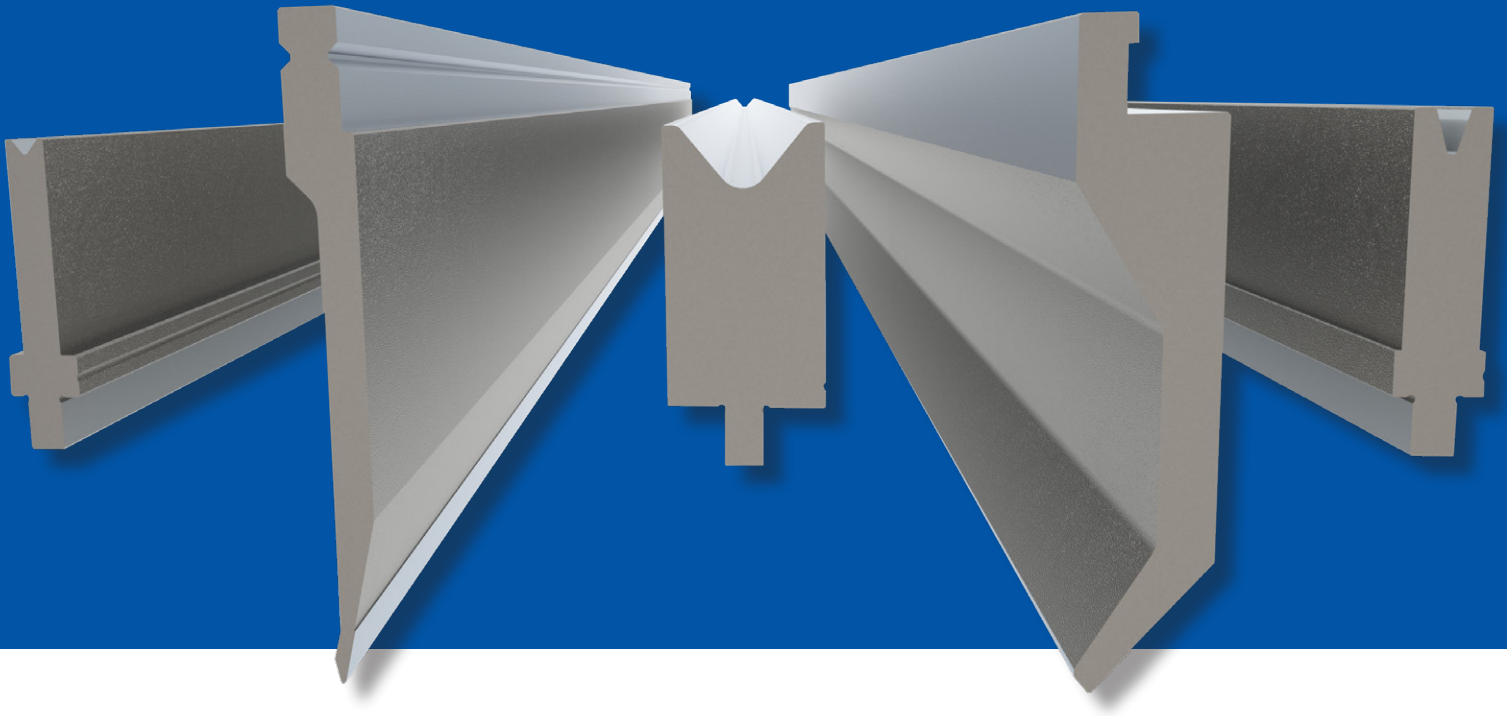


LVD STYLE | Pressbrake Tooling





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HEMMING

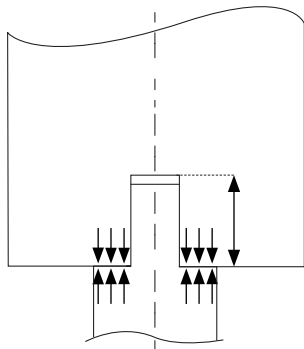
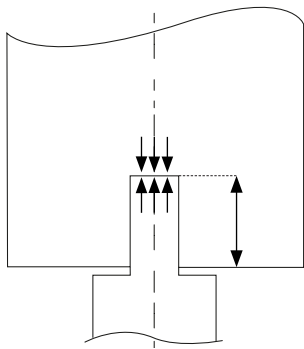
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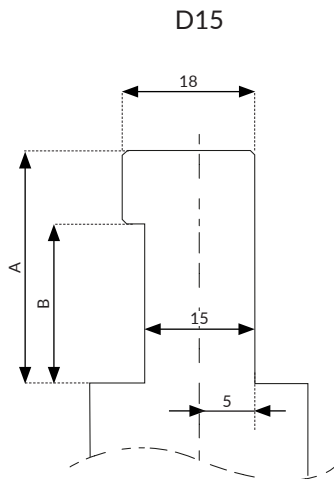
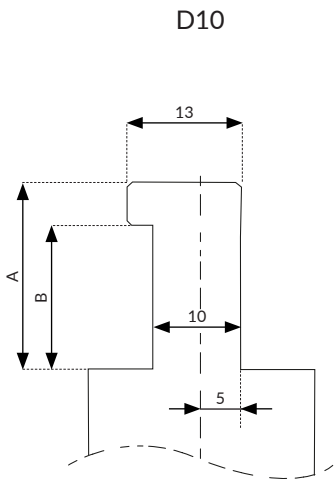
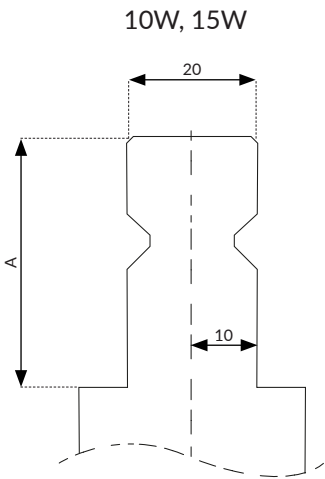


Punch Tang Clamping



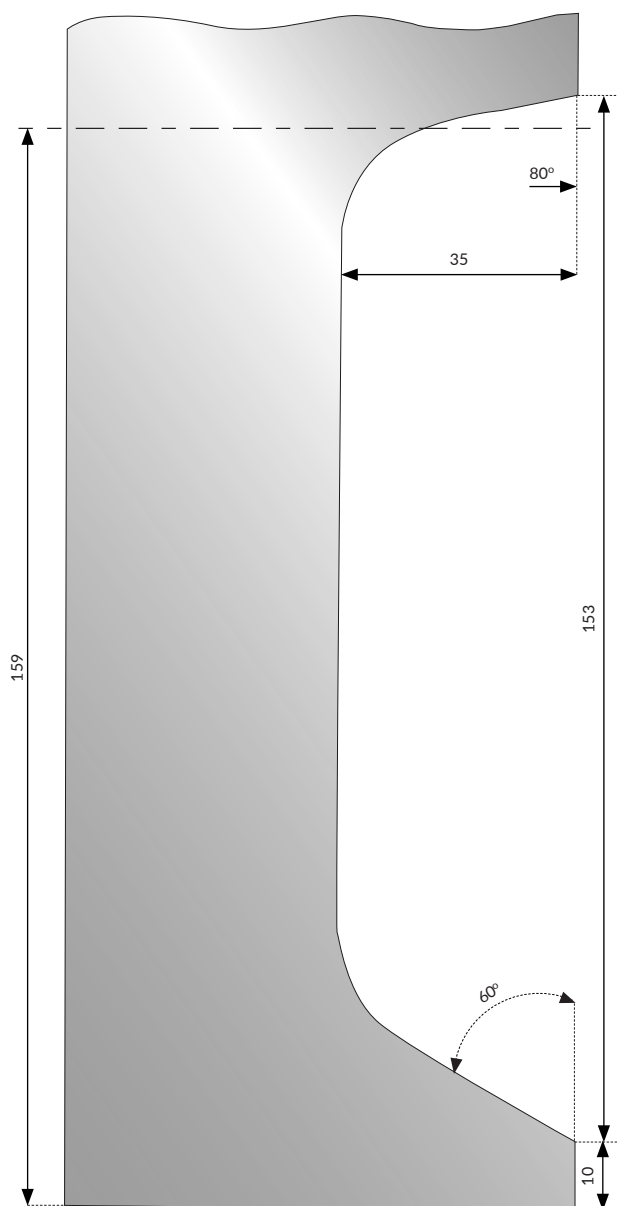
TOP BEARING	A (mm)	B (mm)	C (mm)
W	39	-	37
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SHOULDER BEARING	A (mm)	B (mm)	C (mm)
W	36	-	37
LVD10	20	16	21
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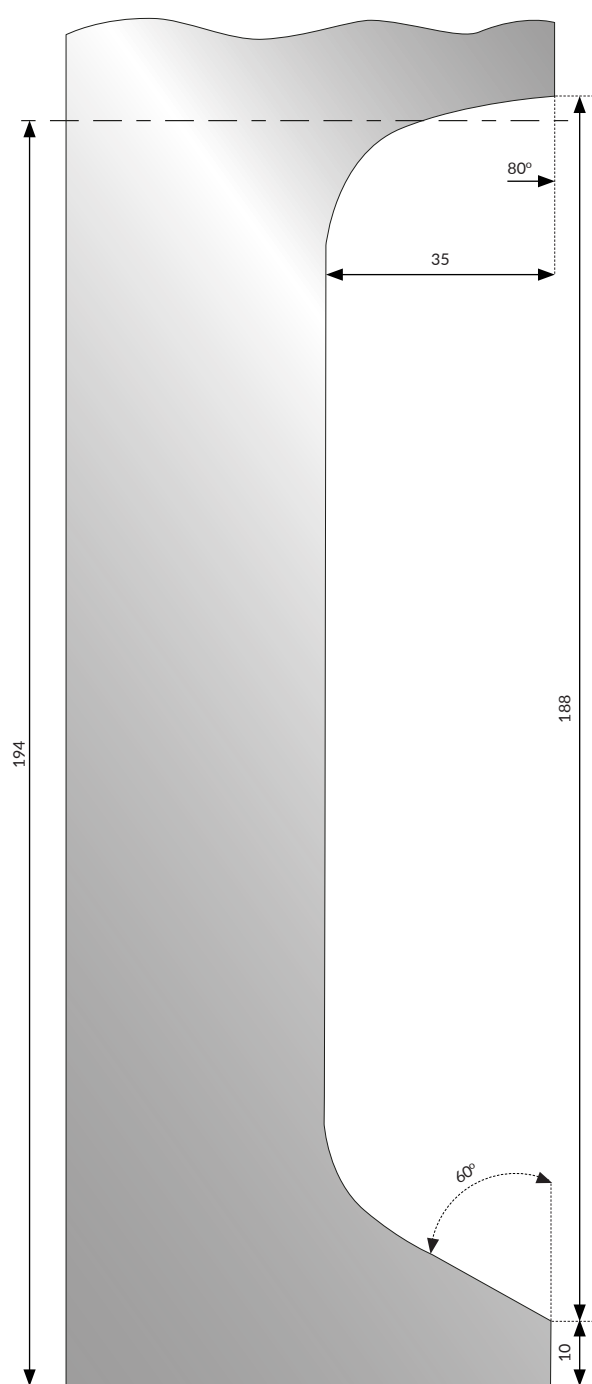


Ears/Horns

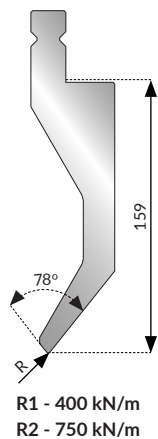
10W and D10



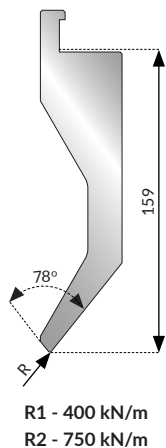
15W and D15



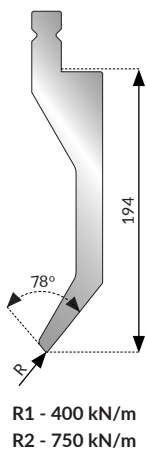
78° Punches



LVD PROFILE D10W		H	L	CATALOGUE NO.	PRICE
78°	R1	159mm	510mm	E80078010-510W	
		159mm	550mm sect.	E80078010-550W	
		159mm	250mm	E80078010-250W	
	R2	159mm	510mm	E80078020-510W	
		159mm	550mm sect.	E80078020-550W	
		159mm	250mm	E80078020-250W	

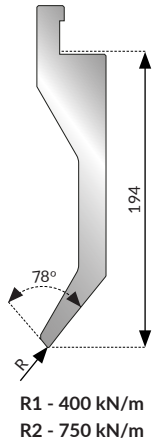


LVD PROFILE D10		H	L	CATALOGUE NO.	PRICE
78°	R1	159mm	510mm	E80078010-510	
		159mm	550mm sect.	E80078010-550	
		159mm	250mm	E80078010-250	
	R2	159mm	510mm	E80078020-510	
		159mm	550mm sect.	E80078020-550	
		159mm	250mm	E80078020-250	

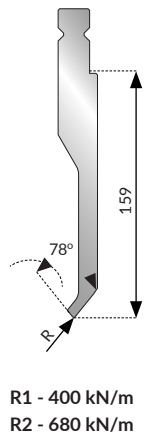


LVD PROFILE D15W		H	L	CATALOGUE NO.	PRICE
78°	R1	194mm	510mm	E81078010-510W	
		194mm	550mm sect.	E81078010-550W	
		194mm	250mm	E81078010-250W	
	R2	194mm	510mm	E81078020-510W	
		194mm	550mm sect.	E81078020-550W	
		194mm	250mm	E81078020-250W	

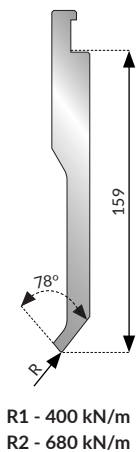
78° Punches



LVD PROFILE D15		H	L	CATALOGUE NO.	PRICE
78°	R1	194mm	510mm	E81078010-510	
		194mm	550mm sect.	E81078010-550	
		194mm	250mm	E81078010-250	
	R2	194mm	510mm	E81078020-510	
		194mm	550mm sect.	E81078020-550	
		194mm	250mm	E81078020-250	

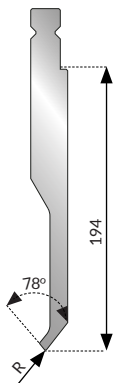


LVD PROFILE E10W		H	L	CATALOGUE NO.	PRICE
78°	R1	159mm	510mm	E80178010-510W	
		159mm	550mm sect.	E80178010-550W	
		159mm	250mm	E80178010-250W	
	R2	159mm	510mm	E80178020-510W	
		159mm	550mm sect.	E80178020-550W	
		159mm	250mm	E80178020-250W	



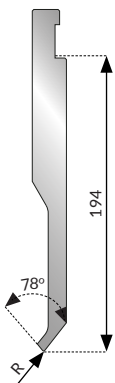
LVD PROFILE E10		H	L	CATALOGUE NO.	PRICE
78°	R1	159mm	510mm	E80178010-510	
		159mm	550mm sect.	E80178010-550	
		159mm	250mm	E80178010-250	
	R2	159mm	510mm	E80178020-510	
		159mm	550mm sect.	E80178020-550	
		159mm	250mm	E80178020-250	

78°, 26° Punches



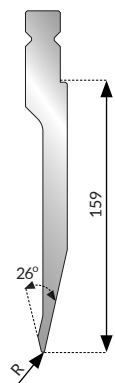
R1 - 400 kN/m
R2 - 750 kN/m

LVD PROFILE E15W		H	L	CATALOGUE NO.	PRICE
78°	R1	194mm	510mm	E81178010-510W	
		194mm	550mm sect.	E81178010-550W	
		194mm	250mm	E81178010-250W	
	R2	194mm	510mm	E81178020-510W	
		194mm	550mm sect.	E81178020-550W	
		194mm	250mm	E81178020-250W	



R1 - 400 kN/m
R2 - 750 kN/m

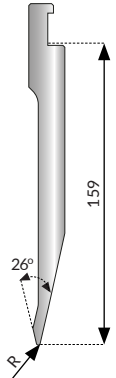
LVD PROFILE E15		H	L	CATALOGUE NO.	PRICE
78°	R1	194mm	510mm	E81178010-510	
		194mm	550mm sect.	E81178010-550	
		194mm	250mm	E81178010-250	
	R2	194mm	510mm	E81178020-510	
		194mm	550mm sect.	E81178020-550	
		194mm	250mm	E81178020-250	



R1 - 400 kN/m
R2 - 600 kN/m

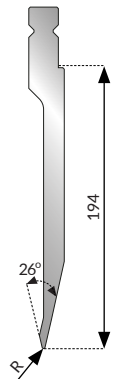
LVD PROFILE J10W		H	L	CATALOGUE NO.	PRICE
26°	R1	159mm	510mm	E80226010-510W	
		159mm	550mm sect.	E80226010-550W	
		159mm	250mm	E80226010-250W	
	R2	159mm	510mm	E80226020-510W	
		159mm	550mm sect.	E80226020-550W	
		159mm	250mm	E80226020-250W	

26° Punches



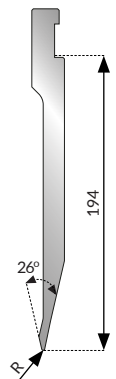
R1 - 400 kN/m
R2 - 600 kN/m

LVD PROFILE J10		H	L	CATALOGUE NO.	PRICE
26°	R1	159mm	510mm	E80226010-510	
		159mm	550mm sect.	E80226010-550	
		159mm	250mm	E82526010-250	
	R2	159mm	510mm	E80226020-510	
		159mm	550mm sect.	E80226020-550	
		159mm	250mm	E80226020-250	



R1 - 400 kN/m
R2 - 600 kN/m

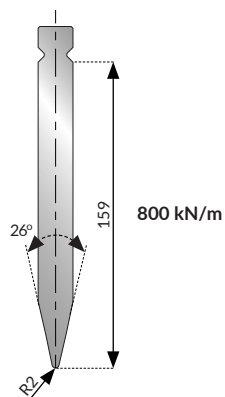
LVD PROFILE J15W		H	L	CATALOGUE NO.	PRICE
26°	R1	194mm	510mm	E81226010-510W	
		194mm	550mm sect.	E81226010-550W	
		194mm	250mm	E81226010-250W	
	R2	194mm	510mm	E81226020-510W	
		194mm	550mm sect.	E81226020-550W	
		194mm	250mm	E81226020-250W	



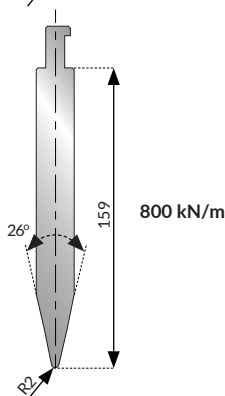
R1 - 400 kN/m
R2 - 600 kN/m

LVD PROFILE J15		H	L	CATALOGUE NO.	PRICE
26°	R1	194mm	510mm	E81226010-510	
		194mm	550mm sect.	E81226010-550	
		194mm	250mm	E81226010-250	
	R2	194mm	510mm	E81226020-510	
		194mm	550mm sect.	E81226020-550	
		194mm	250mm	E81226020-250	

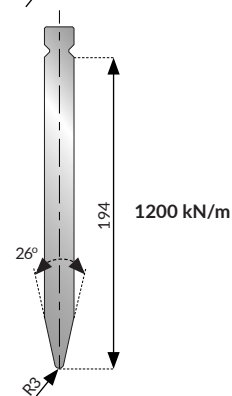
26° Punches



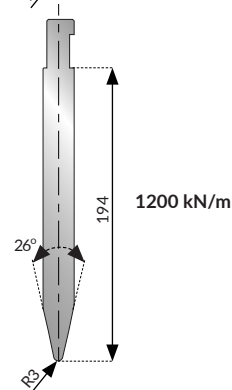
LVD PROFILE R10W		H	L	CATALOGUE NO.	PRICE
26°	R2	159mm	510mm	E80326020-510W	
		159mm	550mm sect.	E80326020-550W	
		159mm	250mm	E80326020-250W	



LVD PROFILE R10		H	L	CATALOGUE NO.	PRICE
26°	R2	159mm	510mm	E80326020-510	
		159mm	550mm sect.	E80326020-550	
		159mm	250mm	E80326020-250	

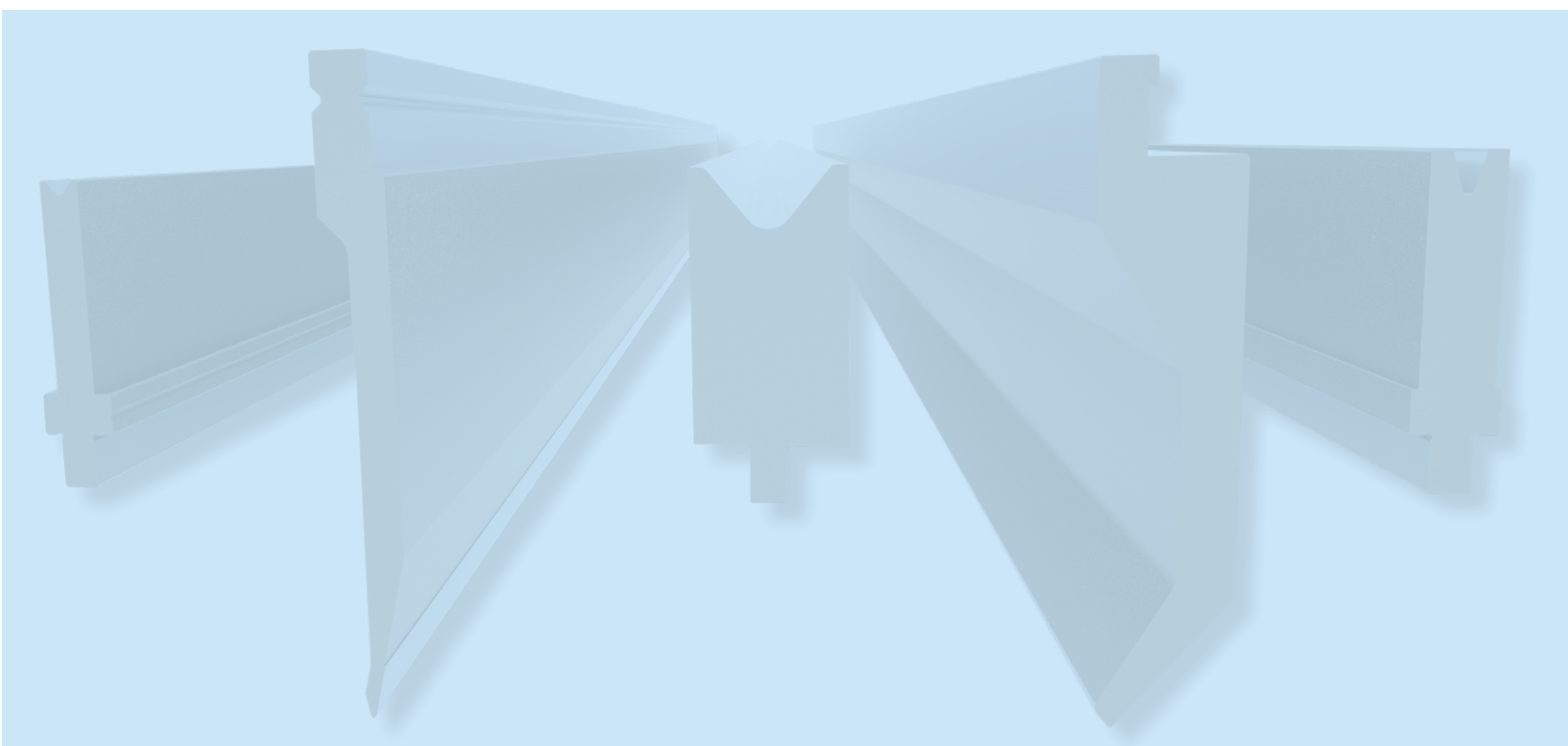


LVD PROFILE R15W		H	L	CATALOGUE NO.	PRICE
26°	R3	194mm	510mm	E81326030-510W	
		194mm	550mm sect.	E81326030-550W	
		194mm	250mm	E81326030-250W	

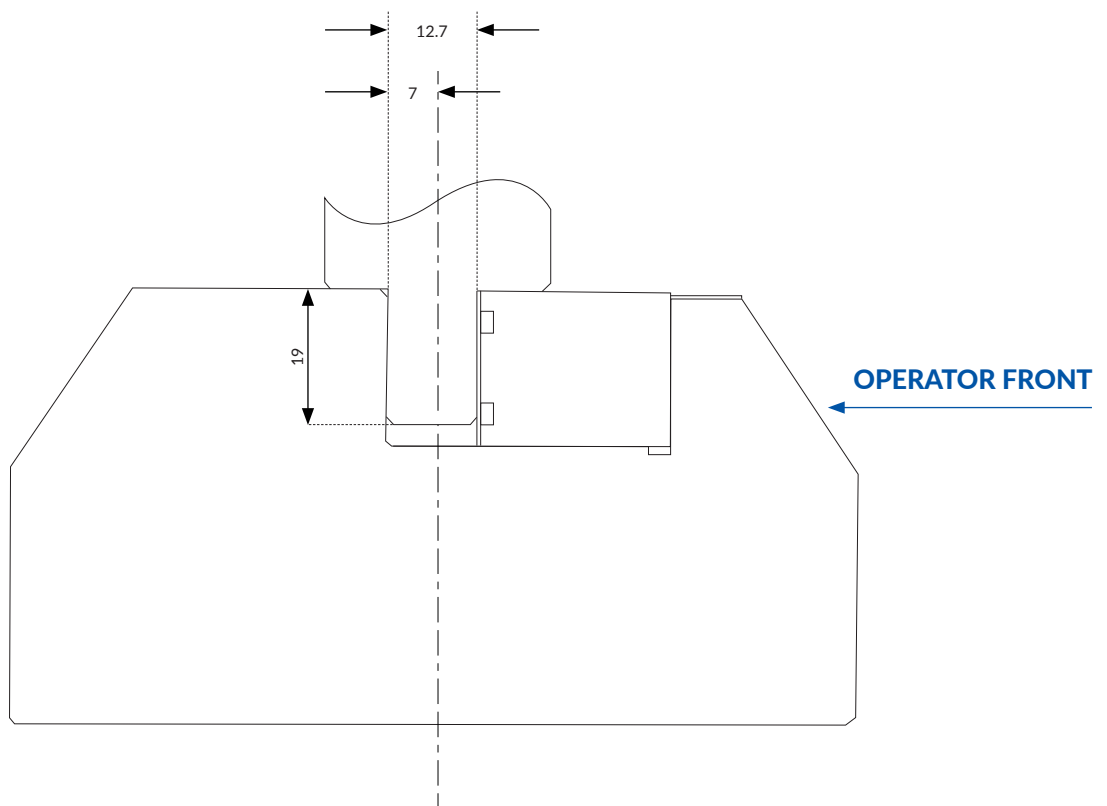


LVD PROFILE R15		H	L	CATALOGUE NO.	PRICE
26°	R3	194mm	510mm	E81326030-510	
		194mm	550mm sect.	E81326030-550	
		194mm	250mm	E81326030-250	

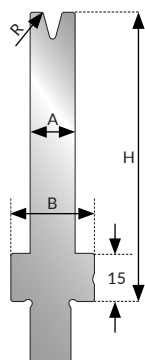
LVD STYLE | Dies



Die Tang Clamping

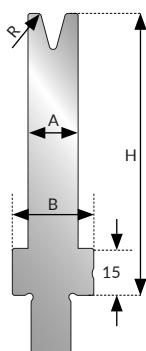


30° Dies



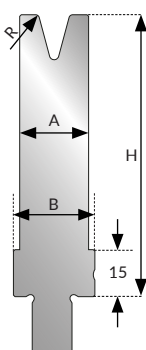
250 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85130006-510	30°	0.8	6	90mm	14-26mm	
E85130006-550				90mm	14-26mm	
E85130006-250				90mm	14-26mm	
E86130006-510	30°	0.8	6	130mm	14-26mm	
E86130006-550				130mm	14-26mm	
E86130006-250				130mm	14-26mm	



260 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85130008-510	30°	1	8	90mm	16-26mm	
E85130008-550				90mm	16-26mm	
E85130008-250				90mm	16-26mm	
E86130008-510	30°	1	8	130mm	16-26mm	
E86130008-550				130mm	16-26mm	
E86130008-250				130mm	16-26mm	

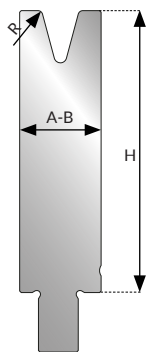


360 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85130010-510	30°	1.2	10	90mm	22-26mm	
E85130010-550				90mm	22-26mm	
E85130010-250				90mm	22-26mm	
E86130010-510	30°	1.2	10	130mm	22-26mm	
E86130010-550				130mm	22-26mm	
E86130010-250				130mm	22-26mm	

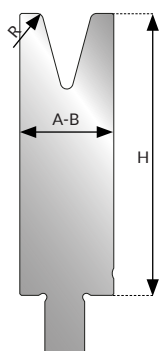
NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

30° Dies



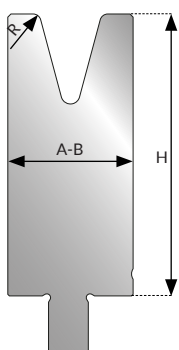
460 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85030012-510	30°	1.5	12	90mm	26mm	
E85030012-550				90mm	26mm	
E85030012-250				90mm	26mm	
E86030012-510	30°	1.5	12	130mm	26mm	
E86030012-550				130mm	26mm	
E86030012-250				130mm	26mm	



510 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85030016-510	30°	2	16	90mm	30mm	
E85030016-550				90mm	30mm	
E85030016-250				90mm	30mm	
E86030016-510	30°	2	16	130mm	30mm	
E86030016-550				130mm	30mm	
E86030016-250				130mm	30mm	

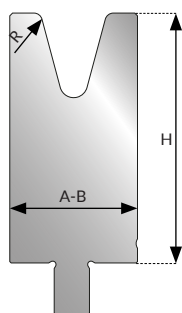


680 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85030020-510	30°	2.5	20	90mm	40mm	
E85030020-550				90mm	40mm	
E85030020-250				90mm	40mm	
E86030020-510	30°	2.5	20	130mm	40mm	
E86030020-550				130mm	40mm	
E86030020-250				130mm	40mm	

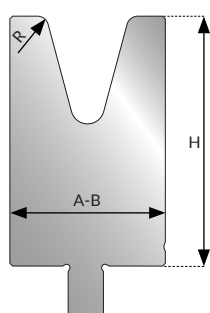
NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

30° Dies



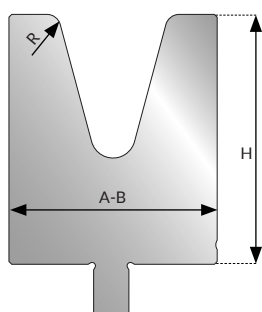
930 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85030024-510	30°	3	24	90mm	46mm	
E85030024-550				90mm	46mm	
E85030024-250				90mm	46mm	
E86030024-510	30°	3	24	130mm	46mm	
E86030024-550				130mm	46mm	
E86030024-250				130mm	46mm	



1100 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85030030-510	30°	4	30	90mm	56mm	
E85030030-550				90mm	56mm	
E85030030-250				90mm	56mm	
E86030030-510	30°	4	30	130mm	56mm	
E86030030-550				130mm	56mm	
E86030030-250				130mm	56mm	

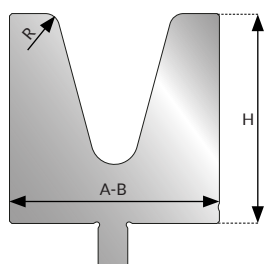


1400 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85030040-510	30°	5	40	90mm	75mm	
E85030040-550				90mm	75mm	
E85030040-250				90mm	75mm	
E86030040-510	30°	5	40	130mm	75mm	
E86030040-550				130mm	75mm	
E86030040-250				130mm	75mm	

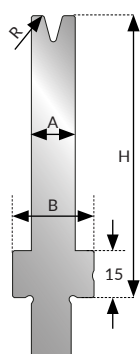
NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

30°, 78° Dies



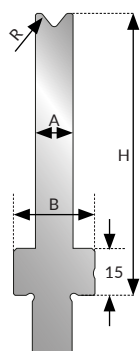
1350 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85030050-510	30°	6	50	90mm	90mm	
E85030050-550				90mm	90mm	
E85030050-250				90mm	90mm	
E86030050-510	30°	6	50	130mm	90mm	
E86030050-550				130mm	90mm	
E86030050-250				130mm	90mm	



280 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85178006-510	78°	0.8	6	90mm	10-26mm	
E85178006-550				90mm	10-26mm	
E85178006-250				90mm	10-26mm	
E86178006-510	78°	0.8	6	130mm	10-26mm	
E86178006-550				130mm	10-26mm	
E86178006-250				130mm	10-26mm	

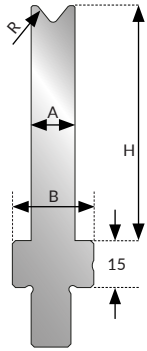


320 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85178008-510	78°	1	8	90mm	12-26mm	
E85178008-550				90mm	12-26mm	
E85178008-250				90mm	12-26mm	
E86178008-510	78°	1	8	130mm	12-26mm	
E86178008-550				130mm	12-26mm	
E86178008-250				130mm	12-26mm	

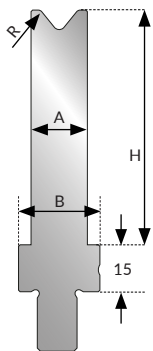
NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

78° Dies



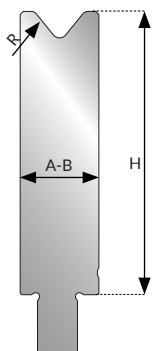
360 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85178010-510	78°	1.2	10	90mm	14-26mm	
E85178010-550				90mm	14-26mm	
E85178010-250				90mm	14-26mm	
E86178010-510	78°	1.2	10	130mm	14-26mm	
E86178010-550				130mm	14-26mm	
E86178010-250				130mm	14-26mm	



500 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85178012-510	78°	1.5	12	90mm	18-26mm	
E85178012-550				90mm	18-26mm	
E85178012-250				90mm	18-26mm	
E86178012-510	78°	1.5	12	130mm	18-26mm	
E86178012-550				130mm	18-26mm	
E86178012-250				130mm	18-26mm	

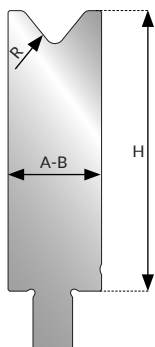


700 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078016-510	78°	2	16	90mm	25mm	
E85078016-550				90mm	25mm	
E85078016-250				90mm	25mm	
E86078016-510	78°	2	16	130mm	25mm	
E86078016-550				130mm	25mm	
E86078016-250				130mm	25mm	

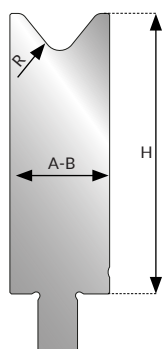
NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

78° Dies



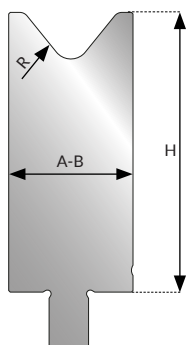
750 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078020-510	78°	2.5	20	90mm	30mm	
E85078020-550				90mm	30mm	
E85078020-250				90mm	30mm	
E86078020-510	78°	2.5	20	130mm	30mm	
E86078020-550				130mm	30mm	
E86078020-250				130mm	30mm	



910 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078024-510	78°	3	24	90mm	32mm	
E85078024-550				90mm	32mm	
E85078024-250				90mm	32mm	
E86078024-510	78°	3	24	130mm	32mm	
E86078024-550				130mm	32mm	
E86078024-250				130mm	32mm	

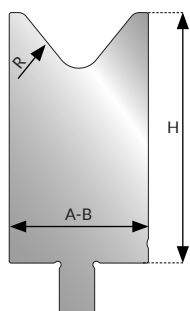


1150 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078030-510	78°	3	30	90mm	40mm	
E85078030-550				90mm	40mm	
E85078030-250				90mm	40mm	
E86078030-510	78°	3	30	130mm	40mm	
E86078030-550				130mm	40mm	
E86078030-250				130mm	40mm	

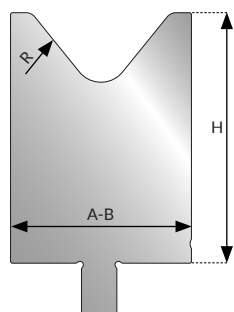
NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

78° Dies



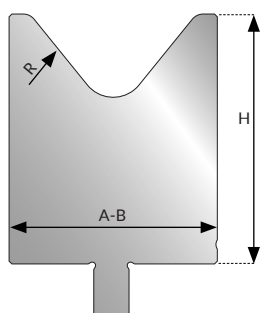
1350 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078040-510	78°	3.5	40	90mm	50mm	
E85078040-550				90mm	50mm	
E85078040-250				90mm	50mm	
E86078040-510	78°	3.5	40	130mm	50mm	
E86078040-550				130mm	50mm	
E86078040-250				130mm	50mm	



1800 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078050-510	78°	4	50	90mm	65mm	
E85078050-550				90mm	65mm	
E85078050-250				90mm	65mm	
E86078050-510	78°	4	50	130mm	65mm	
E86078050-550				130mm	65mm	
E86078050-250				130mm	65mm	

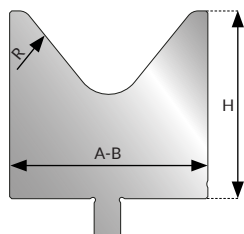


2000 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078060-510	78°	5	60	90mm	75mm	
E85078060-550				90mm	75mm	
E85078060-250				90mm	75mm	
E86078060-510	78°	5	60	130mm	75mm	
E86078060-550				130mm	75mm	
E86078060-250				130mm	75mm	

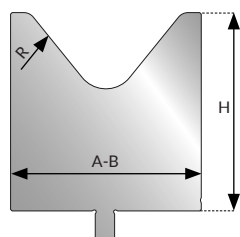
NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

78° Dies



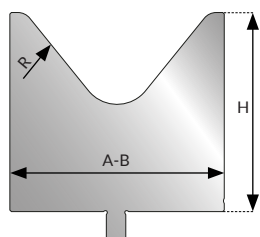
2300 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078080-510	78°	6	80	90mm	95mm	
E85078080-550				90mm	95mm	
E85078080-250				90mm	95mm	
E86078080-510	78°	6	80	130mm	95mm	
E86078080-550				130mm	95mm	
E86078080-250				130mm	95mm	



2500 kN/m

CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E85078100-510	78°	8	100	90mm	125mm	
E85078100-550				90mm	125mm	
E85078100-250				90mm	125mm	
E86078100-510	78°	8	100	130mm	125mm	
E86078100-550				130mm	125mm	
E86078100-250				130mm	125mm	

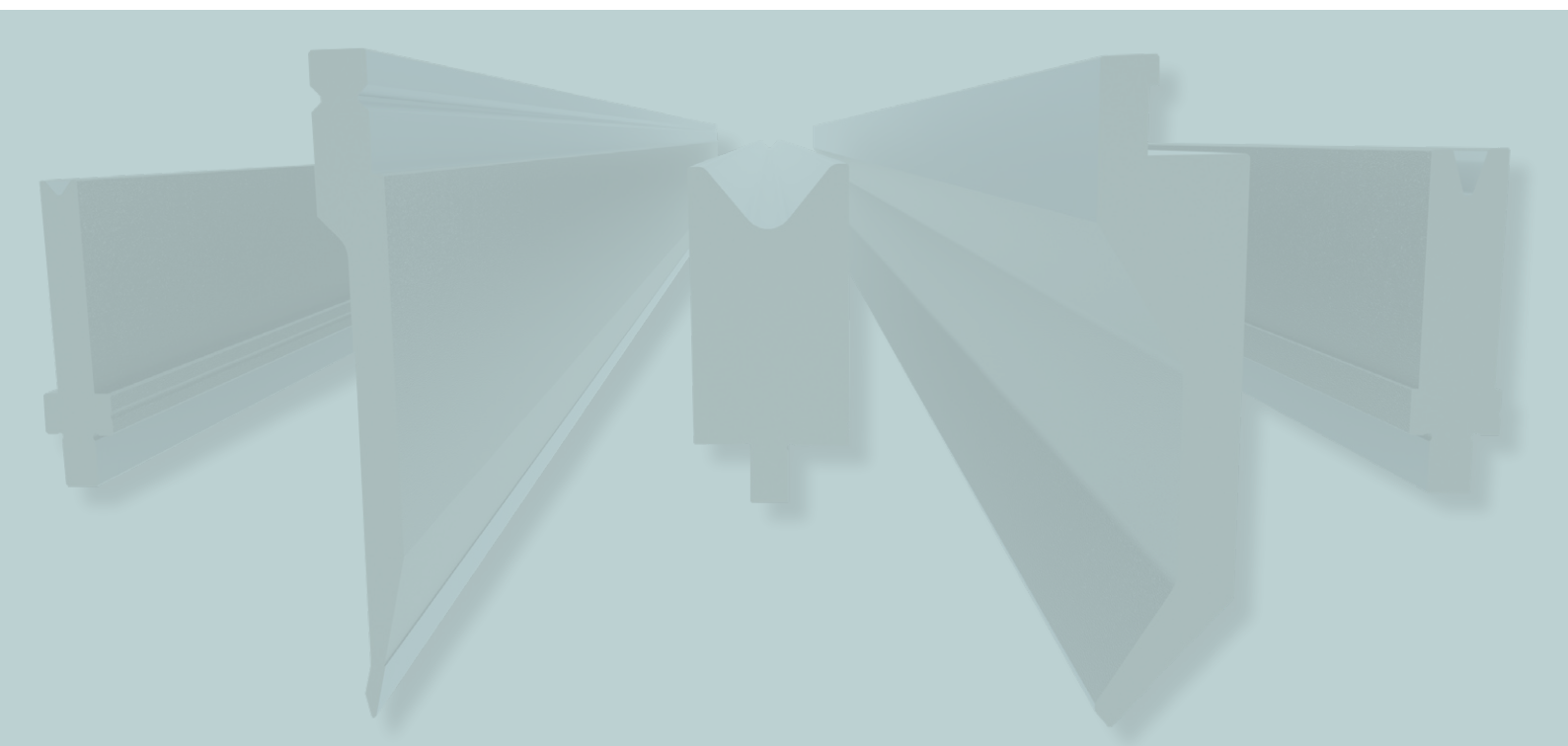


2700 kN/m

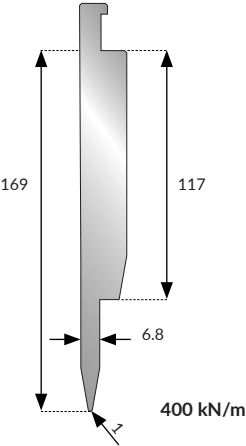
CATALOGUE NO.	ANGLE	R	V OPENING	H	DIE BODY WIDTH (A-B)	PRICE
E86078120-510	78°	10	120	130mm	125mm	
E86078120-550				130mm	125mm	
E86078120-250				130mm	125mm	

NOTE: STONE RADIUS AVAILABLE ON REQUEST • STANDARD INDUCTION HARDENED

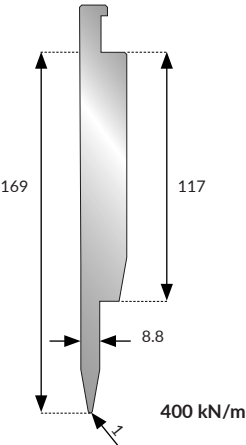
LVD STYLE | Hemming



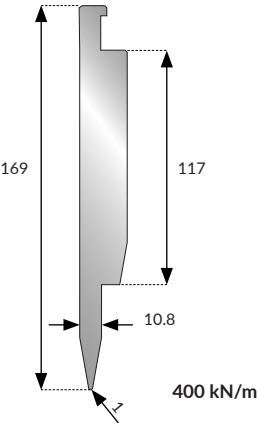
P10 Hemming



LVD PROFILE P10-08		H	L	CATALOGUE NO.	PRICE
20°	R1	169mm	510mm	E80420010-8-510	
		169mm	550mm sect.	E80420010-8-550	
		169mm	250mm	E80420010-8-250	

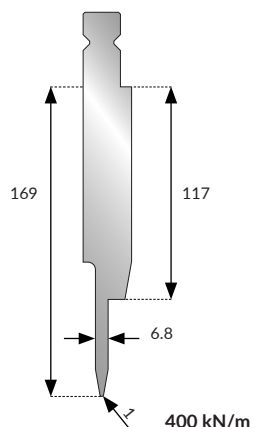


LVD PROFILE P10-10		H	L	CATALOGUE NO.	PRICE
20°	R1	169mm	510mm	E80420010-10-510	
		169mm	550mm sect.	E80420010-10-550	
		169mm	250mm	E80420010-10-250	

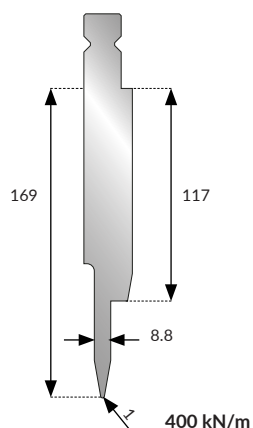


LVD PROFILE P10-12		H	L	CATALOGUE NO.	PRICE
20°	R1	169mm	510mm	E80420010-12-510	
		169mm	550mm sect.	E80420010-12-550	
		169mm	250mm	E80420010-12-250	

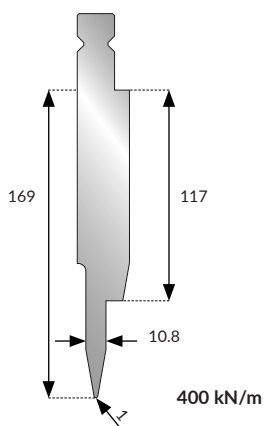
P10W Hemming



LVD PROFILE P10W-08		H	L	CATALOGUE NO.	PRICE
20°	R1	169mm	510mm	E80420010-8-510W	
		169mm	550mm sect.	E80420010-8-550W	
		169mm	250mm	E80420010-8-250W	

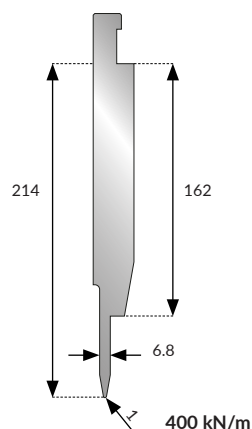


LVD PROFILE P10W-10		H	L	CATALOGUE NO.	PRICE
20°	R1	169mm	510mm	E80420010-10-510W	
		169mm	550mm sect.	E80420010-10-550W	
		169mm	250mm	E80420010-10-250W	

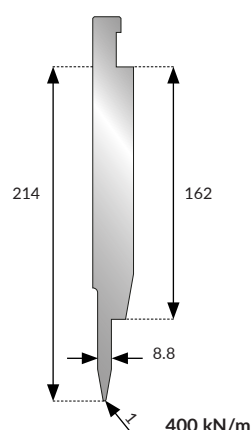


LVD PROFILE P10W-12		H	L	CATALOGUE NO.	PRICE
20°	R1	169mm	510mm	E80420012-10-510W	
		169mm	550mm sect.	E80420012-10-550W	
		169mm	250mm	E80420012-10-250W	

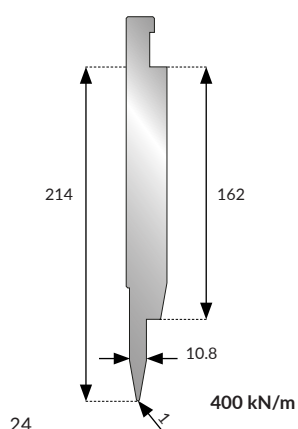
P15 Hemming



LVD PROFILE P15-08		H	L	CATALOGUE NO.	PRICE
20°	R1	214mm	510mm	E81420010-8-510	
		214mm	550mm sect.	E81420010-8-550	
		214mm	250mm	E81420010-8-250	

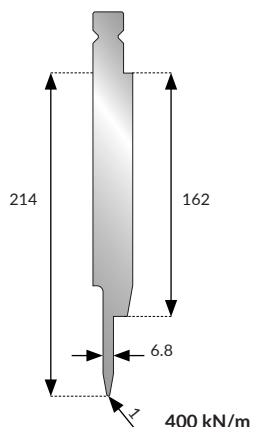


LVD PROFILE P15-10		H	L	CATALOGUE NO.	PRICE
20°	R1	214mm	510mm	E81420010-10-510	
		214mm	550mm sect.	E81420010-10-550	
		214mm	250mm	E81420010-10-250	

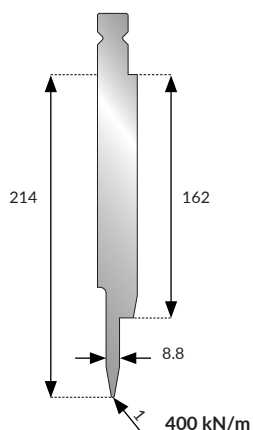


LVD PROFILE P15-12		H	L	CATALOGUE NO.	PRICE
20°	R1	214mm	510mm	E81420010-12-510	
		214mm	550mm sect.	E81420010-12-550	
		214mm	250mm	E81420010-12-250	

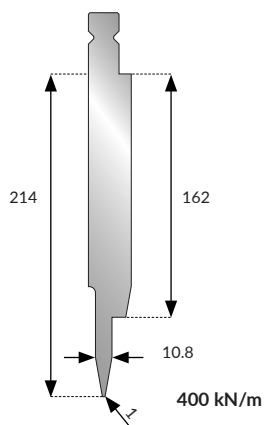
P15W Hemming



LVD PROFILE P15W-08		H	L	CATALOGUE NO.	PRICE
20°	R1	214mm	510mm	E81420010-8-510W	
		214mm	550mm sect.	E81420010-8-550W	
		214mm	250mm	E81420010-8-250W	

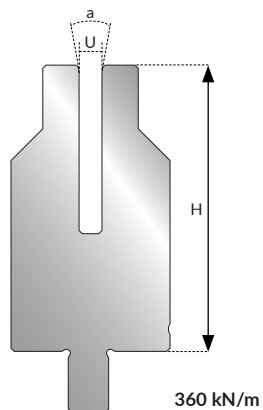


LVD PROFILE P15W-10		H	L	CATALOGUE NO.	PRICE
20°	R1	214mm	510mm	E81420010-10-510W	
		214mm	550mm sect.	E81420010-10-550W	
		214mm	250mm	E81420010-10-250W	

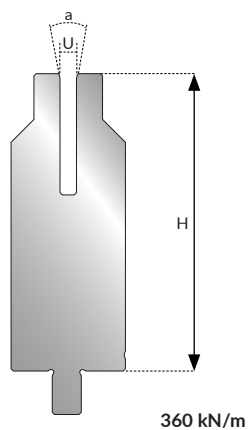


LVD PROFILE P15W-12		H	L	CATALOGUE NO.	PRICE
20°	R1	214mm	510mm	E81420010-12-510W	
		214mm	550mm sect.	E81420010-12-550W	
		214mm	250mm	E81420010-12-250W	

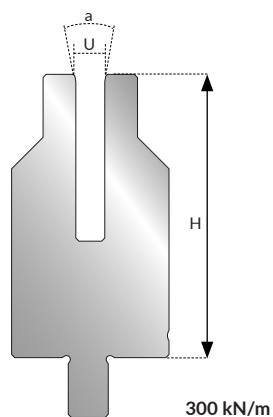
Hemming Dies



CATALOGUE NO.	A	U OPENING	H	PRICE
E85020008-510	20°	8	90mm	
E85020008-550			90mm	
E85020008-250			90mm	

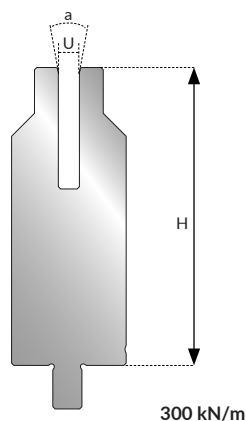


CATALOGUE NO.	A	U OPENING	H	PRICE
E86020008-510	20°	8	130mm	
E86020008-550			130mm	
E86020008-250			130mm	

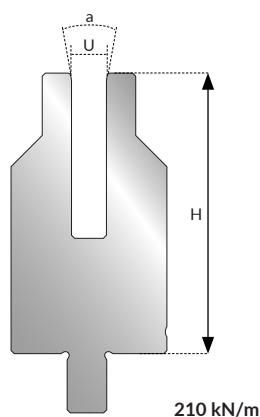


CATALOGUE NO.	A	U OPENING	H	PRICE
E85020010-510	20°	10	90mm	
E85020010-550			90mm	
E85020010-250			90mm	

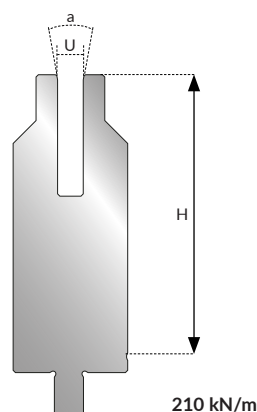
Hemming Dies



CATALOGUE NO.	A	U OPENING	H	PRICE
E86020010-510	20°	10	130mm	
E86020010-550			130mm	
E86020010-250			130mm	

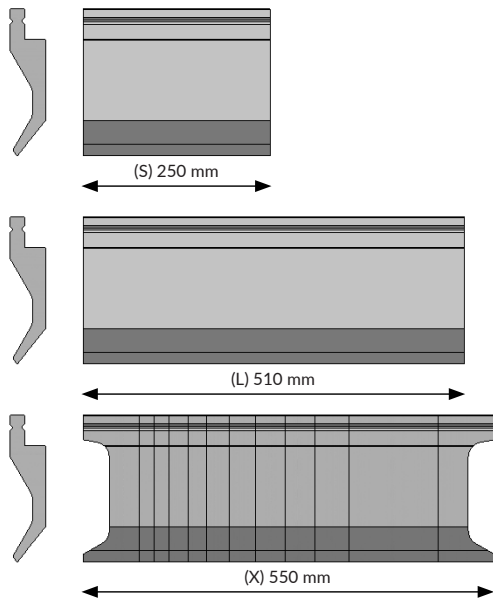


CATALOGUE NO.	A	U OPENING	H	PRICE
E85020012-510	20°	12	90mm	
E85020012-550			90mm	
E85020012-250			90mm	



CATALOGUE NO.	A	U OPENING	H	PRICE
E86020012-510	20°	12	130mm	
E86020012-550			130mm	
E86020012-250			130mm	

Standard Punch Lengths



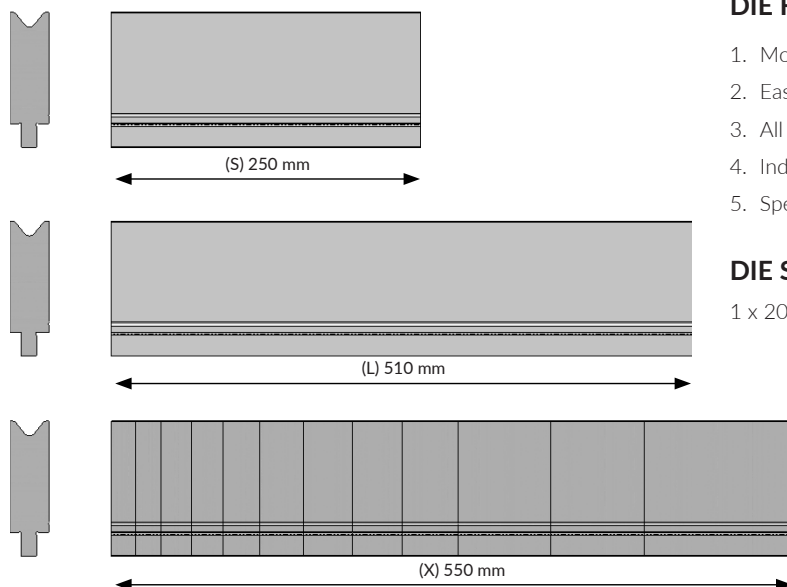
PUNCH FEATURES:

1. Most tools can be easily loaded by a single operator.
2. Easy to store.
3. All sectionalised tools come pre-cut in twelve different pieces.
4. All sectionalised punches include two ear pieces (horns).
5. Punches are induction hardened, to 55–58 HRC.
6. Special Tooling available. Please contact the sales desk.

PUNCH LENGTHS ARE AS FOLLOWS:

1 x 75 **LEFT EAR**, 20, 20, 25, 25, 30, 35, 40, 40, 45, 120, 75 **RIGHT EAR** mm

Standard Dies



DIE FEATURES:

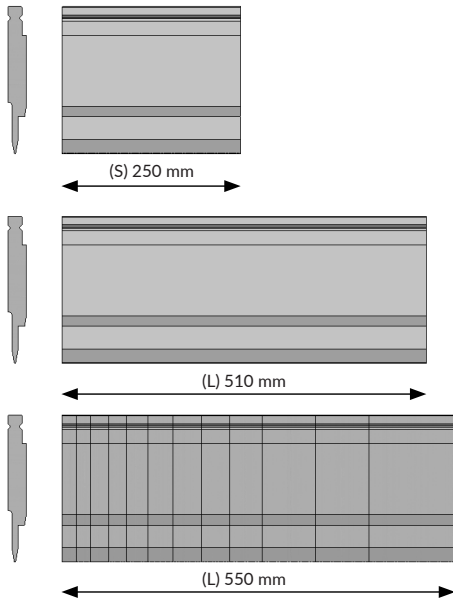
1. Most tools can be easily loaded by a single operator.
2. Easy to store.
3. All sectionalised tools come pre-cut in twelve different pieces.
4. Induction hardened.
5. Special Tooling available. Please contact the sales desk.

DIE SECTION LENGTHS ARE AS FOLLOWS:

1 x 20, 20, 25, 25, 30, 35, 40, 40, 75, 75, 120 mm

NOTE: SPECIAL LENGTHS ARE AVAILABLE AT ADDITIONAL COST, JUST SELECT THE STANDARD LENGTH AND ASK US TO CUT TO YOUR REQUIREMENTS.

Standard Hemming and Die Lengths



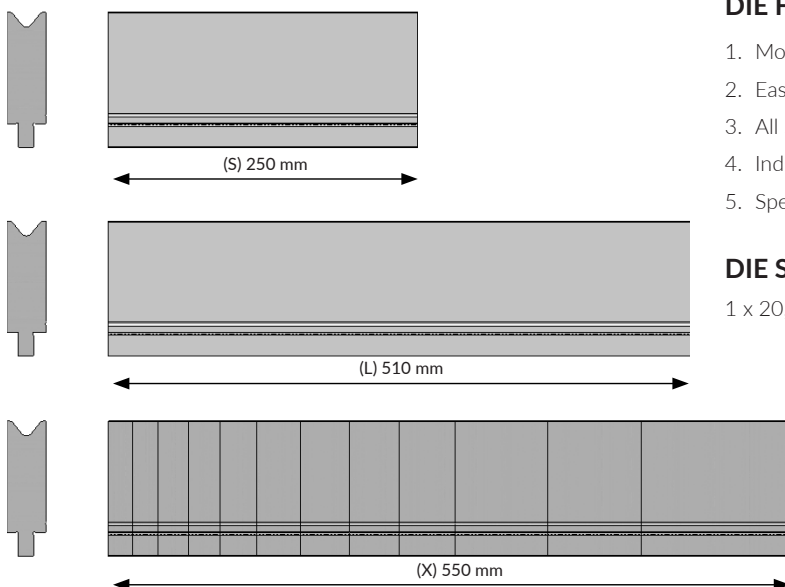
PUNCH FEATURES:

1. Most tools can be easily loaded by a single operator.
2. Easy to store.
3. All sectionalised tools come pre-cut in twelve different pieces.
4. Punches are induction hardened, to 55–58 HRC.
5. Special Tooling available. Please contact the sales desk.

PUNCH LENGTHS ARE AS FOLLOWS:

1 x 20, 20, 25, 25, 30, 35, 40, 40, 45, 75, 75, 120 mm

Hemming Dies



DIE FEATURES:

1. Most tools can be easily loaded by a single operator.
2. Easy to store.
3. All sectionalised tools come pre-cut in twelve different pieces.
4. Induction hardened.
5. Special Tooling available. Please contact the sales desk.

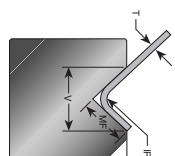
DIE SECTION LENGTHS ARE AS FOLLOWS:

1 x 20, 20, 25, 25, 30, 35, 40, 40, 45, 75, 75, 120 mm

Air Bending Force Chart Metric

STANDARD FORMULAS FOR SELECTING A V-OPENING MATERIAL THICKNESS			
2.6mm OR LESS	=	T x 6	Note: The formulas are for reference only. For more specific information, please refer to the chart below. Chart below is for mild steel.
3.0mm-8.0mm	=	T x 8	
9.0mm-12.0mm	=	T x 10	
14.0mm and THICKER	=	T x 12	

TONNAGE REQUIRED FOR MILD STEEL			
Soft Brass	x	0.5	
Soft Aluminium	x	0.5	
Heat Treated Aluminium Alloys	x	1	
Stainless Steel	x	1.5	



FIGURES BASED ON MILD STEEL		4	6	7	8	10	12	14	16	18	20	22	25	32	40	50	63	80	100	125	160	200	250
THICKNESS	V (mm)	4	6	7	8	10	12	14	16	18	20	22	25	32	40	50	63	80	100	125	160	200	250
	MF	2.8	4.2	4.9	5.6	7.0	8.6	10.1	11.5	13.0	14.4	*15.8	18.0	24.0	30.0	37.5	47.3	60.0	75.0	96.3	123.2	154.0	192.5
THICKNESS	IR	0.7	1.0	1.2	1.3	1.7	2.0	2.3	2.7	3.0	3.3	3.7	4.2	5.3	6.7	8.3	10.5	13.3	16.7	20.8	26.7	33.3	41.7
	0.5mm	4.5	2.8																				
THICKNESS	0.6mm	6.0	4.2	3.3	3.2																		
	0.8mm		8.0	7.2	5.6	4.4																	
THICKNESS	1.0mm			11.0	10.0	9.0	7.0	5.5															
	1.2mm				14.0	13.2	10.8	8.4	7.5	6.6													
THICKNESS	1.4mm					15.4	14.0	12.6	9.8	8.8	7.7												
	1.6mm						17.6	16.0	14.4	11.2	10.0	8.8											
THICKNESS	2.0mm							22.0	20.0	18.0	16.0	14.0	12.5	11.0									
	2.3mm								25.3	23.0	20.7	18.4	16.1	14.4	12.7								
THICKNESS	2.6mm									28.6	26.0	23.4	20.8	18.2	14.3								
	3.0mm										33.0	30.0	28.53	27.0	21.0	16.5							
THICKNESS	3.2mm											35.2	31.9	28.8	22.4	17.6	14.4						
	3.5mm												38.5	35.0	28.0	21.9	15.8	14.0					
THICKNESS	4.0mm													44.0	36.0	28.0	22.0	18.0					
	4.5mm														45.0	36.0	28.1	20.3					
THICKNESS	5.0mm															55.0	45.0	35.0	26.3	22.5			
	6.0mm																60.0	54.0	37.5	31.5	24.0		
THICKNESS	7.0mm																	56.0	43.8	31.5	28.0		
	9.0mm																		72.0	56.3	40.5		
THICKNESS	10.0mm																			90.0	70.0	52.5	
	12.0mm																				108.0	84.0	63.0
THICKNESS	16.0mm																					144.0	112.0
	19.0mm																						152.0
THICKNESS	22.0mm																						176.0
	25.0mm																						225.0
THICKNESS	30.0mm																						270.0

• T = MATERIAL THICKNESS • V = V-OPENING • MF = MINIMUM FLANGE LENGTH • IR = INSIDE RADIUS

The bending force (tonnage) figures listed above are based on mild steel with a tensile strength of 45-50 kilograms per square millimetre. To calculate the approximate bending force (tonnage) requirements for other materials, please use the multipliers listed.

Note: * Based on bending to an included angle of 88 degrees. This dimension will increase when bending to an included angle of less than 88 degrees.



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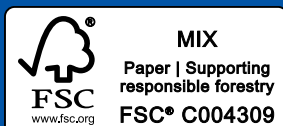
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