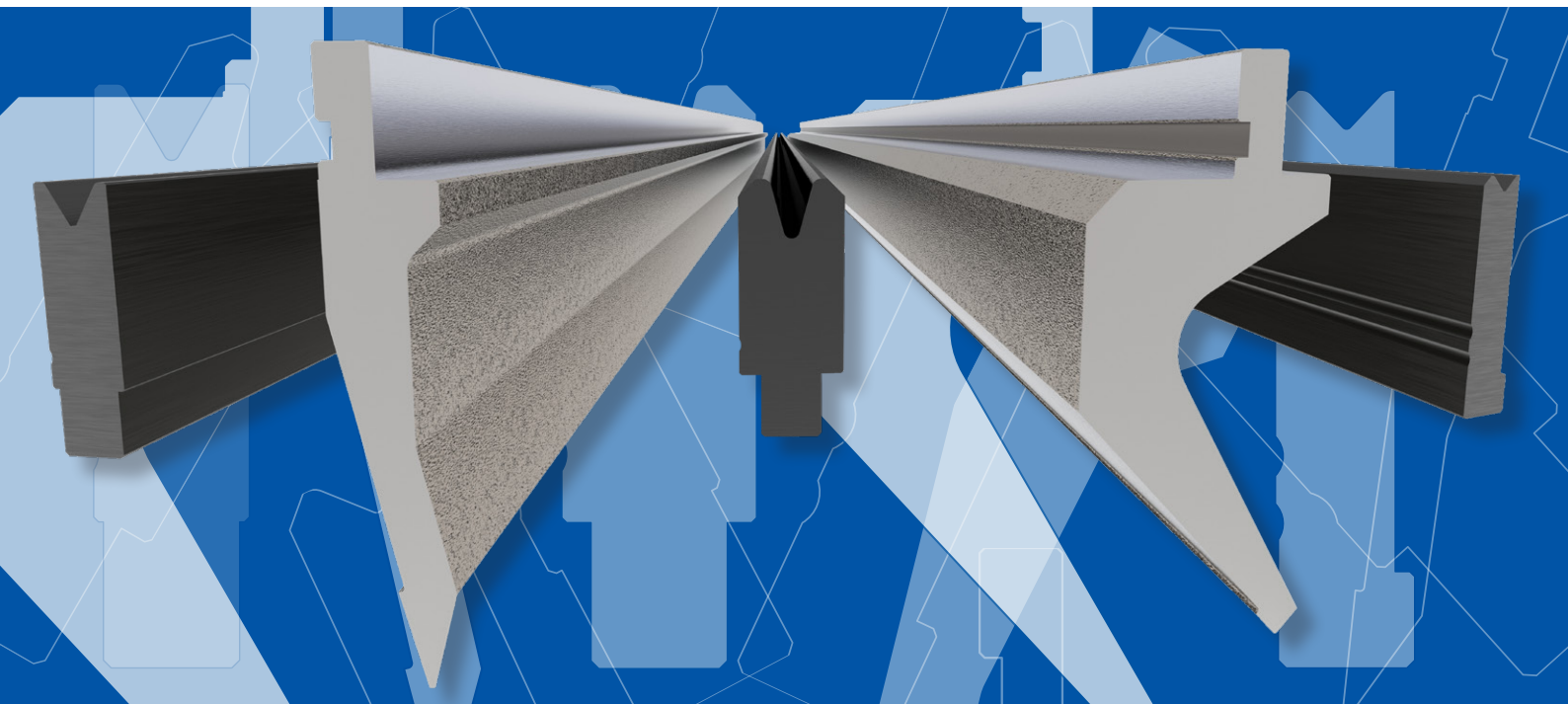


FIXED HEIGHT | Catalogue





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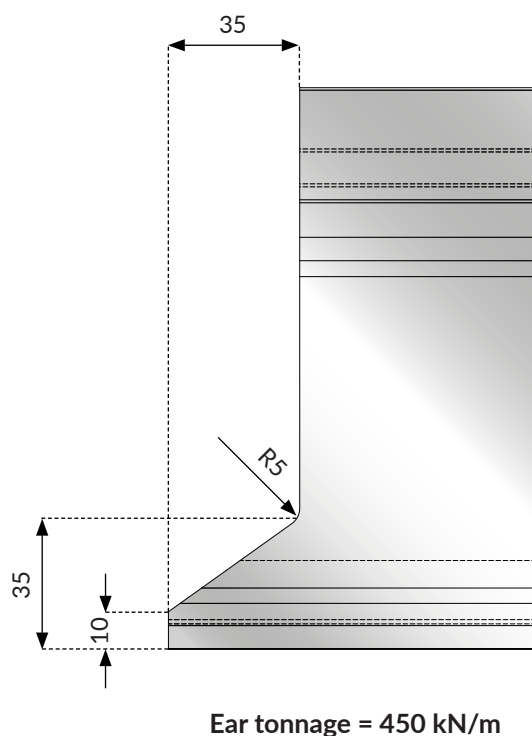
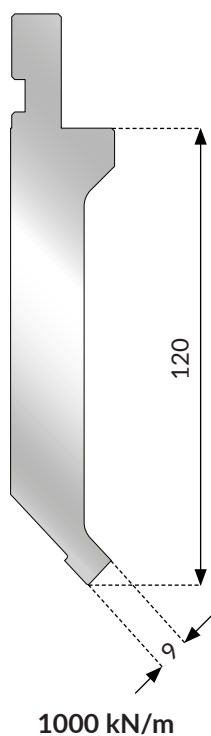
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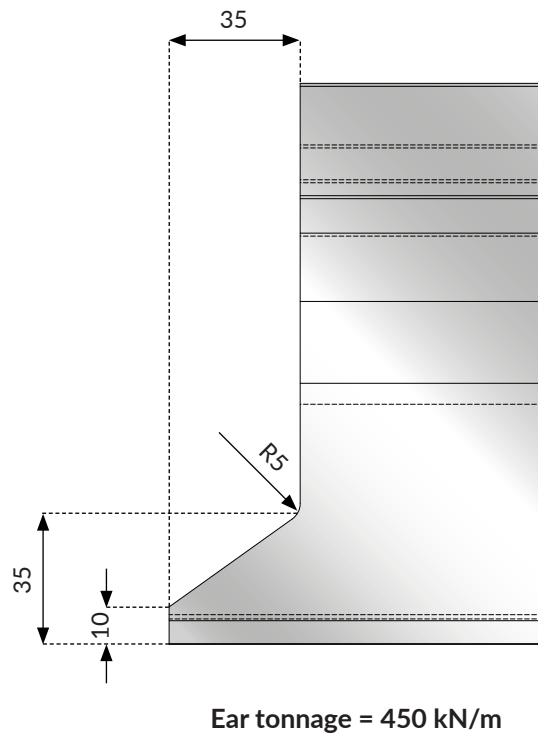
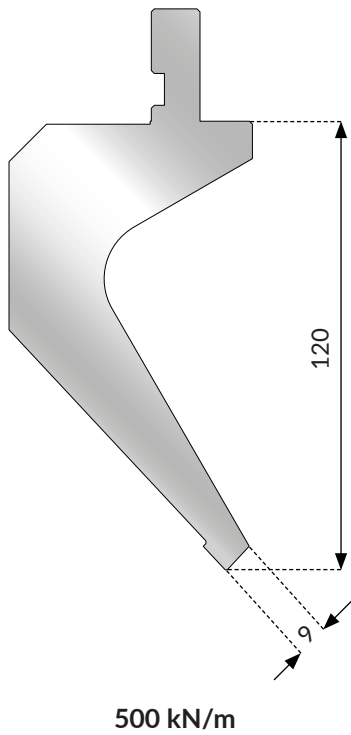
Standard Punch



AMADA® PROFILE #804			CATALOGUE NO.	PRICE
86°	R0.6	835mm	E4804806L	-
		415mm	E4804806S	-
		800mm Sect.	E4804806X	-
	R1.5	835mm	E4804815L	-
		415mm	E4804815S	-
		800mm Sect.	E4804815X	-
	R3	835mm	E4804830L	-
		415mm	E4804830S	-
		800mm Sect.	E4804830X	-
88°	R0.6	835mm	E4804706L	-
		415mm	E4804706S	-
		800mm Sect.	E4804706X	-
90°	R0.6	835mm	E4804906L	-
		415mm	E4804906S	-
		800mm Sect.	E4804906X	-

NOTE: ALL PUNCHES SUPPLIED INDUCTION HARDENED AS STANDARD

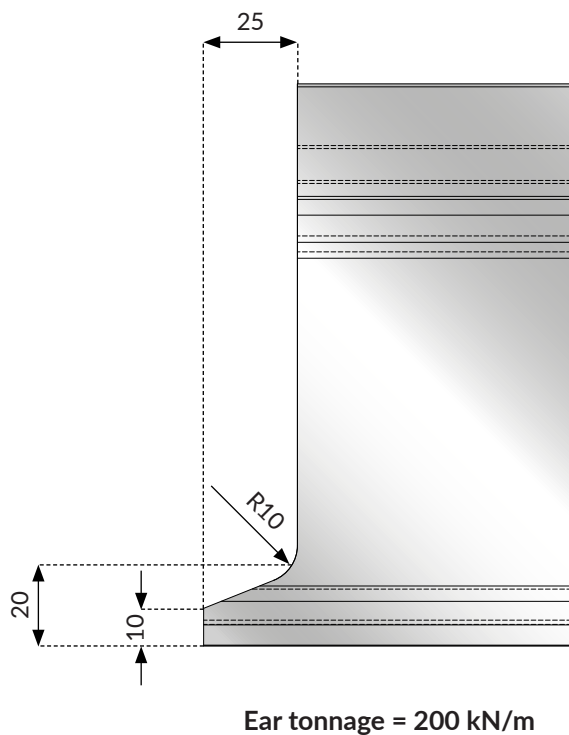
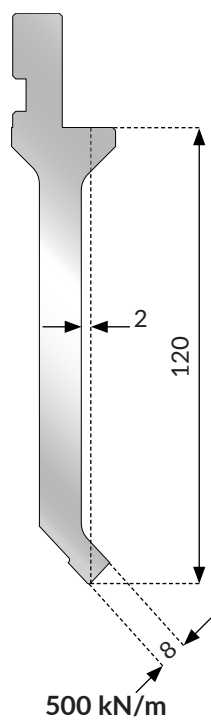
Goose-neck Punch



AMADA® PROFILE #847			CATALOGUE NO.	PRICE
86°	R0.6	835mm	E4847806L	-
		415mm	E4847806S	-
		800mm Sect.	E4847806X	-
	R1.5	835mm	E4847815L	-
		415mm	E4847815S	-
		800mm Sect.	E4847815X	-
	R3	835mm	E4847830L	-
		415mm	E4847830S	-
		800mm Sect.	E4847830X	-
88°	R0.6	835mm	E4847706L	-
		415mm	E4847706S	-
		800mm Sect.	E4847706X	-
90°	R0.6	835mm	E4847906L	-
		415mm	E4847906S	-
		800mm Sect.	E4847906X	-

NOTE: ALL PUNCHES SUPPLIED INDUCTION HARDENED AS STANDARD

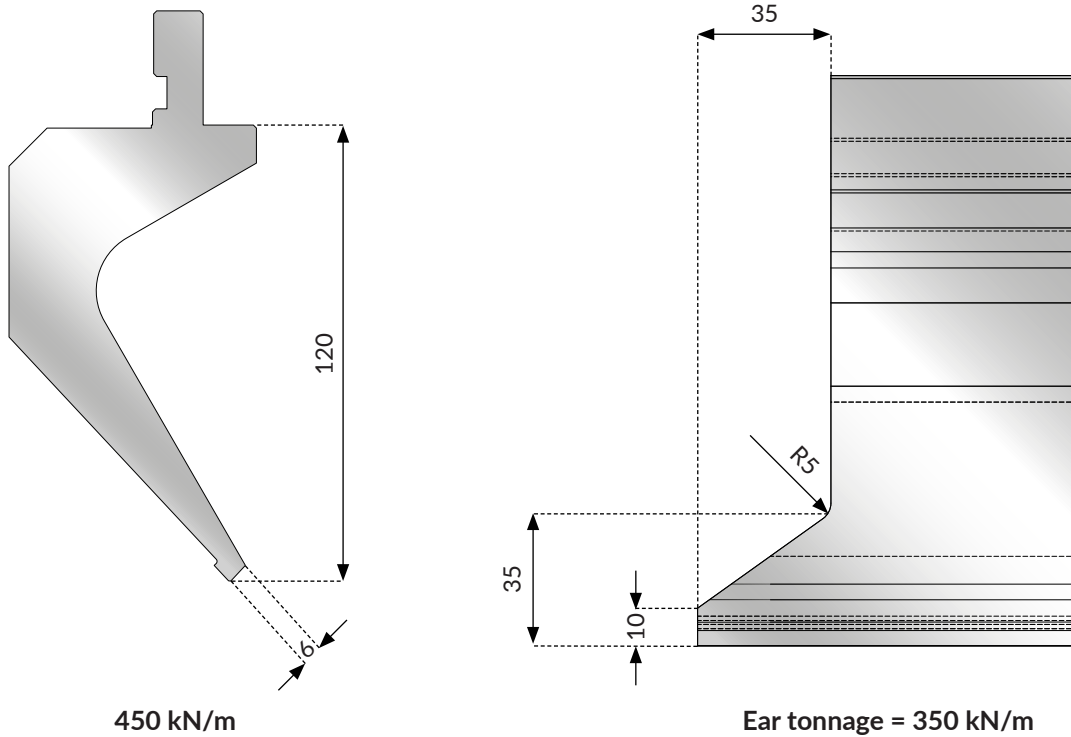
Sash



AMADA® PROFILE #820			CATALOGUE NO.	PRICE
86°	R0.6	835mm	E4820806L	-
		415mm	E4820806S	-
		800mm Sect.	E4820806X	-
	R1.5	835mm	E4820815L	-
		415mm	E4820815S	-
		800mm Sect.	E4820815X	-
88°	R0.6	835mm	E4820706L	-
		415mm	E4820706S	-
		800mm Sect.	E4820706X	-

NOTE: ALL PUNCHES SUPPLIED INDUCTION HARDENED AS STANDARD

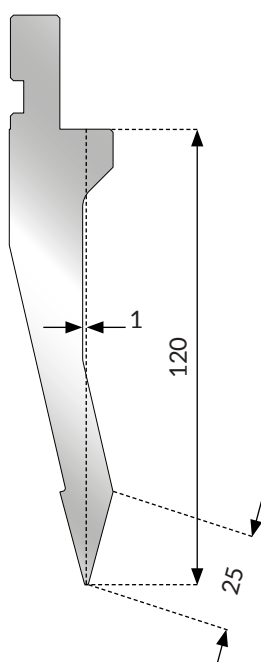
Thin Tip Goose-Neck



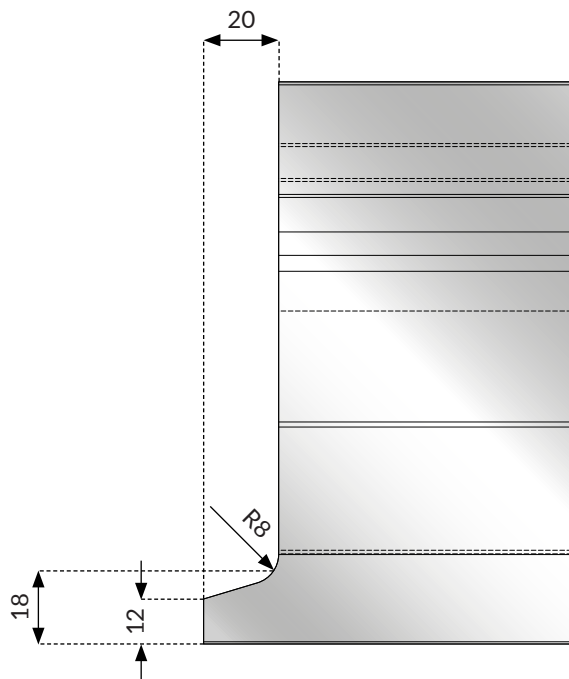
AMADA® PROFILE #846			CATALOGUE NO.	PRICE
86°	R0.6	835mm	E4846806L	-
		415mm	E4846806S	-
		800mm Sect.	E4846806X	-
88°	R0.6	835mm	E4846706L	-
		415mm	E4846706S	-
		800mm Sect.	E4846706X	-

NOTE: ALL PUNCHES SUPPLIED INDUCTION HARDENED AS STANDARD

Acute Angle



1000 kN/m

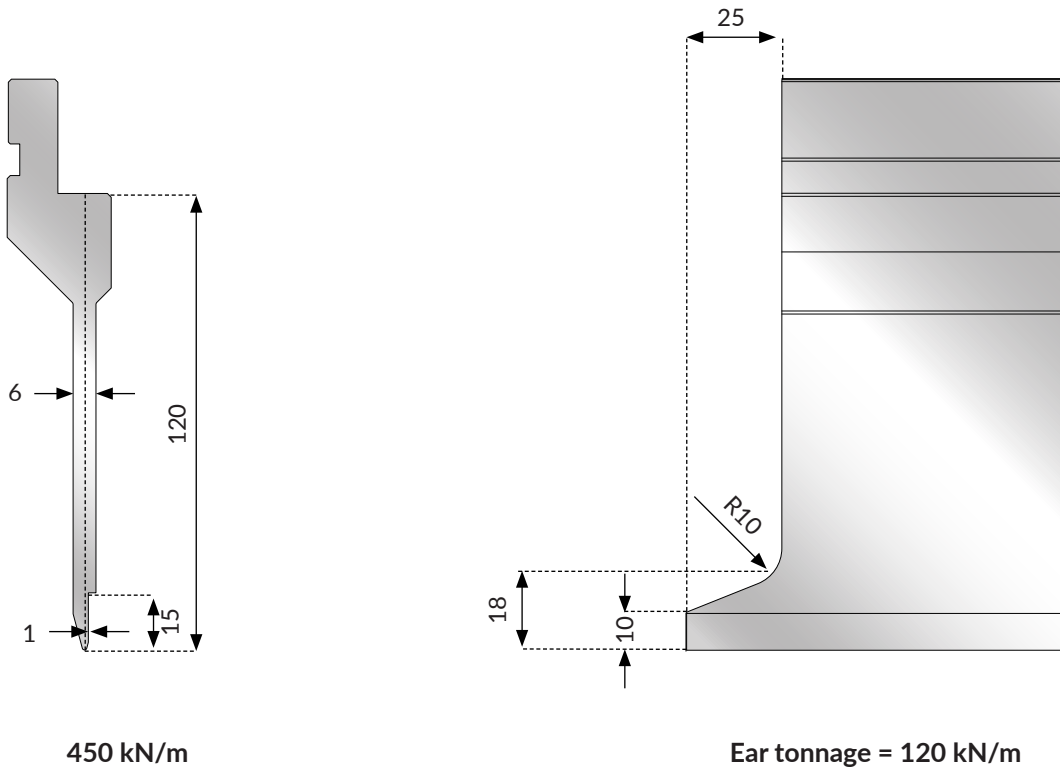


Ear tonnage = 300 kN/m

AMADA® PROFILE #831			CATALOGUE NO.	PRICE
26°	R0.6	835mm	E4831206L	-
		415mm	E4831206S	-
		800mm Sect.	E4831206X	-
30°	R0.6	835mm	E4831306L	-
		415mm	E4831306S	-
		800mm Sect.	E4831306X	-
	R1.5	835mm	E4831315L	-
		415mm	E4831315S	-
		800mm Sect.	E4831315X	-
	R3	835mm	E4831330L	-
		415mm	E4831330S	-
		800mm Sect.	E4831330X	-
	R4	835mm	E4831340L	-
		415mm	E4831340S	-
		800mm Sect.	E4831340X	-

NOTE: ALL PUNCHES SUPPLIED INDUCTION HARDENED AS STANDARD

Acute Angle



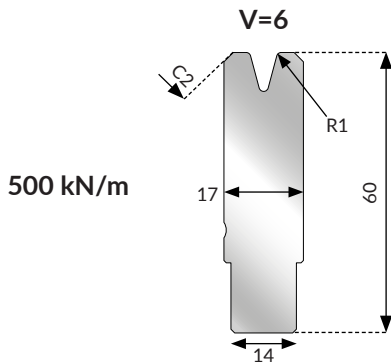
AMADA® PROFILE #814			CATALOGUE NO.	PRICE
30°	R0.6	835mm	E4814306L	-
		415mm	E4814306S	-
		800mm Sect.	E4814306X	-

NOTE: ALL PUNCHES SUPPLIED INDUCTION HARDENED AS STANDARD

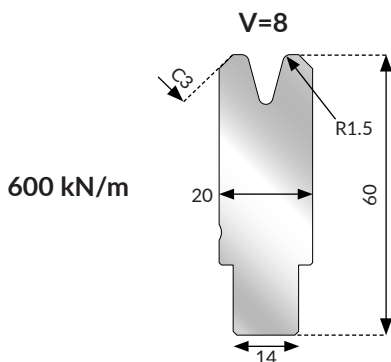
FIXED HEIGHT | Dies



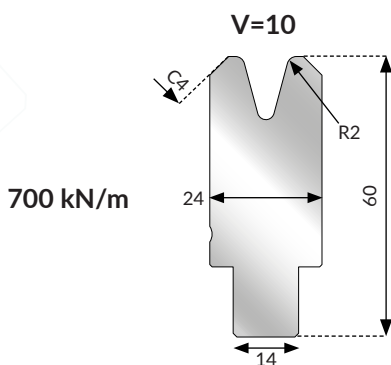
30° Dies



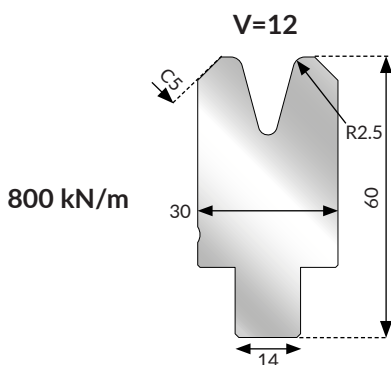
AMADA® PROFILE #0703			CATALOGUE NO.	PRICE
30°	V=6	835mm	E4070310L	-
		415mm	E4070310S	-
		800mm Sect.	E4070310X	-



AMADA® PROFILE #0713			CATALOGUE NO.	PRICE
30°	V=8	835mm	E4071315L	-
		415mm	E4071315S	-
		800mm Sect.	E4071315X	-



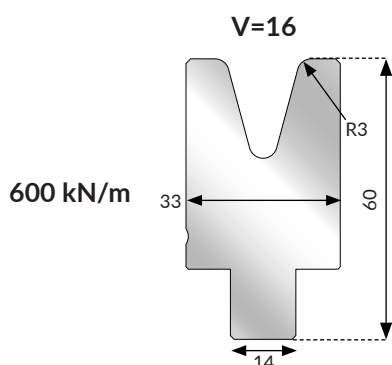
AMADA® PROFILE #0723			CATALOGUE NO.	PRICE
30°	V=10	835mm	E4072320L	-
		415mm	E4072320S	-
		800mm Sect	E4072320X	-



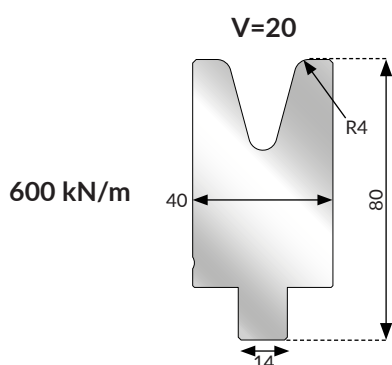
AMADA® PROFILE #0743			CATALOGUE NO.	PRICE
30°	V=12	835mm	E4074325L	-
		415mm	E4074325S	-
		800mm Sect.	E4074325X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

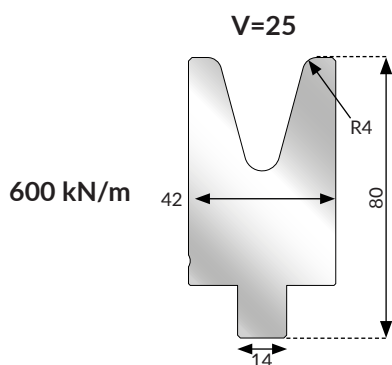
30° Dies



AMADA® PROFILE #0773			CATALOGUE NO.	PRICE
30°	V=16	835mm	E4077330L	-
		415mm	E4077330S	-
		800mm Sect.	E4077330X	-



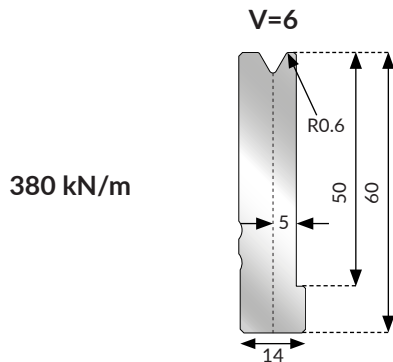
AMADA® PROFILE #0793			CATALOGUE NO.	PRICE
30°	V=20	835mm	E4079340L	-
		415mm	E4079340S	-
		800mm Sect.	E4079340X	-



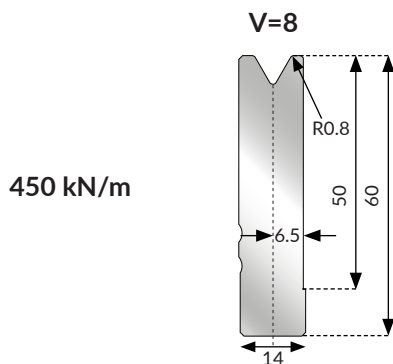
AMADA® PROFILE #0823			CATALOGUE NO.	PRICE
30°	V=25	835mm	E4082340L	-
		415mm	E4082340S	-
		800mm Sect.	E4082340X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

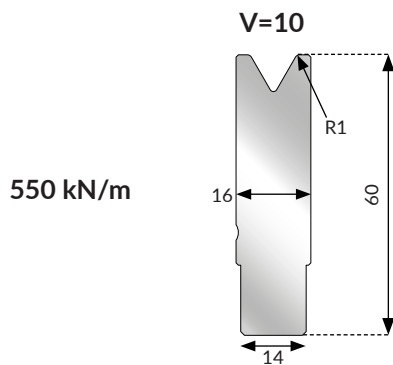
60° Dies



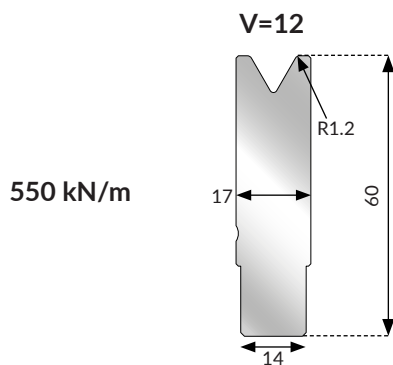
AMADA® PROFILE #0706			CATALOGUE NO.	PRICE
60°	V=6	835mm	E4070606L	-
		415mm	E4070606S	-
		800mm Sect.	E4070606X	-



AMADA® PROFILE #0716			CATALOGUE NO.	PRICE
60°	V=8	835mm	E4071608L	-
		415mm	E4071608S	-
		800mm Sect.	E4071608X	-



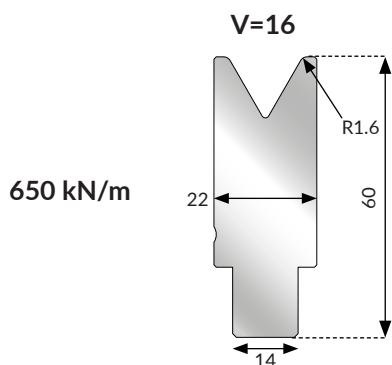
AMADA® PROFILE #0726			CATALOGUE NO.	PRICE
60°	V=10	835mm	E4072610L	-
		415mm	E4072610S	-
		800mm Sect	E4072610X	-



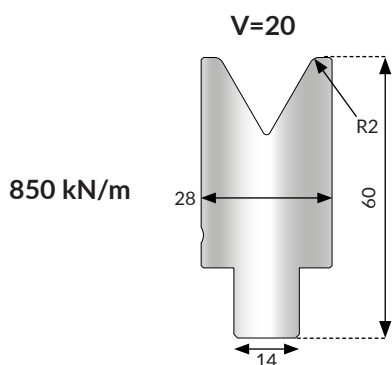
AMADA® PROFILE #0746			CATALOGUE NO.	PRICE
60°	V=12	835mm	E4074612L	-
		415mm	E4074612S	-
		800mm Sect.	E4074612X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

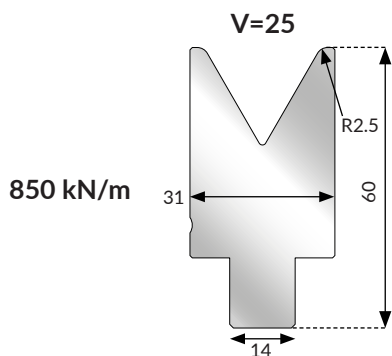
60° Dies



AMADA® PROFILE #0776			CATALOGUE NO.	PRICE
60°	V=16	835mm	E4077616L	-
		415mm	E4077616S	-
		800mm Sect.	E4077616X	-



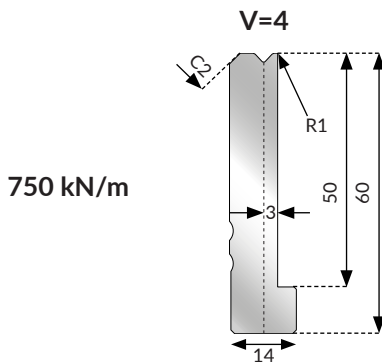
AMADA® PROFILE #0796			CATALOGUE NO.	PRICE
60°	V=20	835mm	E4079620L	-
		415mm	E4079620S	-
		800mm Sect.	E4079620X	-



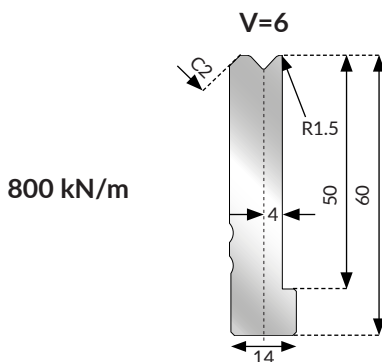
AMADA® PROFILE #0826			CATALOGUE NO.	PRICE
60°	V=25	835mm	E4082625L	-
		415mm	E4082625S	-
		800mm Sect.	E4082625X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

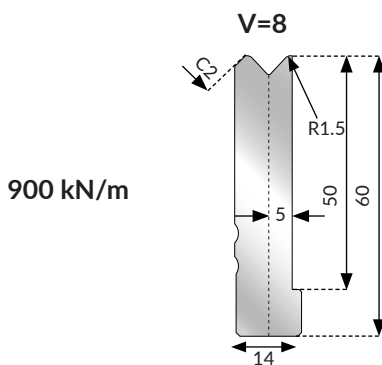
86°, 88°, 90° Dies



AMADA® PROFILE #084			CATALOGUE NO.	PRICE
86°	V=4	835mm	E4084810L	-
		415mm	E4084810S	-
		800mm Sect.	E4084810X	-
88°	V=4	835mm	E4084710L	-
		415mm	E4084710S	-
		800mm Sect.	E4084710X	-
90°	V=4	835mm	E4084910L	-
		415mm	E4084910S	-
		800mm Sect.	E4084910X	-



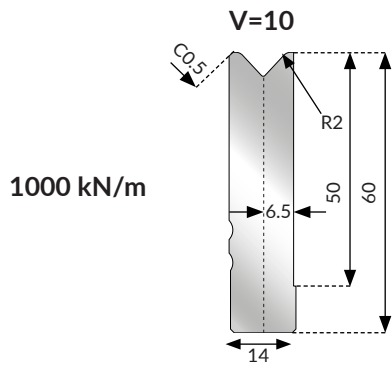
AMADA® PROFILE #070			CATALOGUE NO.	PRICE
86°	V=6	835mm	E4070815L	-
		415mm	E4070815S	-
		800mm Sect.	E4070815X	-
88°	V=6	835mm	E4070715L	-
		415mm	E4070715S	-
		800mm Sect.	E4070715X	-
90°	V=6	835mm	E4070915L	-
		415mm	E4070915S	-
		800mm Sect.	E4070915X	-



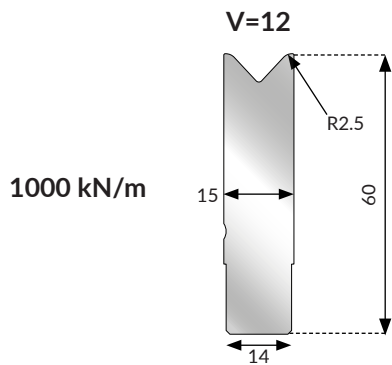
AMADA® PROFILE #071			CATALOGUE NO.	PRICE
86°	V=8	835mm	E4071815L	-
		415mm	E4071815S	-
		800mm Sect.	E4071815X	-
88°	V=8	835mm	E4071715L	-
		415mm	E4071715S	-
		800mm Sect.	E4071715X	-
90°	V=8	835mm	E4071915L	-
		415mm	E4071915S	-
		800mm Sect.	E4071915X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

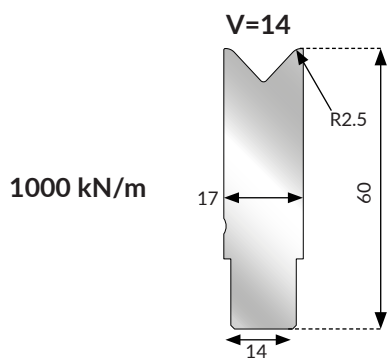
86°, 88°, 90° Dies



AMADA® PROFILE #072			CATALOGUE NO.	PRICE
86°	V=10	835mm	E4072820L	-
		415mm	E4072820S	-
		800mm Sect.	E4072820X	-
88°	V=10	835mm	E4072720L	-
		415mm	E4072720S	-
		800mm Sect.	E4072720X	-
90°	V=10	835mm	E4072920L	-
		415mm	E4072920S	-
		800mm Sect.	E4072920X	-



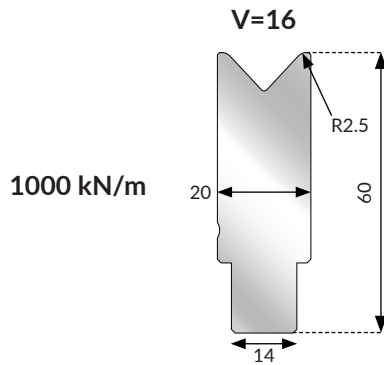
AMADA® PROFILE #074			CATALOGUE NO.	PRICE
86°	V=12	835mm	E4074825L	-
		415mm	E4074825S	-
		800mm Sect.	E4074825X	-
88°	V=12	835mm	E4074725L	-
		415mm	E4074725S	-
		800mm Sect.	E4074725X	-
90°	V=12	835mm	E4074925L	-
		415mm	E4074925S	-
		800mm Sect.	E4074925X	-



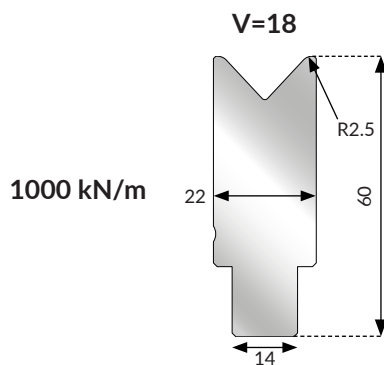
AMADA® PROFILE #076			CATALOGUE NO.	PRICE
86°	V=14	835mm	E4076825L	-
		415mm	E4076825S	-
		800mm Sect.	E4076825X	-
88°	V=14	835mm	E4076725L	-
		415mm	E4076725S	-
		800mm Sect.	E4076725X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

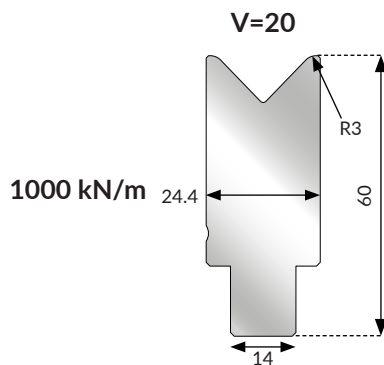
86°, 88° Dies



AMADA® PROFILE #077			CATALOGUE NO.	PRICE
86°	V=16	835mm	E4077825L	-
		415mm	E4077825S	-
		800mm Sect.	E4077825X	-
88°	V=16	835mm	E4077725L	-
		415mm	E4077725S	-
		800mm Sect.	E4077725X	-



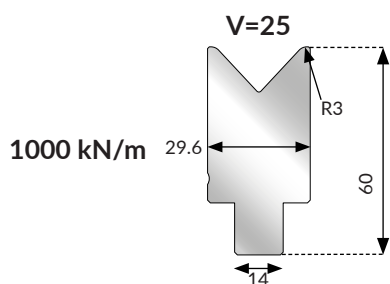
AMADA® PROFILE #078			CATALOGUE NO.	PRICE
86°	V=18	835mm	E4078825L	-
		415mm	E4078825S	-
		800mm Sect.	E4078825X	-
88°	V=18	835mm	E4078725L	-
		415mm	E4078725S	-
		800mm Sect.	E4078725X	-



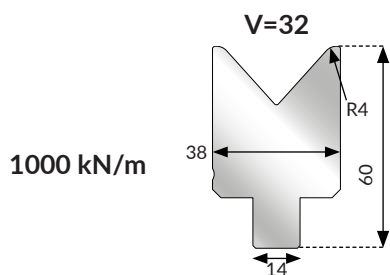
AMADA® PROFILE #079			CATALOGUE NO.	PRICE
86°	V=20	835mm	E4079830L	-
		415mm	E4079830S	-
		800mm Sect.	E4079830X	-
88°	V=20	835mm	E4079730L	-
		415mm	E4079730S	-
		800mm Sect.	E4079730X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

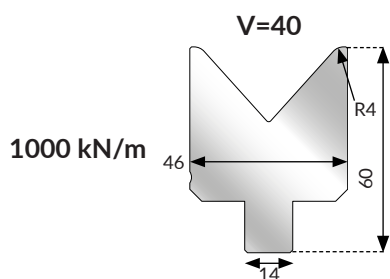
86°, 88°, 84° Dies



AMADA® PROFILE #082			CATALOGUE NO.	PRICE
86°	V=25	835mm	E4082830L	-
		415mm	E4082830S	-
		800mm Sect.	E4082830X	-
88°	V=25	835mm	E4082730L	-
		415mm	E4082730S	-
		800mm Sect.	E4082730X	-



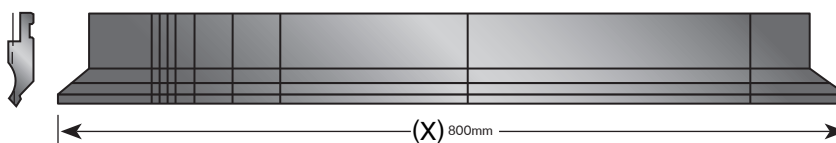
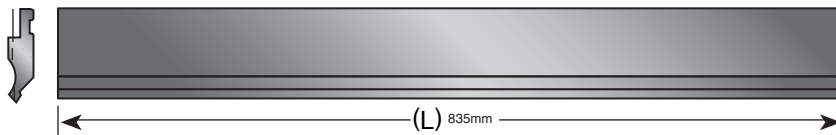
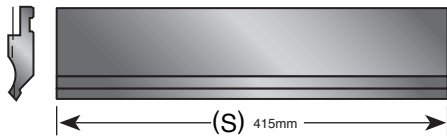
AMADA® PROFILE #087			CATALOGUE NO.	PRICE
84°	V=32	835mm	E4087440L	-
		415mm	E4087440S	-
		800mm Sect.	E4087440X	-



AMADA® PROFILE #088			CATALOGUE NO.	PRICE
84°	V=40	835mm	E4088440L	-
		415mm	E4088440S	-
		800mm Sect.	E4088440X	-

NOTE: ALL DIES SUPPLIED WITH NITREX® AS STANDARD

Available Lengths



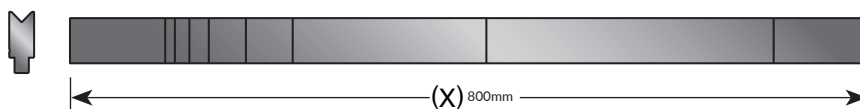
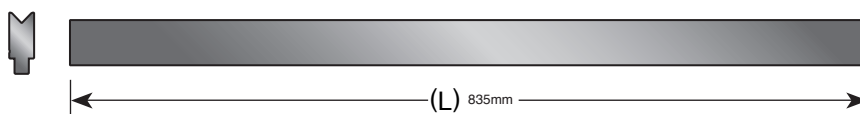
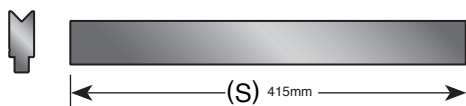
PUNCH FEATURES:

1. Most tools can be easily loaded by a single operator.
2. Easy to store.
3. All sectionalised tools come pre-cut in ten different pieces.
4. Most 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 100 **LEFT EAR**, 10, 15, 15, 20, 40, 50, 150, 300, 100 **RIGHT EAR** (10 pieces total)

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



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 nine different pieces.
4. All dies are NITREX® enhanced (HRC 60) as standard.
5. Special Tooling available. Please contact the sales desk.

DIE SECTION WIDTHS ARE AS FOLLOWS:

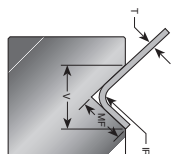
100mm / 10, 15, 15, 20, 40, 50, 150, 400

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

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	



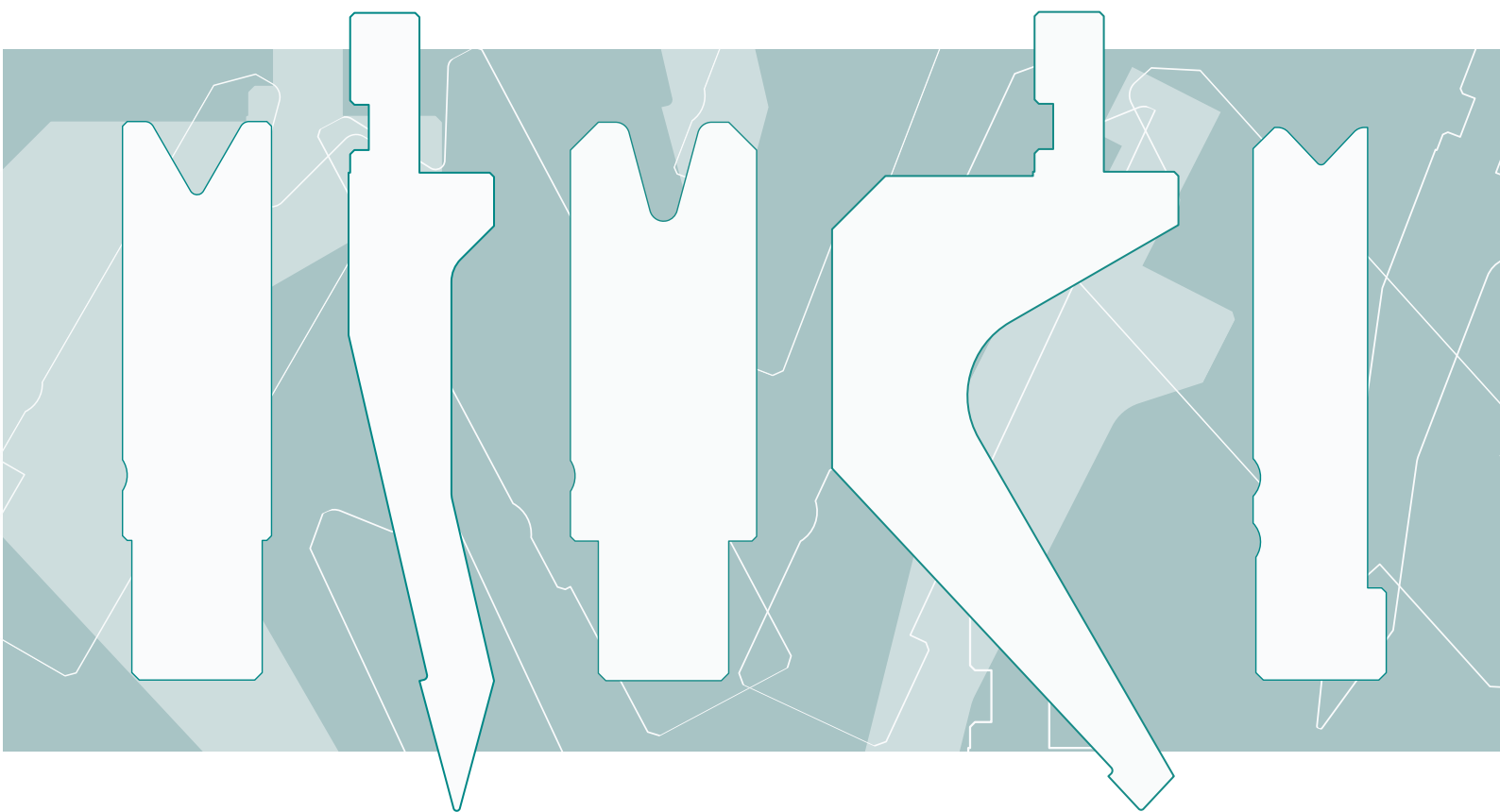
FIGURES BASED ON MILD STEEL		4	6	7	8	10	12	14	16	18	20	22	25	32	40	50	63	80	100	125	160	200	250
THICKNESS	V (mm)	4	6	7	8	10	12	14	16	18	20	22	25	32	40	50	63	80	100	125	160	200	250
	MF	2.8	4.2	4.9	5.6	7.0	8.6	10.1	11.5	13.0	14.4	*15.8	18.0	24.0	30.0	37.5	47.3	60.0	75.0	96.3	123.2	154.0	192.5
0.5mm	IR	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
		4.5	2.8																				
		6.0	4.2	3.3	3.2																		
			8.0	7.2	5.6	4.4																	
				11.0	10.0	9.0	7.0	5.5															
					14.0	13.2	10.8	8.4	7.5	6.6													
						15.4	14.0	12.6	9.8	8.8	7.7												
							17.6	16.0	14.4	11.2	10.0	8.8											
								22.0	20.0	18.0	16.0	14.0	12.5	11.0									
									25.3	23.0	20.7	18.4	16.1	14.4	12.7								
										28.6	26.0	23.4	20.8	18.2	14.3								
											33.0	30.0	28.53	27.0	21.0	16.5							
												35.2	31.9	28.8	22.4	17.6	14.4						
													38.5	35.0	28.0	21.9	15.8	14.0					
3.5mm	P																						
4.0mm	E												44.0	36.0	28.0	22.0	18.0						
4.5mm	R													45.0	36.0	28.1	20.3						
5.0mm														55.0	45.0	35.0	26.3	22.5					
6.0mm	M														60.0	54.0	37.5	31.5	24.0				
7.0mm	E																56.0	43.8	31.5	28.0			
9.0mm	T																	72.0	56.3	40.5			
10.0mm	R																	90.0	70.0	52.5	45.0		
12.0mm	E																		108.0	84.0	63.0	54.0	
16.0mm																				144.0	112.0	84.0	72.0
19.0mm																					152.0	118.8	99.8
22.0mm																						176.0	137.5
25.0mm																							225.0
30.0mm																							270.0

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

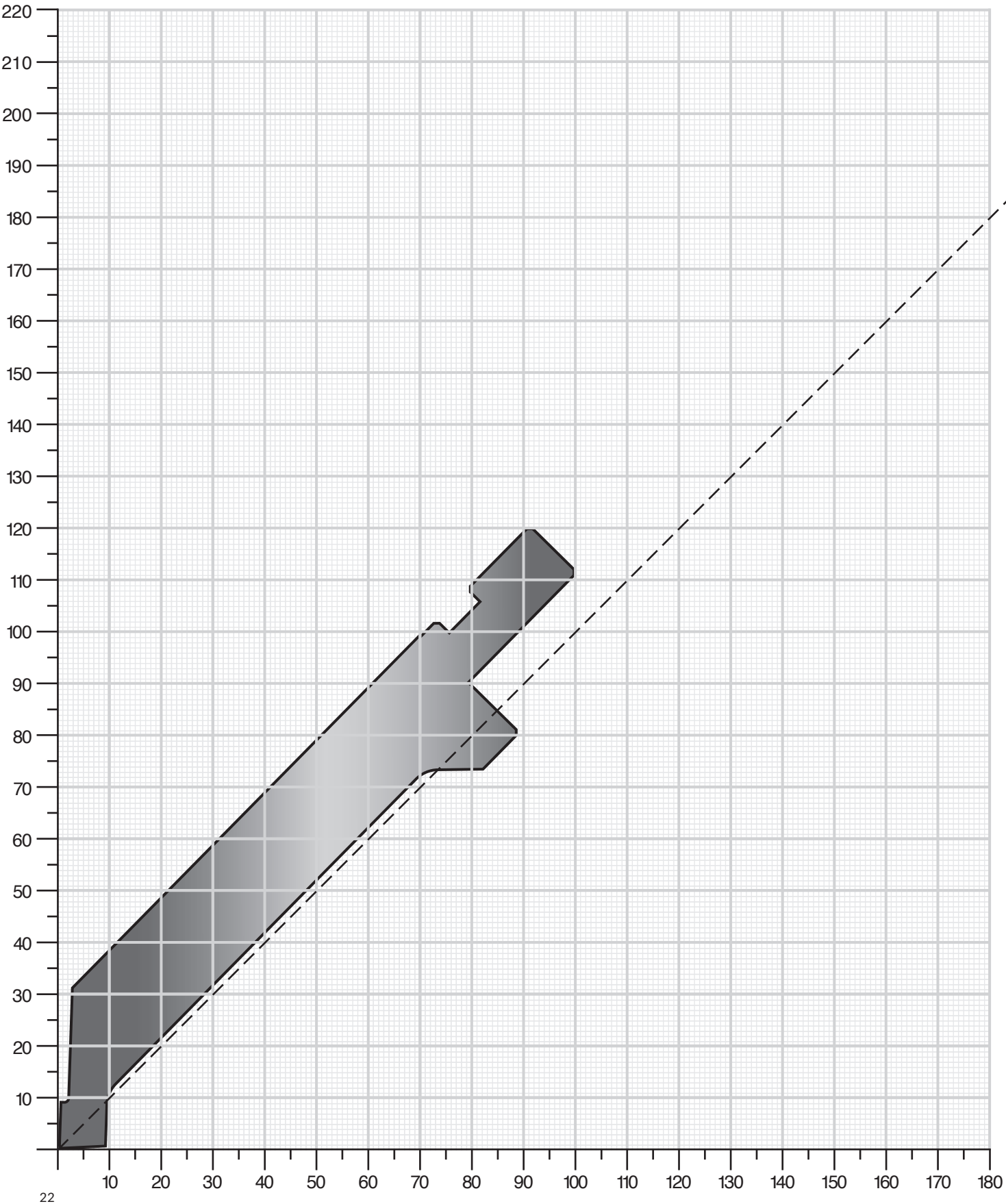
The bending force (tonnage) figures listed above are based on mild steel with a tensile strength of 45-50 kilograms per square millimetre. To calculate the approximate bending force (tonnage) requirements for other materials, please use the multipliers listed.

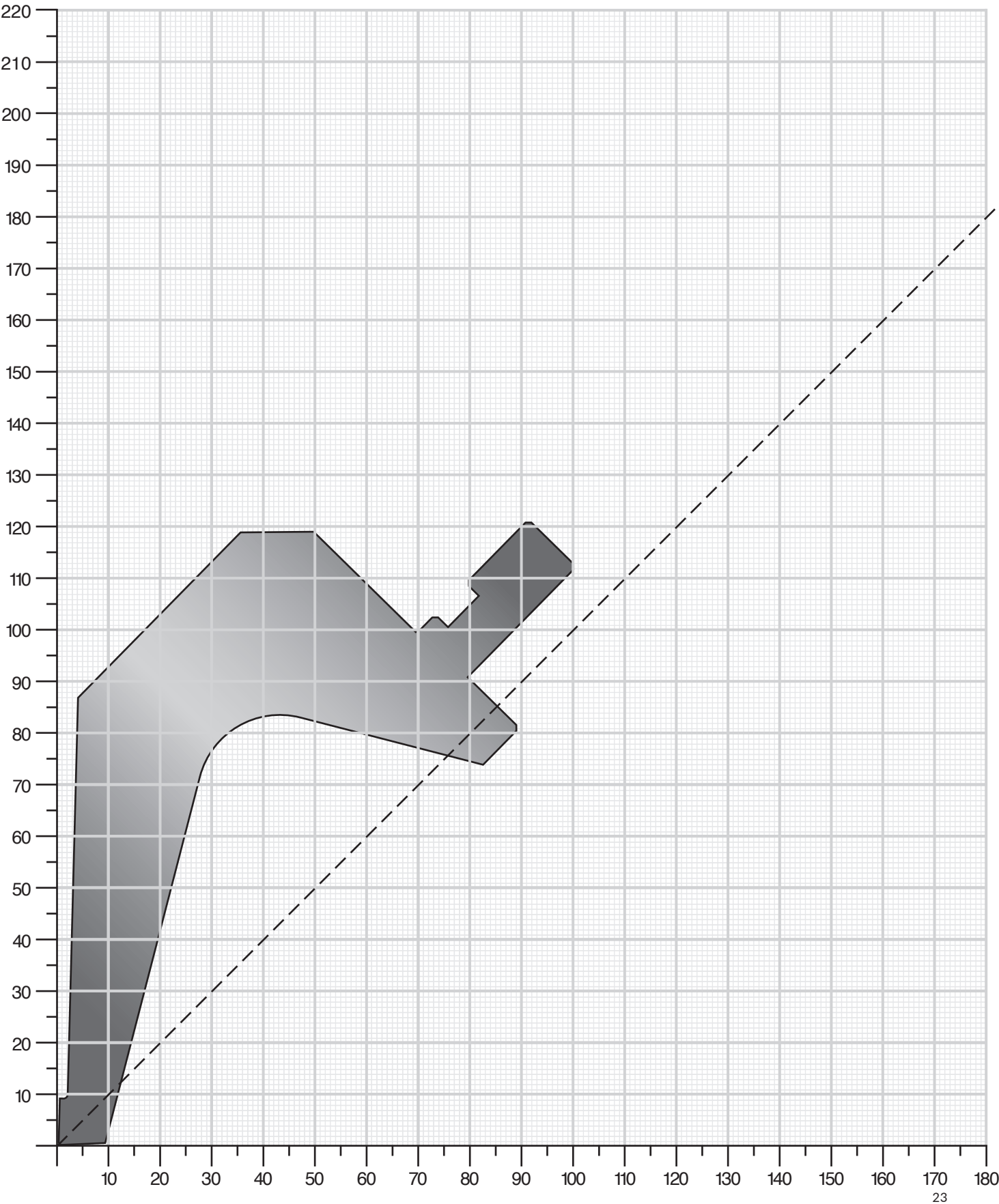
Note: * Based on bending to an included angle of 88 degrees. This dimension will increase when bending to an included angle of less than 88 degrees.

FIXED HEIGHT | Bend Limit Graphs

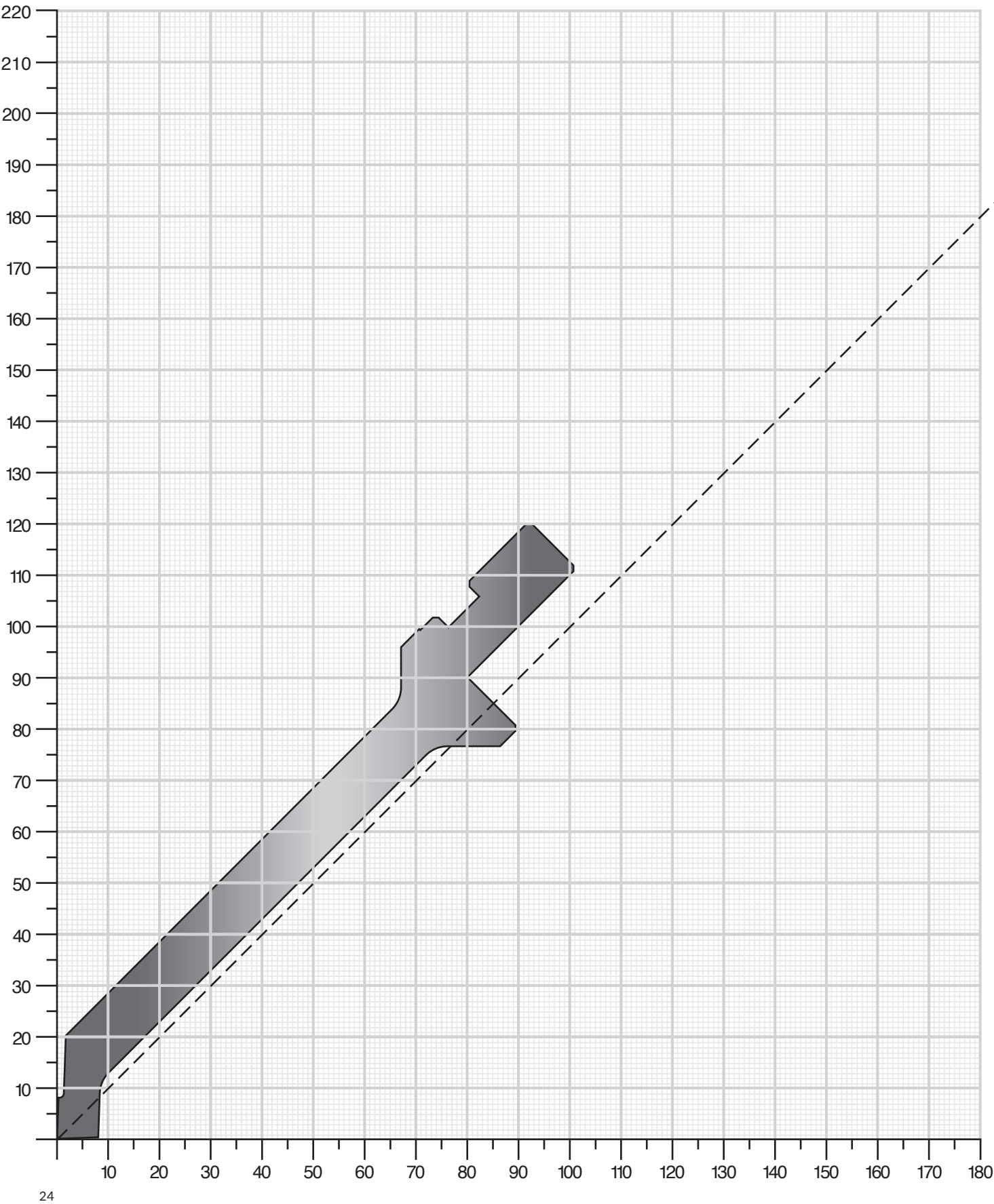


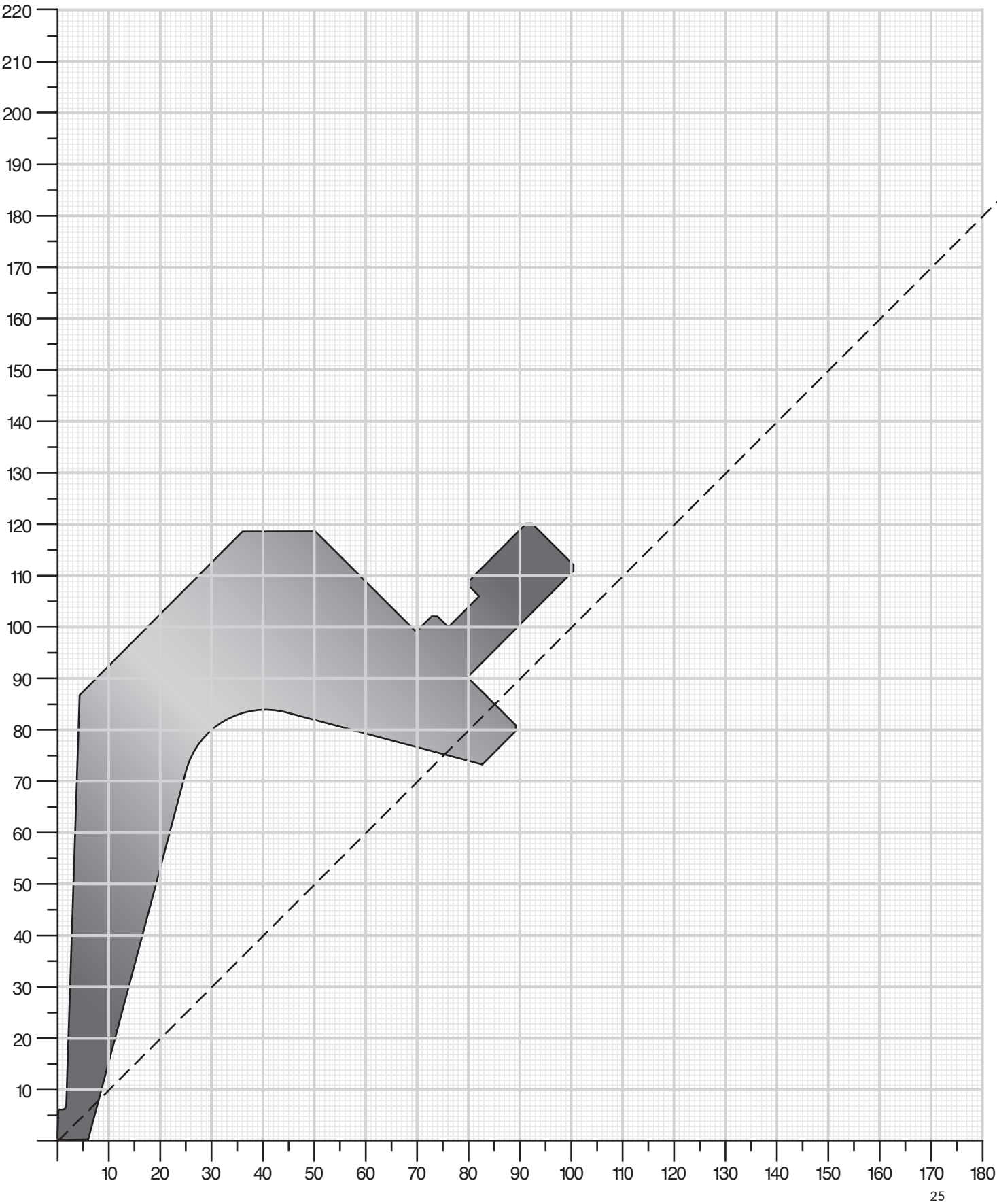
BEND LIMIT GRAPH E4804



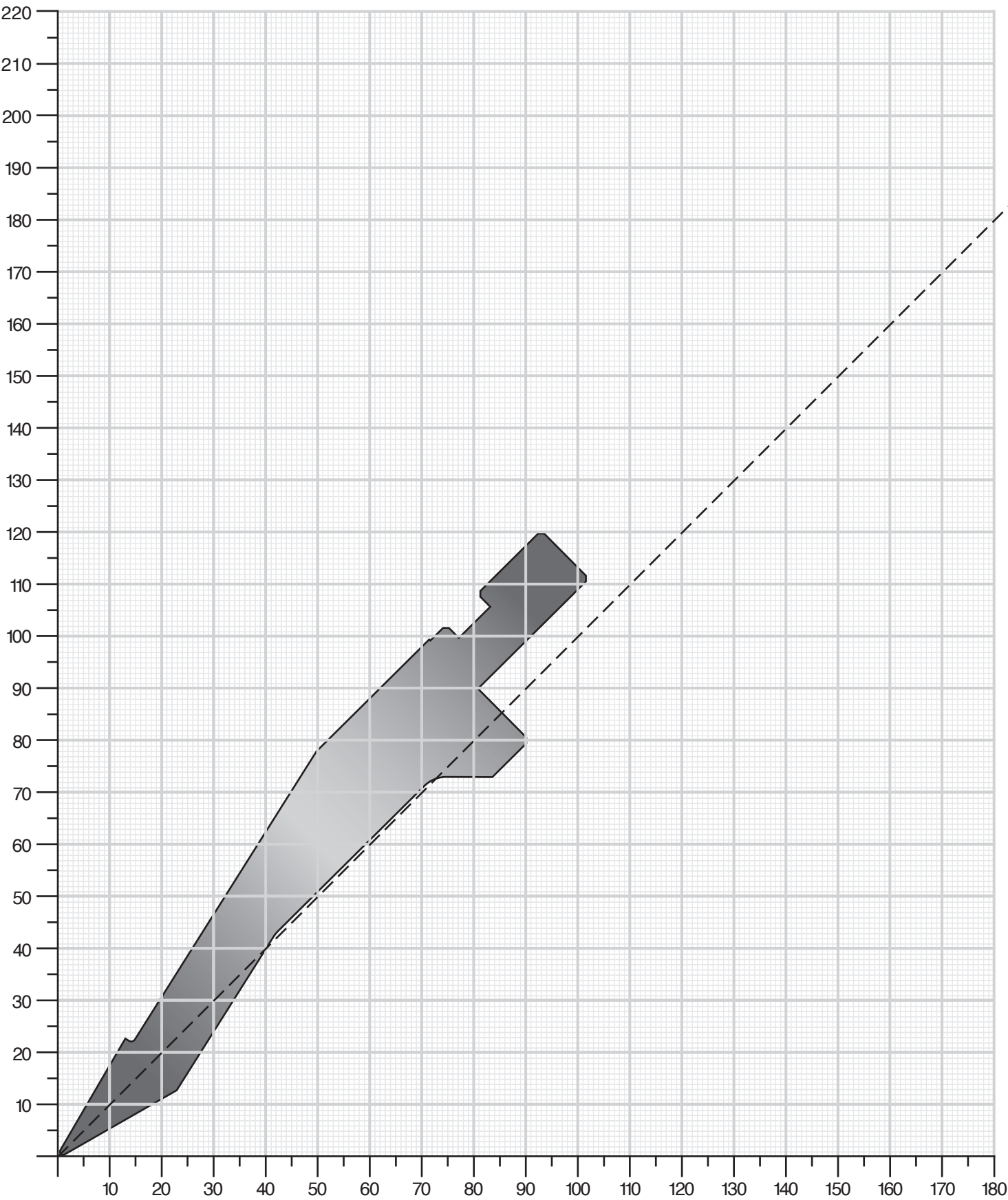


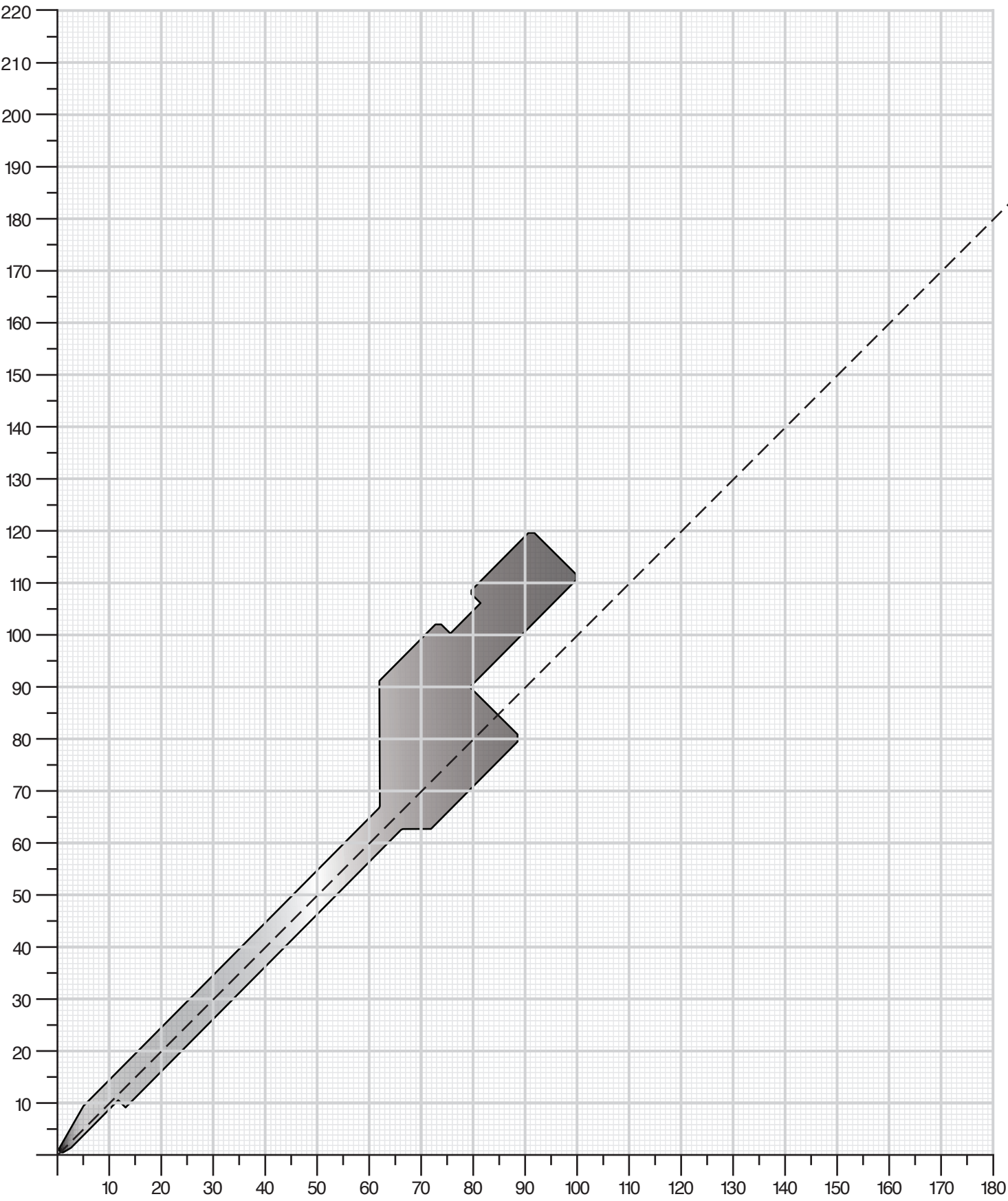
BEND LIMIT GRAPH E4820





BEND LIMIT GRAPH E4831





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