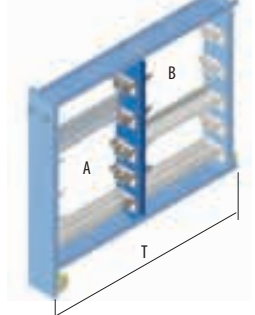
Model	L (mm)	L (in)	Weight
UV-1	270	10.63	1.0 kg
UV-2	580	22.83	2.0 kg
UV-3	1050	41.34	4.3 kg
UV-4	1360	53.54	5.5 kg

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



Article on stock



Please ask for delivery time!

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



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

ROLLERI ACCESSORIES

Tool Trolley

Our Advantages – Your Convenience

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

Tool Trolleys

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



Rolleri Videos

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

Bending Box

Bending Box



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

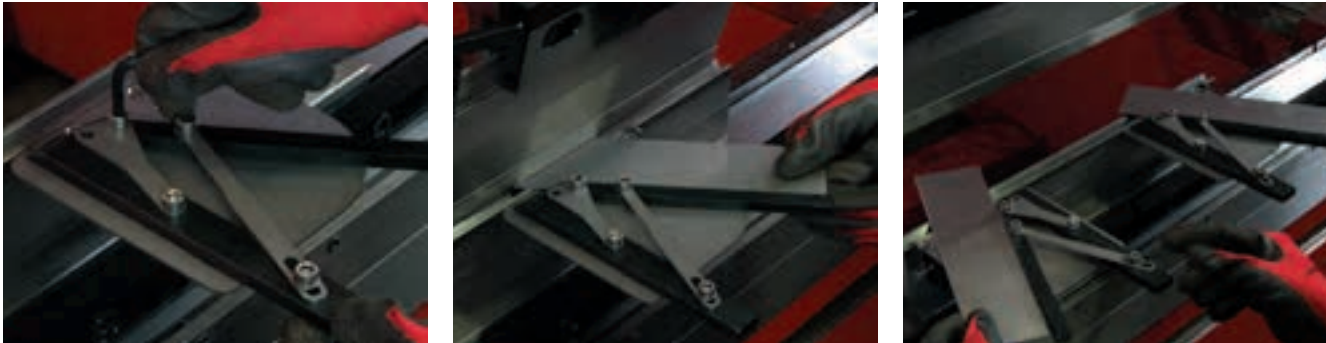
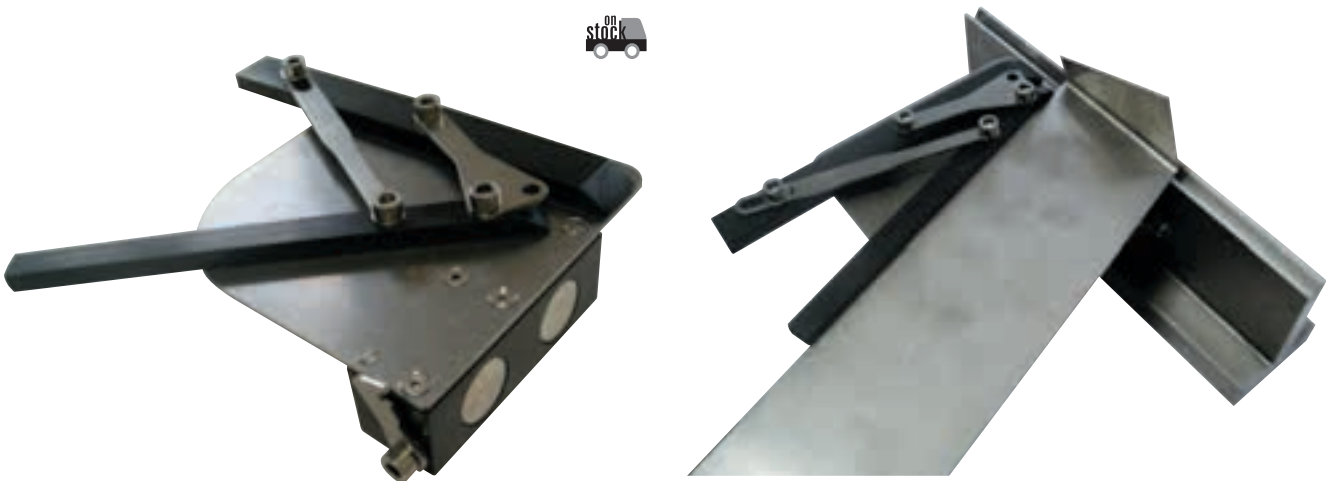


Rolleri Videos

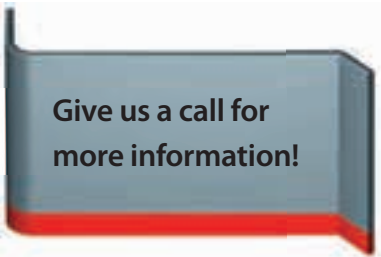
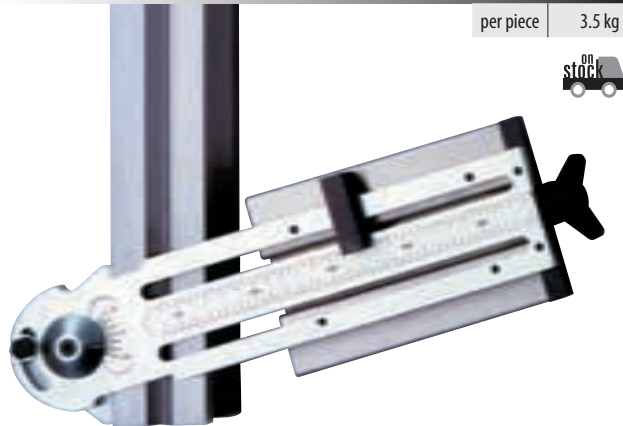
Magnetic Squaring Arms :
www.rolleritools.com/videos/squaring-arms

MSA – magnetic

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



AS



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

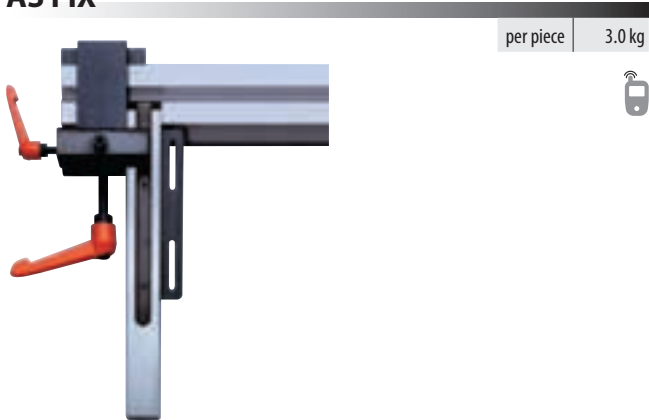
RP-Back Gauge



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



Shear Blades

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

High-quality steels are finished according to your specifications.

Please provide us with the following information:

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



ROLLERI SHEAR BLADES

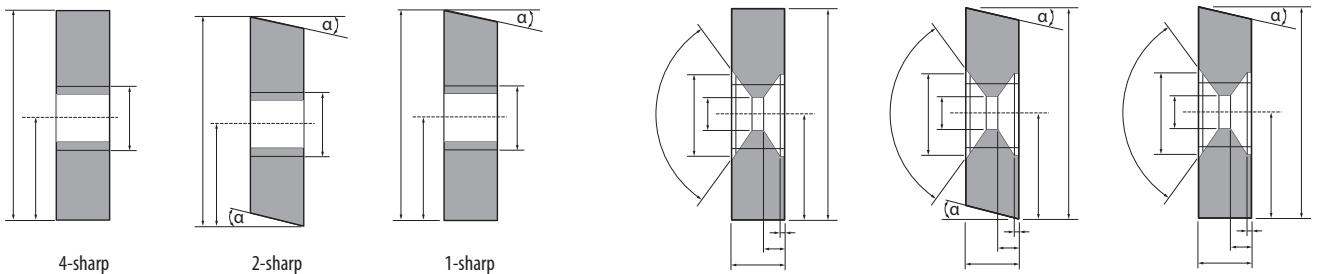
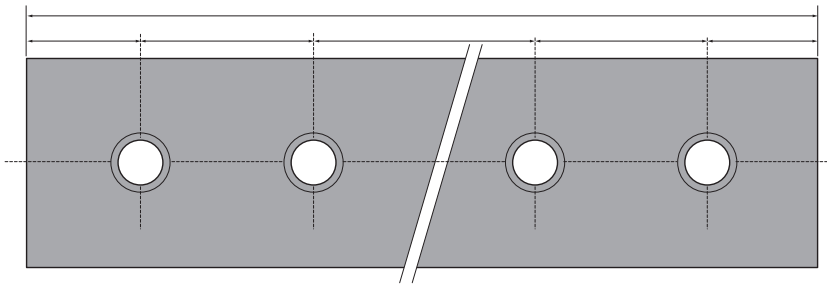
Shear Blades

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)				

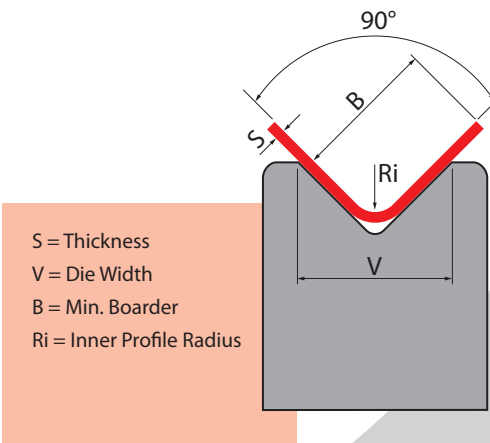


Press Force Table

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.



420 N/mm²																				
S (mm)	4	5	6	8	10	12	16	20	25	32	40	50	63	80	100	125	160	200	250	V
	3.0	3.5	4.0	5.5	6.5	8.0	10.5	13.0	16.5	21.0	26.0	32.5	41.0	52.0	65.0	81.5	104.0	130.0	163.0	B
	0,5	0,7	0,8	1,0	1,3	1,5	2,0	2,5	3,2	4,4	5,0	6,5	8,0	10,0	12,0	15,0	20,0	25,0	37,0	Ri
0.6	60	50	30	20																
0.8	120	90	70	50	40															
1.0		150	110	80	60	50														
1.2			180	120	90	70	50													
1.5				210	150	120	80	60												
2.0					300	230	160	120	90											
2.5						390	270	200	140	110										
3.0							430	310	230	160	120									
4.0								600	440	320	230	180								
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/mm²	r x 0.8	Al
60°	B x 1.1			
90°	B x 1.0	R=420 N/mm²	r x 1.0	Fe
120°	B x 0.9			
150°	B x 0.7	R=700 N/mm²	r x 1.4	INOX

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