


TOOLING COMPARISON CHART FOR BENDING CATALOG ITEMS

									
		EUROPEAN PRECISION	EUROPEAN FIXED HEIGHT	WT PRECISION	LVD PRECISION	AMERICAN PRECISION	BYSTRONIC PRECISION	AMERICAN CONVENTIONAL	V-SERIES BLACK (VSB) DIES
TOLERANCE	CRITICAL DIMS	± .0008"/.0004"	± .0008"/.0004"	± .0004"	± .0004"	± .0008"/.0004"	± .0004"	± .002"	± .0004"
	BOW/CAMBER	± .002"	± .002"	± .002"	± .002"	± .002"	± .002"	± .030"/6 Feet	± .002"
STAGED		No	Semi	Semi	Semi	Yes	No	No	No
HEAT TREAT	PUNCHES	Laser	Laser	Laser	Laser	Laser	Laser	Pre-Hard, Induction Option	—
	DIES	Laser/Nitrex* depends on V size		Laser/Nitrex* depends on V size		Laser/Nitrex* depends on V size			Through Hard
	HOLDERS	Nitrex*	Nitrex*	Nitrex*	Nitrex*	Nitrex*	Nitrex*		—
SURFACE FINISH		Ground	Ground	Ground	Ground	Ground	Ground	Planed	Ground
BASE STEEL		28-32 RC	28-32 RC	28-32 RC	28-32 RC	28-32 RC	28-32 RC	28-32 RC	55-60 RC
PUNCH PROFILES OFFERED		31	11	31	5	27	22	35	—
PUNCH ANGLES		90, 88, 85, 75, 60, 30, LR, FL	90, 86, 30	86, 60, 28, LR, FL	78, 26, 20	90, 88, 85, 75, 30, LR, FL	85, 30, 60, FL	88, 85, 30, FL	
SAFETY TANG	PUNCHES	Inverted	Inverted	Pin/Button	Button	Solid/Button < 28lbs	Inverted	Optional	
	PUNCH HOLDERS	Inverted	Inverted	Pin/Button	MTO		Inverted	Solid	
PUNCH TANG/MOUNTING		one, 14mm wide	one, 14mm	two or one, .787"/20mm	one, .787"/20mm	two, .500"	.787"/20mm	two, .500"	
PUNCH HARDNESS		55-60 RCS	55-60 RCS	55-60 RCS	55-60 RCS	55-60 RCS	55-60 RCS	28-32 RCS	
DIE PROFILES OFFERED		17	2	7	3	7	11	4	6
DIE ANGLES OFFERED		90, 88, 85, 80, 75, 45, 30, FL	90, 86, 30	86, 84, 80, 30, FL	78, 60, 30, Hem	90, 88, 85, 75, 30, FL	85, 30, 60, 80, FL	89, 85, 30, FL	180-34
DIE TANG/MOUNTING		Rail, QC 1V, 60mm, all bottom load	Rail, QC	.512"/13mm, Shoulder Load	.500", Shoulder Load, Off Center	.500", Shoulder Load	.512"/13mm, Shoulder Load	.500", Shoulder Load	AM/EU/WT Shoulder Load
DIE URETHANE OFFERED		2v	No	No	No	Not Staged	No	—	No
DIE HARDNESS		68-70 RCS or 55-60 RCS	68-70 RCS or 55-60 RCS	68-70 RCS or 55-60 RCS	68-70 RCS or 55-60 RCS	68-70 RCS or 55-60 RCS	68-70 RCS or 55-60 RCS	28-32 std, 55-60 opt	55-60 RCS
DIE SHOULDER CALL OUT		Theo Sharp	Theo Sharp	Radius End (6) or Theo Sharp (9)	Stone Radius (multiple blended)	Theo Sharp or Radius Center 30°	Theo Sharp	Theo Sharp	Theo Pivot Point

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