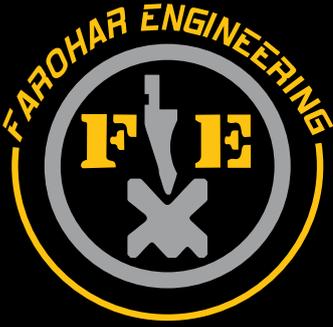


Manufacturers of : Press Brake tools, Panel Bending Tools. Hardened and ground liner Plates.
AN ISO 9001 : 2015 CERTIFIED



FARO HAR ENGINEERING



■ **PRESS
BRAKE
TOOLS**



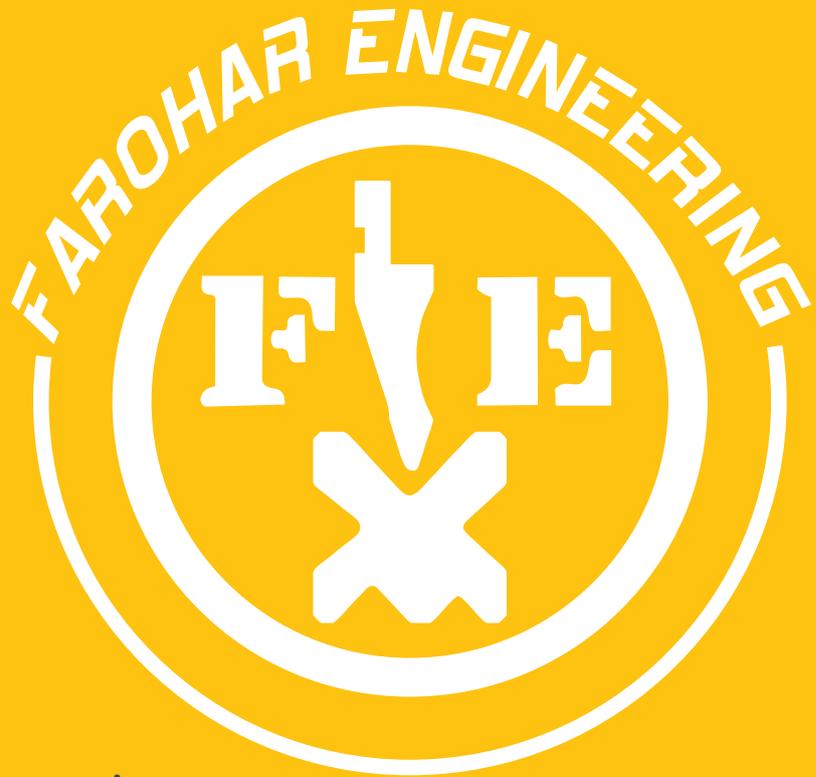
Enquiry





Bend with Confidence

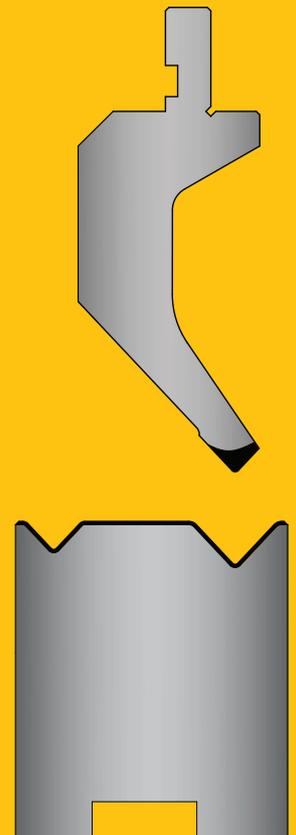
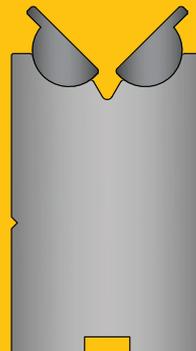
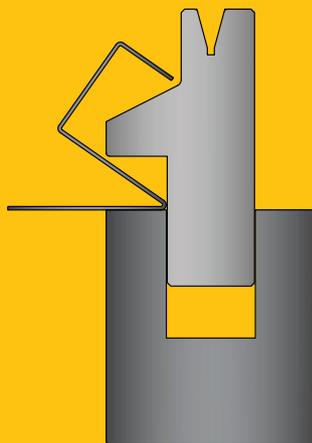
Effective Solutions,
Delivered with Ease



- ✦ Press Brake Tools
- ✦ Panel Bending Tools
- ✦ Rocker Bending Tools
- ✦ Profile Bending Tools

- ✦ Hardened Housing Liners for Steel Mills
- ✦ Manufacturing and Re-Sharpening of Carbide and shearing Blades

- ✦ Surface Grinding and Machining of Jobs up to 4.5 mtrs.
- ✦ Slideway Grinding of Machine bed and Table
- ✦ CNC Milling (VMC) Labour Jobs up to 3 mtrs.



ABOUT US



Bend with Confidence:

Precision Crafted for Lasting Performance

Mr. Percy M. Karani

Sr. Partner B.E. (Mech); DMS.
(Ex- Godrej M/c. tool Division)

Introduction

Farohar Engineering is a leading manufacturer of press brake tools, committed to delivering top-notch quality products with robust built and long-lasting performance. Our mission is to provide superior quality tools at competitive prices and making premium quality tools accessible in India.

Behind the brand

Founded by Mr. Percy Karani, a veteran with over 47 years of experience in the manufacturing industry, including 15 years in the Machine Tool Division of Godrej & Boyce, Farohar Engineering brings expertise and passion to manufacturing press brake tools and steel mill components. With a legacy tracing back to 1991 through Technica, and strengthened by the involvement of his son Delzad Karani from 2008, Farohar Engineering was established in 2013. Today, we serve over 1000 clients with a diverse range of press brake tools and solutions, backed by a dedicated team.

Core Values

At Farohar Engineering, we prioritize:

- **Customer Centricity:** Providing maximum support to our customers through customization, ensuring our products meet their specific needs.
- **Quality Excellence:** Delivering superior quality products that exceed our customers' expectations.
- **Innovation:** Continuously improving our products and processes to stay ahead in the industry.

Our Commitment to Longevity

- **Performance Grade:** Precision Engineering, Imported Alloy Steel, Toughened to 30 HRC with working Area Induction Hardened to 55 HRc for Minimal Wear.
- **Economy Grade:** Features Carbon Steel with working Area Induction Hardened 50HRc to 54HRc.

ABOUT US



LIST OF MACHINERY AND FACILITY AVAILABLE

MACHINE NAME	MACHINE CAPACITY (LxWxH)
SURFACE GRINDING MACHINES	
CNC DANOBAT (SPAIN)	4000 X 700 X 850 mm
CANTALUPPI (ITALIAN)	4500 X 750 X 400 mm
FAVRETTO (ITALIAN) DOUBLE COLUMN SLIDEWAY GRINDER	4000 X 1250 X 750 mm
KEHREN (GERMAN)	3000 X 700 X 400 mm
BLOHM (GERMAN)	1600 X 350 X 300 mm
CANTALUPPI (ITALIAN)	2500 X 400 X 350 mm
COSMOS NC (ELB COLLABORATION)	1500 X 700 mm
PROTH	2000 X 1200 X 600 mm
VERTICAL MACHINING CENTER	
HASS (USA) VMC	2000 X 800 mm
YAMARA (JAPAN) VMC	3000 X 1000 X 650 mm
YAMARA (JAPAN) DOUBLE COLUMN VMC	2000 X 1500 X 750 mm
BFW (INDIA) VMC	1050 X 610 X 610 mm
Bed Milling Machine (HURON)	3500 X 600 mm
Pensotti Planomiller	1500 X 600 mm
OTHER MACHINES	
CNC Wire Cut (Concord) EDM Machine 7740	500 X 400 X 500 mm
LASER MARKING MACHINE (LASER TECHNOLOGIES)	20W
ELECTRIC FURNACE	
SURFACE FINISH TESTER (CARL ZEISS INDIA)	
MITUTOYO 2D DIGITAL LINEAR HEIGHT Gauge RANGE	0-977MM



Certificate of Registration

This certificate has been awarded to

Farohar Engineering

Plot No.: W-9, B/1, Opp., Hotel Sachin, Additional Ambernath MIDC, Anand Nagar,
Ambernath (E), Dist Thane Maharashtra, 421506, India

in recognition of the organization's Quality Management System which complies with

ISO 9001:2015

The scope of activities covered by this certificate is defined below

Manufacture of Hardened and Ground Press Brake Bending Tools, Steel Mill Components like Hardened Housing Liner, Carbide and Shearing Blades and Provision of Sideway Grinding of Machine Bed and Table and Reconditioning of Tools

Certificate Number **102586/A/0001/NB/En**

A certificate number of 0001, confirms the Client has a single site Certified & the site is their Head Office or Main site in relation to the Certified scope with URS. A certificate number of 0002, or greater (e.g. xxx/0/0002/UK/En) refers to a client that has more than one site certified with URS, as such, the following statement shall apply: "The validity of this certificate depends on the validity of the main certificate".

Date of Issue of Certification Cycle	Issue Number	Certificate Expiry Date	Certification Cycle
08 April 2025	3	25 February 2028	3
Revision Date	Revision Number	Original Certificate Issue Date	Scheme Number
08 April 2025	0	26 February 2019	n/a

For detailed explanation for the data fields above, refer to <http://www.urs-holdings.com/logos-and-regulations>

Issued by

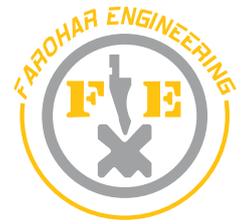
Mukesh Singhal - On behalf of the Schemes Manager



URS Certification Limited, F 3, Sector 6, Noida, 201301 India. info@ursindia.com. Please contact above address to check current validity of Certificate. URS Certification Limited is part of United Registrar of Systems (Holdings) Ltd.

URS is a member of United Registrar of Systems (Holdings) Ltd, United House, 28 Poole Hill, Bournemouth, BH2 5PS, UK. Company Registration no. 5298466

1 / 1



CONTENT

01

MATERIAL OPTION 11

02

PUNCH 12

a. Standard Neck Holdings 12

b. Standard Segment 14

c. Standard Horn Profile 15

d. Amada Type Tooling 17

i. Introduction 17

ii. Straight Punch 18

iii. Semi Gooseneck Punch 22

iv. Gooseneck Punch 28

v. Profile Punch 36

e. Trumpf – Wila Type Tooling 38

i. Introduction 38

ii. Straight Punch 39

iii. Semi Gooseneck Punch 41

iv. Gooseneck Punch 44

f. LVD Type Tooling 47

i. Introduction 47

ii. Straight Punch 48

iii. Semi Gooseneck Punch 50

iv. Gooseneck Punch 51

g. Bystronic Type Tooling 54

i. Introduction 54

ii. Straight Punch 55

iii. Semi Gooseneck Punch 57

iv. Gooseneck Punch 59

03

DIE 62

a. Die Segment 62

b. Amada Type Single Vee Die 63

i. SVD A86° V6, V8, V10 63

ii. SVD A86° V12, V16, V20 64

iii. SVD A86° V25, V32, V40 65

iv. SVD A86° V50, V60, V125 66

c. Trumpf - Wila Type Single Vee Die 67

i. SVD A30° V6, V8 67

ii. SVD A30° V10, V12 68

iii. SVD A30° V16, V20 69

iv. SVD A30° V24, V32 70

v. SVD A30° V40, V48 71

vi. SVD A78° V6, V8 72

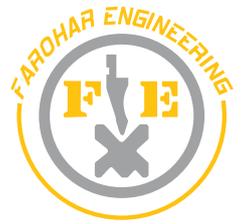
vii. SVD A78° V10, V12 73

viii. SVD A78° V16, V20 74

ix. SVD A78° V24, V32 75

x. SVD A78° V40, V48 76

xi. SVD A78° V60, V80 77



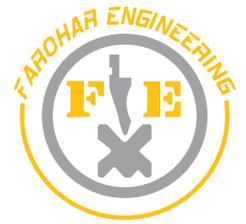
d. LVD Type Single Vee Die	78
i. SVD A30° V6, V8	78
ii. SVD A30° V10, V12	79
iii. SVD A30° V16, V20	80
iv. SVD A30° V24, V32	81
v. SVD A30° V40, V48	82
vi. SVD A78° V6, V8	83
vii. SVD A78° V10, V12	84
viii. SVD A78° V16, V20	85
ix. SVD A78° V24, V32	86
x. SVD A78° V40, V48	87
xi. SVD A78° V60, V80	88
e. Adaptive Vee Die	89
i. AVD – 1 (40 to 120)	89
ii. AVD – 2 (48 to 160)	90
f. Self Centering 2 Vee Die	91
i. F.E. I-Type 2 Vee Die	91
ii. F.E. Die Holder	92
g. Self Centering 2 Vee Die	93
i. SC2VD A86°	93
ii. SC2VD A60°	94
iii. SC2VD A30° & L-Type 2 Vee Die A86°	95
h. 2 Vee Die Bolted Type	96
i. Self Centering Rail	97
j. Multi Vee Die	98

04

WINDOW PUNCH	101
a. WP Swivel Type	101
b. WP Insert	103
c. Variable WP with Variable Radius	104
d. WP Pocket Type	105

05

Hemming Die	106
a. Introduction	106
b. Spring Loaded Hemming Die	107
i. Spring Loaded Hemming Die V6	107
ii. Spring Loaded Hemming Die V8	108
iii. Spring Loaded Hemming Die V10	109
iv. Spring Loaded Hemming Die V12	110
c. Incline Hemming Die	111
d. Slender Hemming Die	112
e. Fixed Hemming Die	113
i. Fixed Hemming Die V8	113
ii. Fixed Hemming Die V10	114
iii. Fixed Hemming Die V12	115



f. Variable Insert Hemming Die 116

g. Pneumatic Hemming Die 117

06

ROCKER DIE 118

a. Introduction 118

b. Advantages of Rocker Die 119

c. Rocker Die 120

i. Rocker Die CD6 120

ii. Rocker Die CD8 121

iii. Rocker Die CD13 122

iv. Rocker Die CD18 123

v. Rocker Die CD22 124

d. Customized Rocker Die 125

e. Adaptive Rocker Die – 1 126

f. Adaptive Rocker Die – 2 127

g. Types Of Rocker Insert 128

h. Adaptive Joggle Die 129

i. U-Bend Rocker Die 130

j. Rocker Wiping Tool 131

07

Z-Bend 132

a. Fixed Type Z-Bend Tool 132

b. Z-Bend Insert Holder 133

c. Z-Bend Insert Tool 134

d. Adaptive Joggle Tool 140

e. Adaptive Rocker Joggle Tool 141

08

BEADING PUNCH AND DIE 142

a. Closed Profile Beading 142

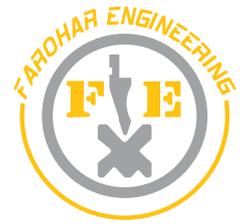
b. Open Profile Beading 143

09

GASSET BENDING 144

a. Gusset Insert 144

b. Gusset Insert Selection 145



10

CURLING DIE AND PUNCH 146

11

Forming Tool 148

- a. Hat Forming Tool 148
- b. Radius Forming Tool 149
- c. Conduit Bending 150
- d. Unequal Bending Punch And Die 151

12

PUNCH HOLDER AND RADIUS HOLDER 152

- a. PH & RI R3 – R7 152
- b. Punch Holder Adaptor for Quick Clamp 153
- c. Punch Holder & Radius Holder 154
 - i. PH & RI R7.5 - R12 154
 - ii. PH & RI R13 – R30 155
 - iii. PH & RI R35 – R50 156

d. Punch holder Adaptor R3 – R7 157

e. Angular Punch Insert 158

f. Flattening Insert 159

g. Extended Holder 160

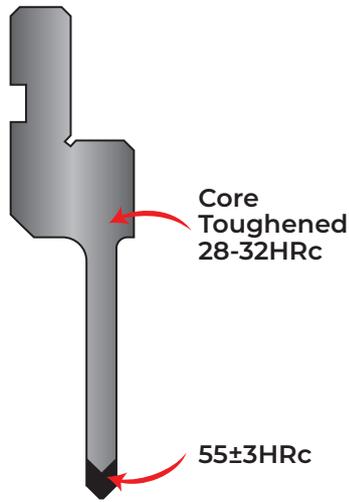
13

Accessories 161

- a. Punch Adaptor 161
 - i. Conversion Punch Adaptor 161
 - ii. Adjustable Punch Adaptor 163
 - iii. Standard Punch Adaptor 164
- b. Punch Clamp 165
 - i. Bolted & Lever Type Clamp 165
 - ii. Pneumatic Type Clamp 166
- c. Die Clamping 167
 - i. Die Clamping Style – 1 167
 - ii. Die Clamping Style – 2 168
 - iii. Lower Adaptor 169
- d. Gauge 170
 - i. Magnetic Gauge 170
 - ii. Front Support Blanking Type Gauge 171

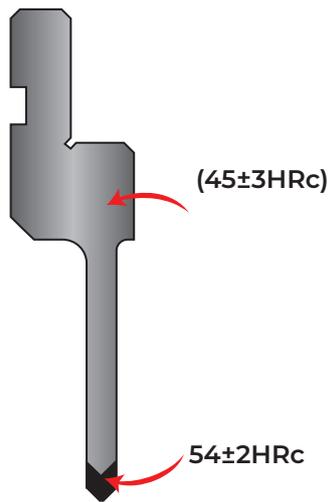
MATERIAL

1 | MATERIAL OPTIONS



M01 Toughened for Optimum Performance for 1.3 times max Load & 1.5 times tool life

Cr+Mn+Mo 900-1020N/mm²
Quenched & Tempered 30±2 HRc 55±3HRc

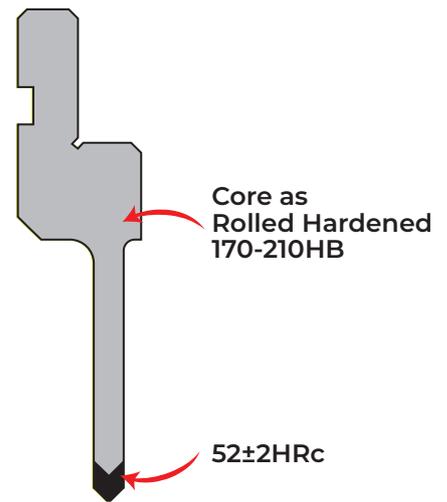


M08 Tough Hardened and Groundened

42Cr+Mo4
Quenched & Tempered 30±2 HRc

Why Choose Farohar Engineering?

- 1 Competitive Pricing:** We offer premium quality tools at lower prices than our competitors.
- 2 Robust Built and Long-Lasting Performance:** Our products are designed to deliver exceptional performance and durability.
- 3 Customization:** We work closely with our customers to provide tailored solutions that meet their specific needs.



M03 Economy Grade

C45 :570-680 N/mm²
 52±2HRc

DECODE

SP01 H90 R0.8 A86 N01 M01

Straight Punch = SP
Semi Gooseneck Punch = SGNP
Gooseneck Punch = GNP
Profile Punch = PP

Height of the punch excluding neck

Punch tip radius

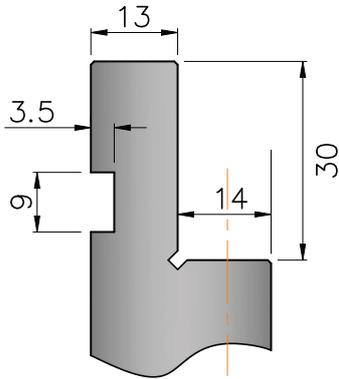
Punch Angle

Material refer this page

Punch neck type refer page 9

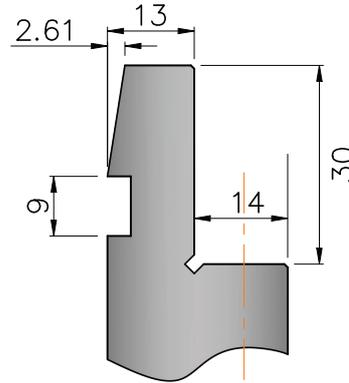
PUNCH | STANDARD NECK HOLDINGS

2:A | STD. PUNCH NECK HOLDINGS

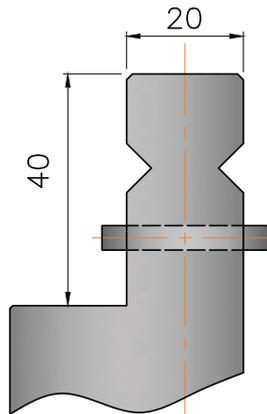


N01 EUROPEAN

Amada Type Neck

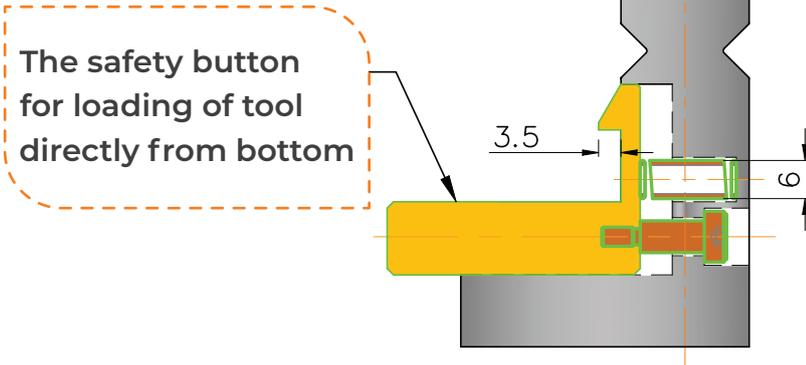


N02 ONE TOUCH

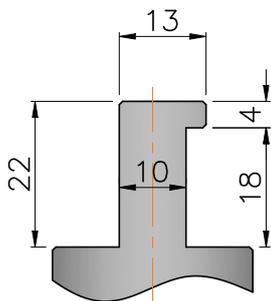


N03 WILA TYPE

Various Wila Type Clamping Neck on page no. 38

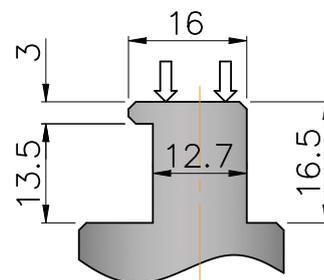


N04 WILA NECK WITH BUTTON



N05 AMERICAN A

LVD Type Clamping Neck refer page no. 47



N06 AMERICAN SAFETY

Material Option

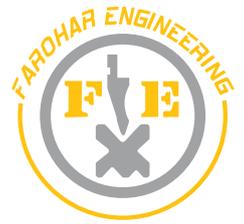
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

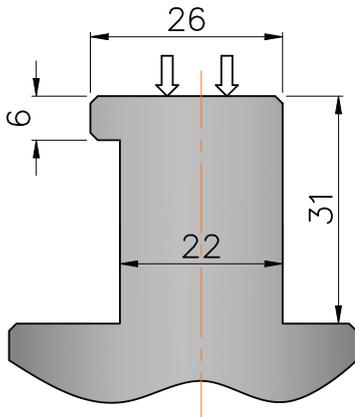
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



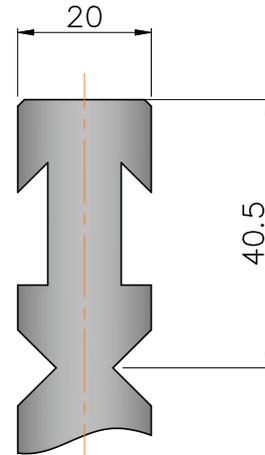


PUNCH | STANDARD NECK HOLDINGS

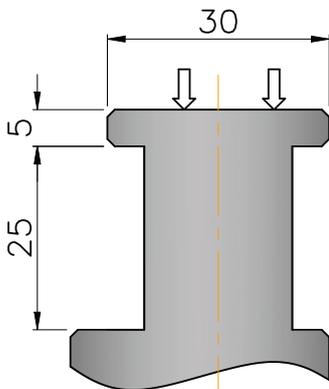
2:A | STD. PUNCH NECK HOLDINGS



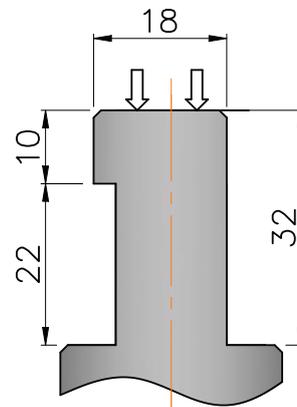
N07 DARLE



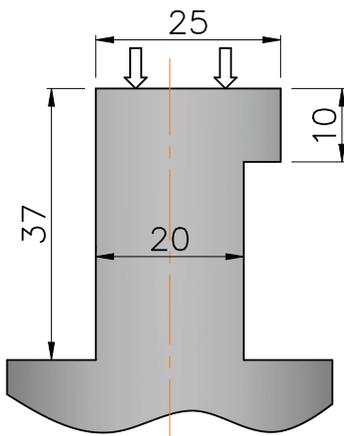
N08 BYSTRONIC
Refer page no. 54



N09 GASPARINI TYPE



N10 AMERICAN B



N11 AMERICAN C

For Other Neck Holding System Contact us with Your Neck Drawing

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



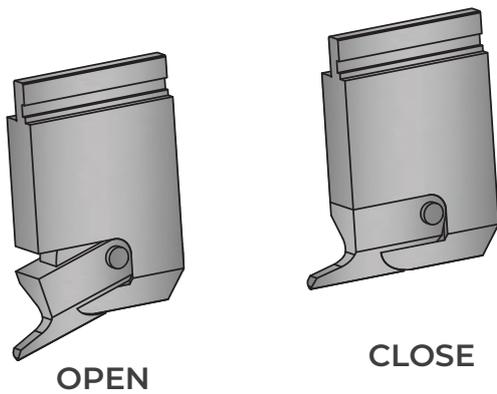
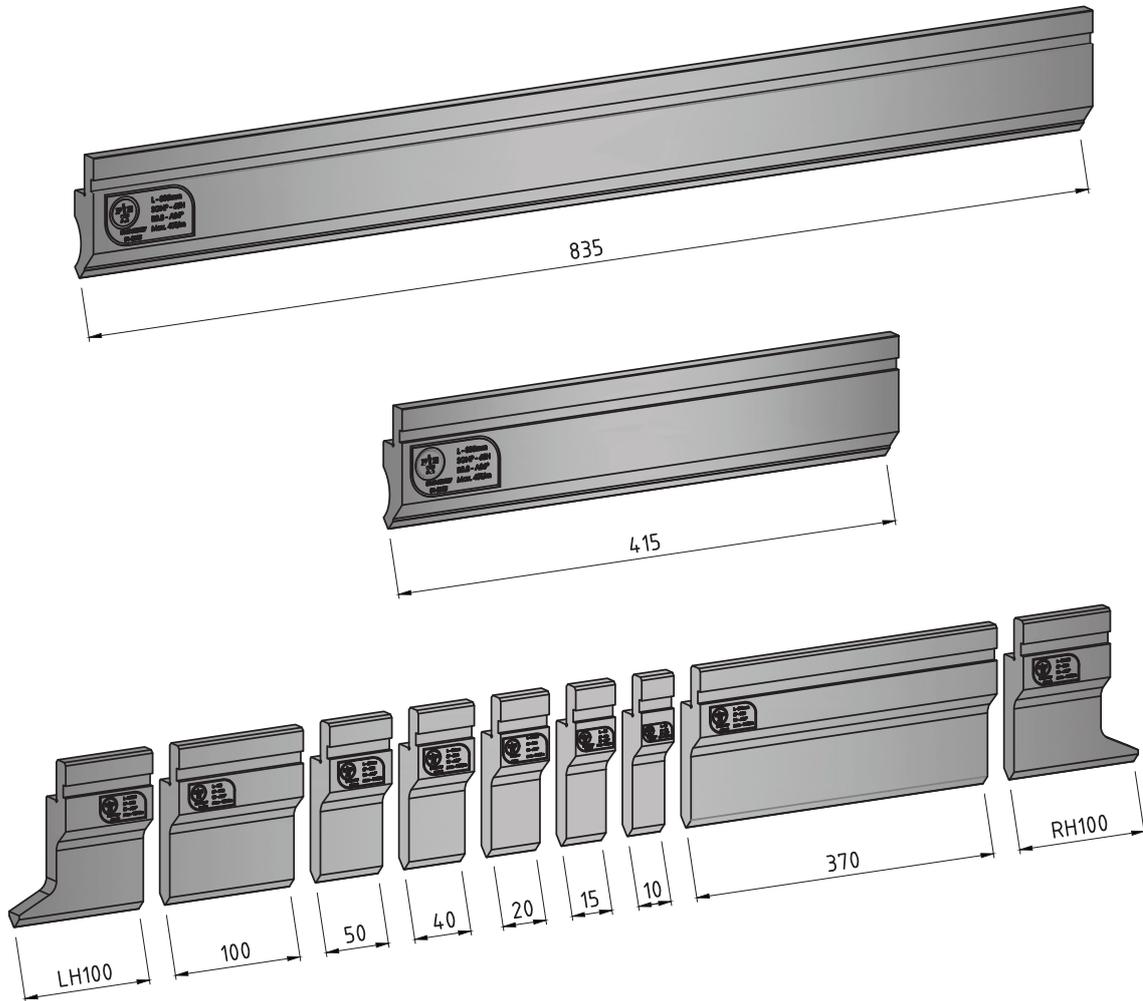
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | SEGMENTS

2:B | STANDARD SEGMENTS



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

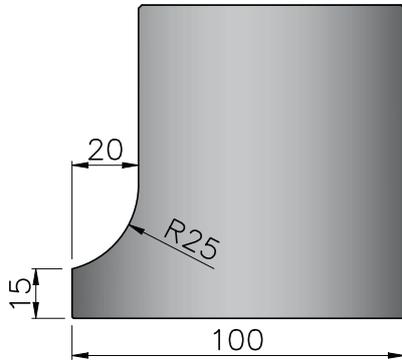
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



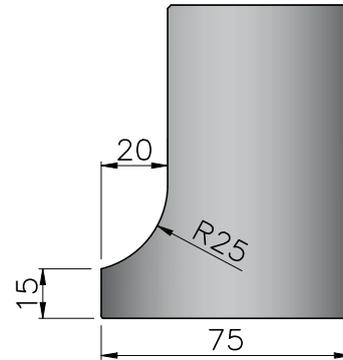


PUNCH | STANDARD HORNS PROFILE

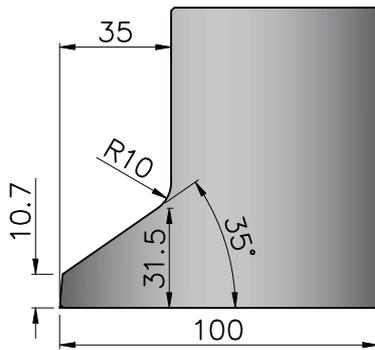
2:C | STANDARD HORNS PROFILE



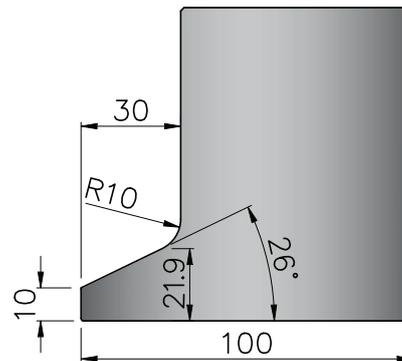
H.P-1
Fmax. 60% of
Max Load Punch



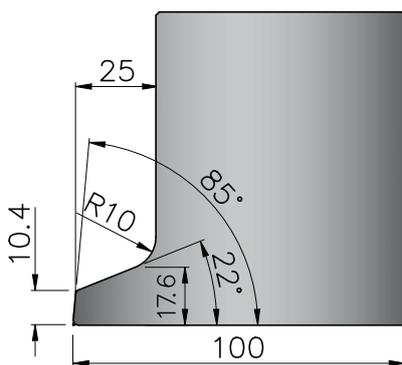
H.P-2
Fmax. 60% of
Max Load Punch



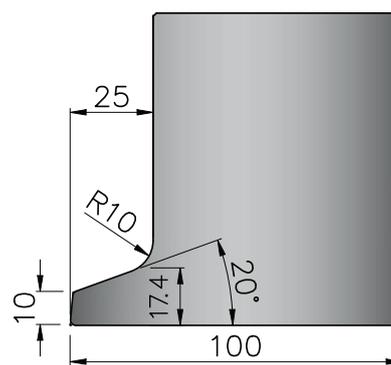
H.P-3
Fmax. 38% of
Max Load Punch



H.P-4
Fmax. 35% of
Max Load Punch



H.P-5
Fmax. 40% of
Max Load Punch



H.P-6
Fmax. 40% of
Max Load Punch

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



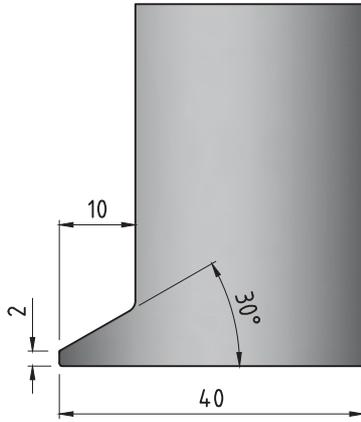
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

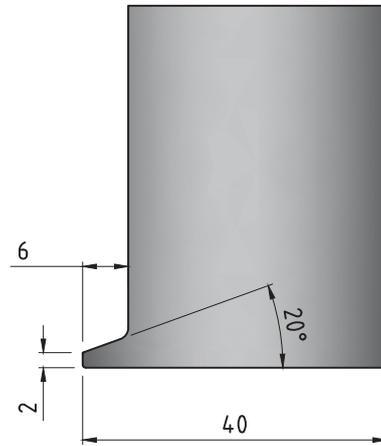


PUNCH | STANDARD HORNS PROFILE

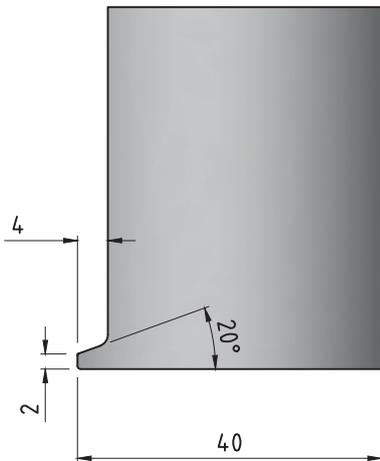
2:C | STANDARD HORNS PROFILE



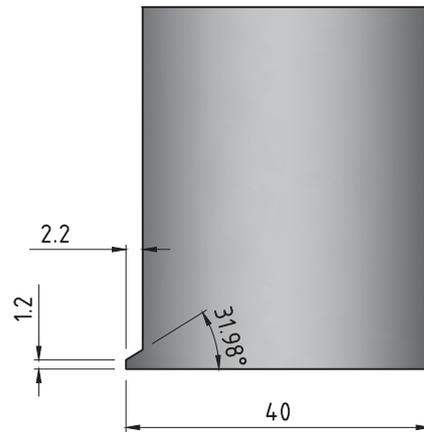
H.P-7
Fmax. 30% of
Max Load Punch



H.P-8
Fmax. 40% of
Max Load Punch



H.P-9
Fmax. 60% of
Max Load Punch



H.P-10
Fmax. 80% of
Max Load Punch

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | AMADA TYPE TOOLING

2:D:i | INTRODUCTION

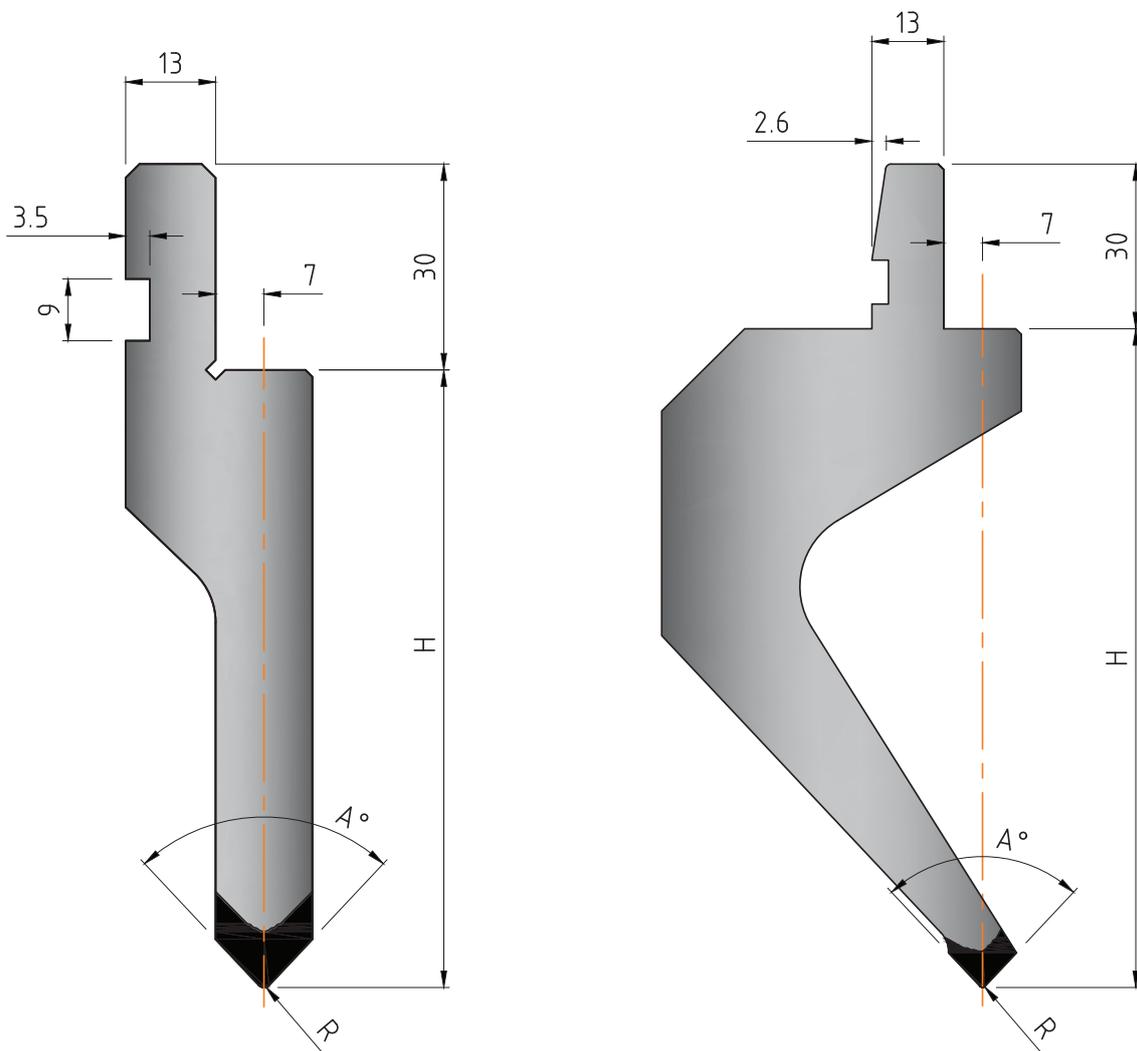
Our punches are made from **premium alloy steel**, dual **heat-treated**, **CNC machined and ground** to ensure dimensional accuracy, superior surface finish, and Highest in class wear resistance.

Straight Punch (SP) : Designed for standard bending operations and general-purpose fabrication.

Semi Goose Neck Punch (SGNP) : Offers additional clearance for medium-depth bends and return flanges.

Goose Neck Punch (GNP) : Perfect for forming deep boxes, channels, and complex parts.

Profile Punch (PP) : Custom-designed punches built to match specific bending profiles or part geometries.



N01 EUROPEAN TYPE

N02 ONE TOUCH TYPE

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



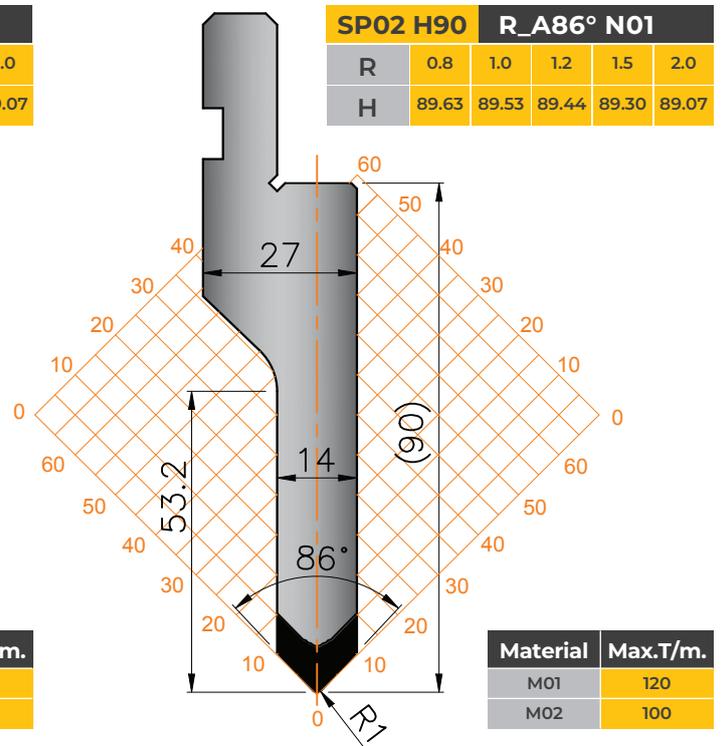
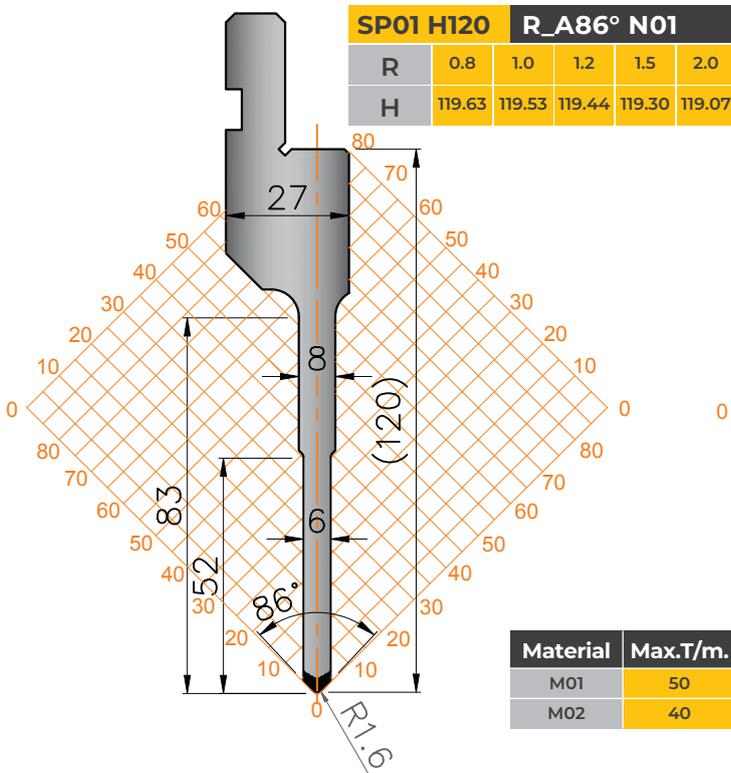
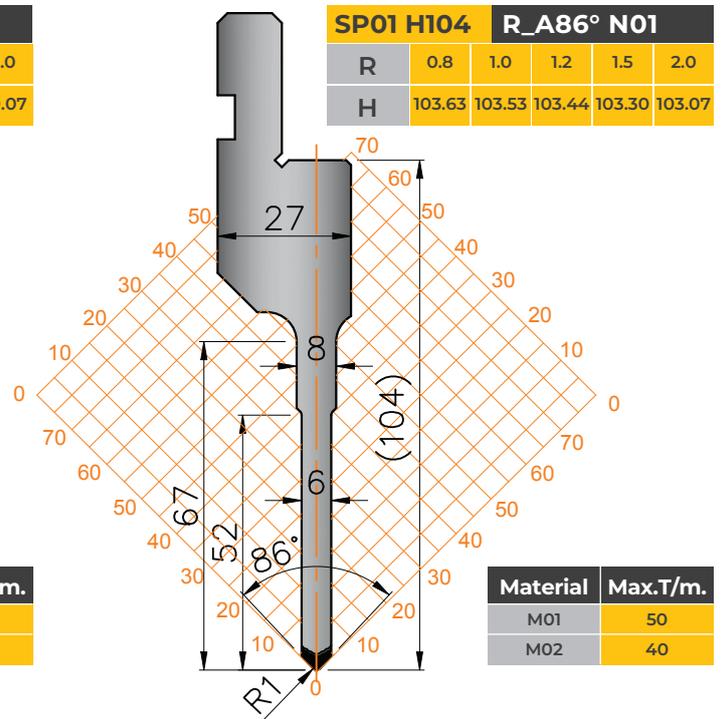
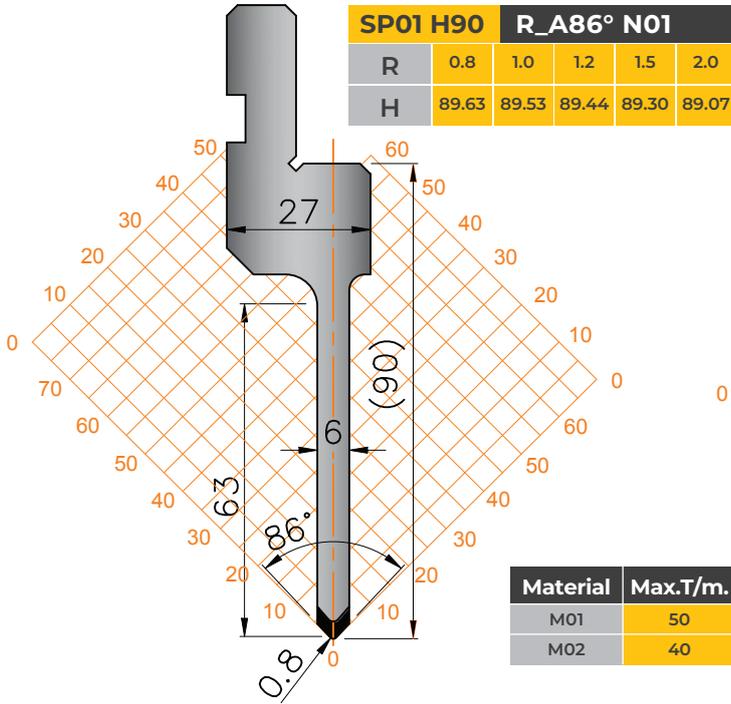
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | AMADA TYPE TOOLING

2:E:ii | STRAIGHT PUNCH



Material Option

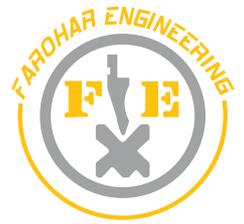
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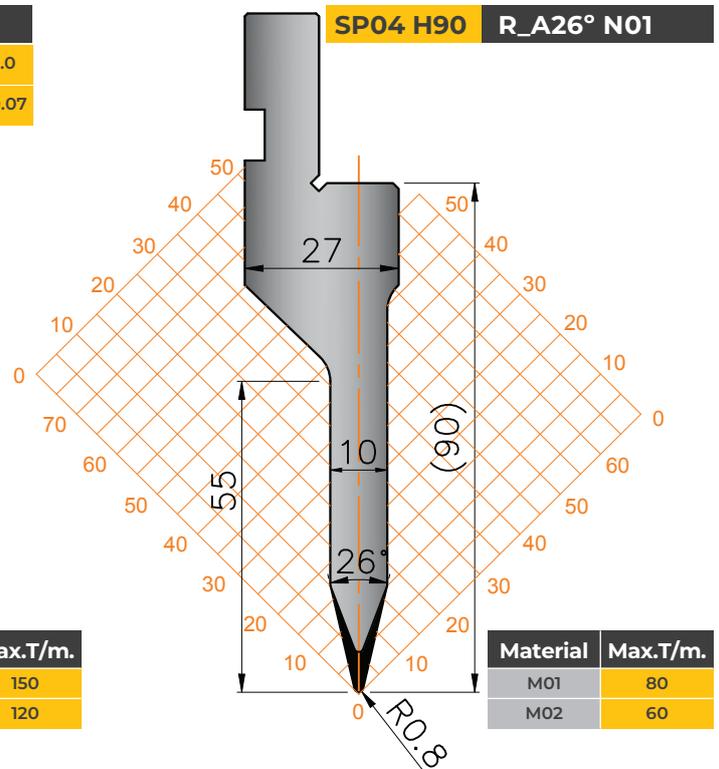
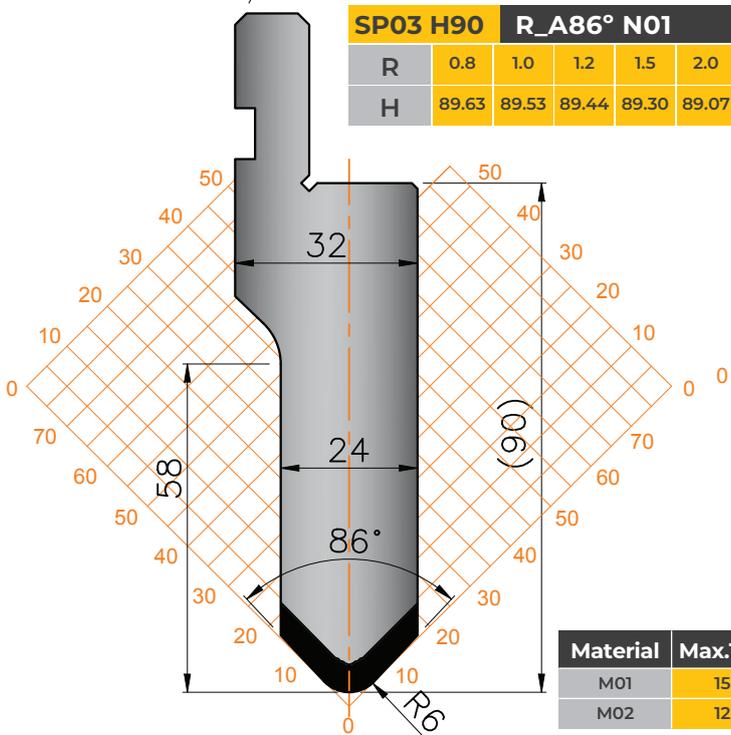
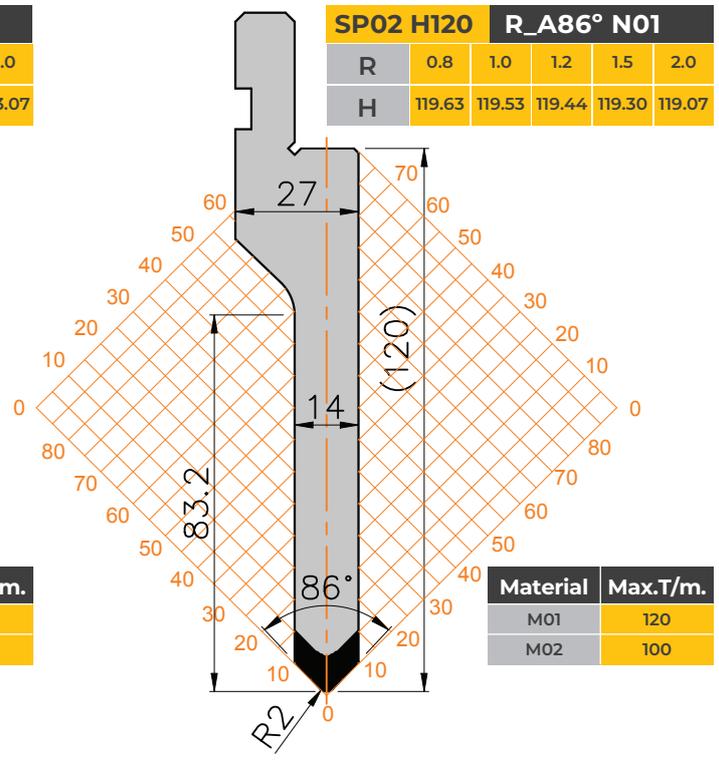
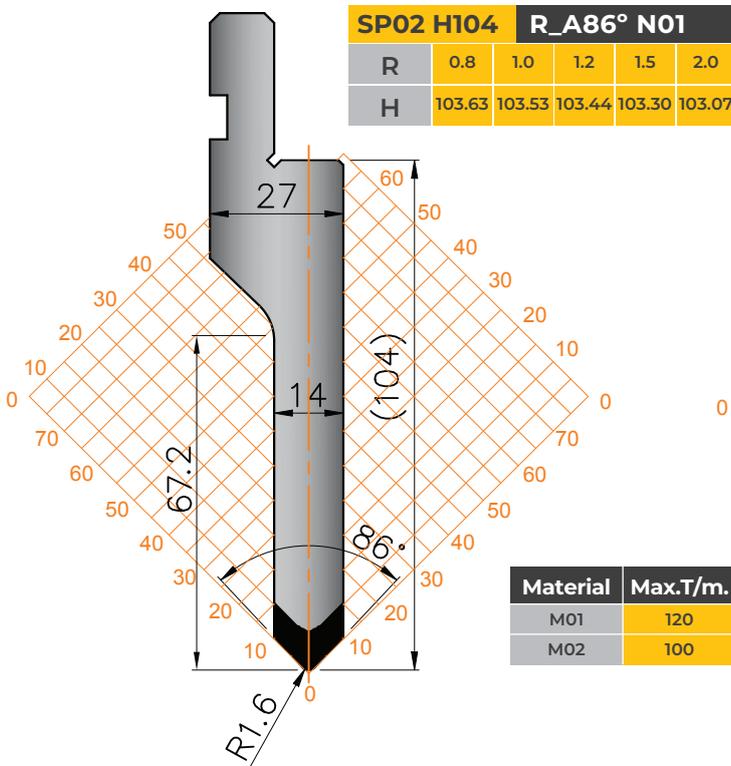
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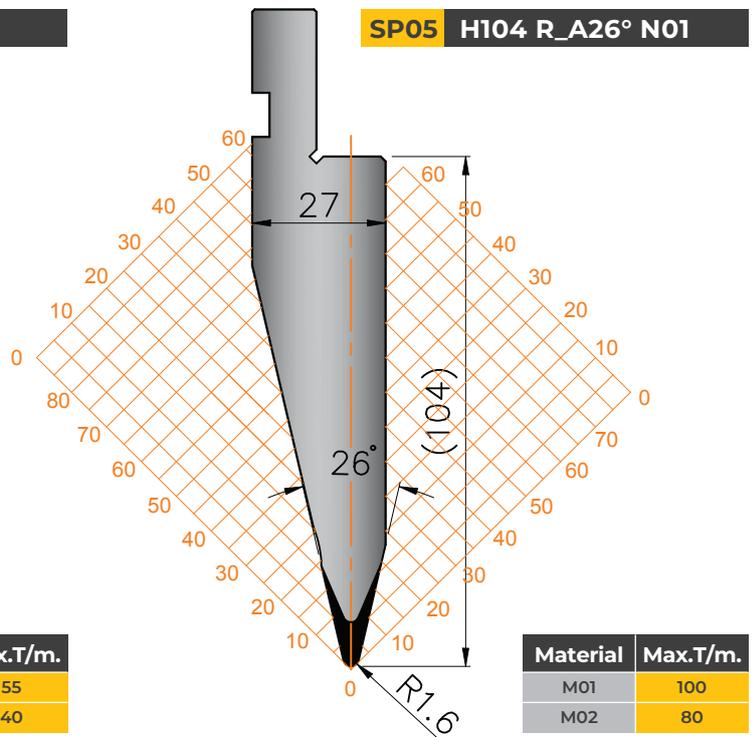
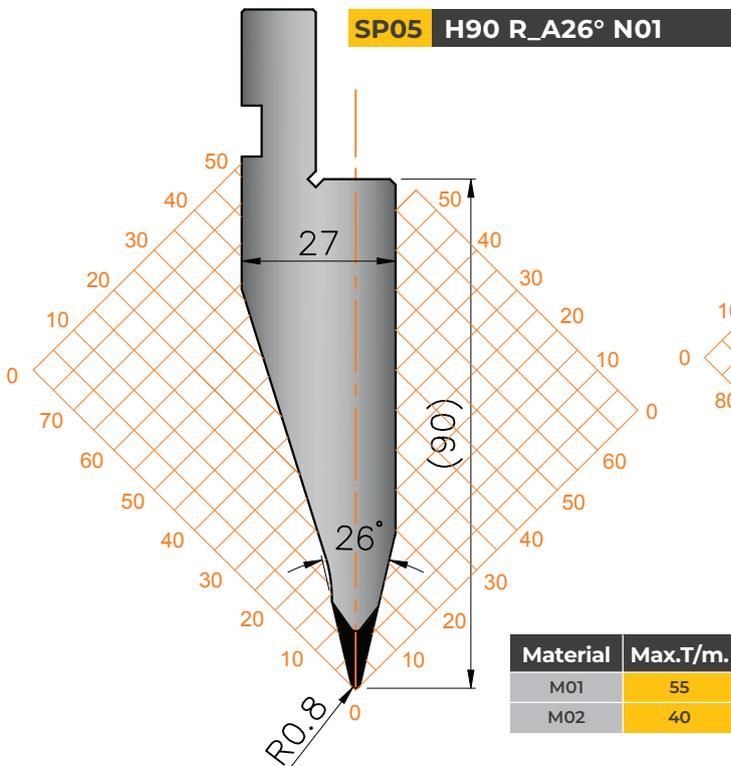
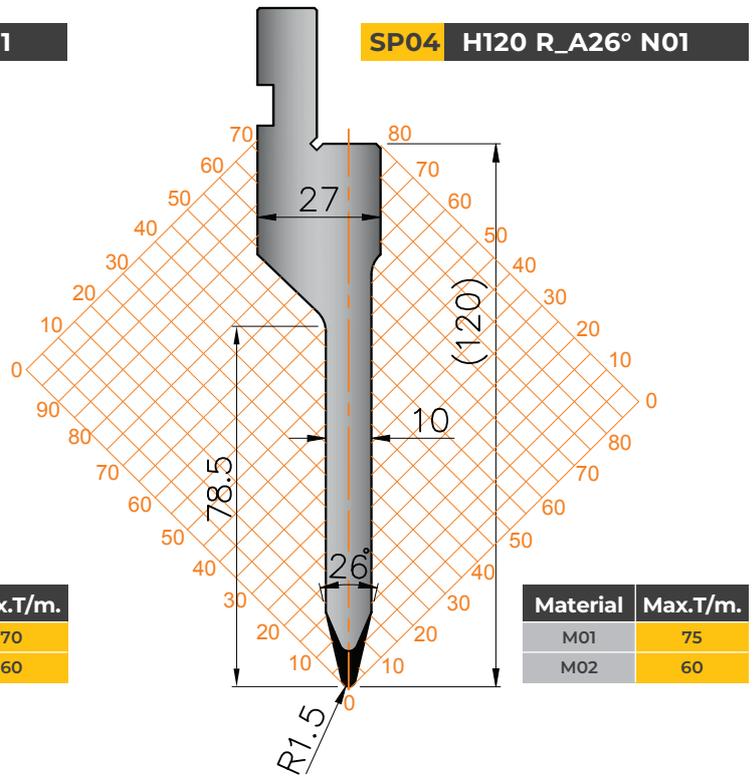
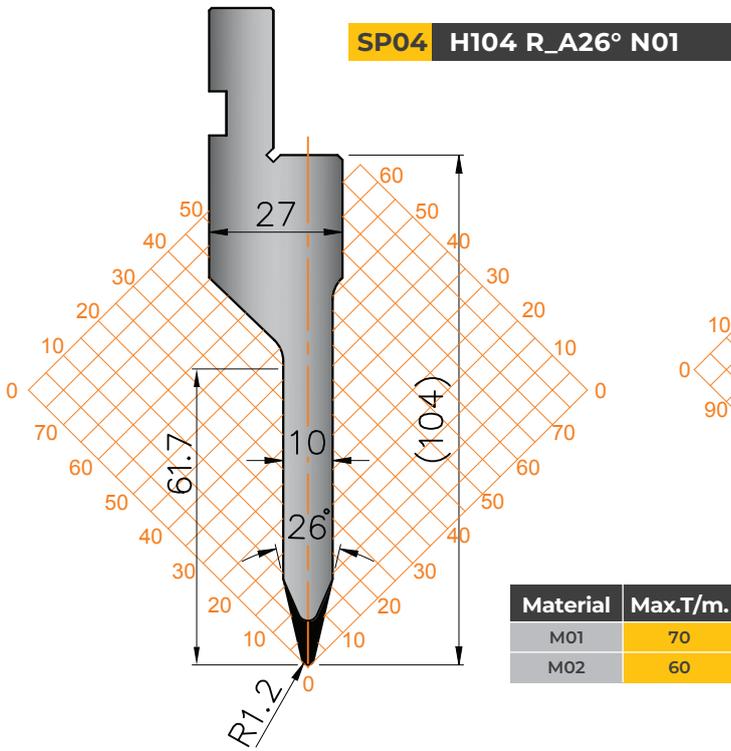
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PUNCH | AMADA TYPE TOOLING

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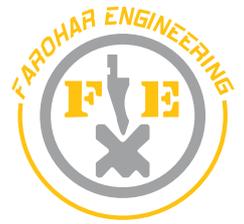
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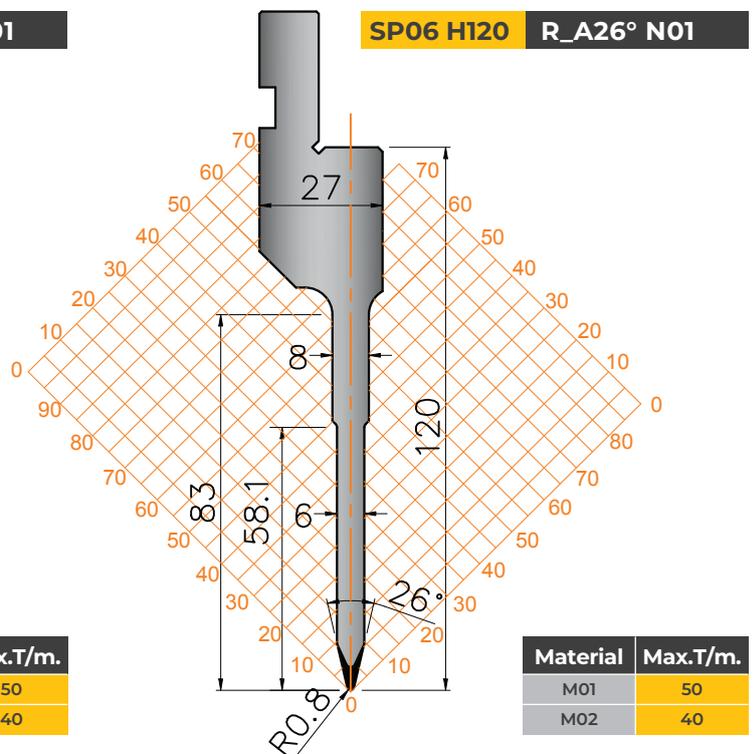
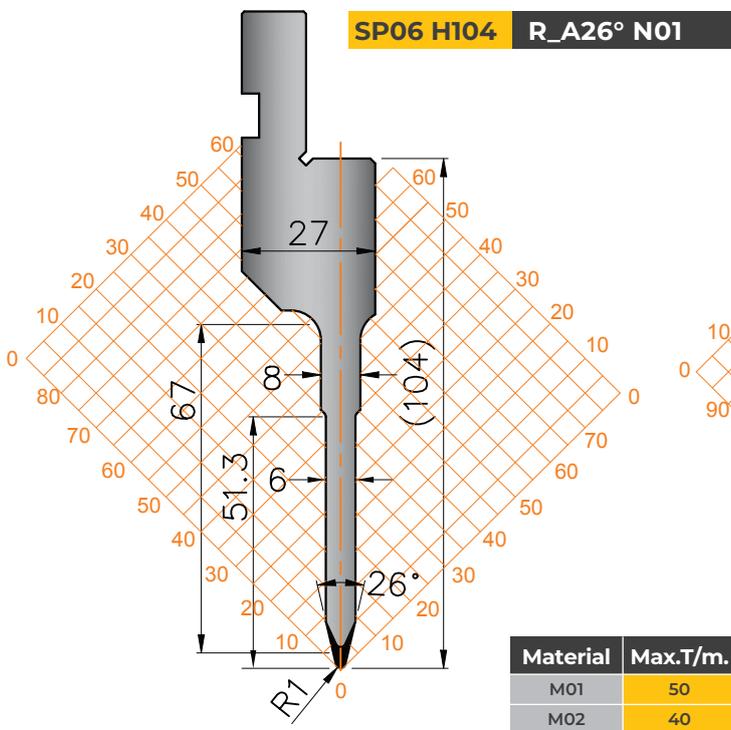
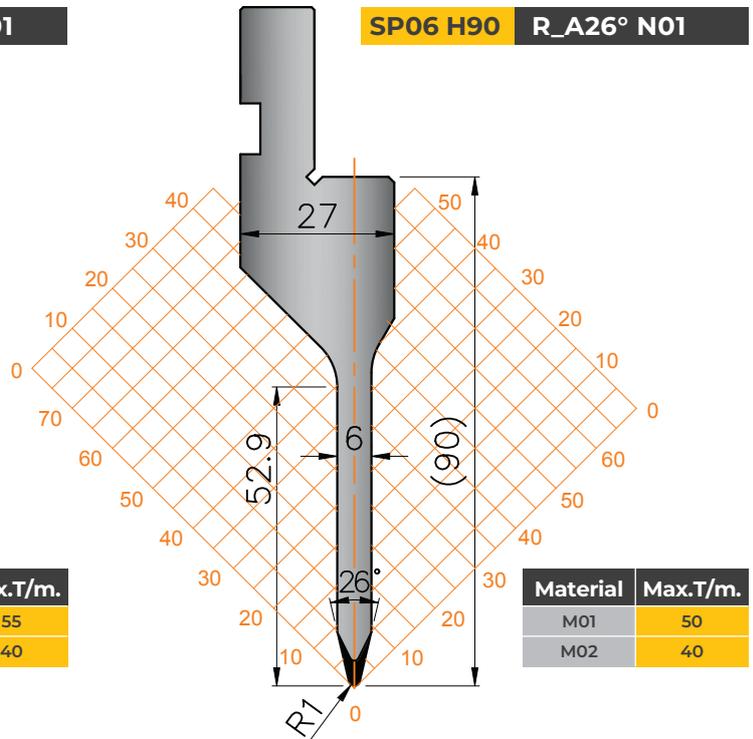
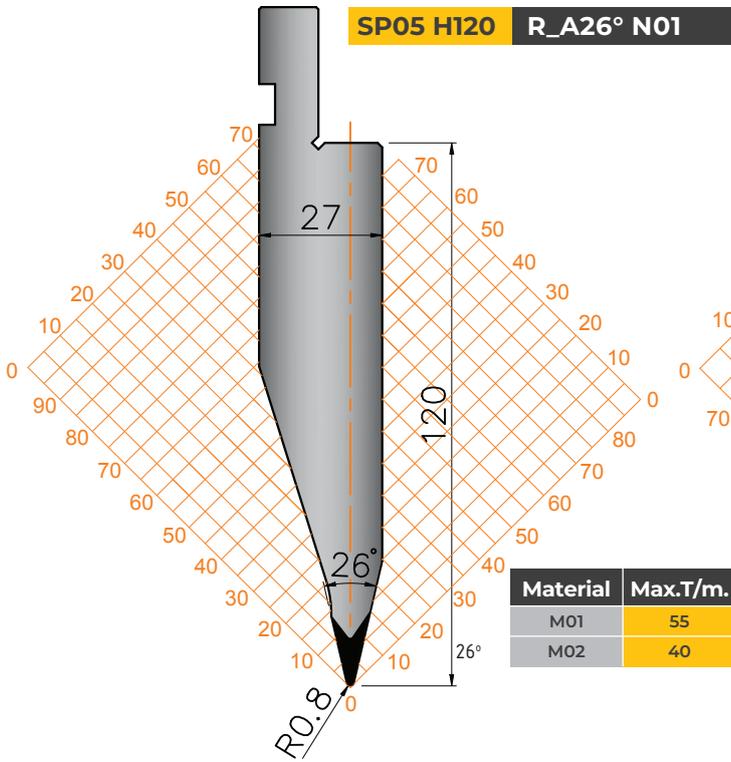
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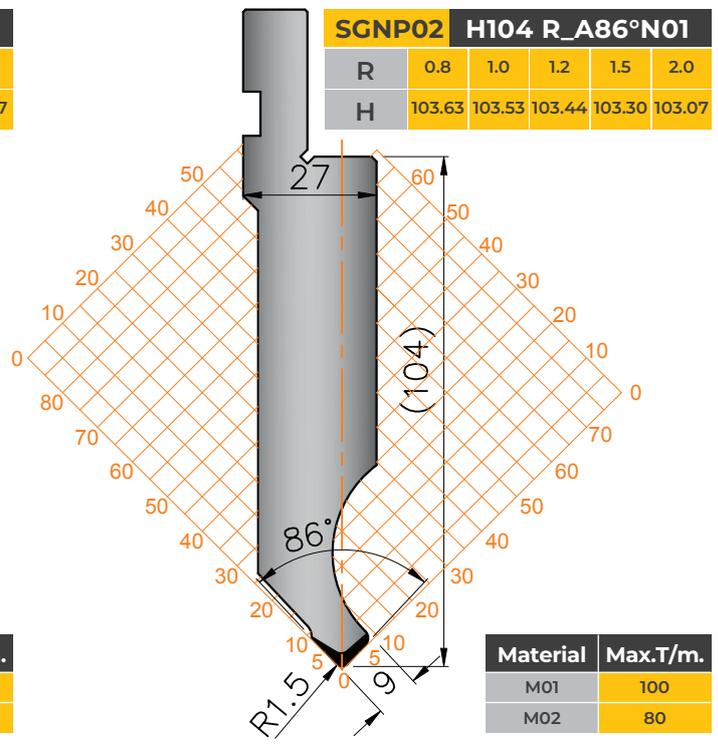
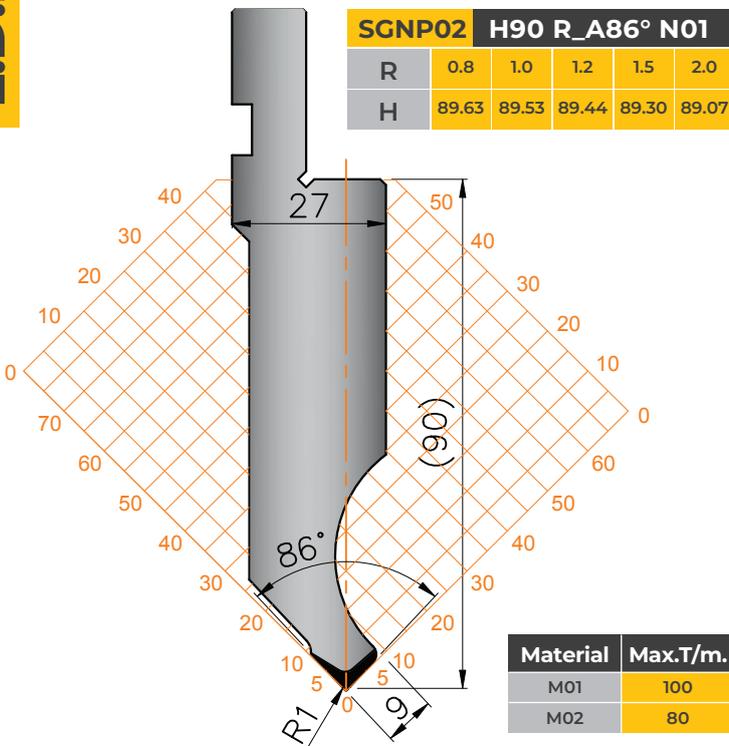
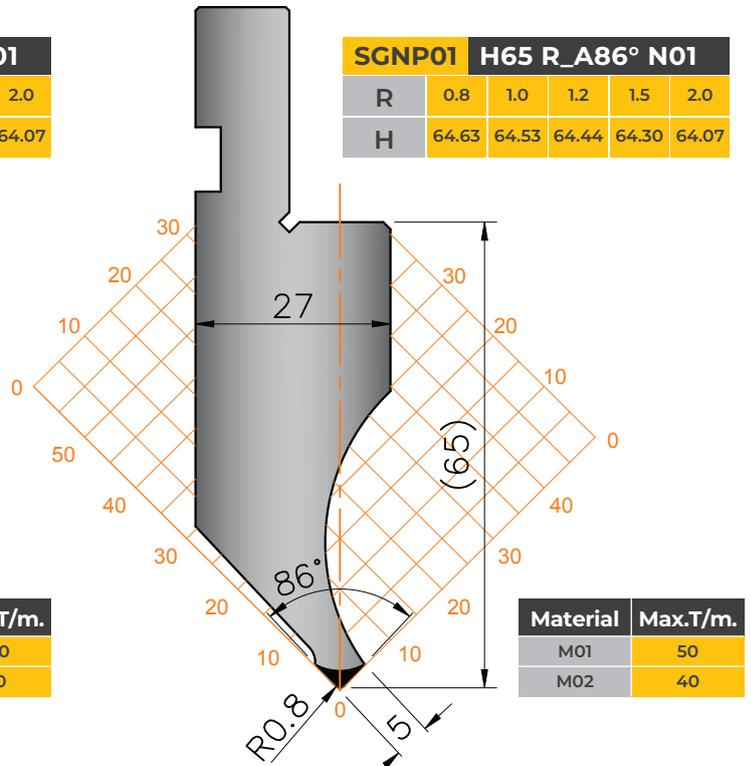
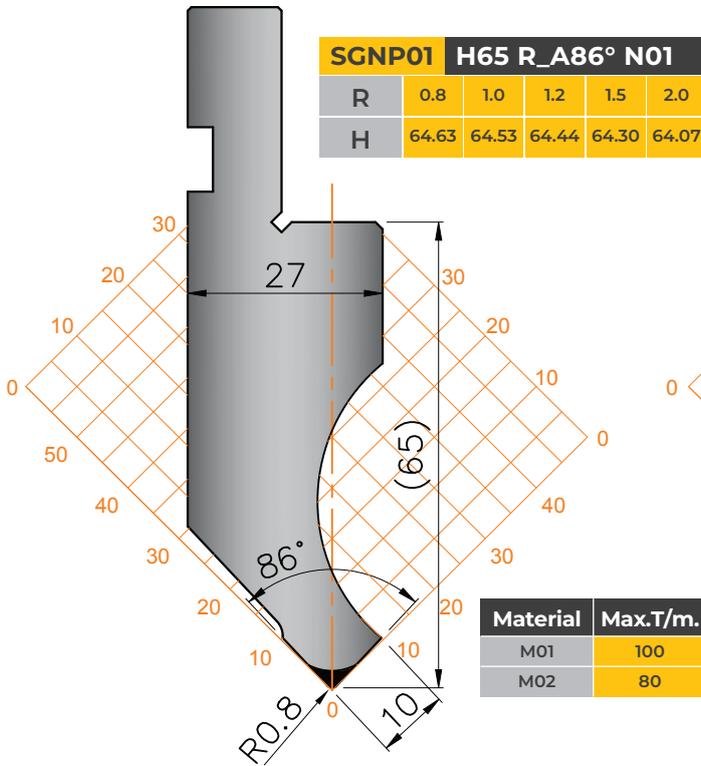
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PUNCH | AMADA TYPE TOOLING

2:D:iii | SEMI GOOSENECK PUNCH



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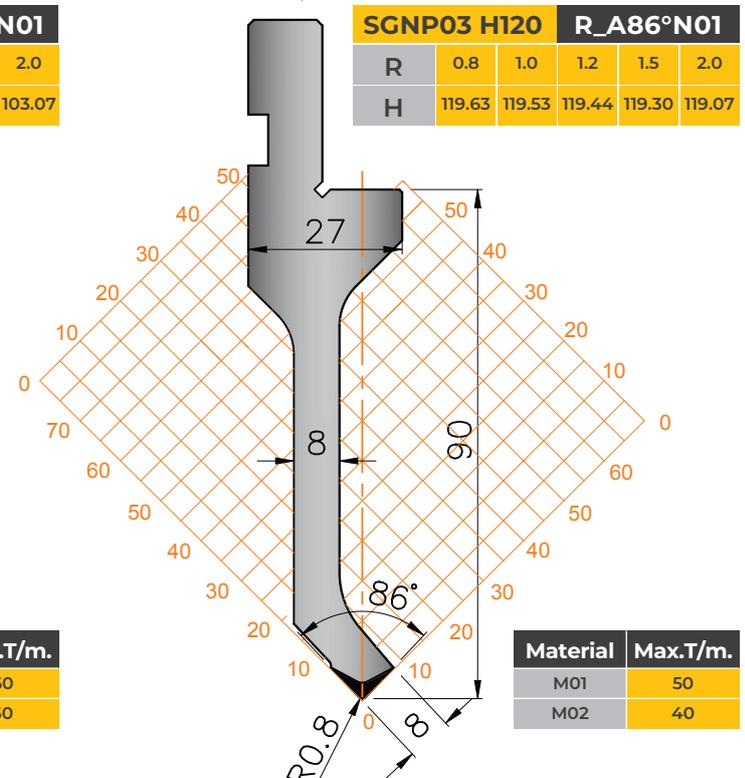
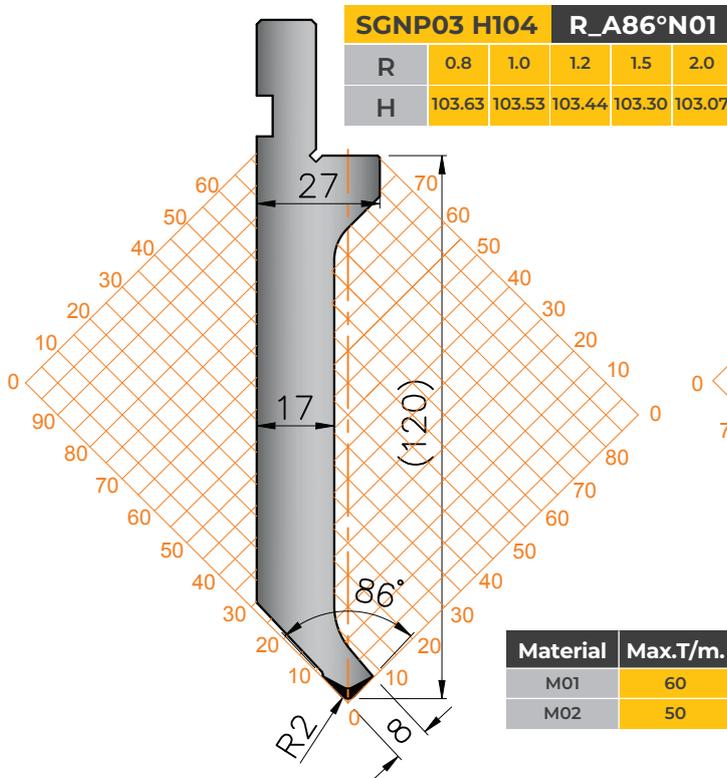
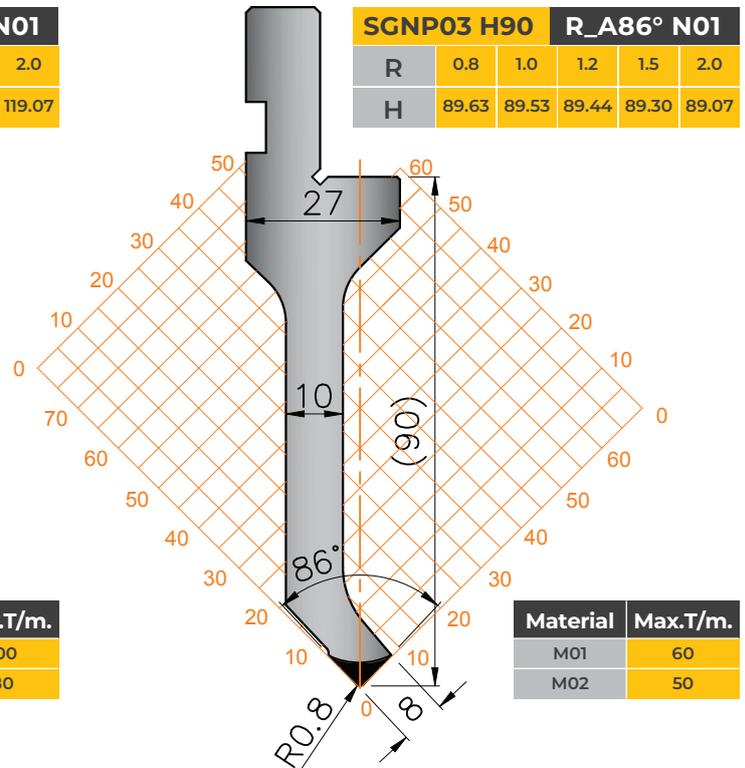
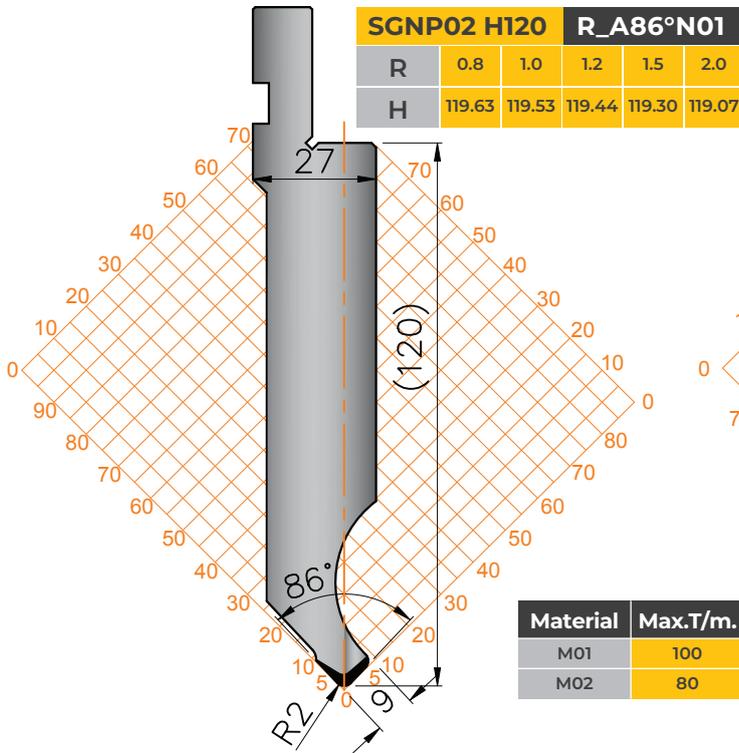
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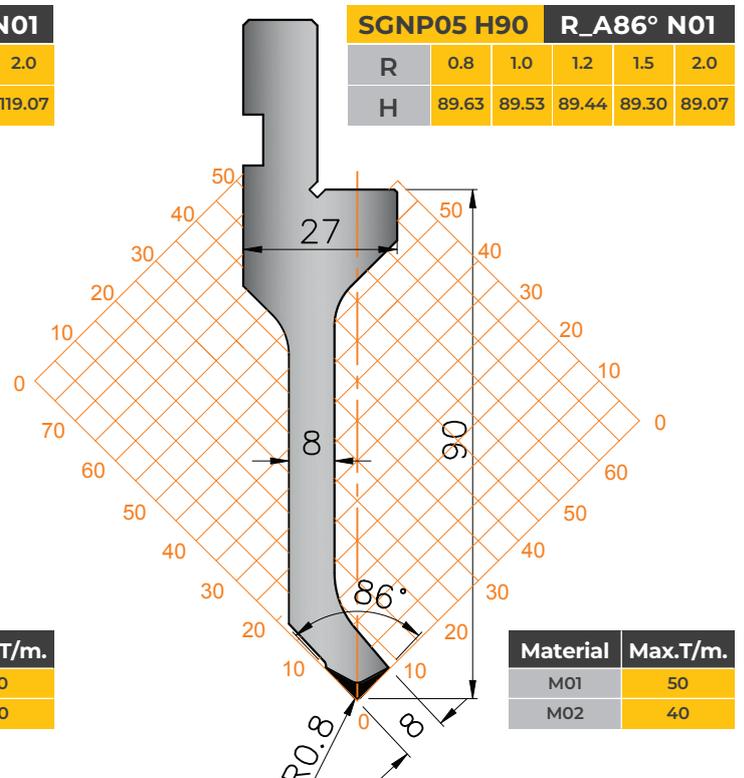
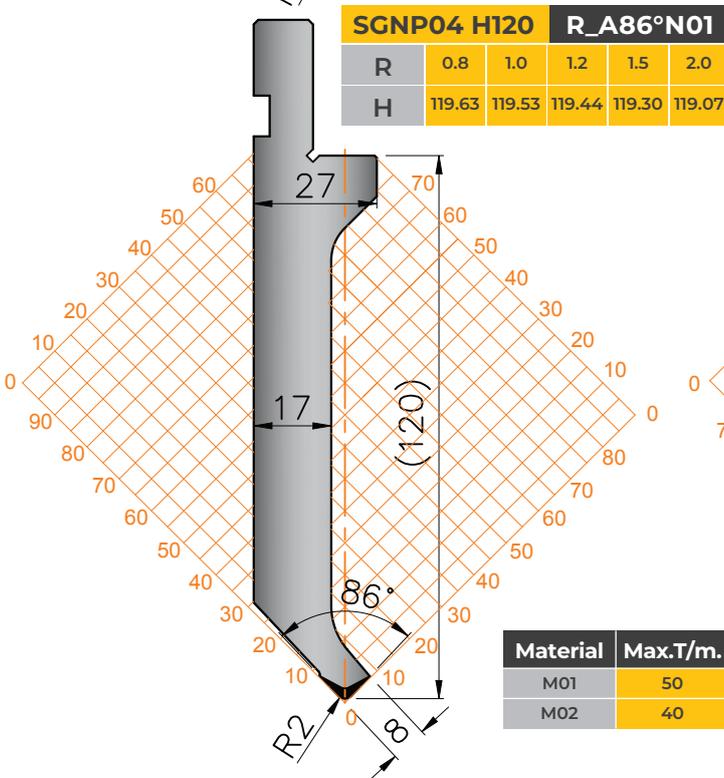
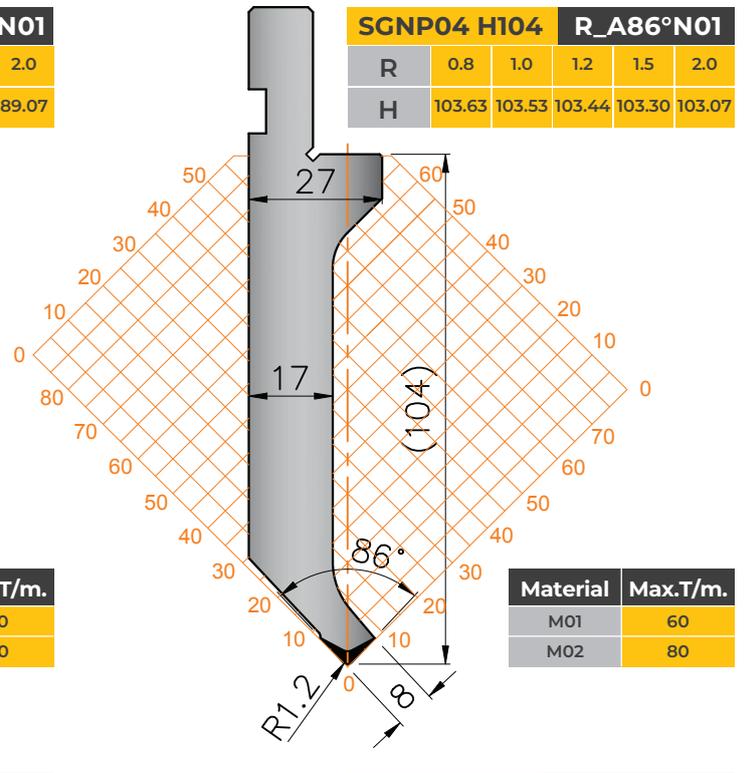
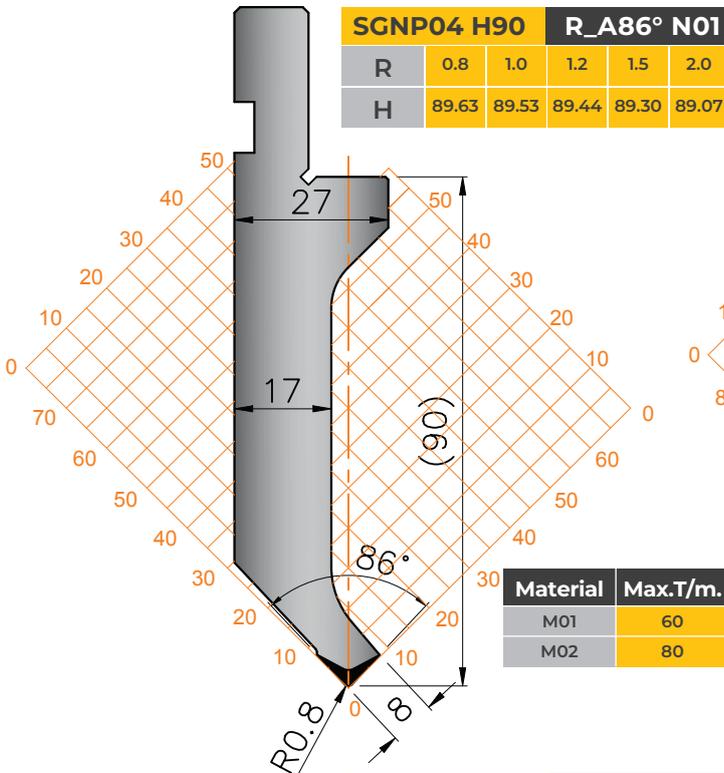
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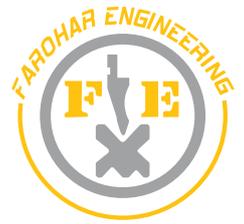
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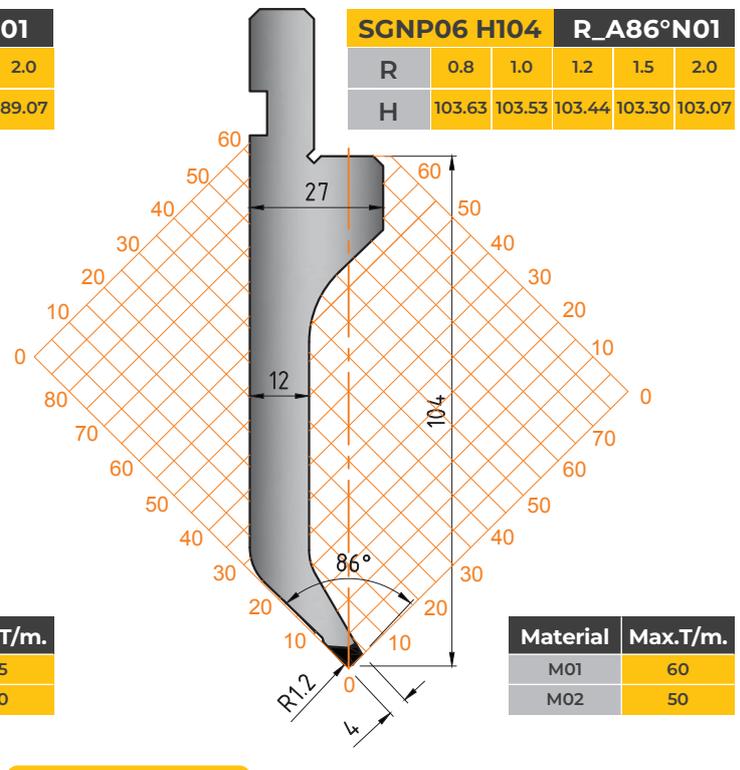
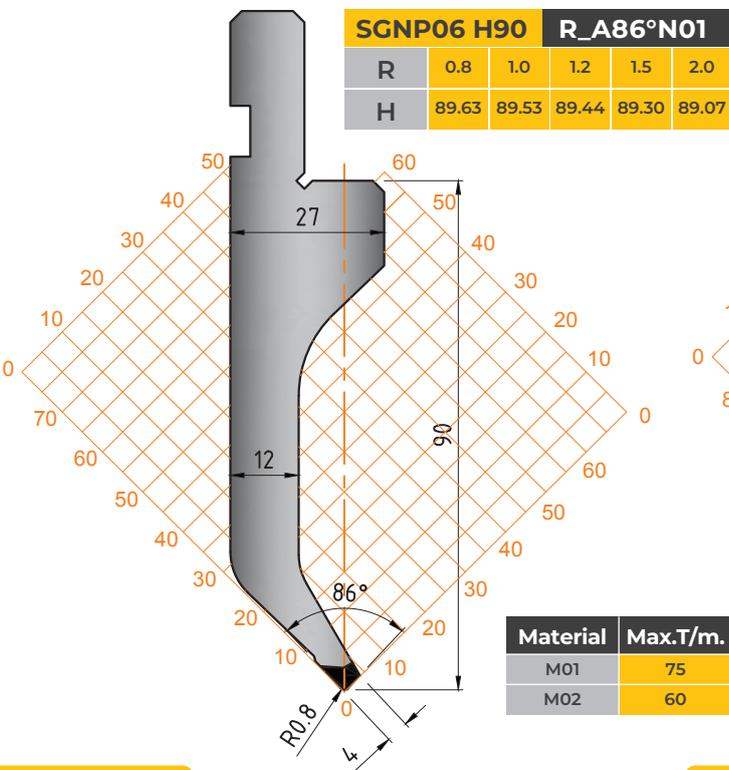
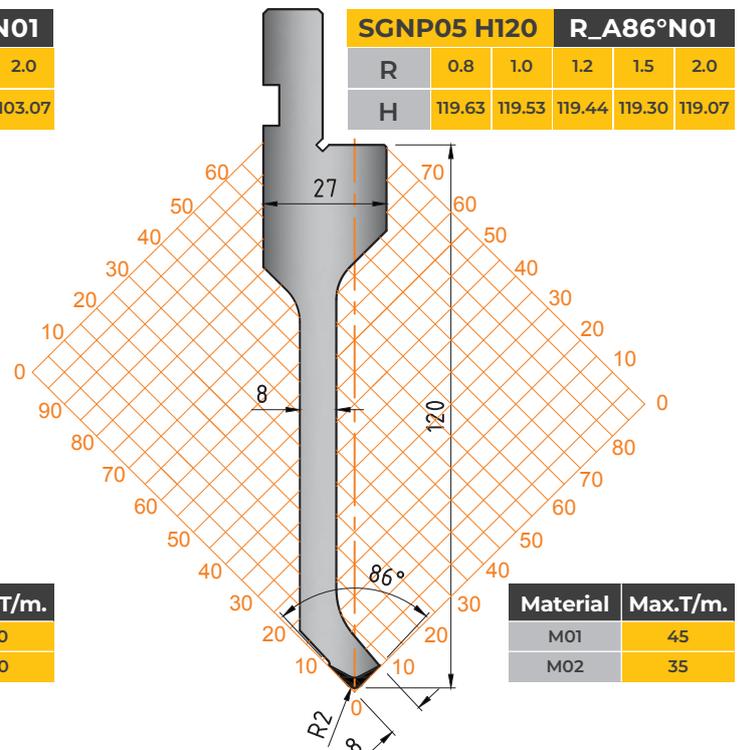
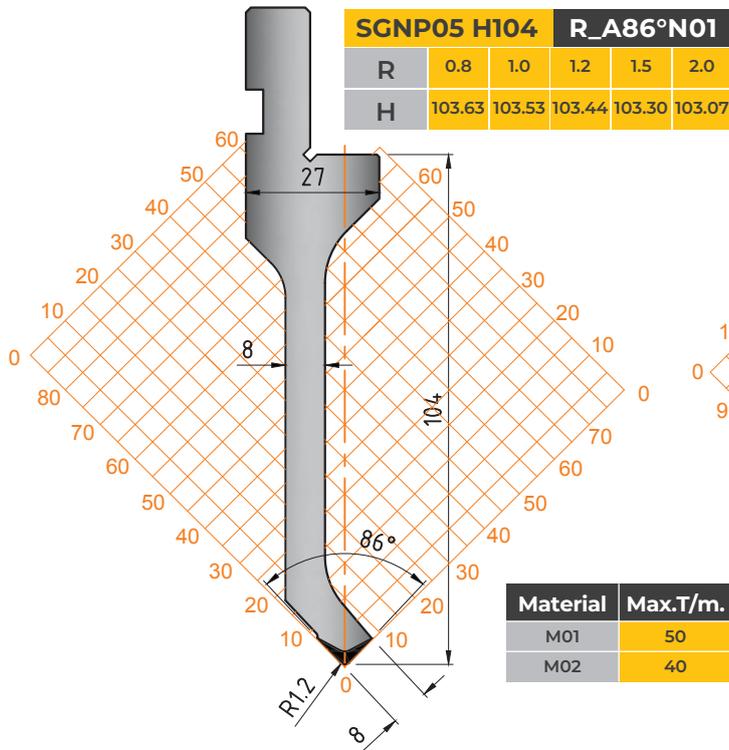
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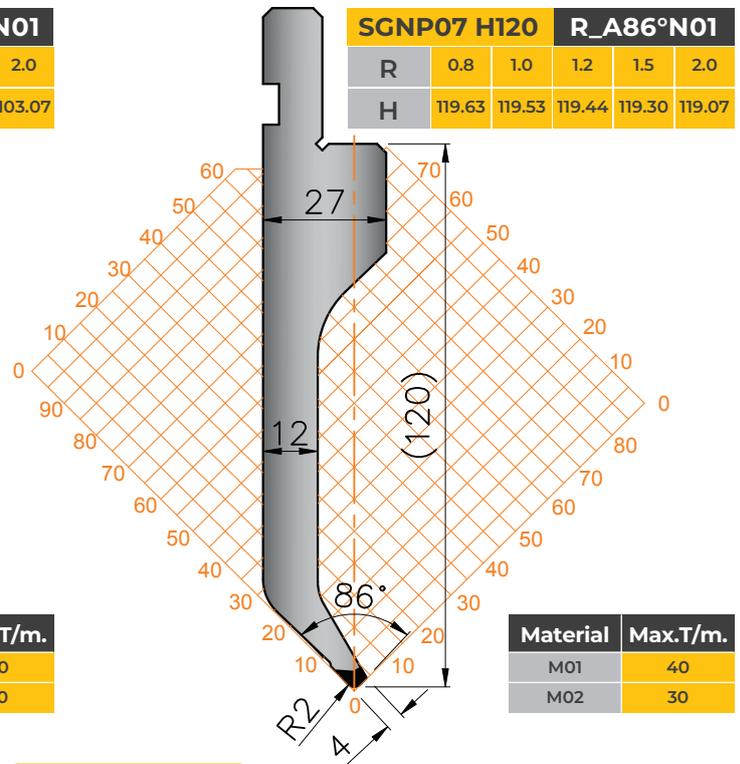
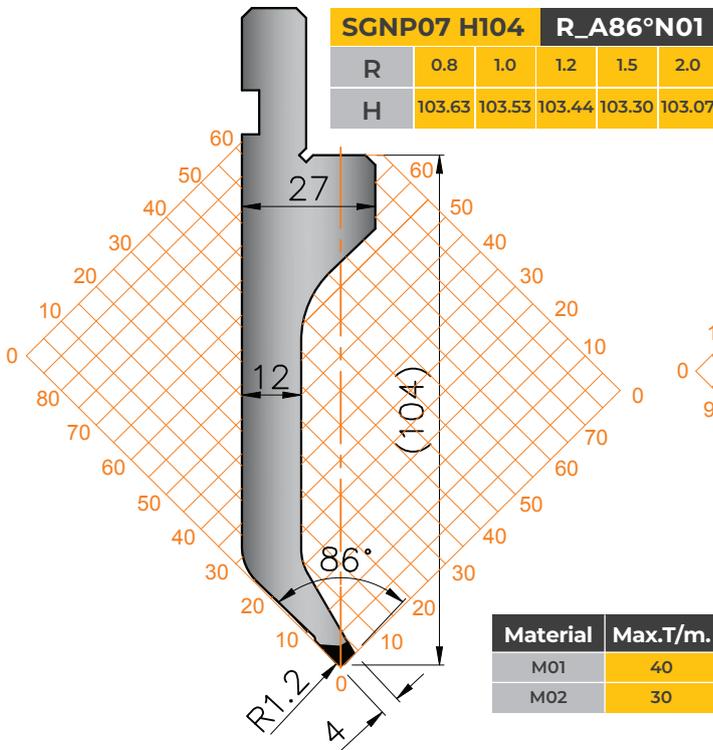
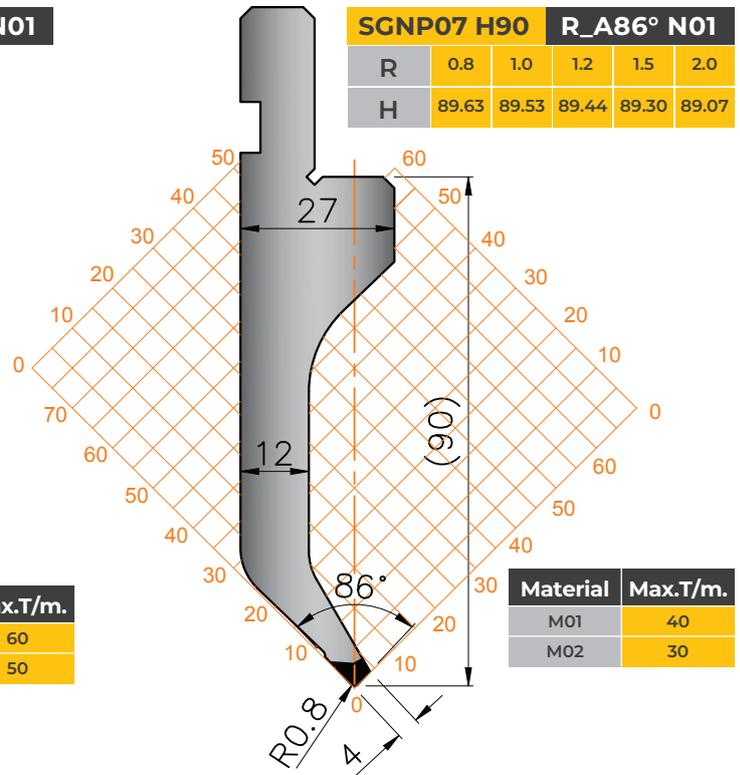
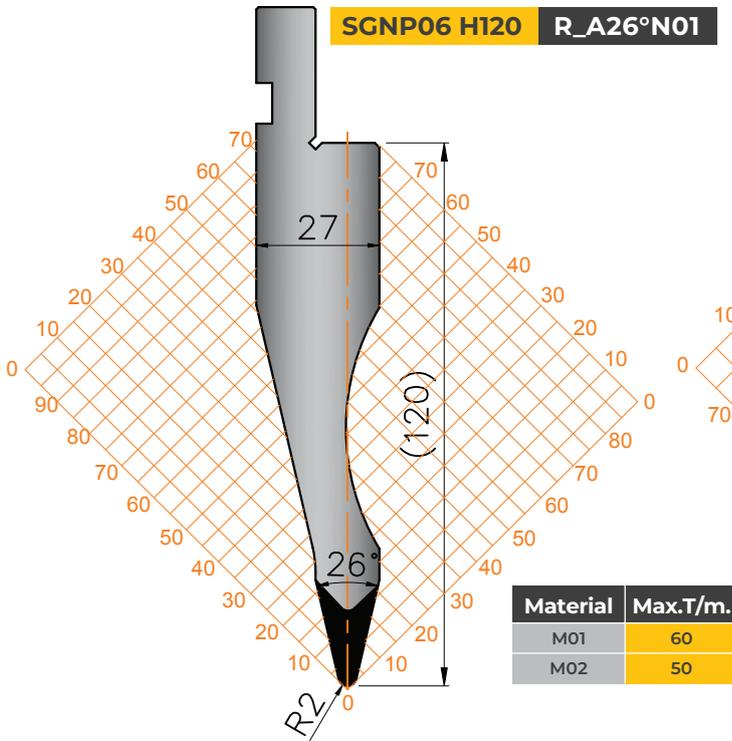
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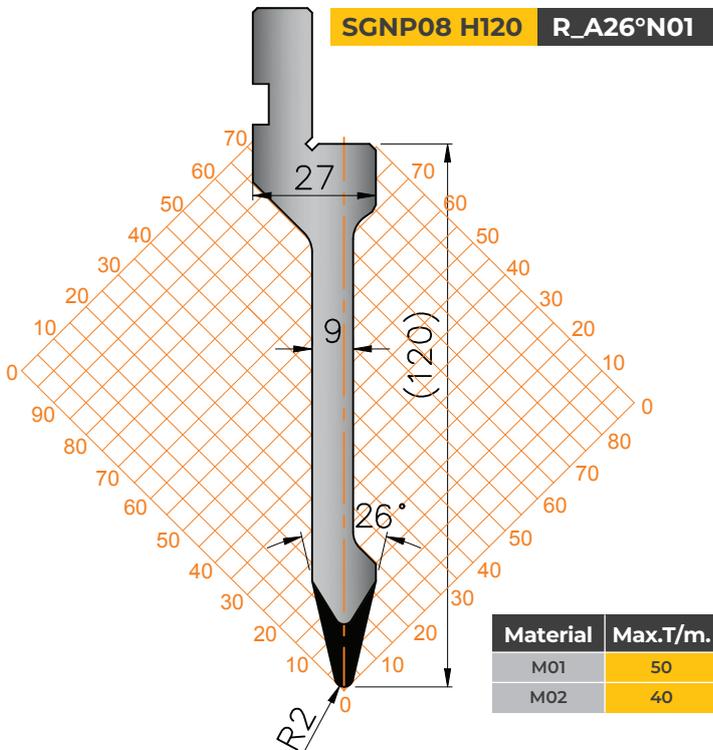
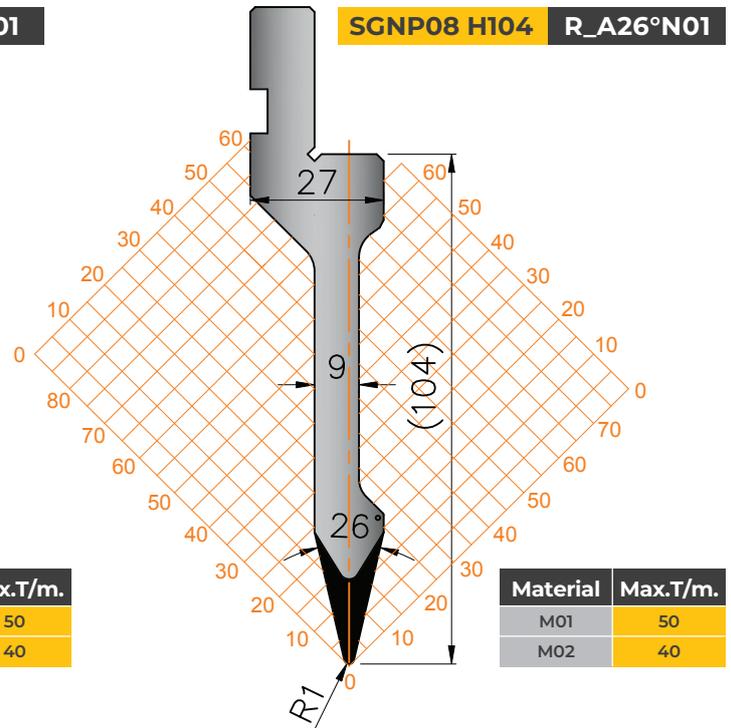
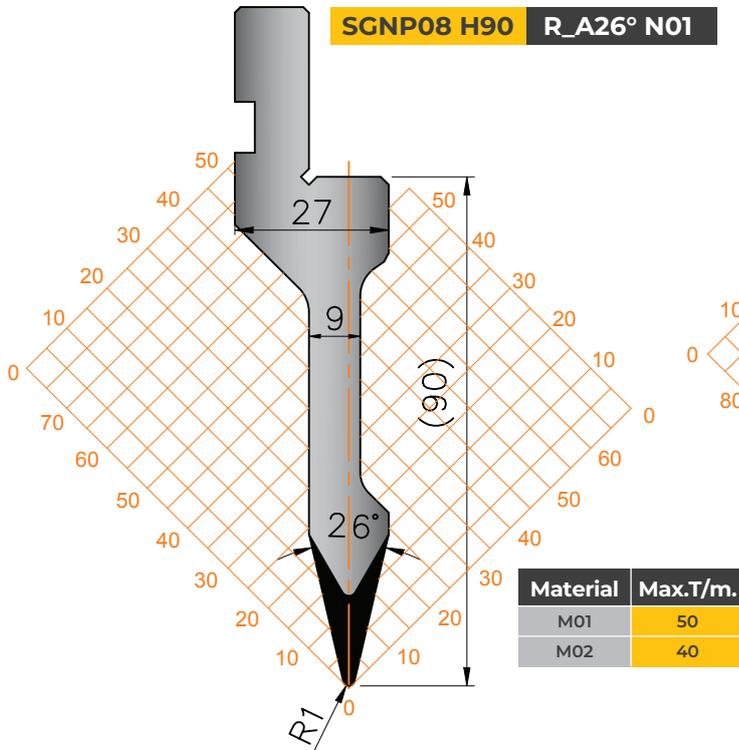
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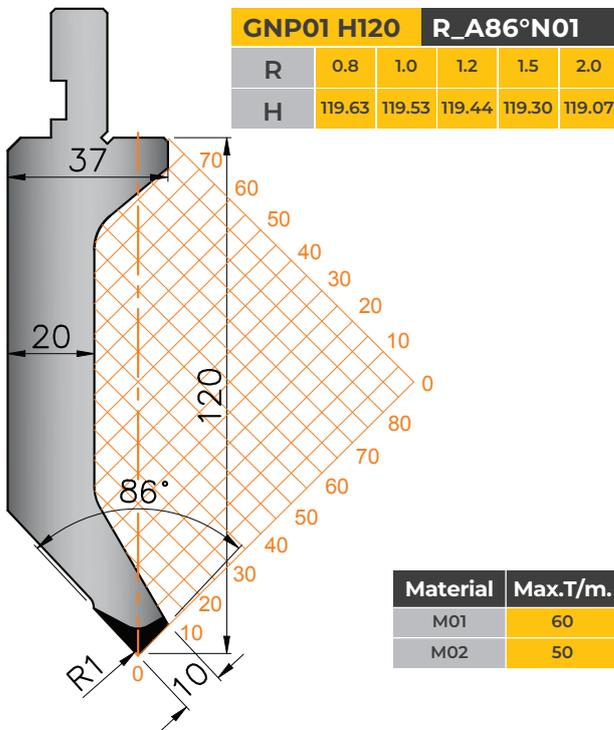
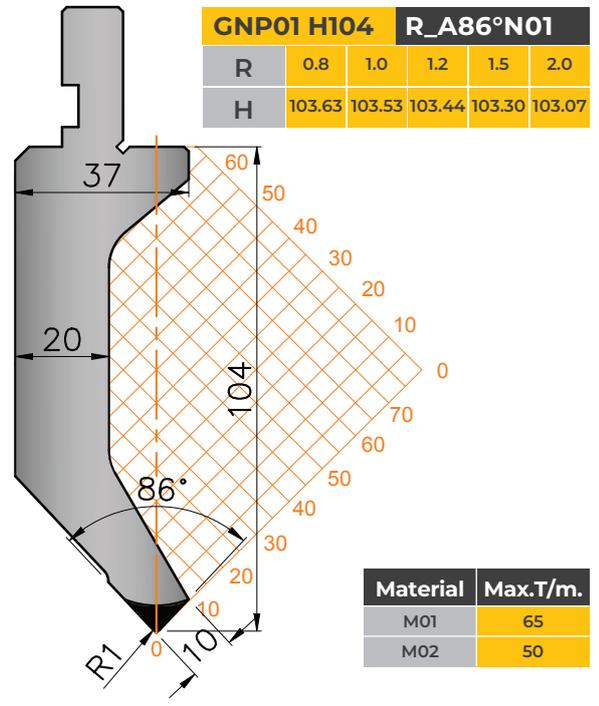
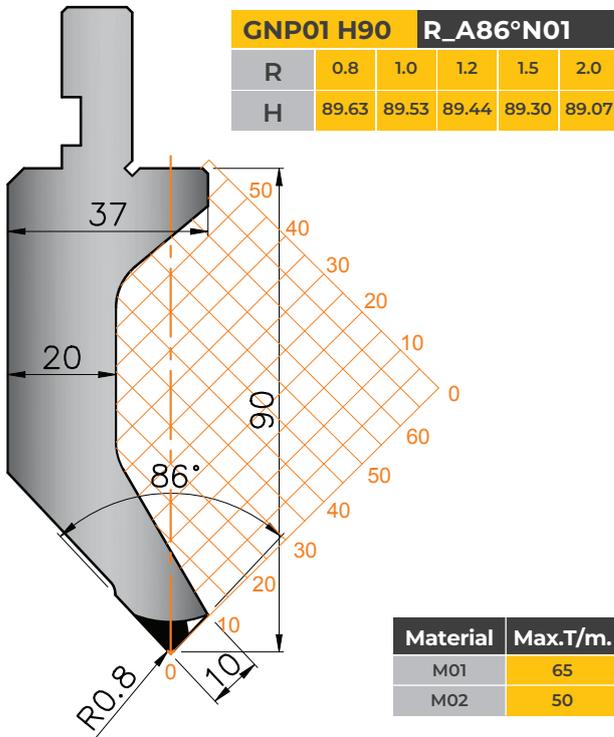
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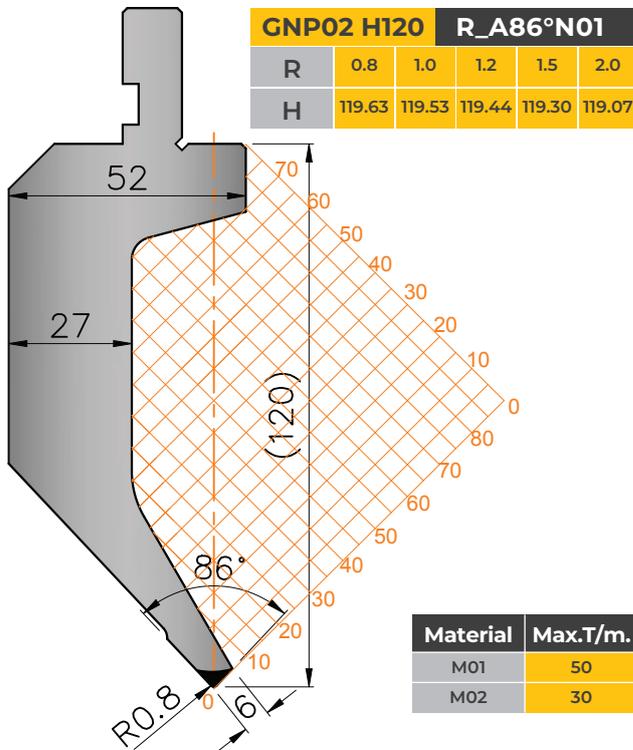
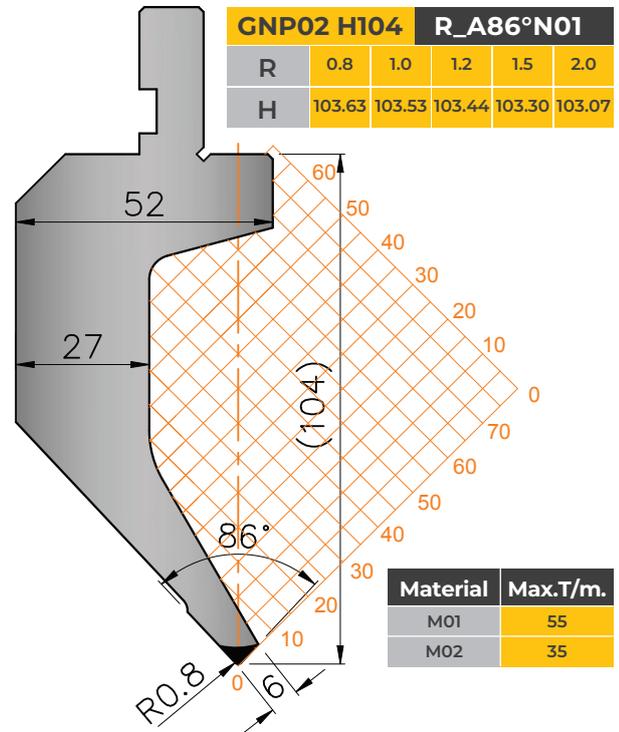
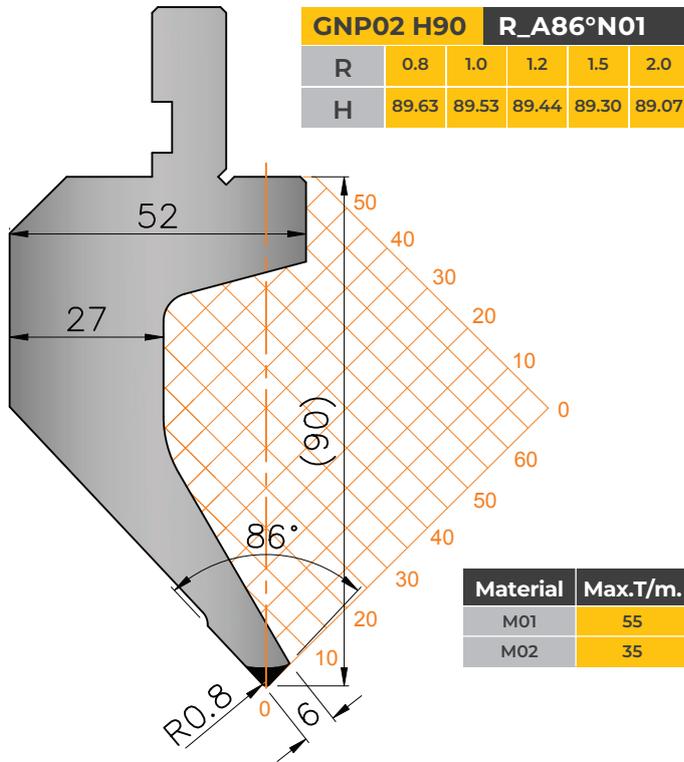
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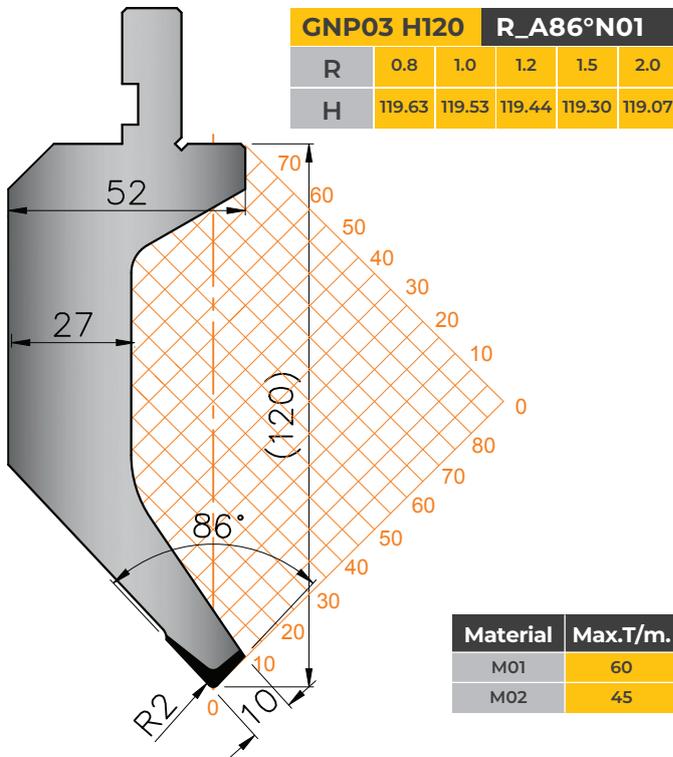
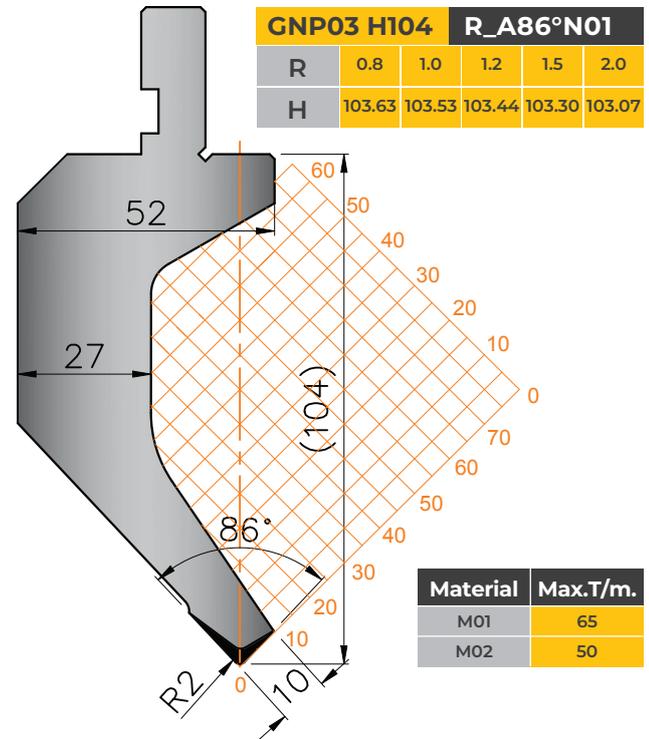
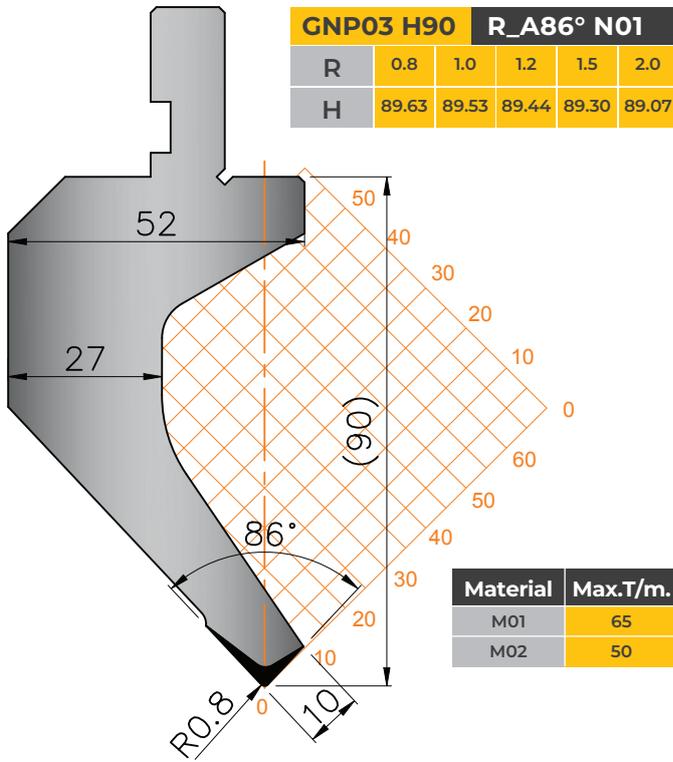
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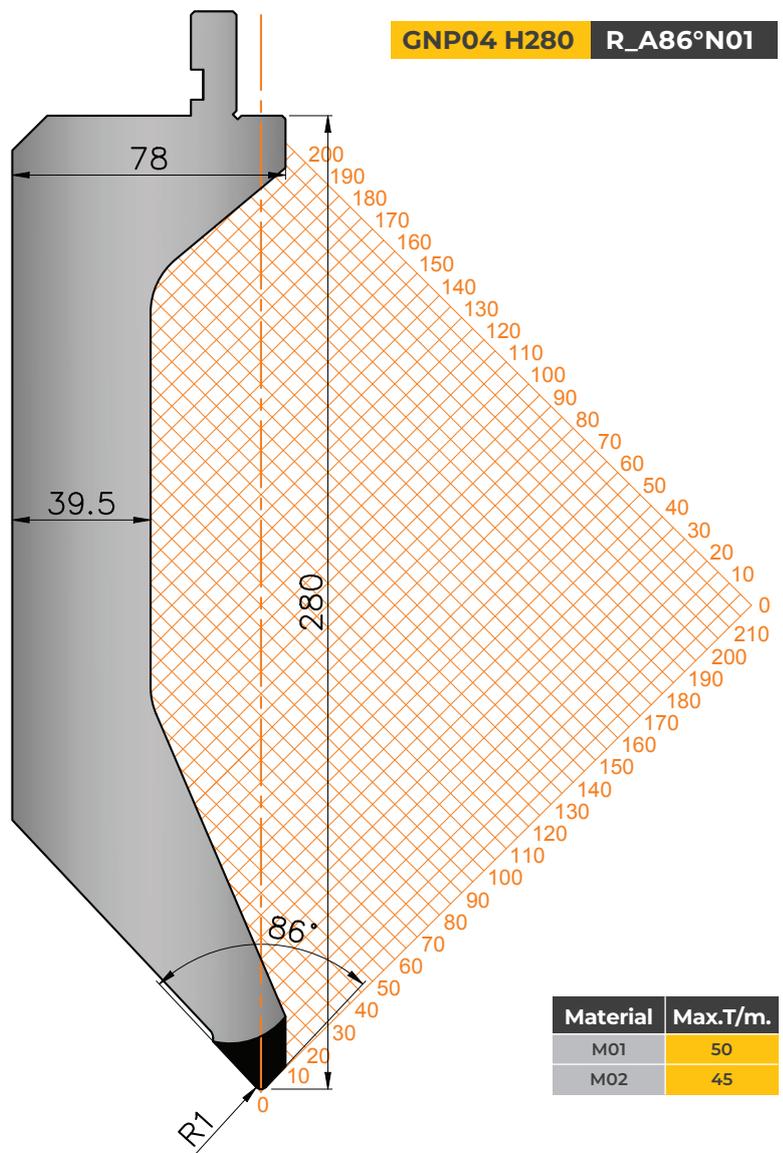
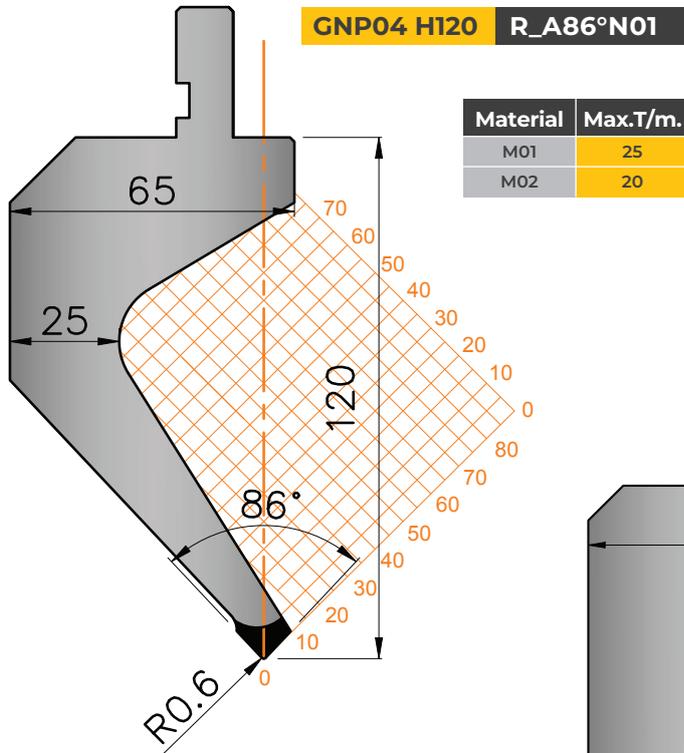
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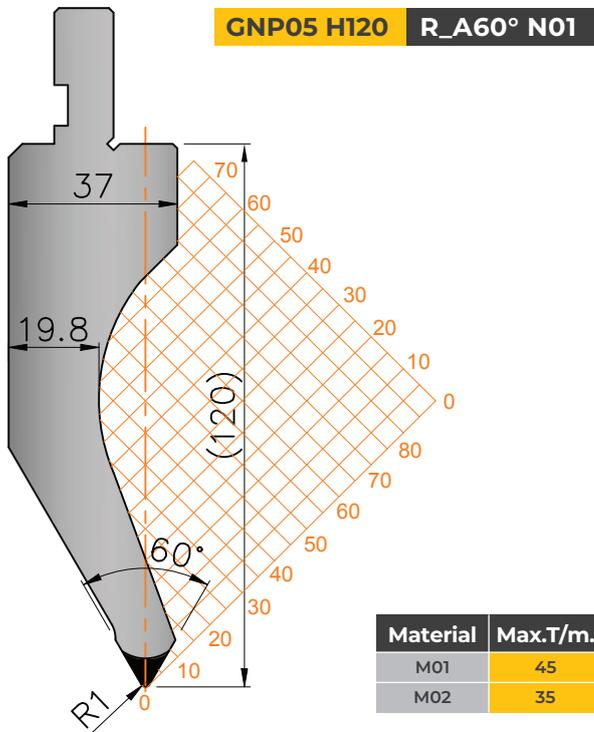
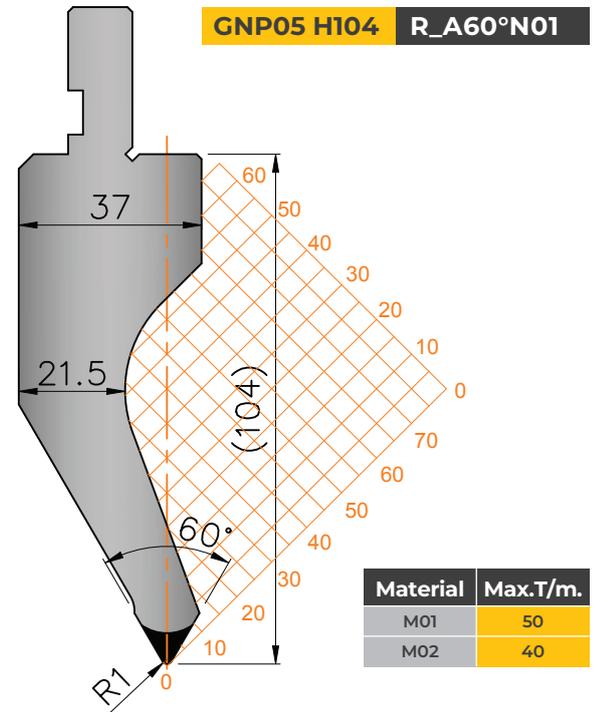
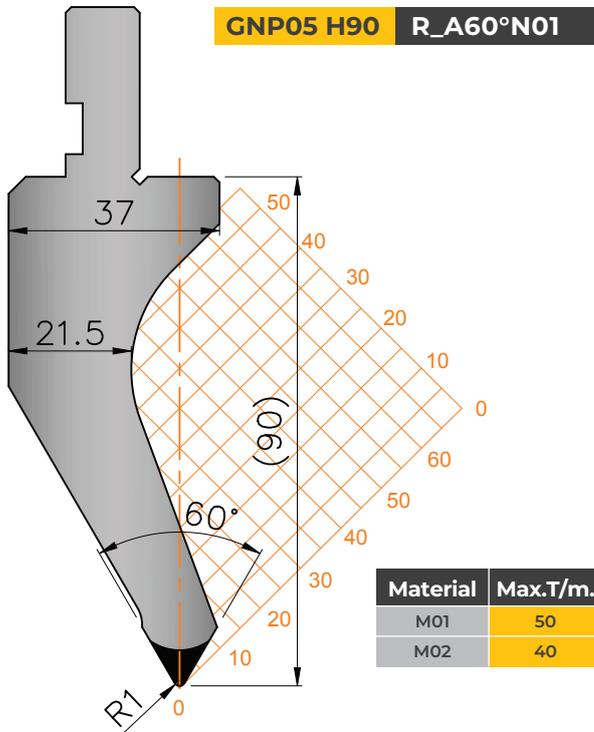
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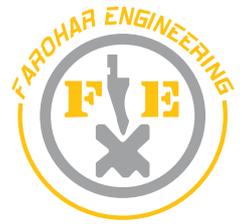
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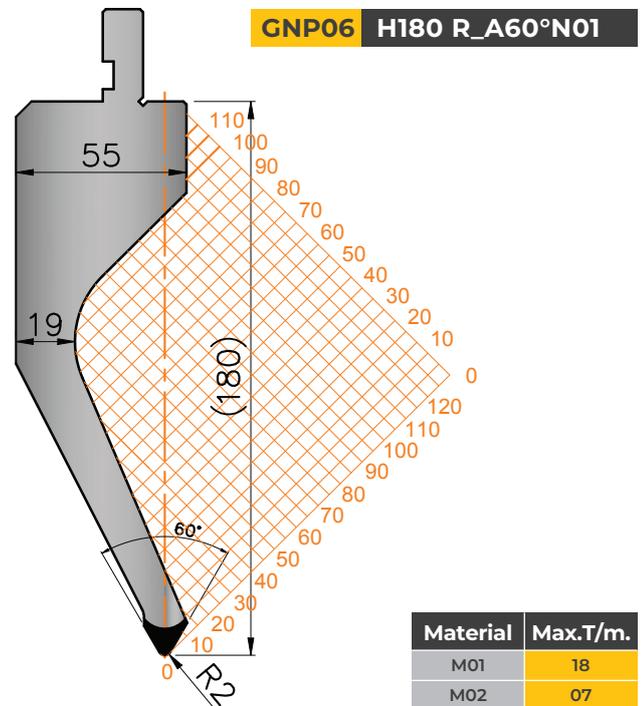
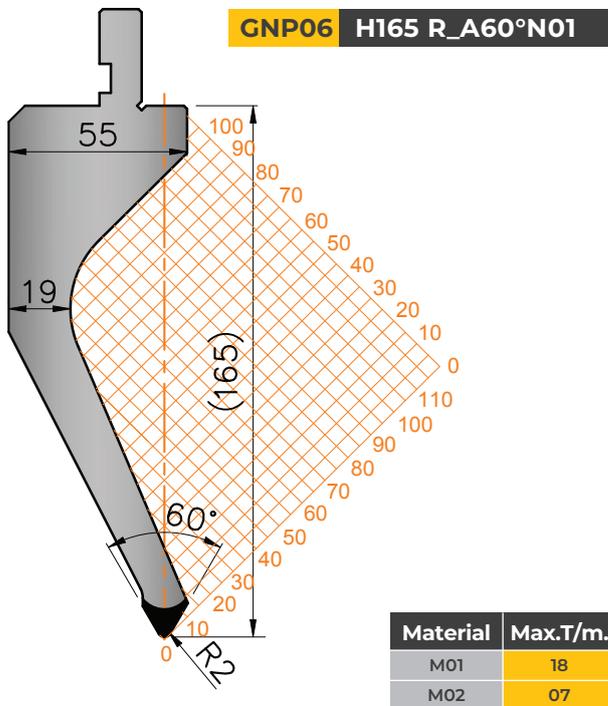
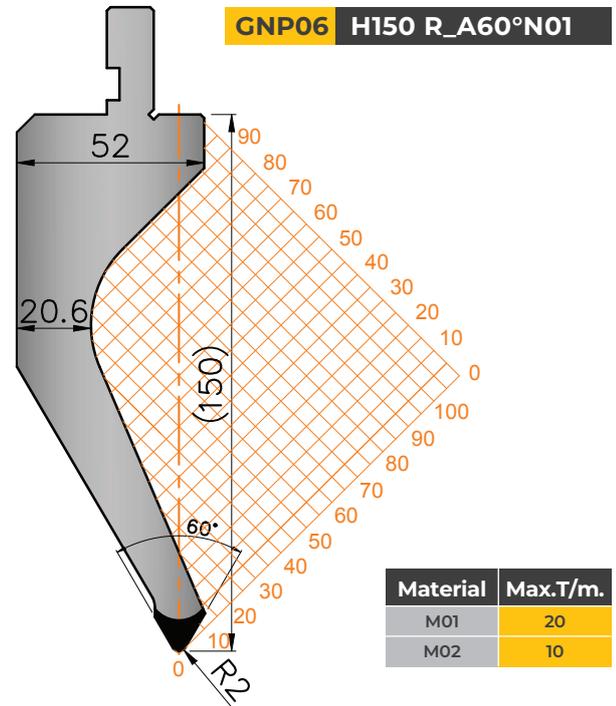
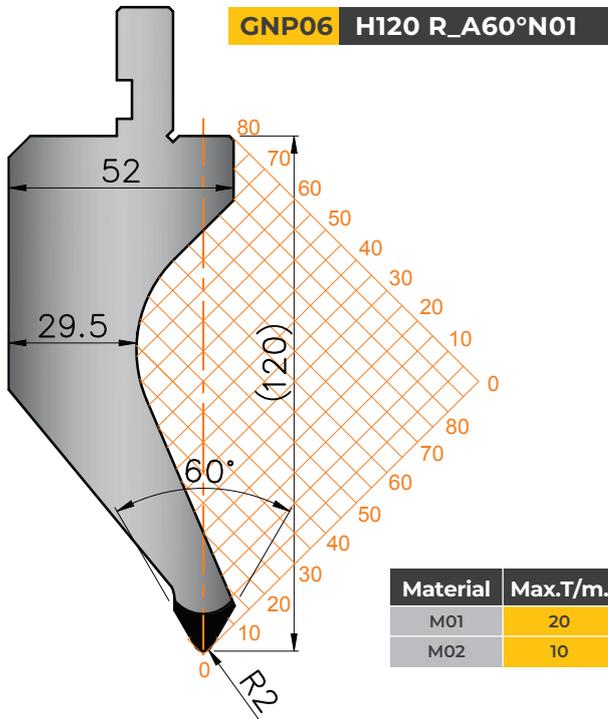
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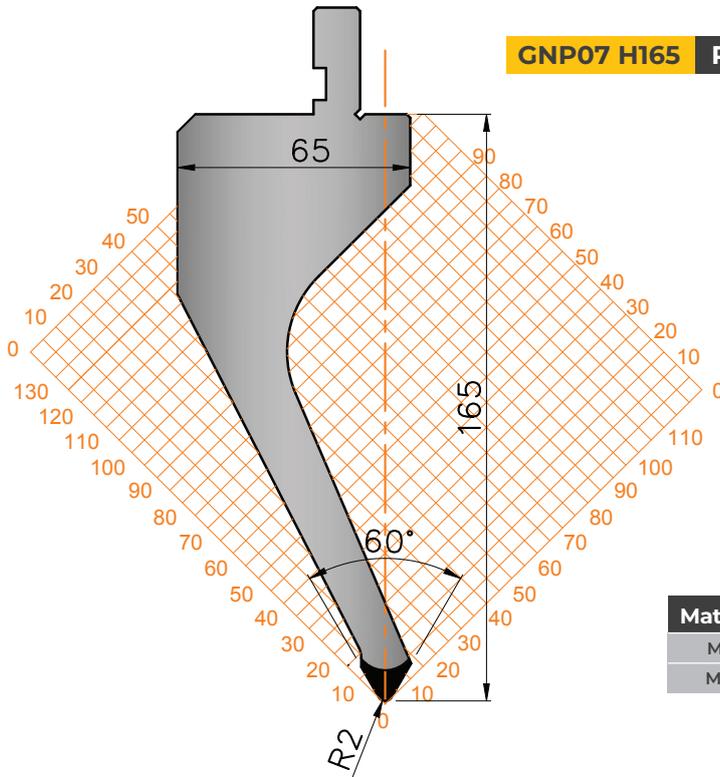
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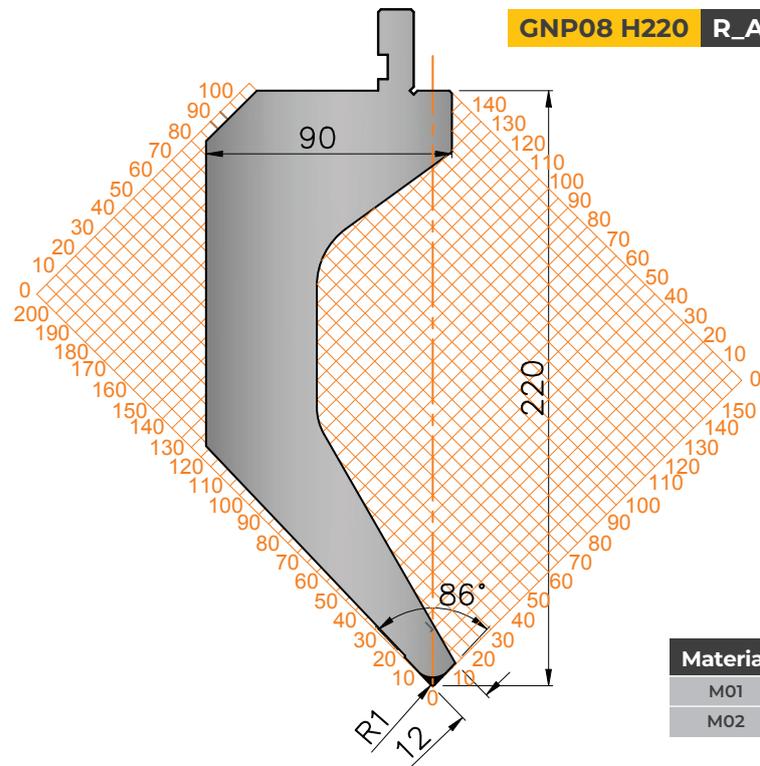
PUNCH | AMADA TYPE TOOLING

2:D:iv | GOOSENECK PUNCH



GNP07 H165 R_A60°N01

Material	Max.T/m.
M01	35
M02	30



GNP08 H220 R_A86°N01

Material	Max.T/m.
M01	85
M02	75

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

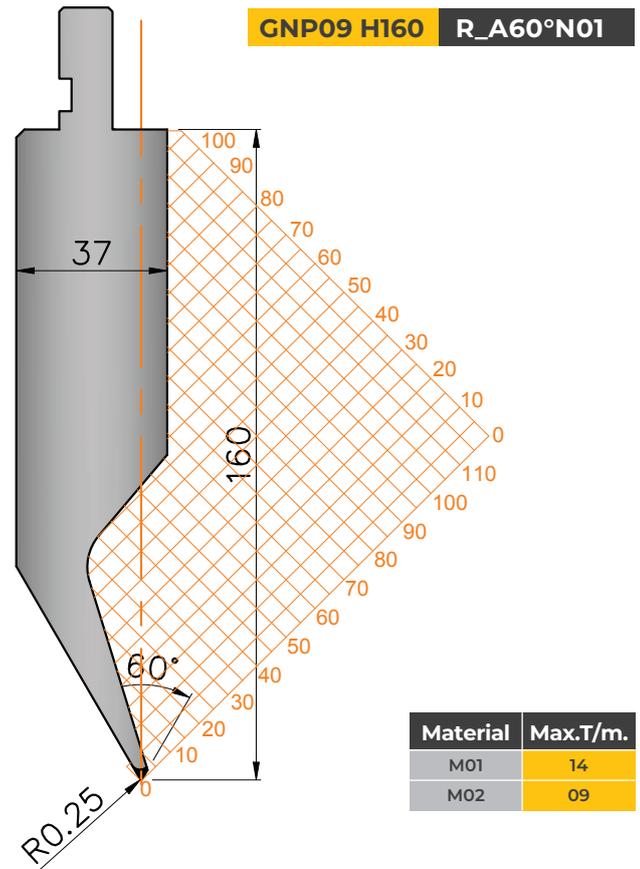
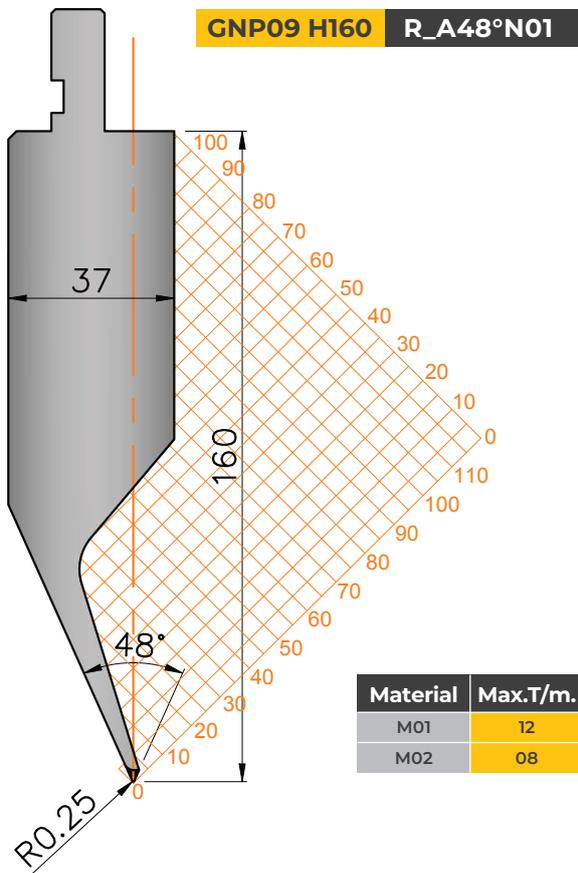
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





PUNCH | AMADA TYPE TOOLING

2:D:iv | GOOSENECK PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



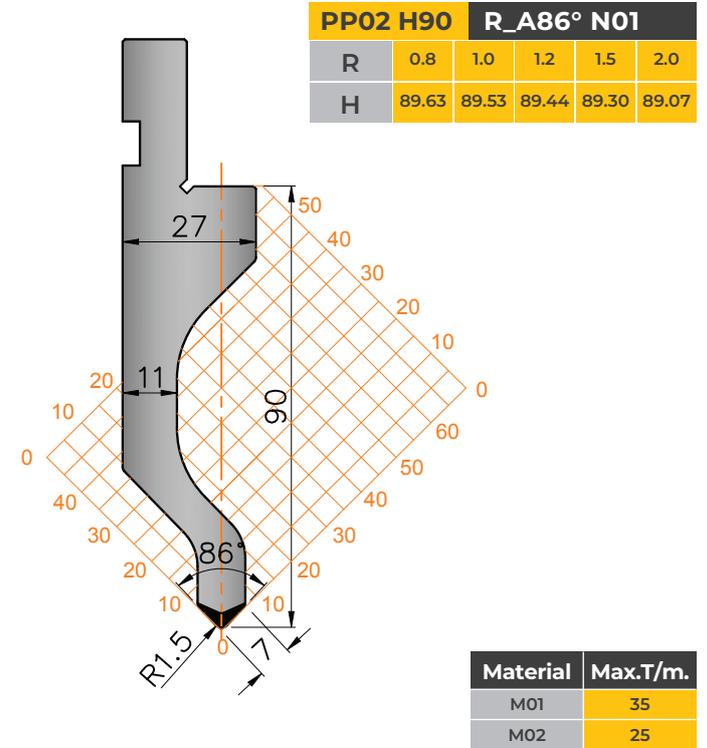
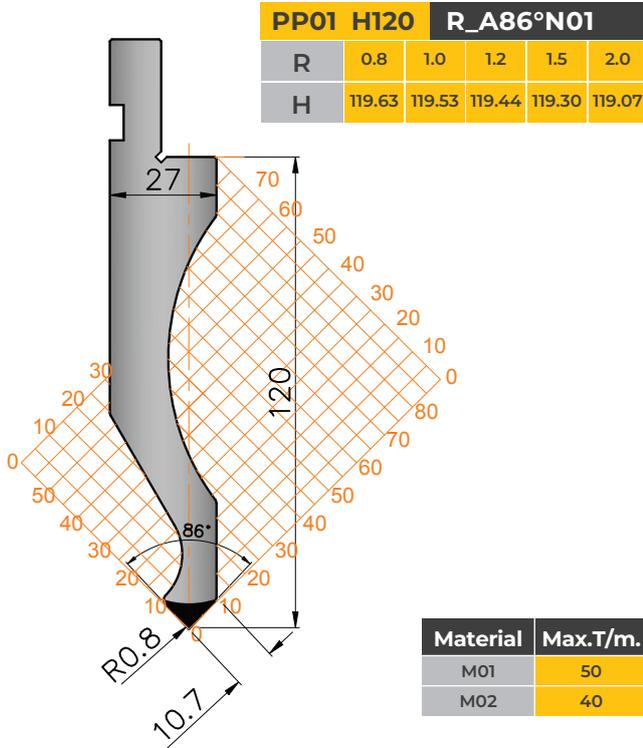
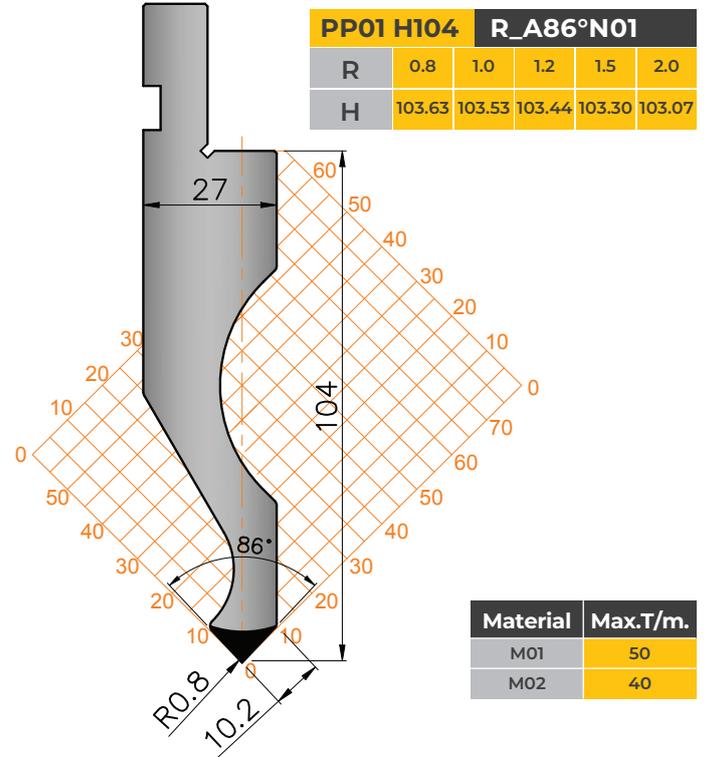
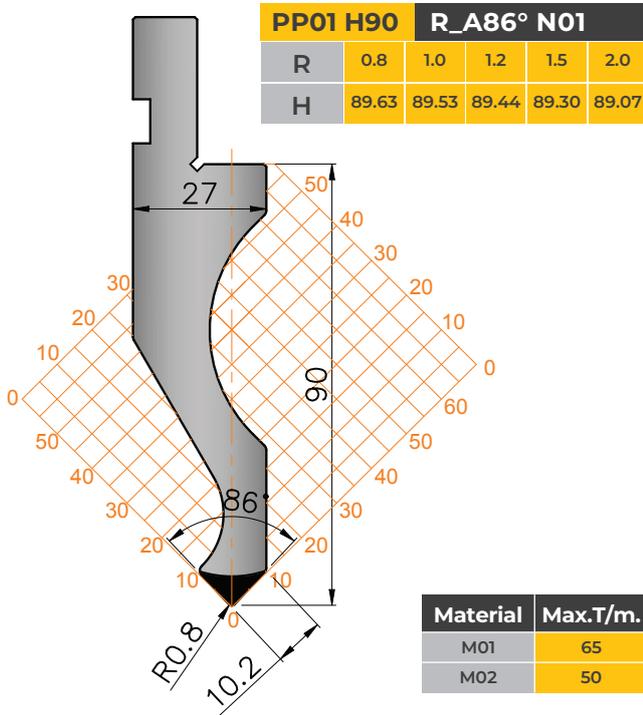
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | AMADA TYPE TOOLING

2:D:V | PROFILE PUNCH



Material Option

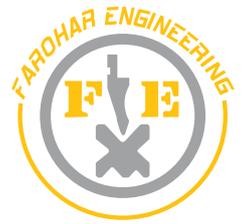
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

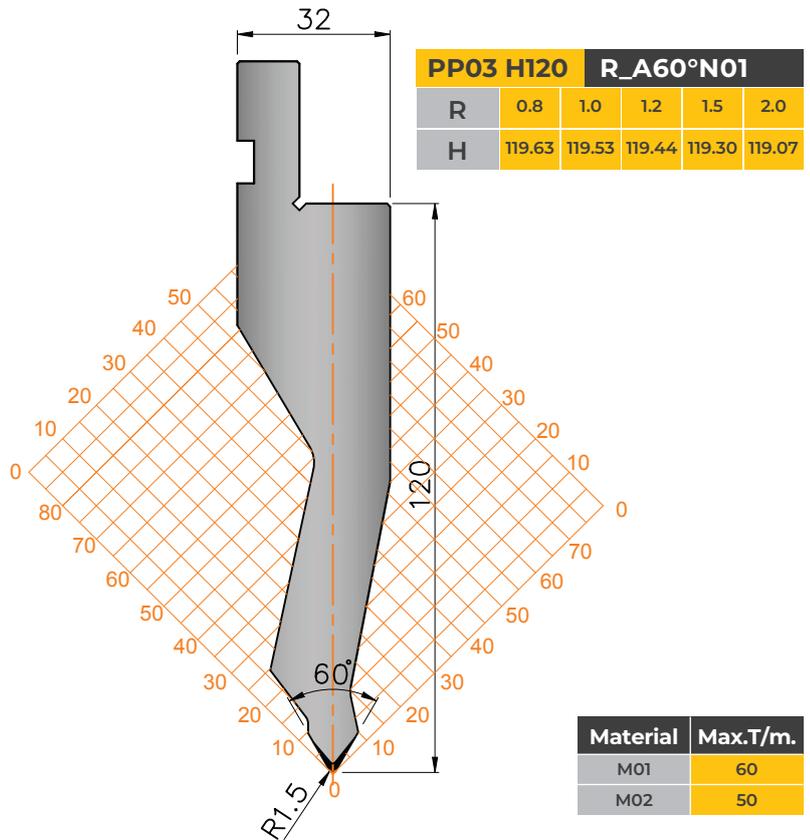
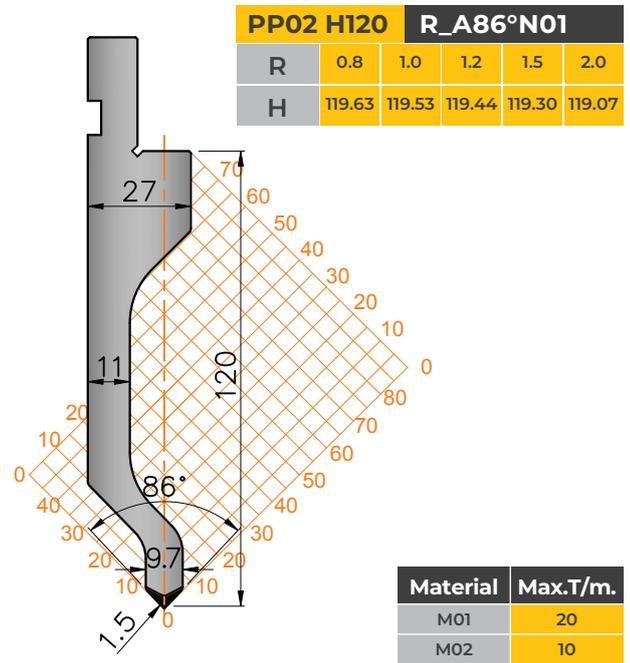
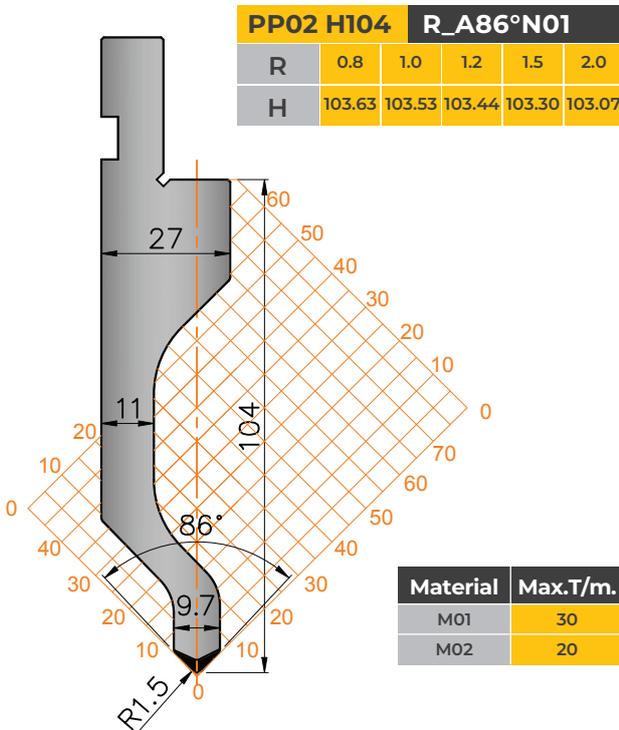
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





PUNCH | AMADA TYPE TOOLING

2:D:V | PROFILE PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



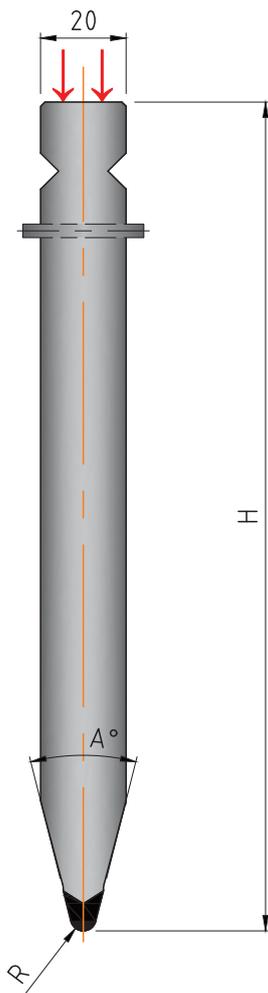
PUNCH | TRUMPF - WILATYPE TOOLING

2:E:i | INTRODUCTION

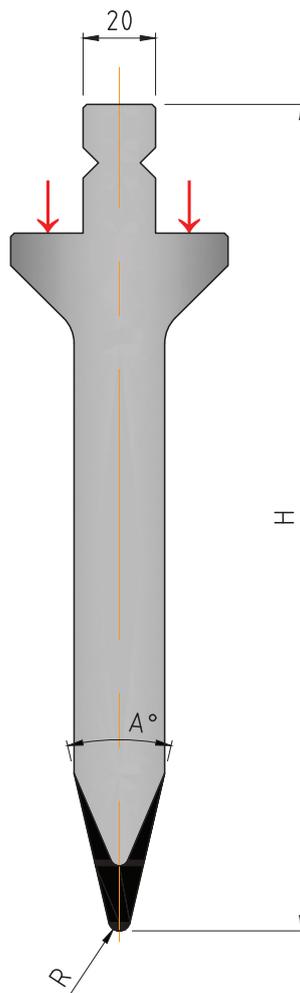
The unique feature of this tool is that it can be used from both sides.

The segmented punch can be effortlessly positioned between two punches using the button-type, without requiring the removal of all tools.

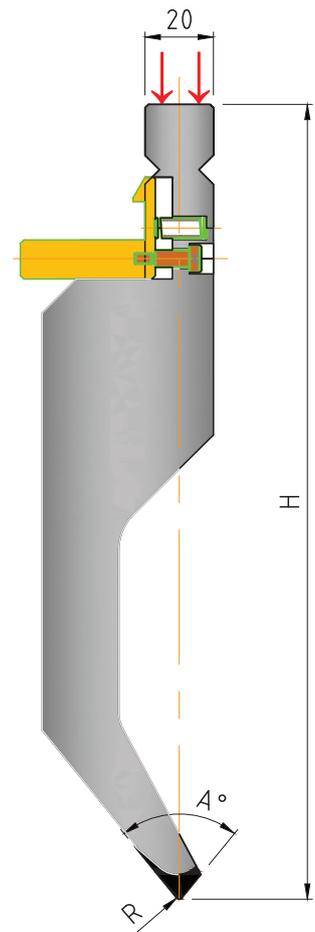
Fast tool change over



**WILA TYPE
Neck Head Loading
(N03)**



**WILA TYPE
Shoulder Loading
(N12)**



**BUTTON TYPE WILA
(N04)**

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

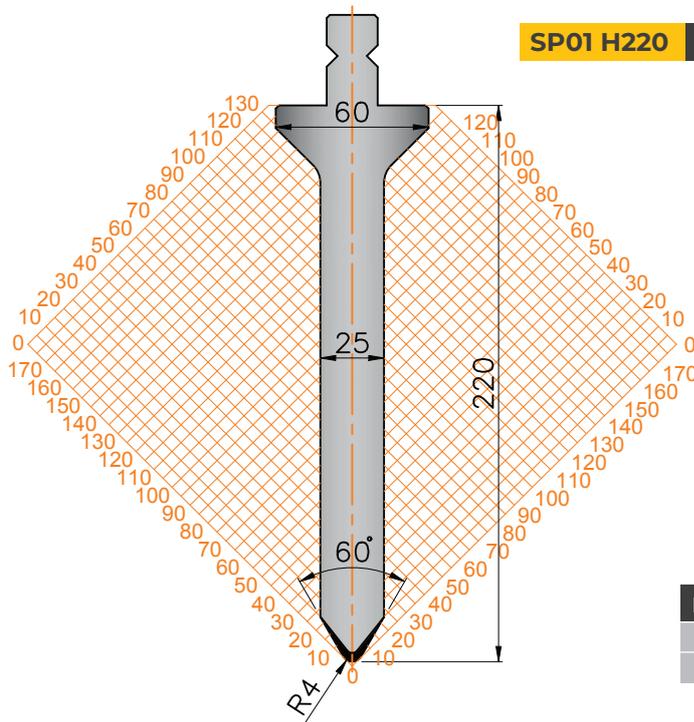
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





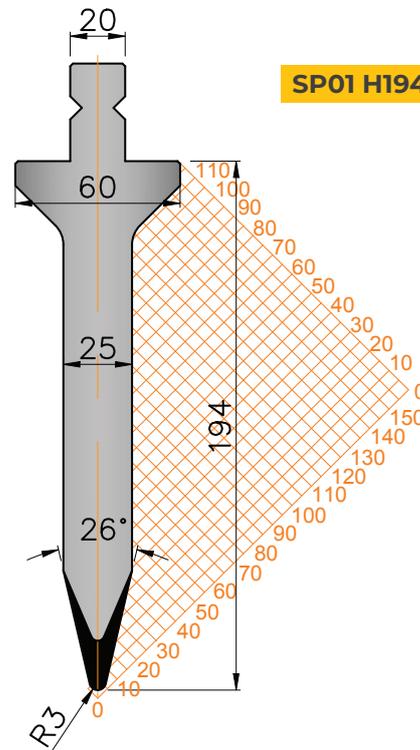
PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:ii | STRAIGHT PUNCH



SP01 H220 R_A60°N12

Material	Max.T/m.
M01	100
M02	80



SP01 H194 R_A26°N12

Material	Max.T/m.
M01	90
M02	72

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



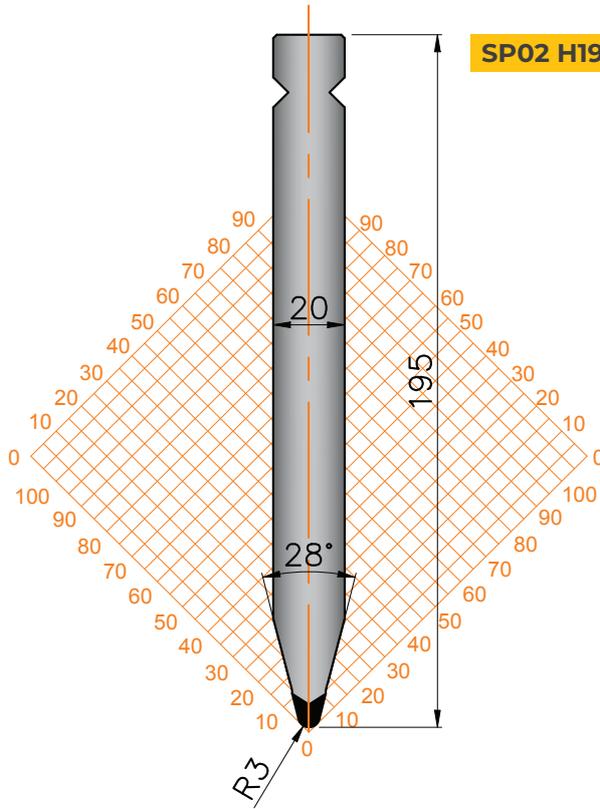
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



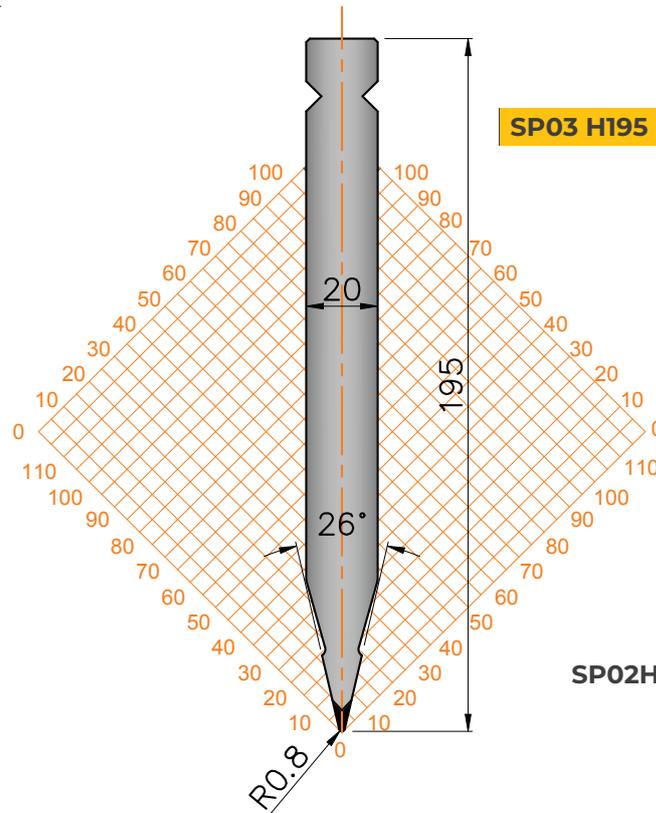
PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:ii | STRAIGHT PUNCH



SP02 H195 R_A28°N03

Material	Max.T/m.
M01	100
M02	80



SP03 H195 R_A26°N03

SP02H195R0.8A26N01M

Material	Max.T/m.
M01	100
M02	80

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

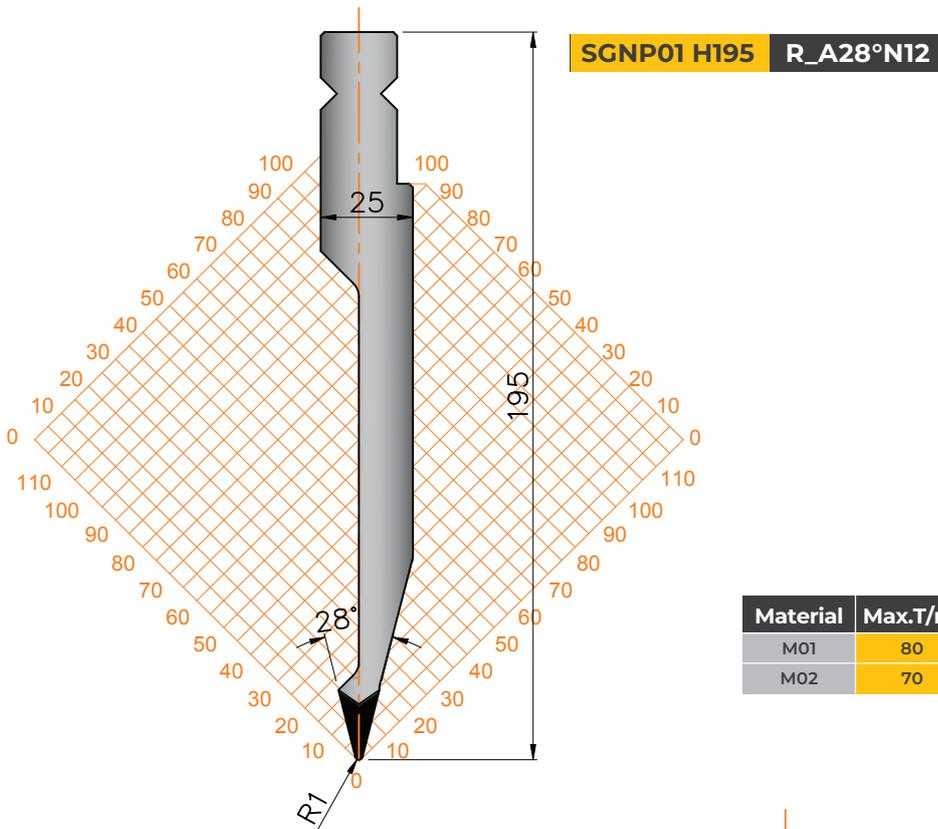
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



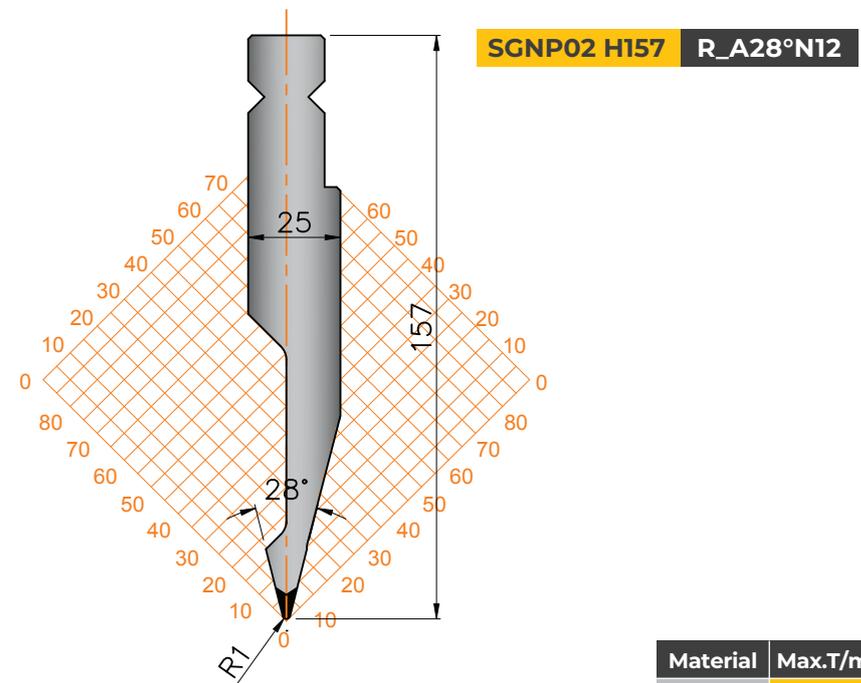


PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:iii | SEMI GOOSENECK PUNCH



Material	Max.T/m.
M01	80
M02	70



Material	Max.T/m.
M01	80
M02	70

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



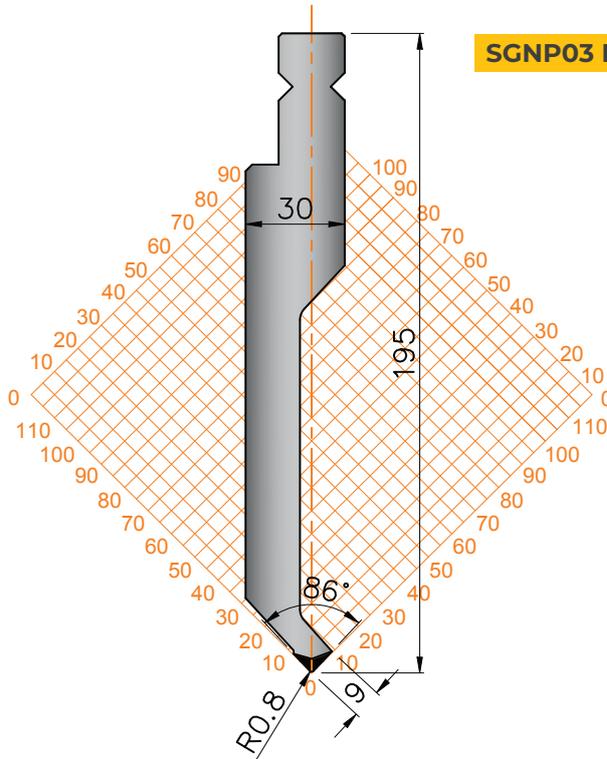
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



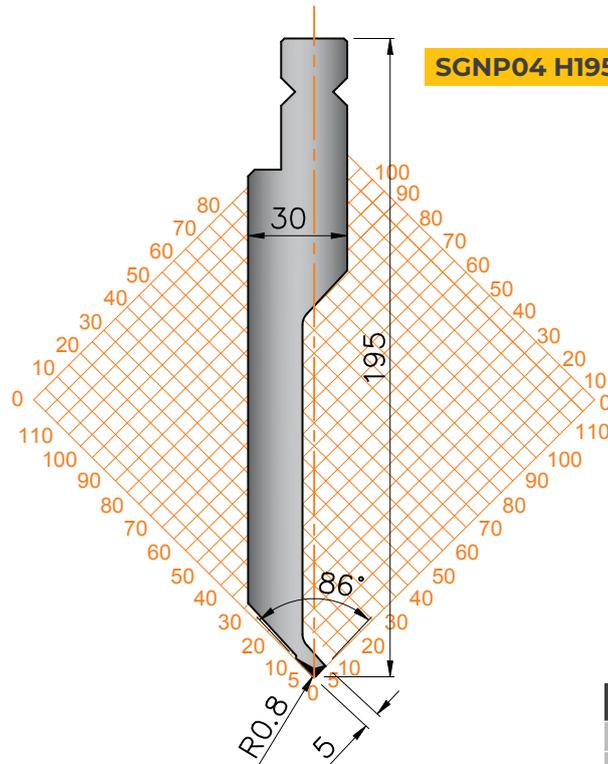
PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:iii | SEMI GOOSENECK PUNCH



SGNP03 H195 R_A86°N12

Material	Max.T/m.
M01	100
M02	80



SGNP04 H195 R_A86°N12

Material	Max.T/m.
M01	30
M02	25

Material Option

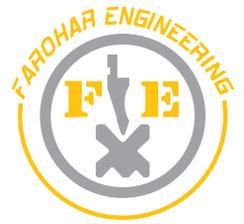
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

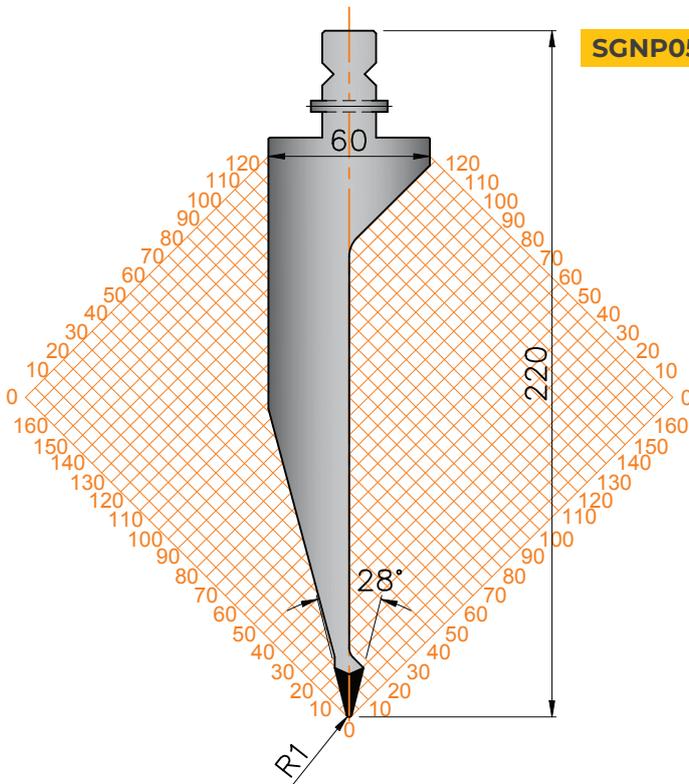
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





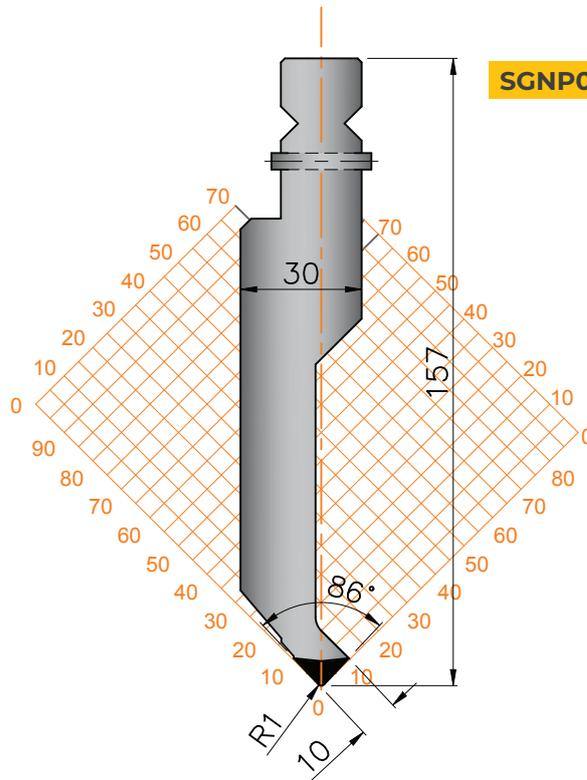
PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:iii | SEMI GOOSENECK PUNCH



SGNP05 H220 R_A28°N03

Material	Max.T/m.
M01	60
M02	55



SGNP06 H157 R_A86°N03

Material	Max.T/m.
M01	100
M02	80

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



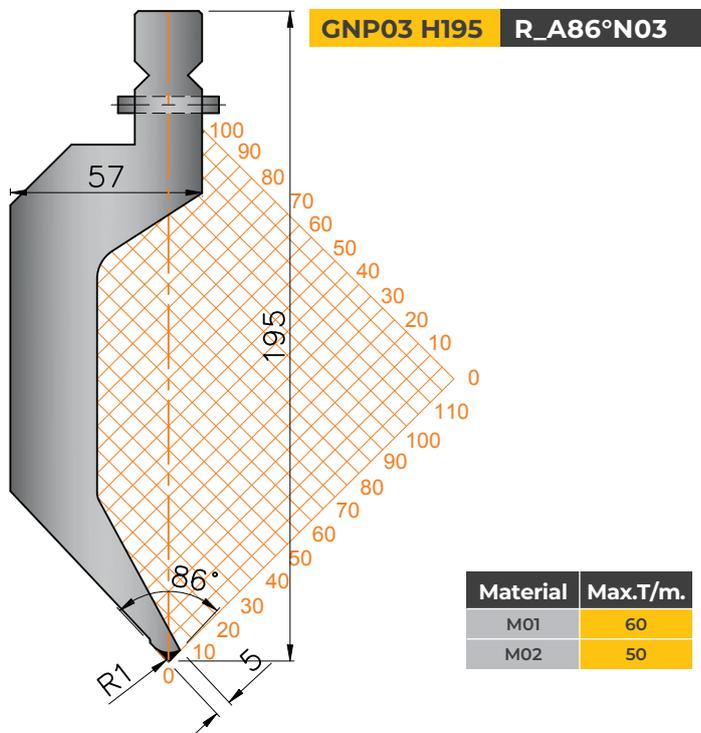
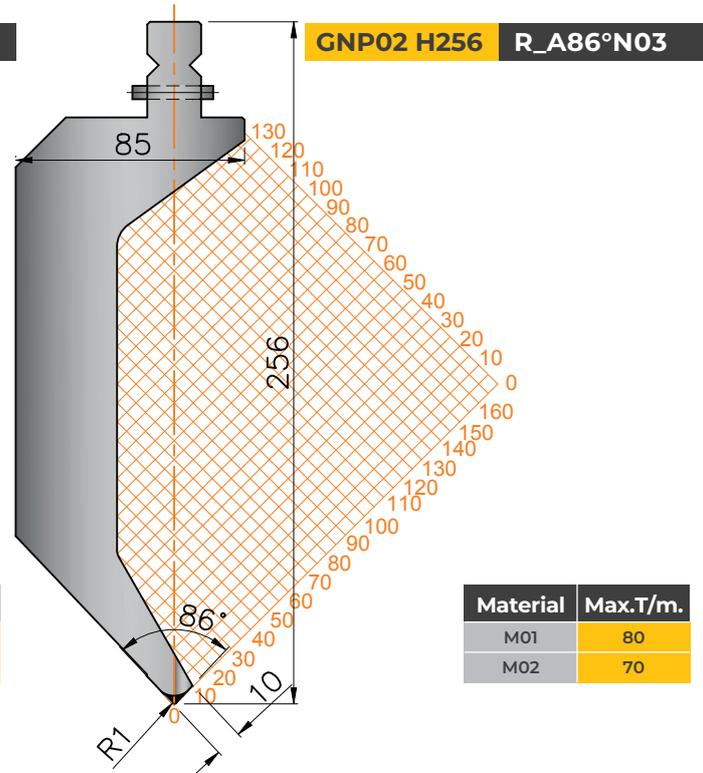
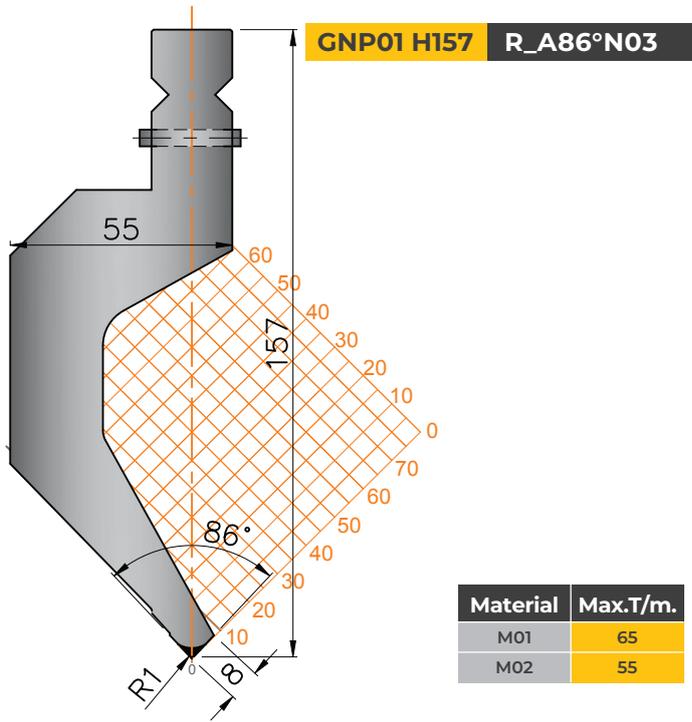
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:iv | GOOSENECK PUNCH



Material Option

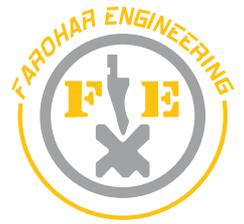
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

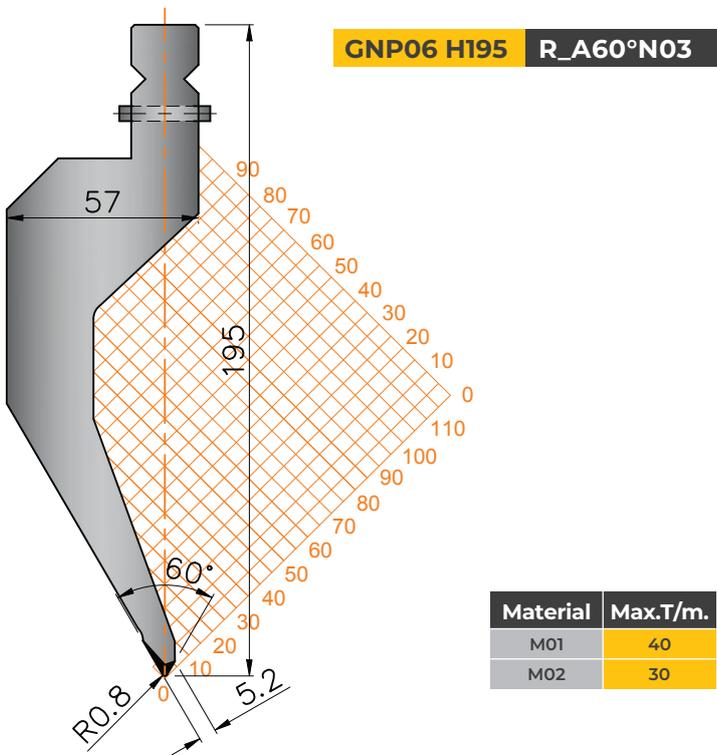
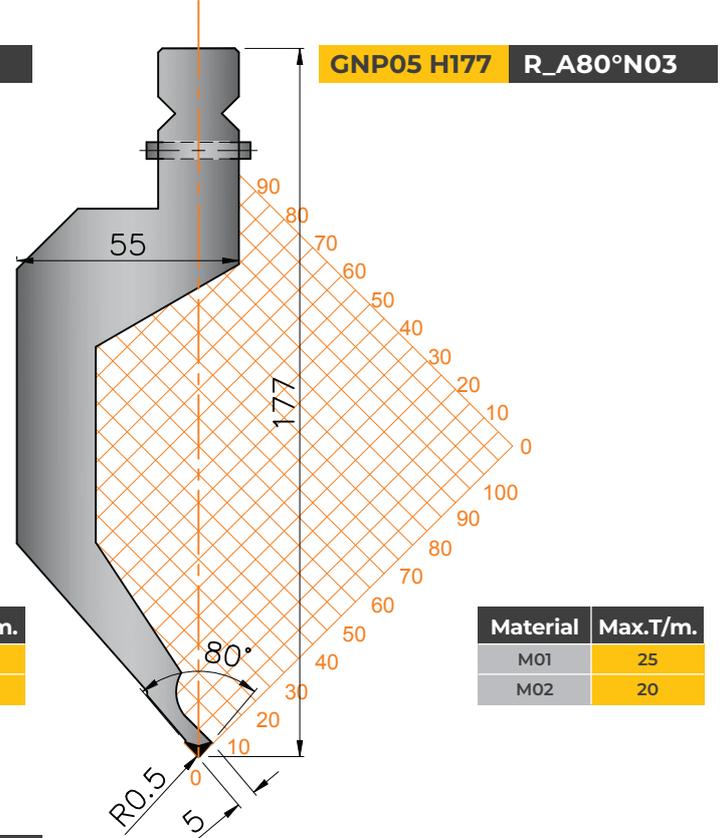
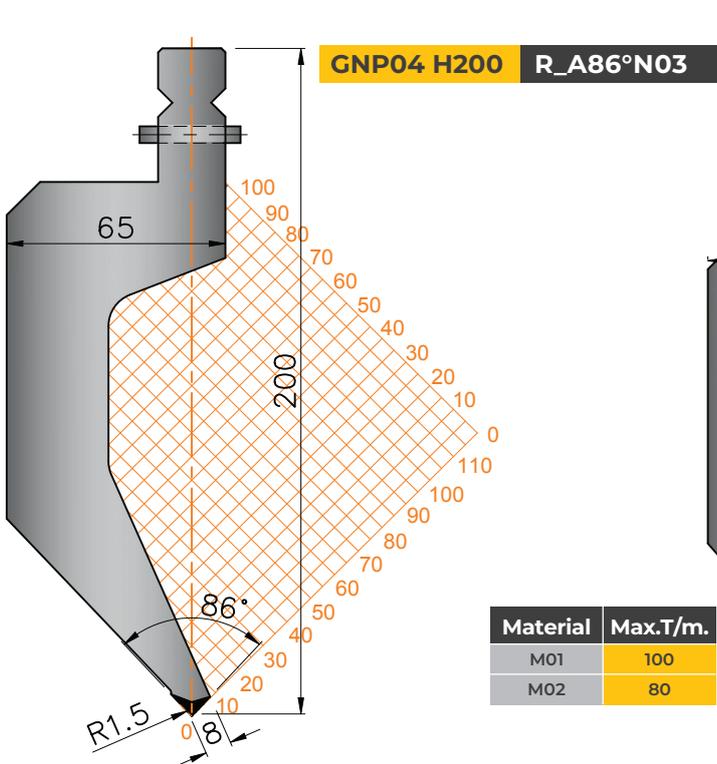
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:iv | GOOSENECK PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



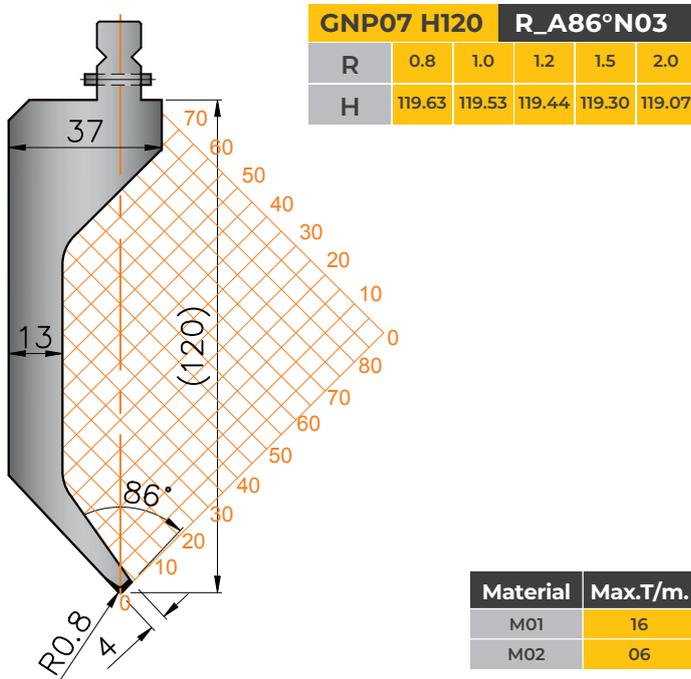
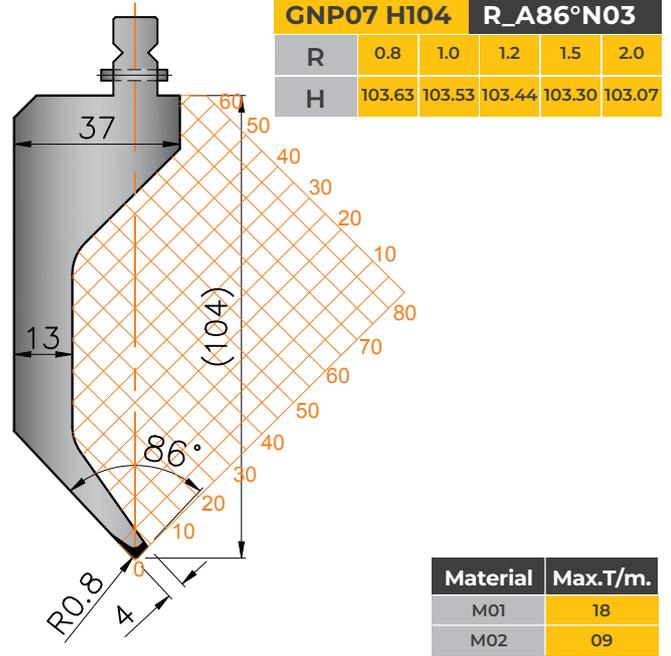
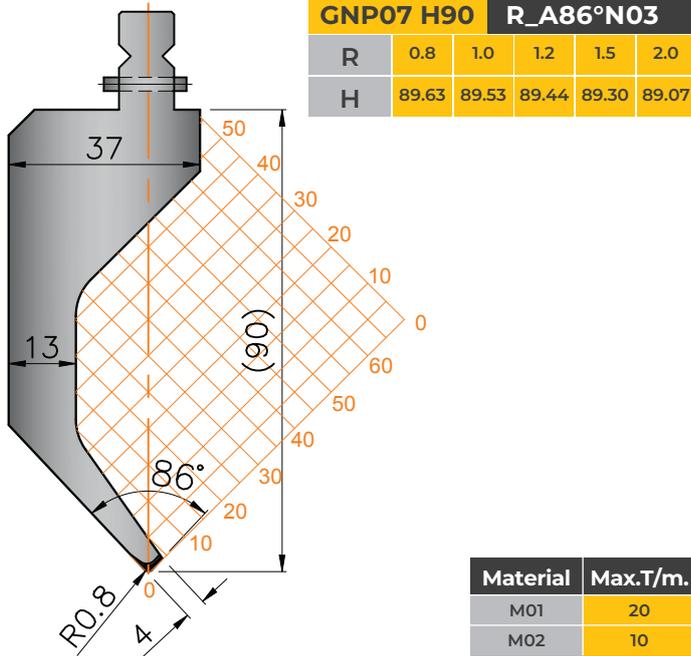
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | TRUMPF - WILA TYPE TOOLING

2:E:iv | GOOSENECK PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

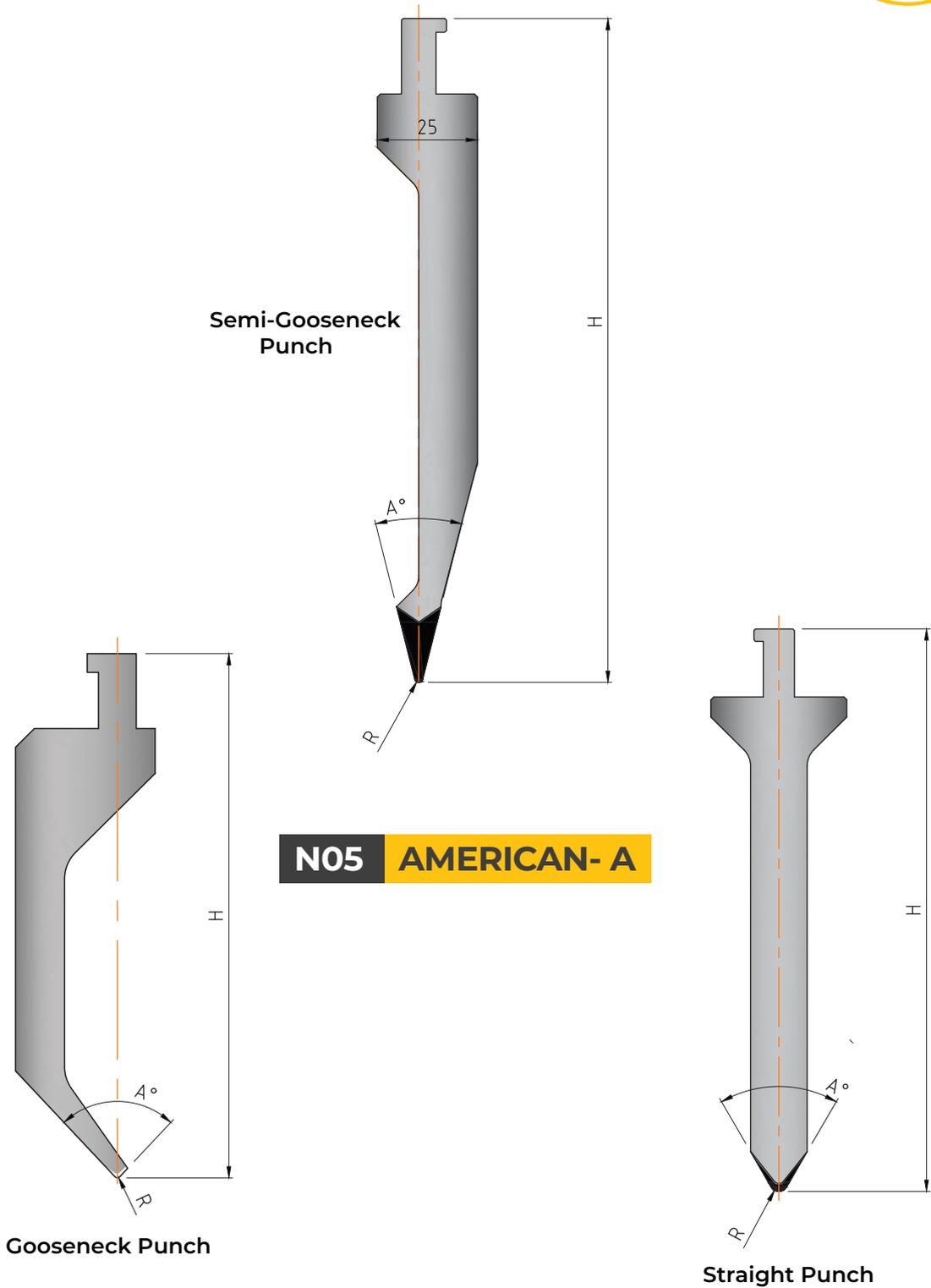
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





PUNCH | LVD TYPE TOOLING

2:F:i | INTRODUCTION



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



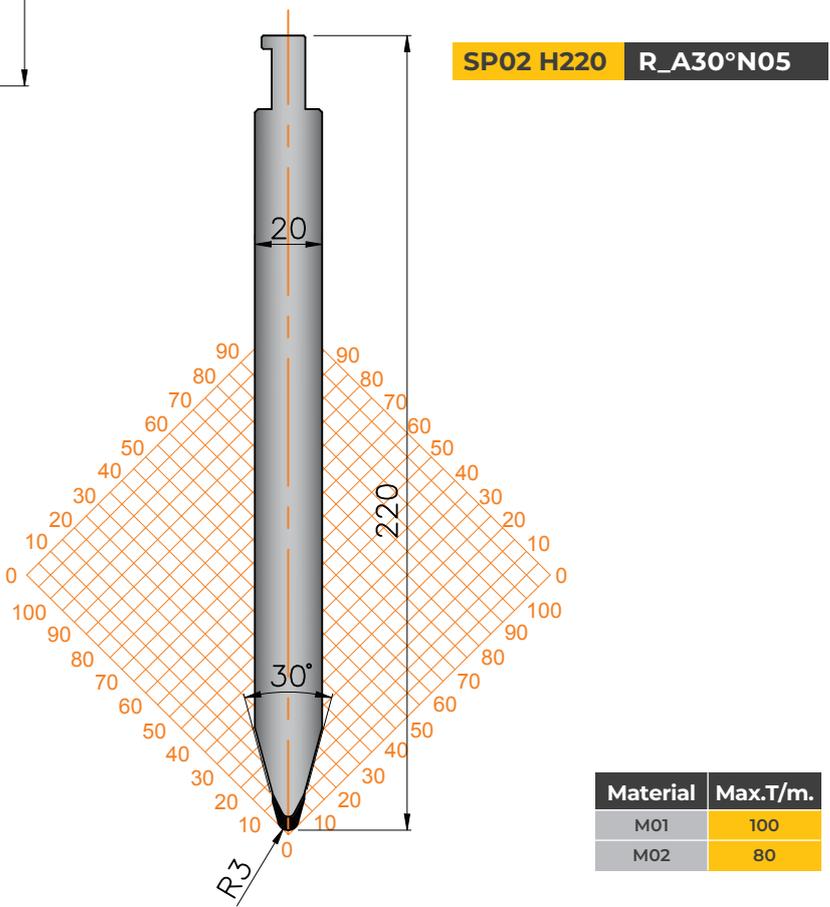
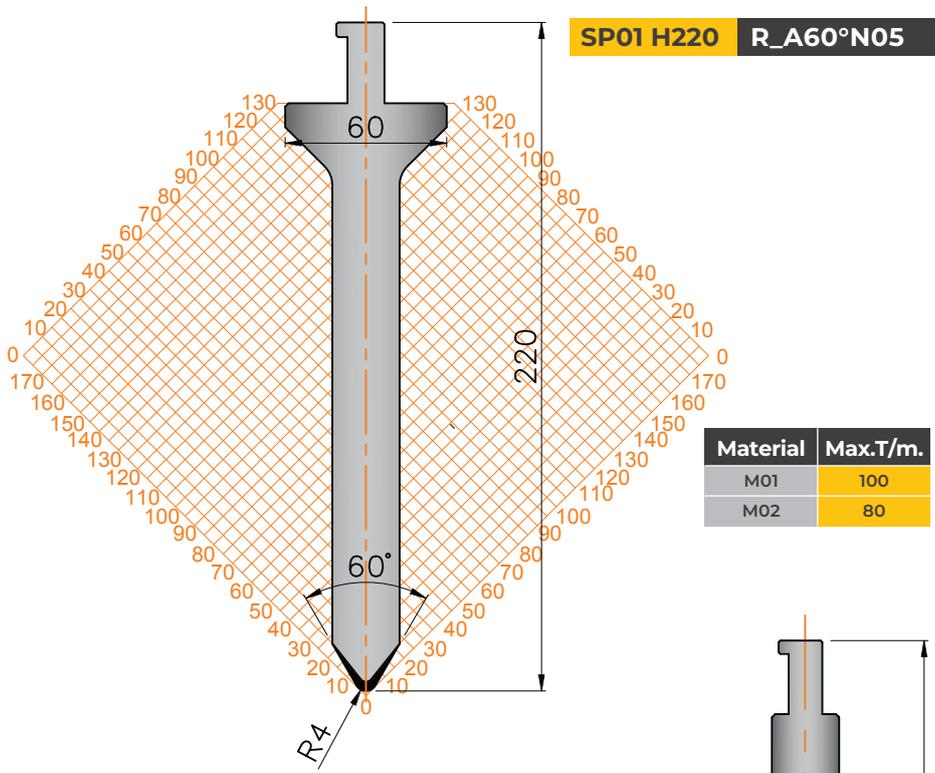
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | LVD TYPE TOOLING

2:F:ii | STRAIGHT PUNCH



Material Option

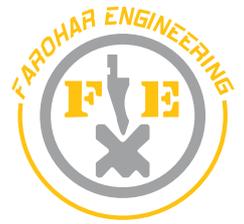
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

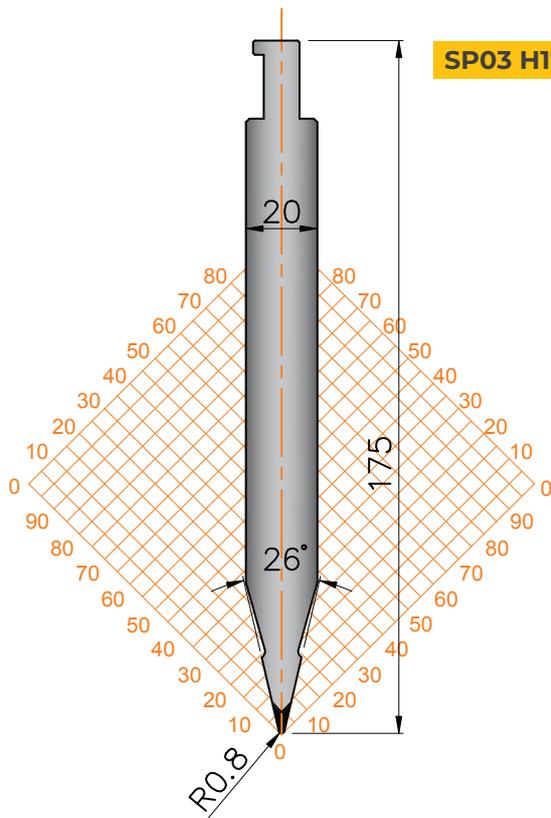
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





PUNCH | LVD TYPE TOOLING

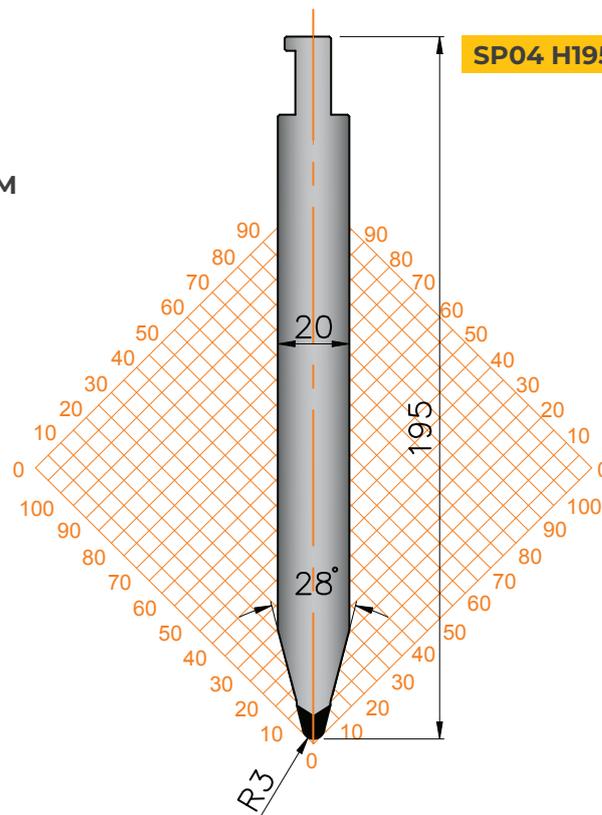
2:F:ii | STRAIGHT PUNCH



SP03 H175 R_A26°N05

Material	Max.T/m.
M01	100
M02	80

SP02H195R0.8A26N01M



SP04 H195 R_A28°N05

Material	Max.T/m.
M01	100
M02	80

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



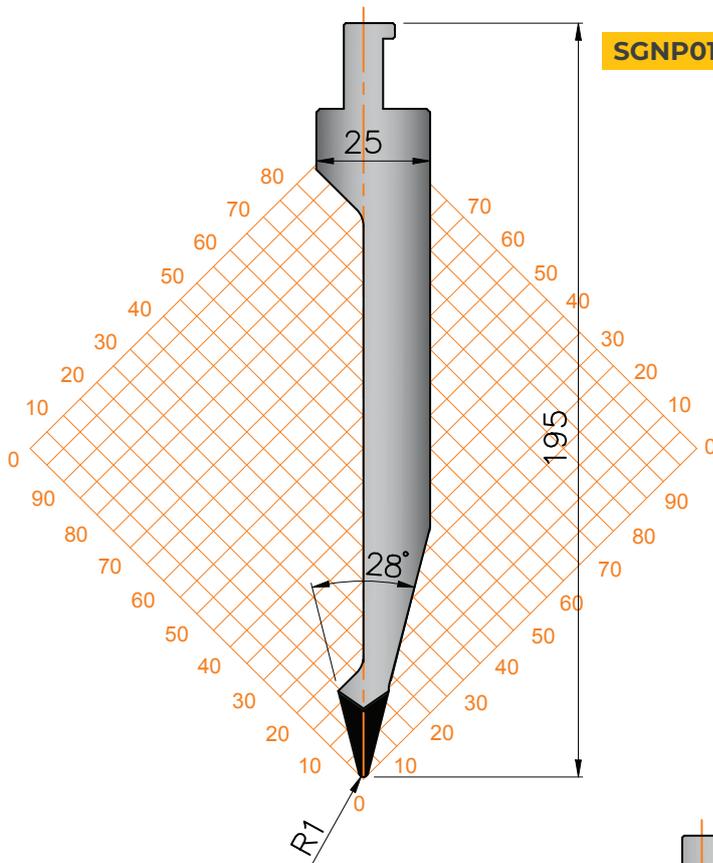
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



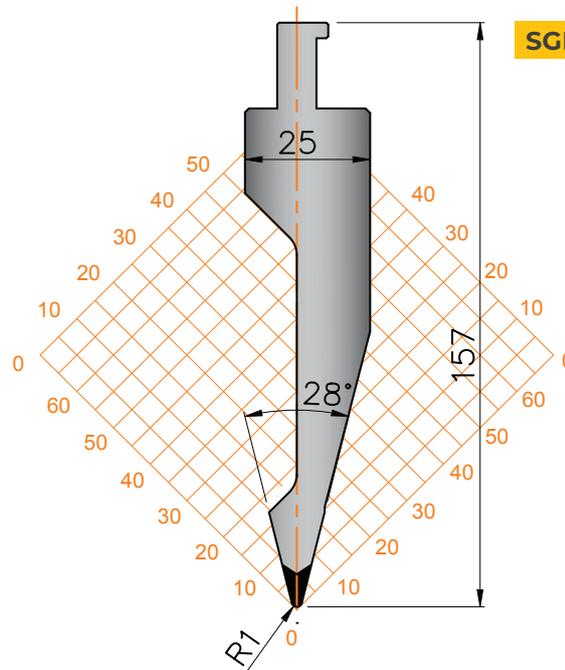
PUNCH | LVD TYPE TOOLING

2:F:iii | SEMI GOOSE NECK PUNCH



SGNP01 H195 R_A28°N05

Material	Max.T/m.
M01	80
M02	70



SGNP02 H157 R_A28°N05

Material	Max.T/m.
M01	80
M02	70

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

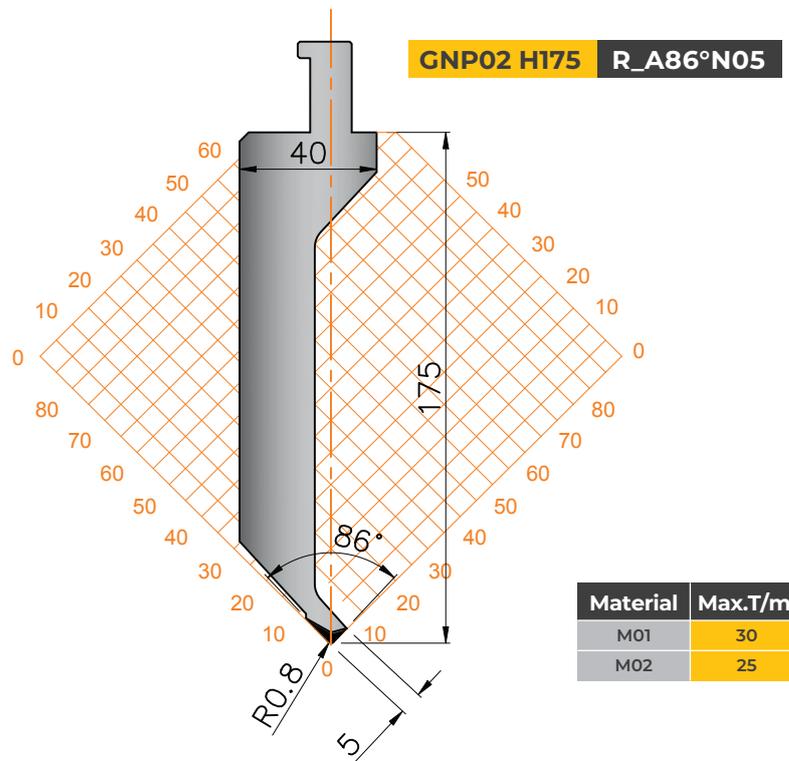
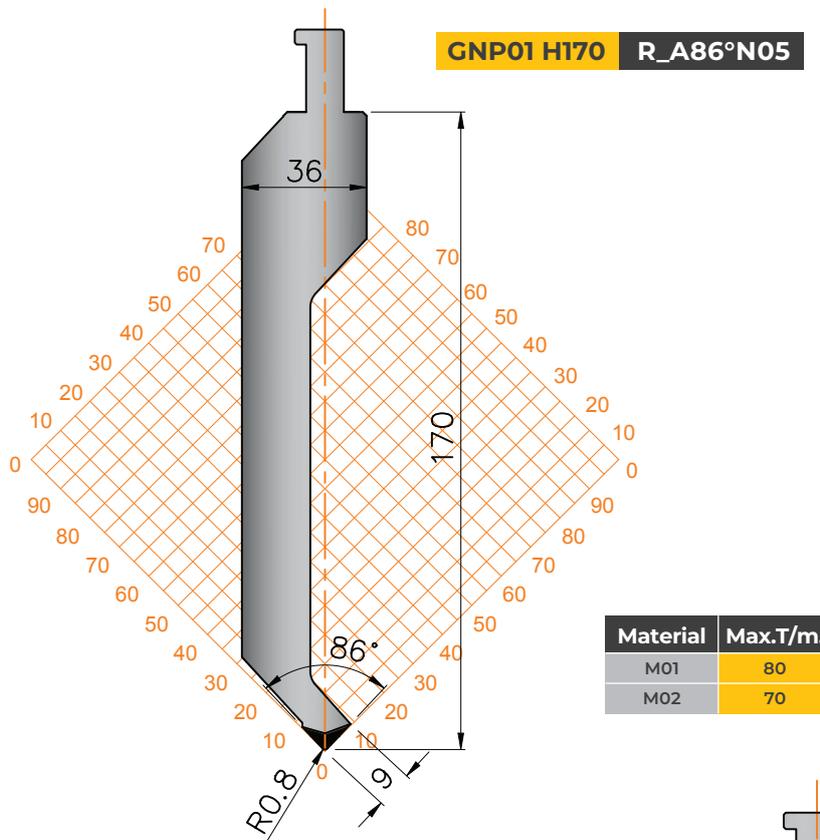
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





PUNCH | LVD TYPE TOOLING

2:F:iv | GOOSE NECK PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



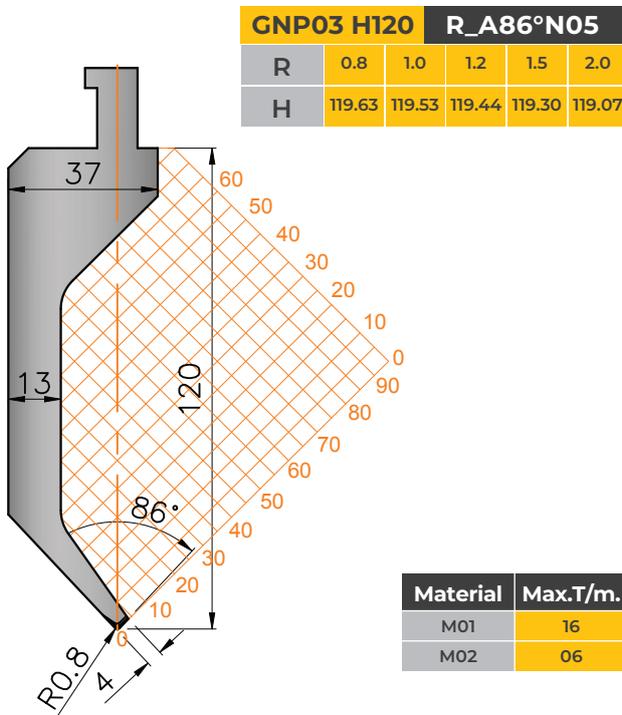
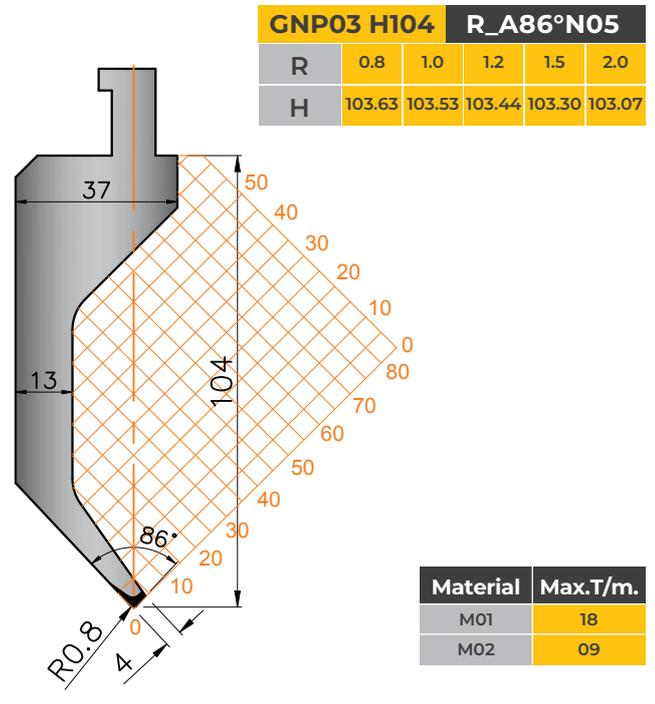
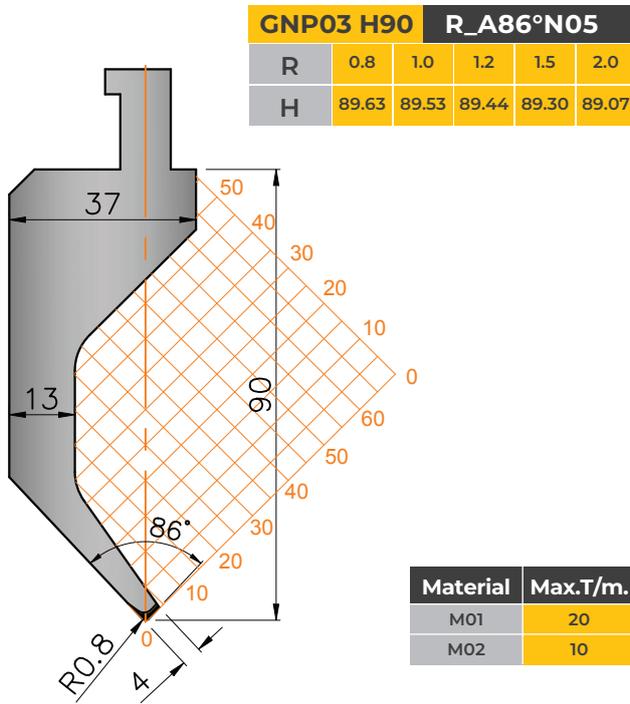
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



PUNCH | LVD TYPE TOOLING

2:F:iv | GOOSE NECK PUNCH



Material Option

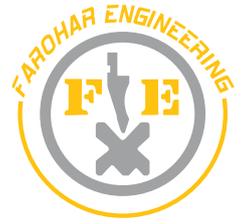
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

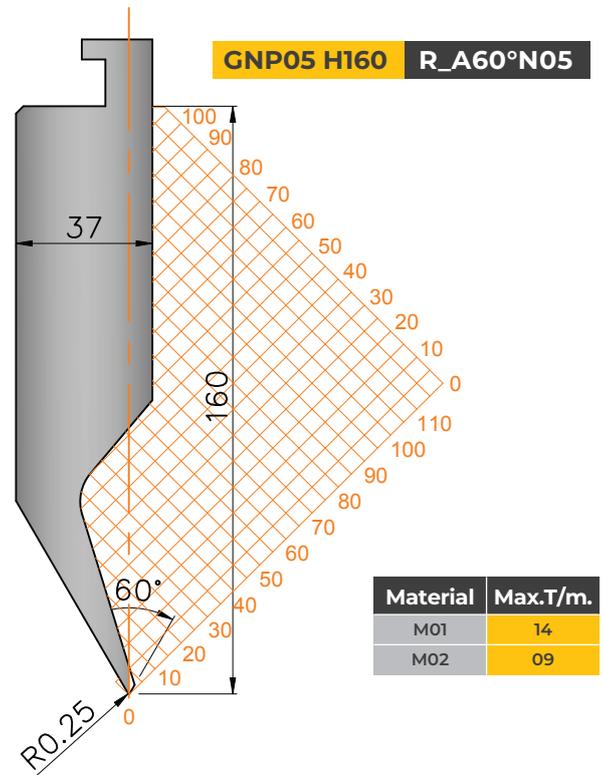
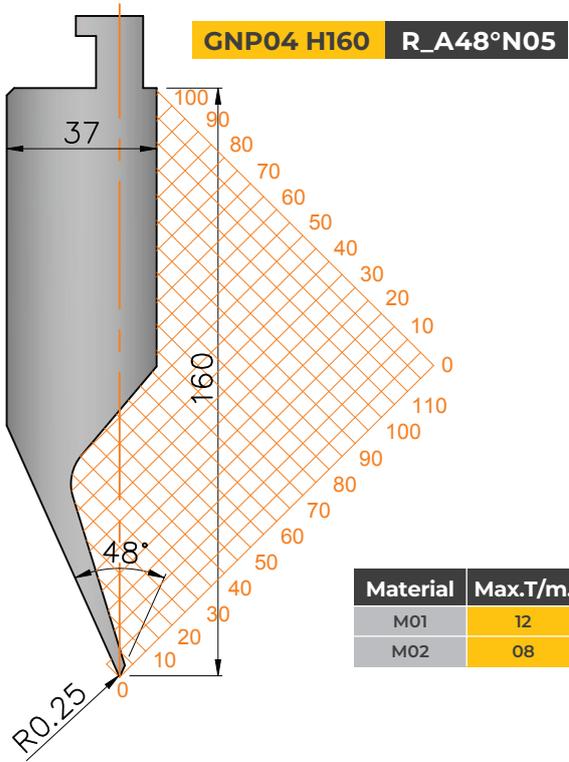
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





PUNCH | LVD TYPE TOOLING

2:F:iv | GOOSE NECK PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



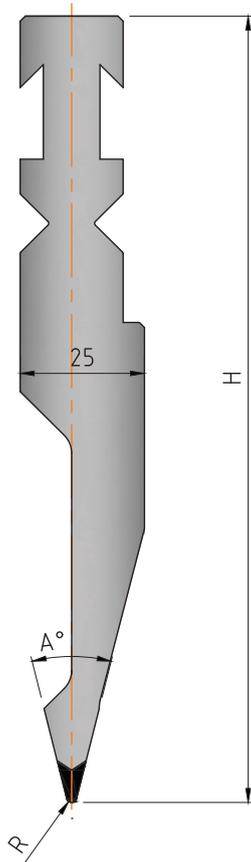
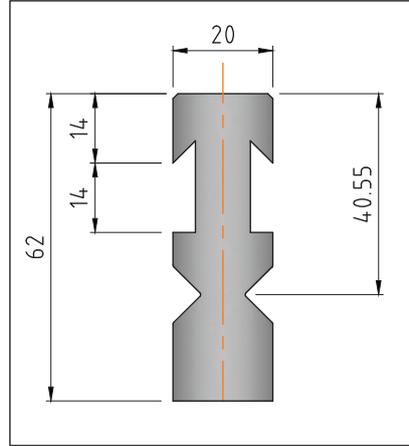
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

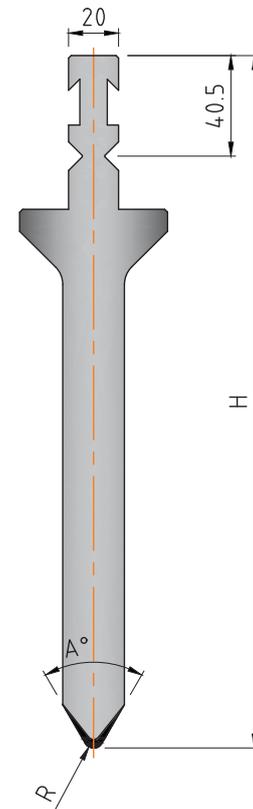


PUNCH | BYSTRONIC TYPE TOOLING

2:G:i | INTRODUCTION



N08 Type Bystronic



N08 Type Bystronic

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

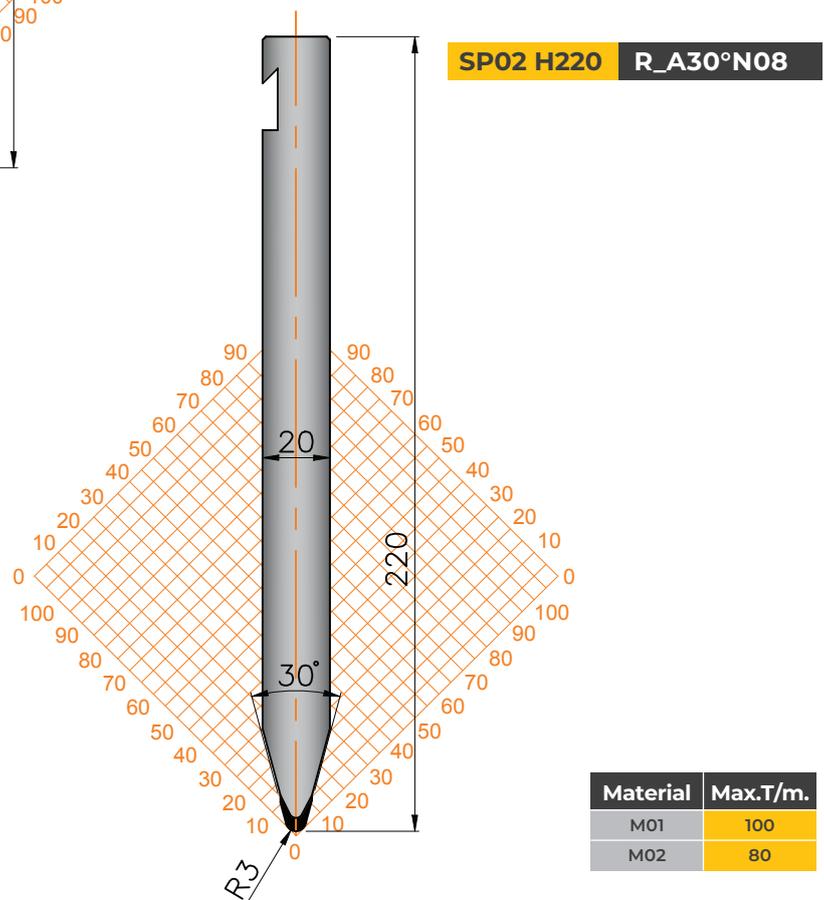
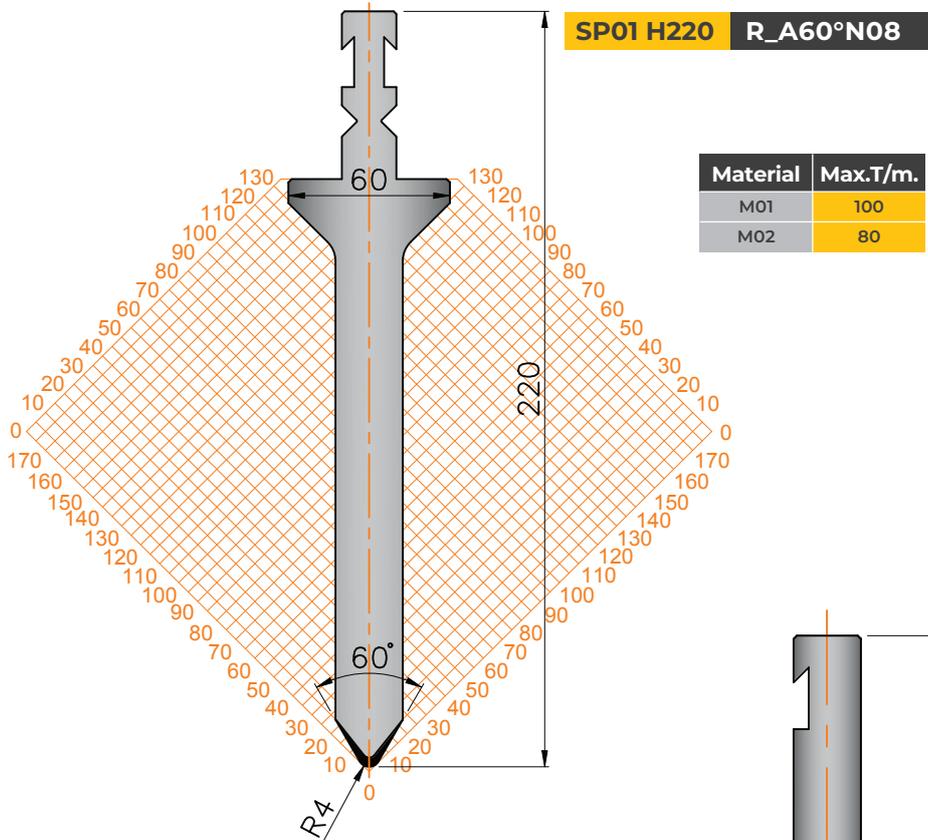
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





PUNCH | BYSTRONIC TYPE TOOLING

2:G:ii | STRAIGHT PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



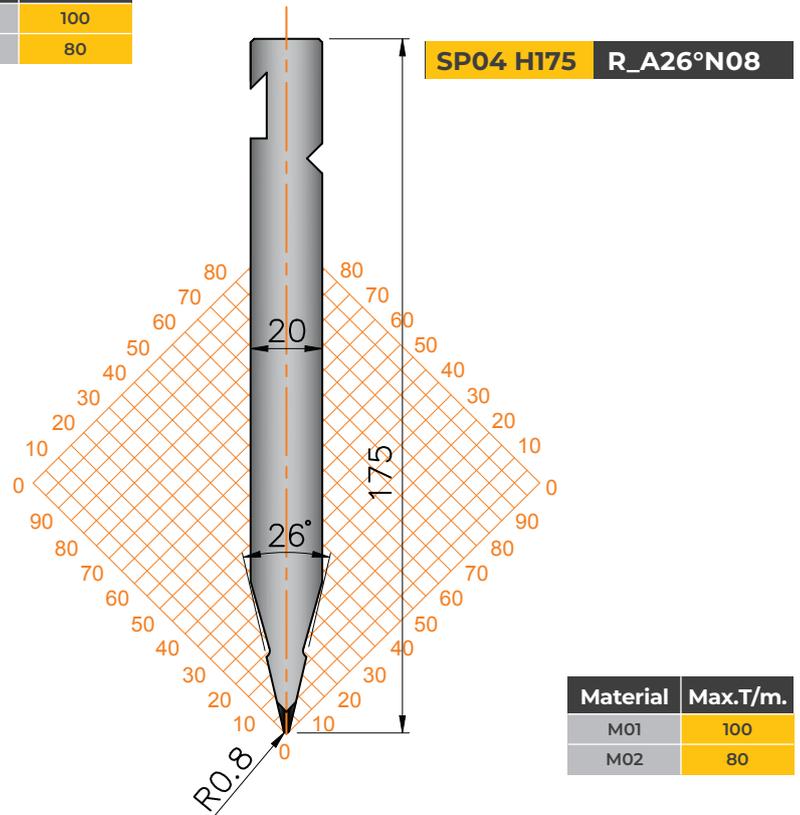
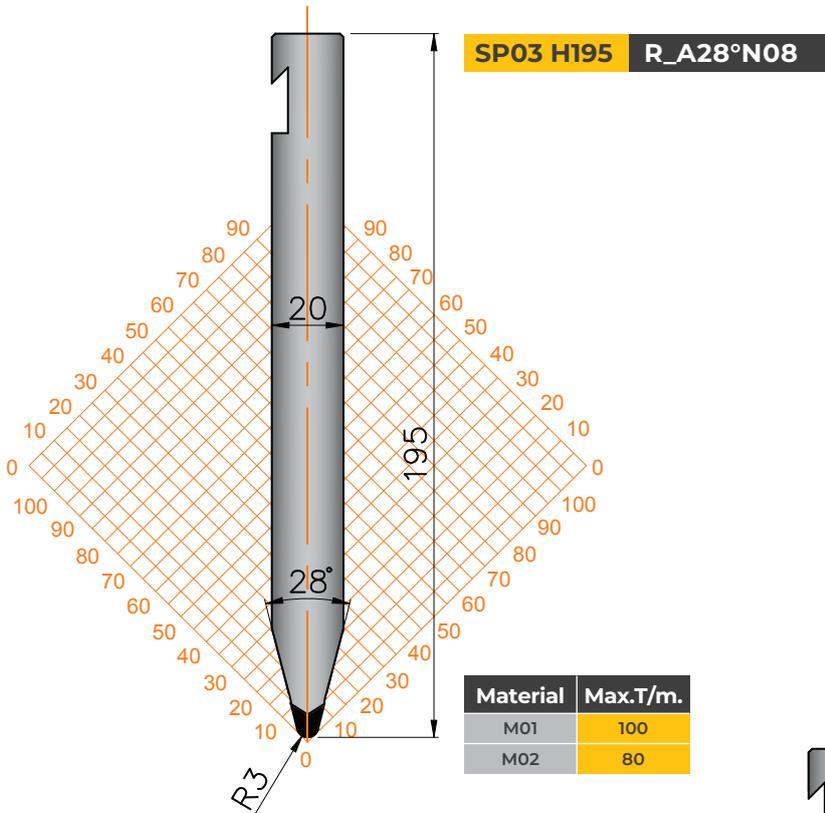
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



PUNCH | BYSTRONIC TYPE TOOLING

2:G:ii | STRAIGHT PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

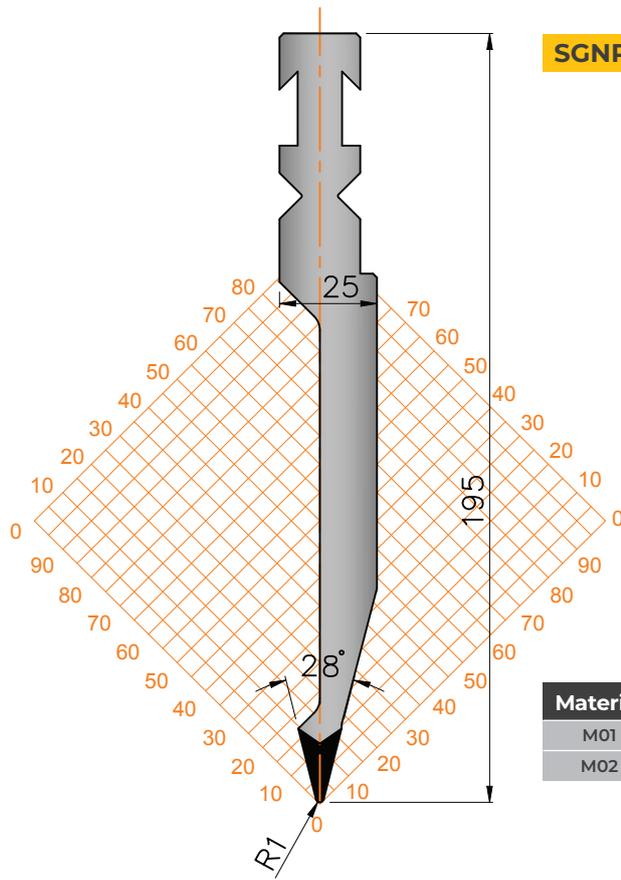
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





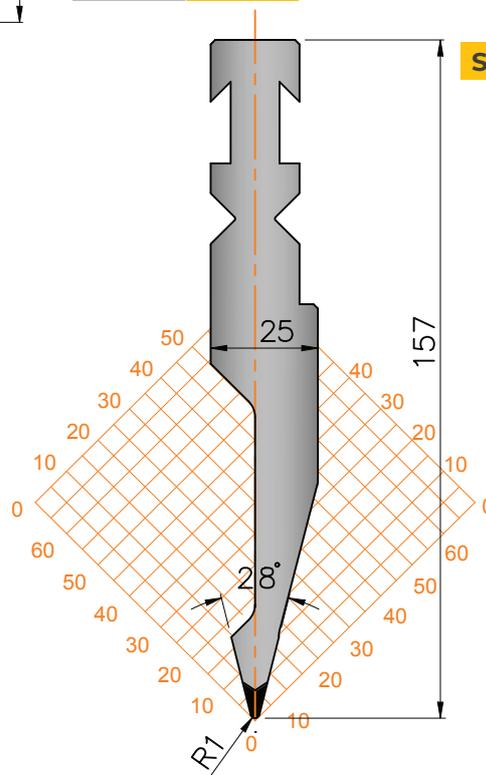
PUNCH | BYSTRONIC TYPE TOOLING

2:G:iii | SEMI STRAIGHT PUNCH



SGNP01 H195 R_A28°N08

Material	Max.T/m.
M01	80
M02	70



SGNP02 H157 R_A28°N08

Material	Max.T/m.
M01	80
M02	70

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



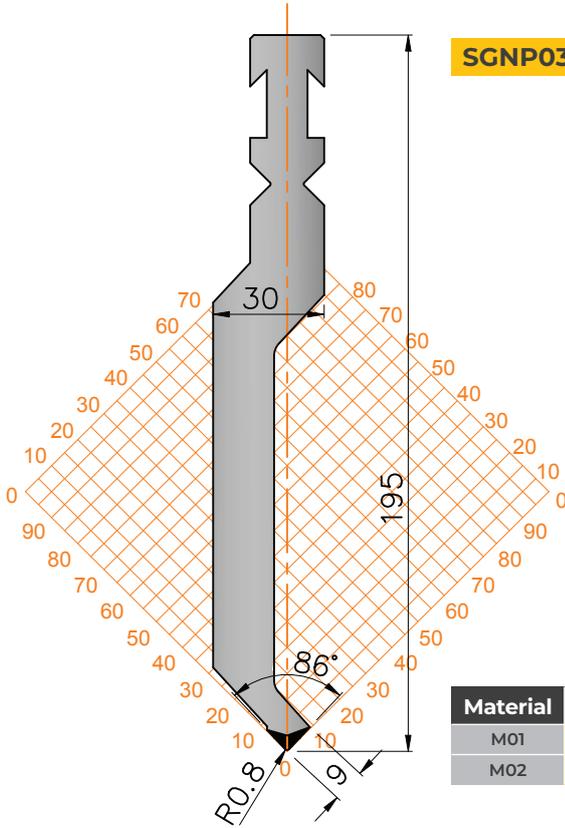
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



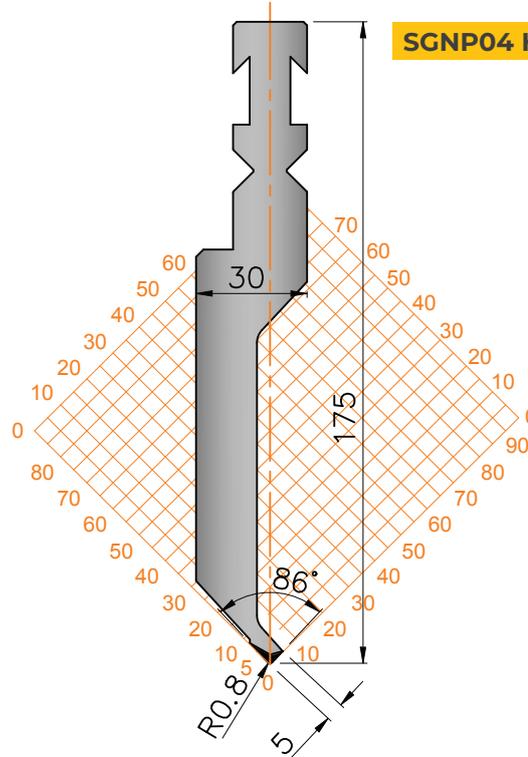
PUNCH | BYSTRONIC TYPE TOOLING

2:G:iii | SEMI STRAIGHT PUNCH



SGNP03 H195 R_A86°N08

Material	Max.T/m.
M01	80
M02	70



SGNP04 H175 R_A86°N08

Material	Max.T/m.
M01	30
M02	25

Material Option

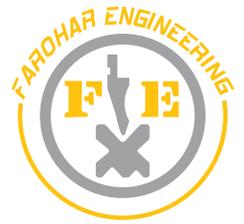
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

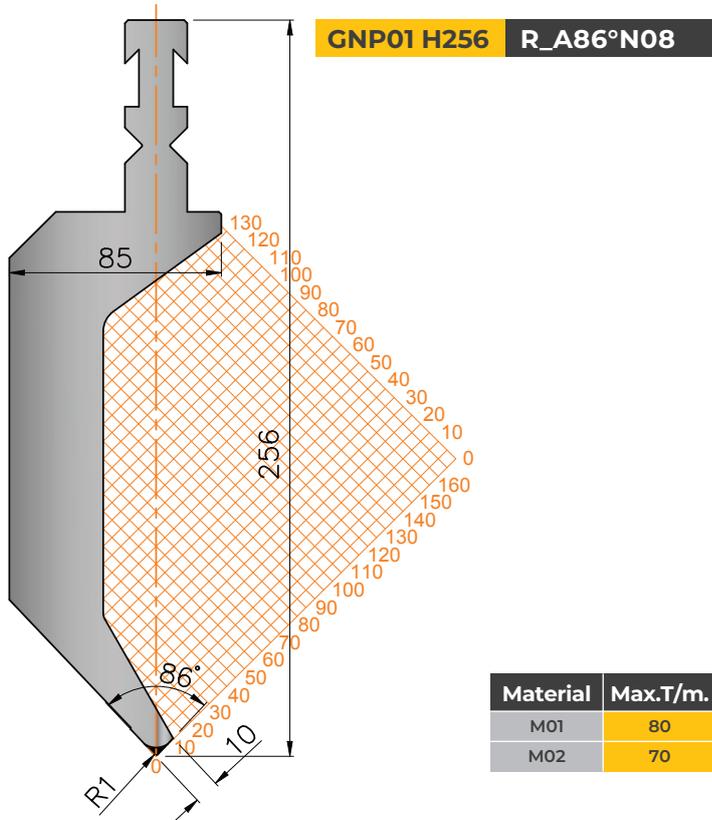
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



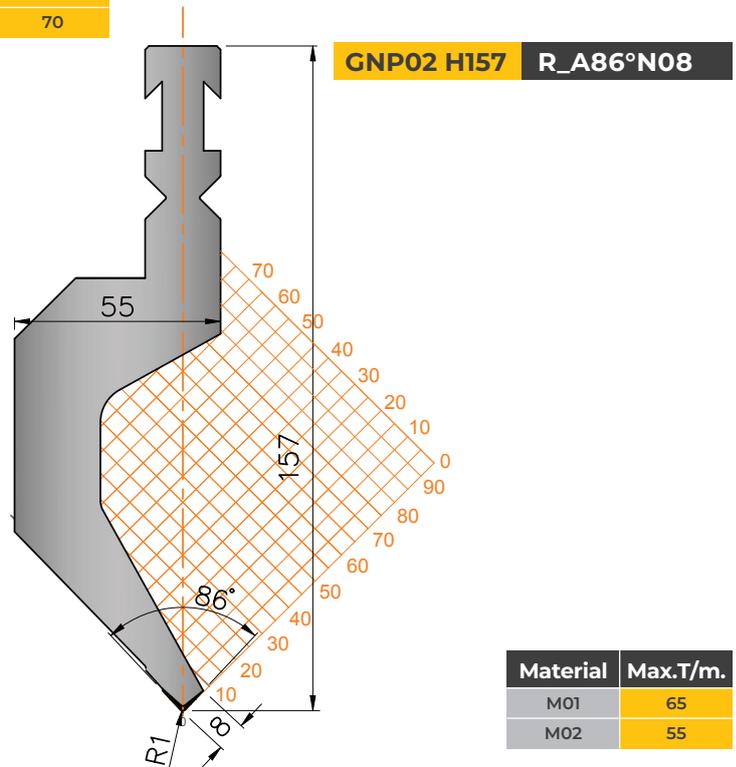
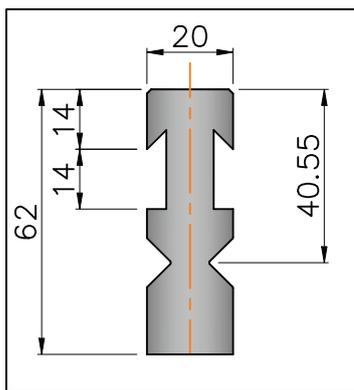


PUNCH | BYSTRONIC TYPE TOOLING

2:G:iv | GOOSE NECK PUNCH



Material	Max.T/m.
M01	80
M02	70



Material	Max.T/m.
M01	65
M02	55

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



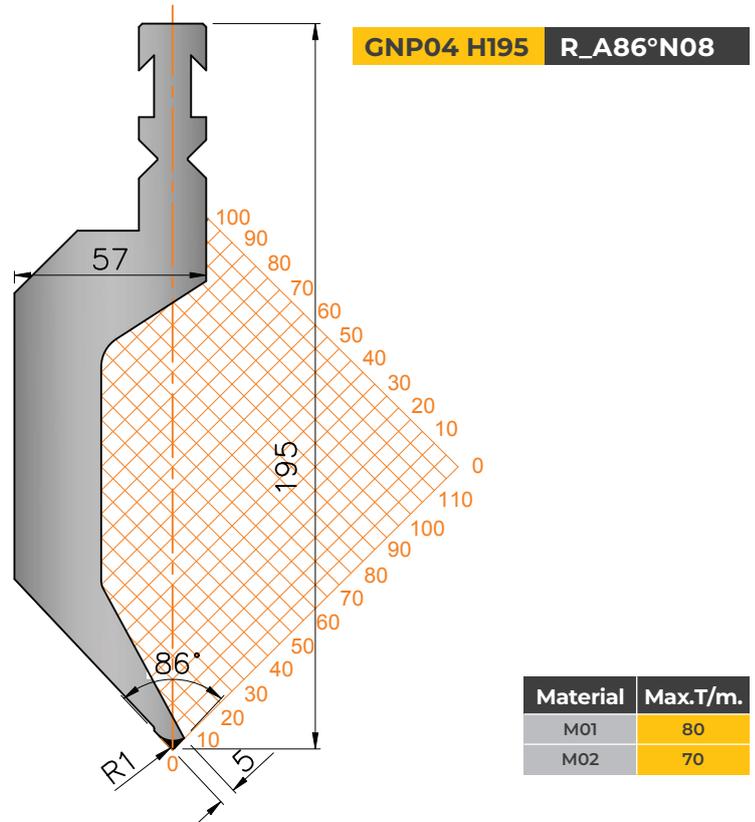
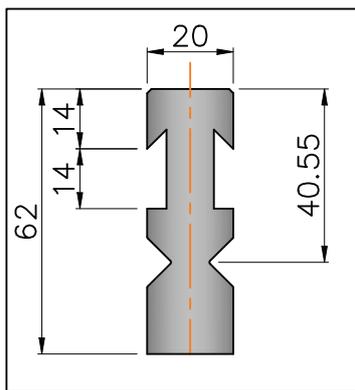
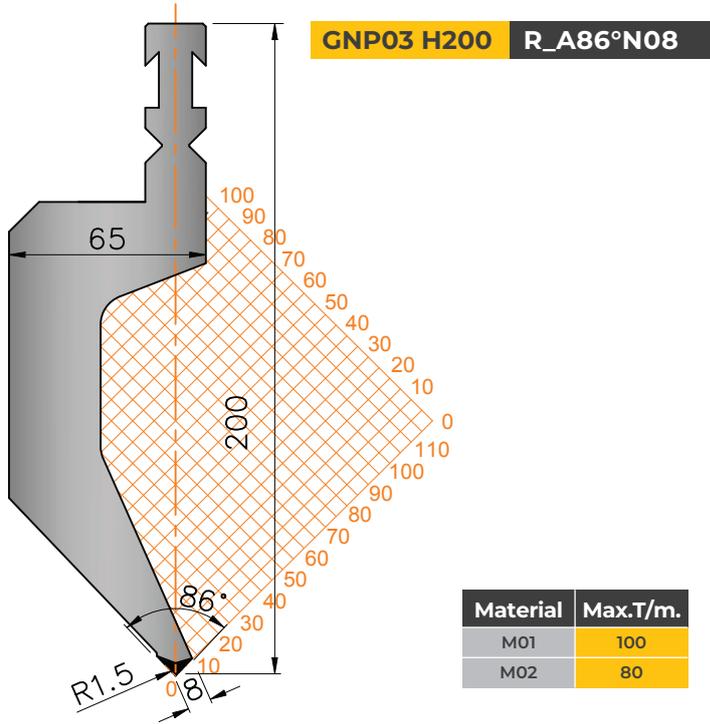
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH | BYSTRONIC TYPE TOOLING

2:G:iv | GOOSE NECK PUNCH



Material Option

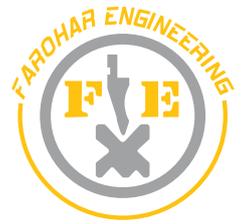
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

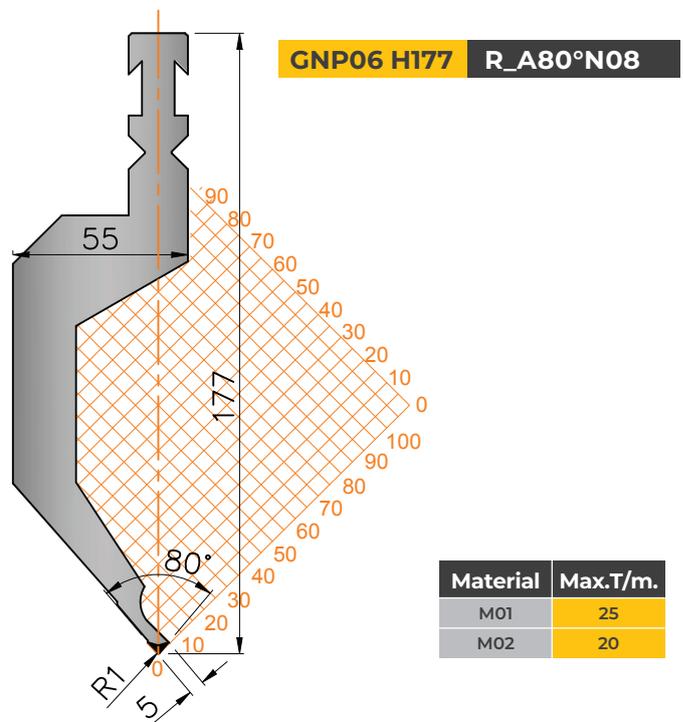
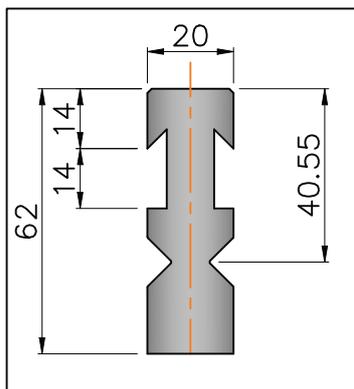
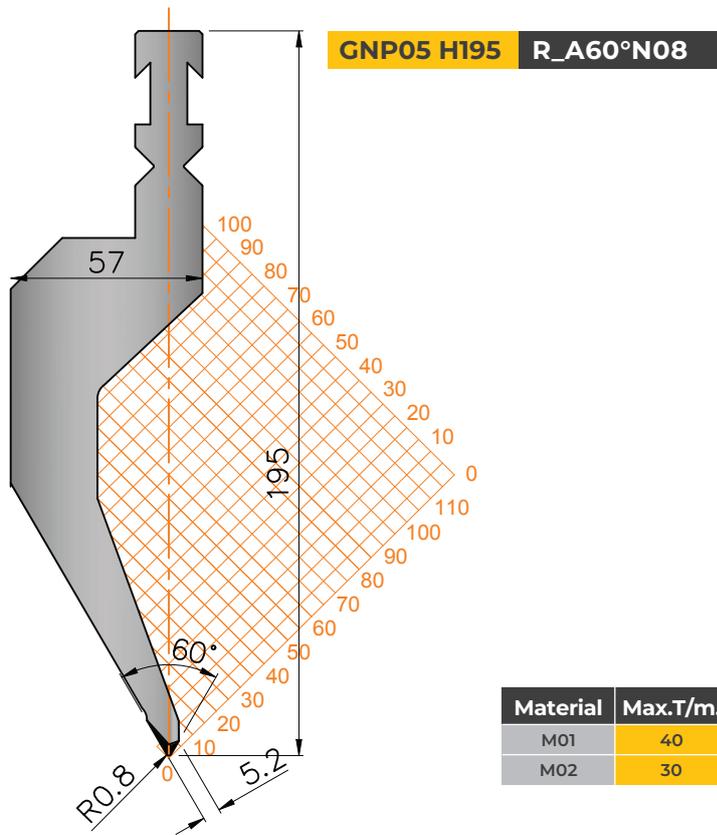
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





PUNCH | BYSTRONIC TYPE TOOLING

2:G:iv | GOOSE NECK PUNCH



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



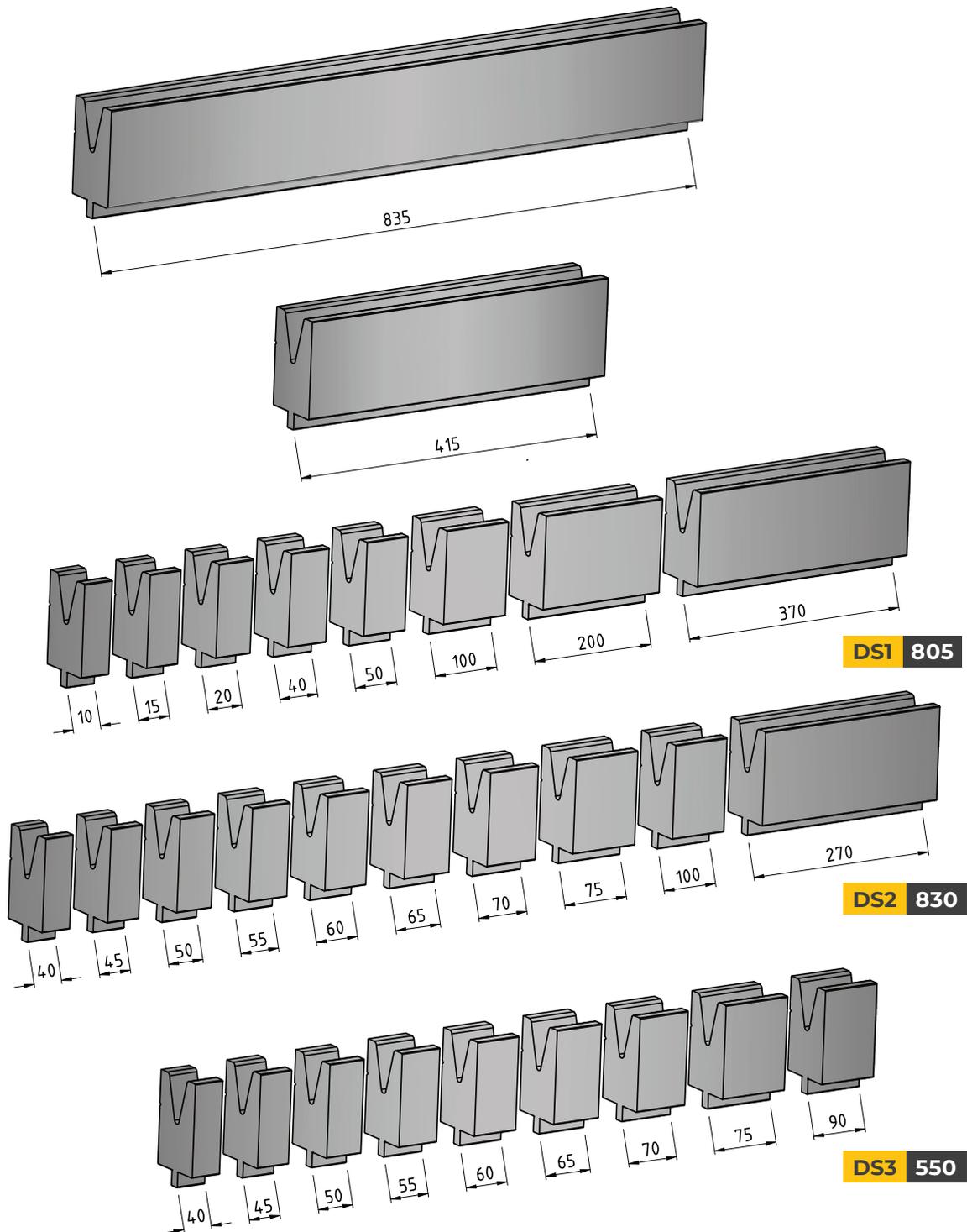
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



DIE | SINGLE VEE DIE

3:A | DIE SEGMENTS



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

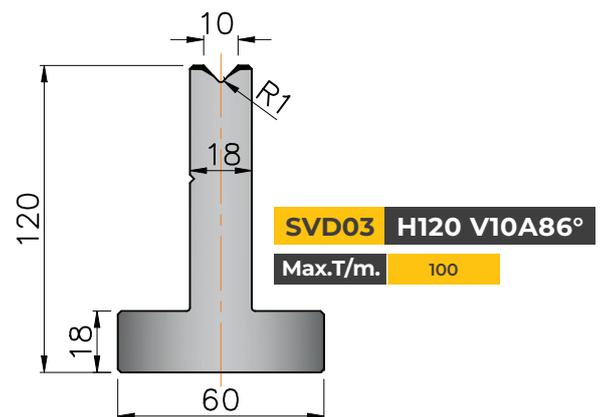
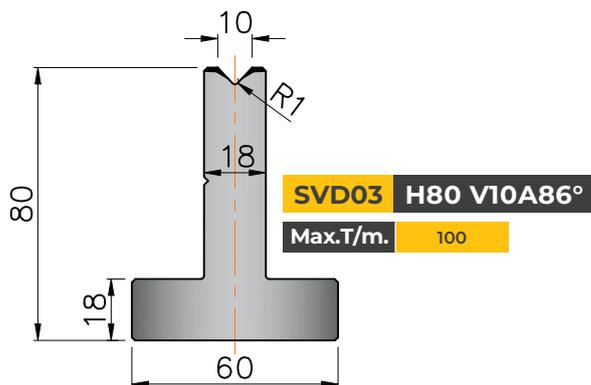
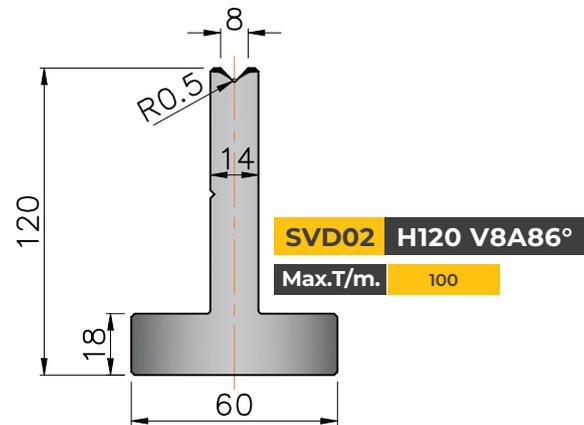
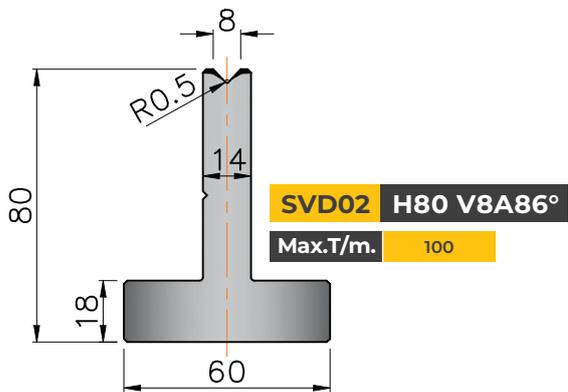
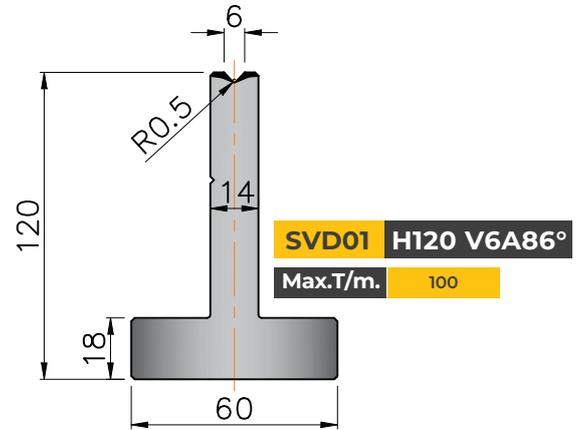
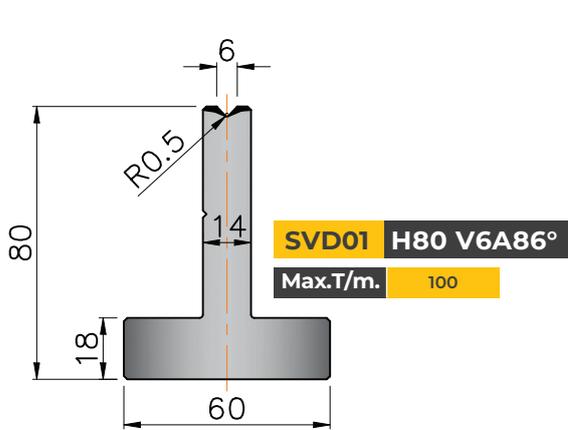
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





DIE | AMADA - TYPE SINGLE VEE DIE

3:Bi | SVD A86° V6, V8, V10



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



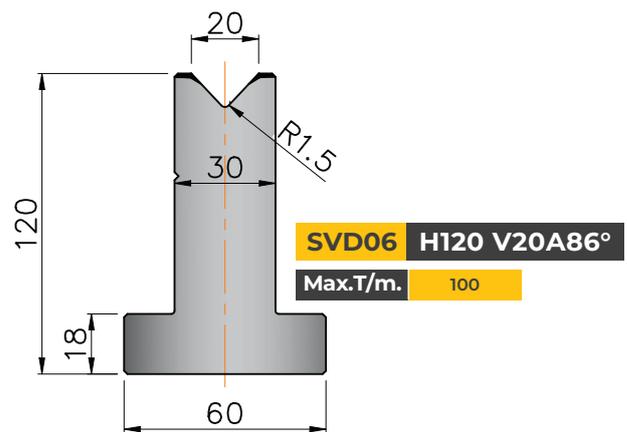
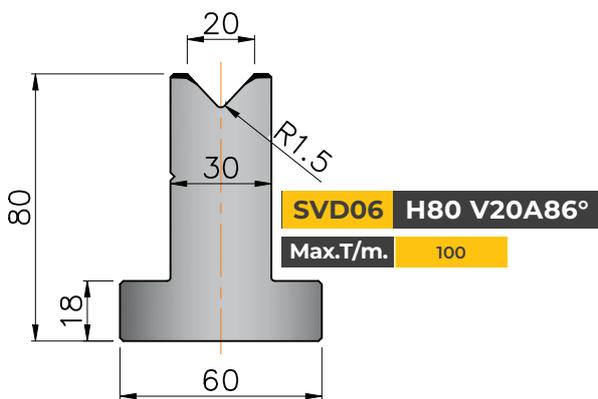
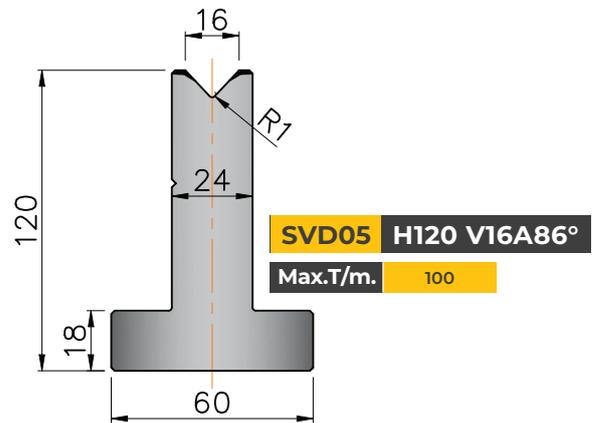
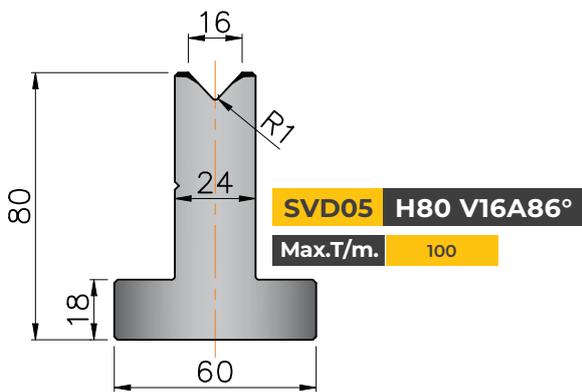
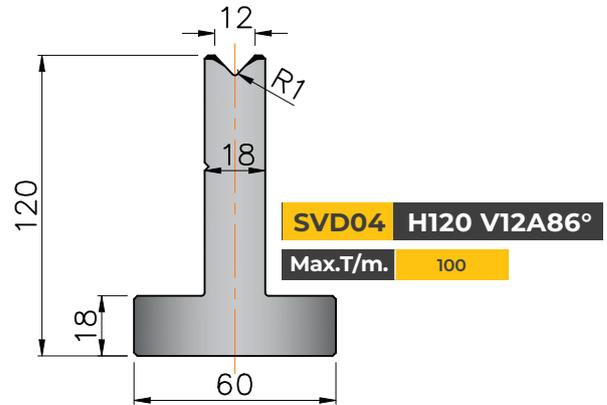
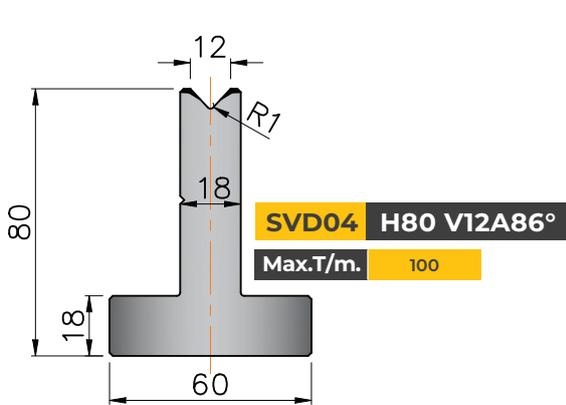
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



DIE | AMADA - TYPE SINGLE VEE DIE

3:B:ii | SVD A86° V12, V16, V20



Material Option

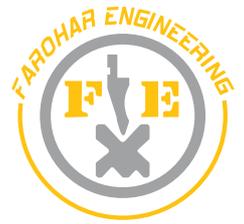
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

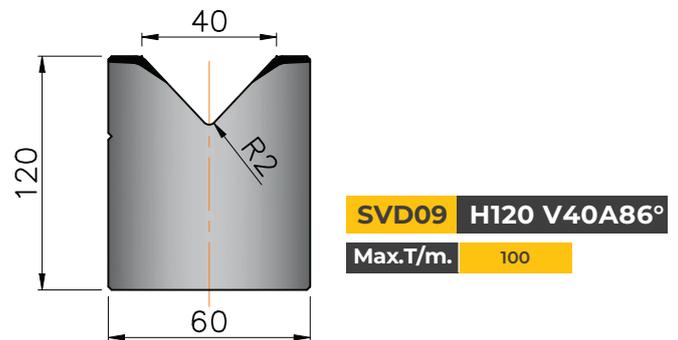
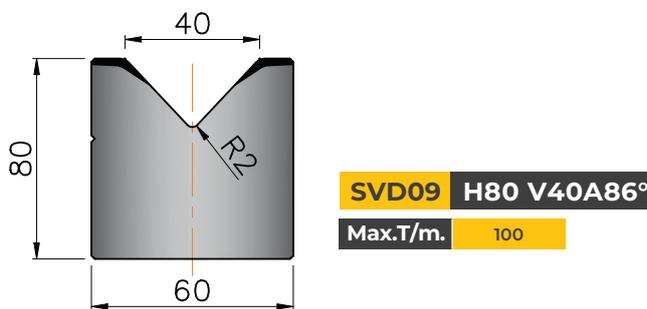
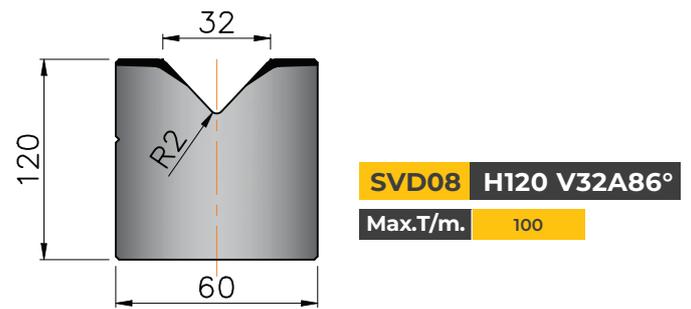
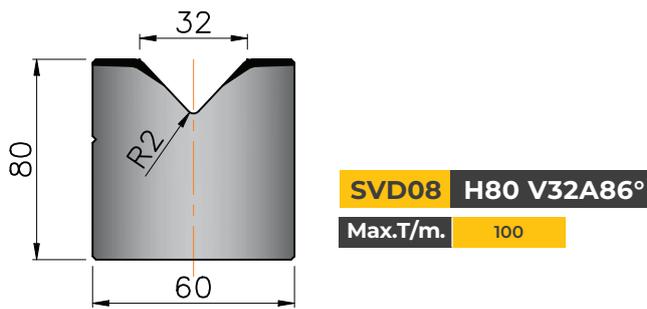
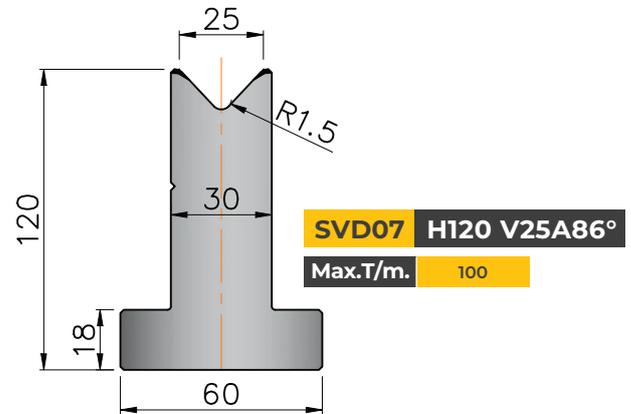
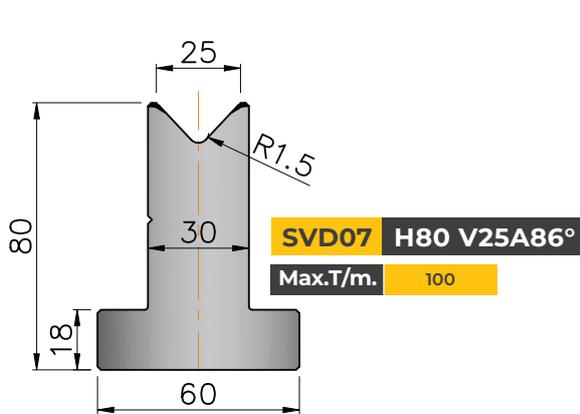
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





DIE | AMADA - TYPE SINGLE VEE DIE

3:B:iii | SVD A86° V25, V32, V40



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



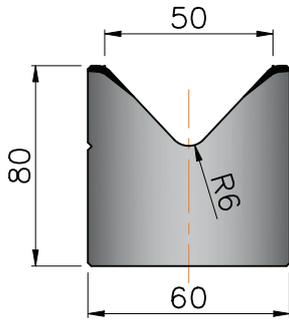
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.

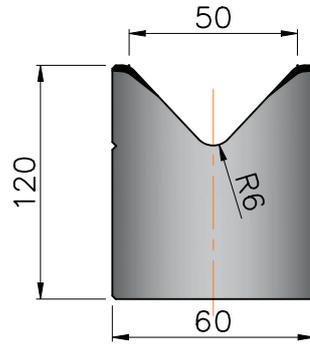


DIE | AMADA - TYPE SINGLE VEE DIE

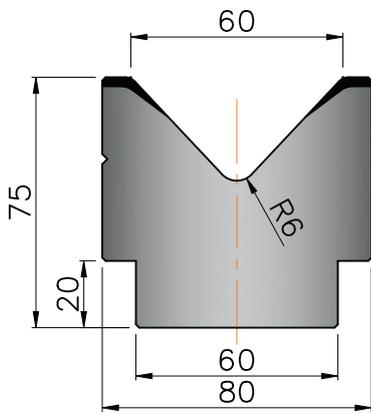
3:B:iv | SVD A86° V50, V60, V100, V125



SVD10 H80 V50A86°
Max.T/m. 100

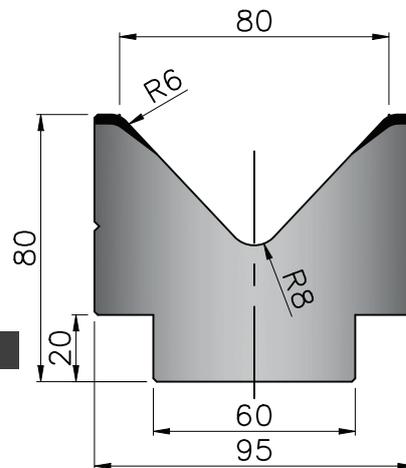


SVD10 H120 V50A86°
Max.T/m. 100



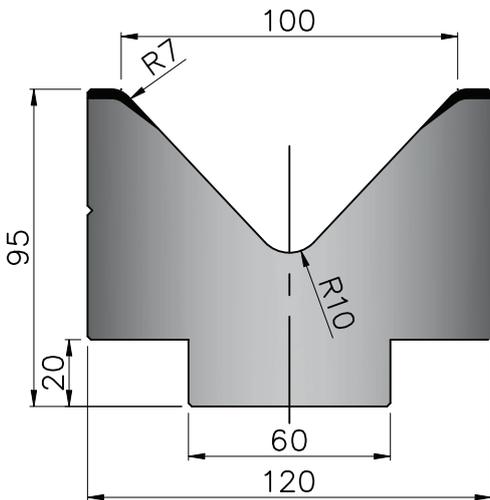
SVD11 H75 V60A86°
Max.T/m. 100

SVD-11H75V60A86°.
MAX.T/m-100.

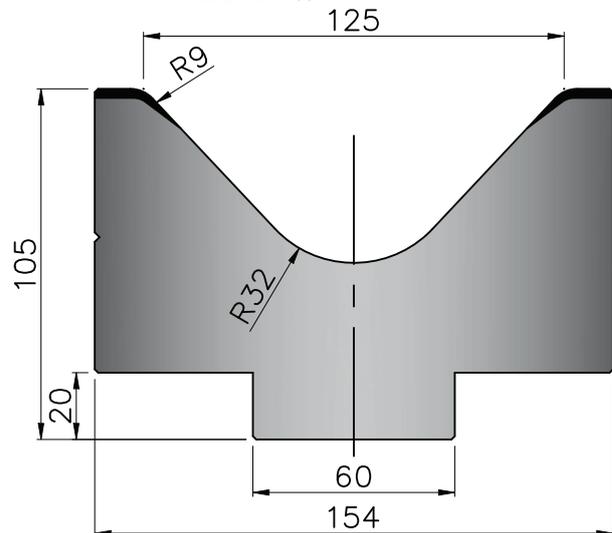


SVD12 H80 V80A86°
Max.T/m. 100

SVD-12H80V80A86°.
MAX.T/m-100.



SVD13 H95 V100A86°
Max.T/m. 120



SVD14 H105 V125A86°
Max.T/m. 120

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

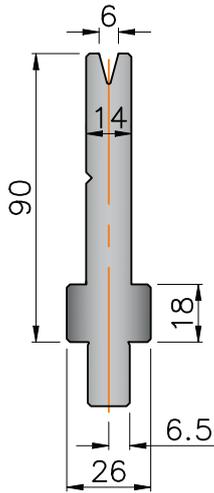
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



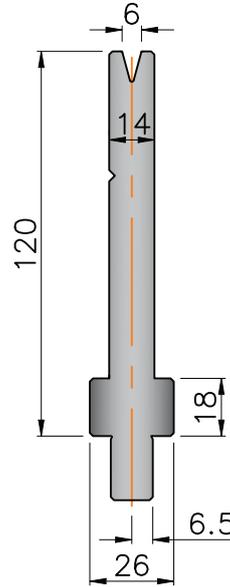


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

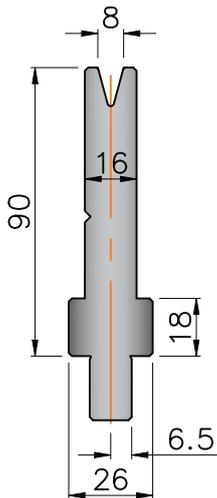
3:C:i | SVD A30° V6, V8



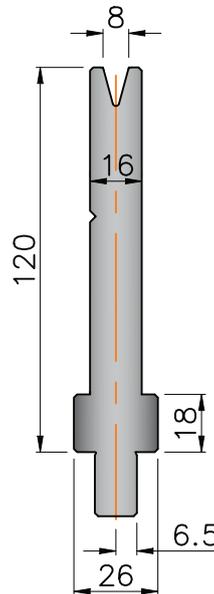
SVD01 H90 V6A30°
Max.T/m. 25



SVD01 H120 V6A30°
Max.T/m. 25



SVD02 H90 V8A30°
Max.T/m. 25



SVD02 H120 V8A30°
Max.T/m. 25

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



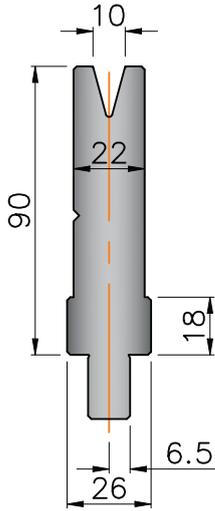
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

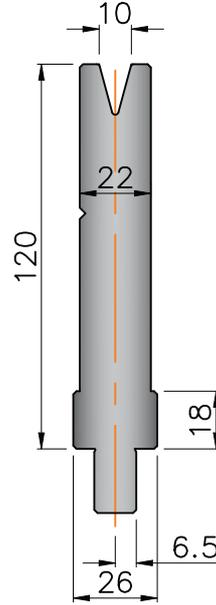


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

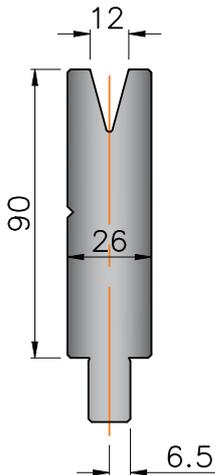
3:C:ii | SVD A30° V10, V12



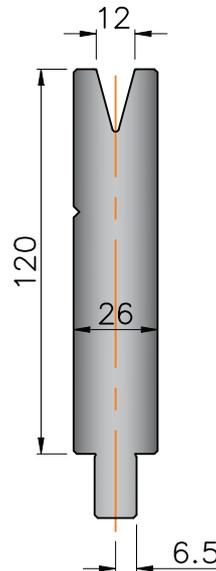
SVD03 H90 V10A30°
Max.T/m. 35



SVD03 H120 V10A30°
Max.T/m. 35



SVD04 H90 V12A30°
Max.T/m. 40



SVD04 H120 V12A30°
Max.T/m. 40

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

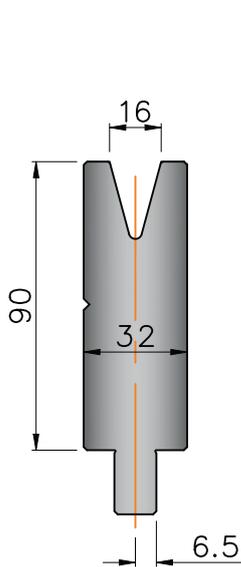
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



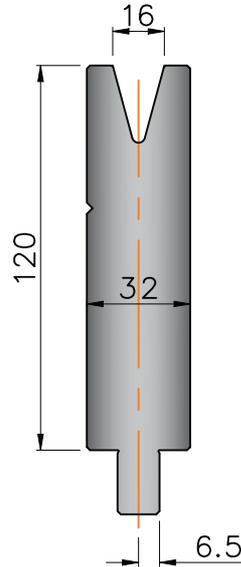


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

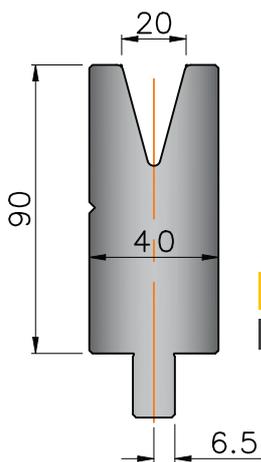
3:C:iii | SVD A30° V16, V20



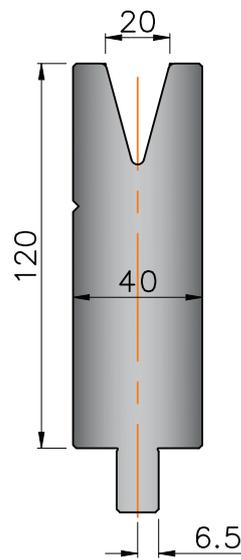
SVD05 H90 V16A30°
Max.T/m. 50



SVD05 H120 V16A30°
Max.T/m. 50



SVD06 H90 V20A30°
Max.T/m. 60



SVD06 H120 V20A30°
Max.T/m. 60

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



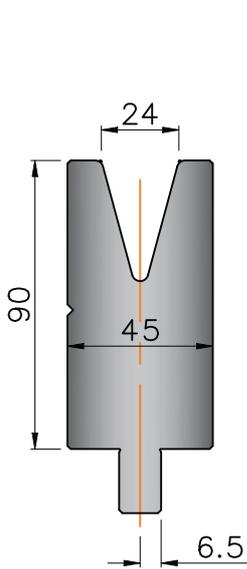
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

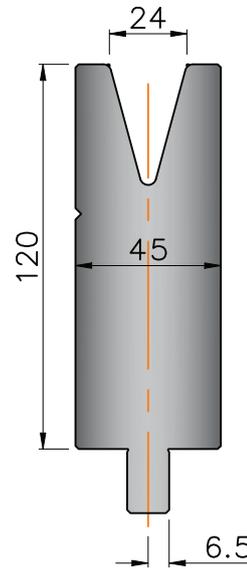


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

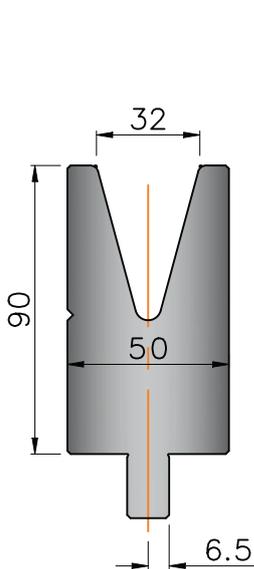
3:C:iv | SVD A30° V24, V32



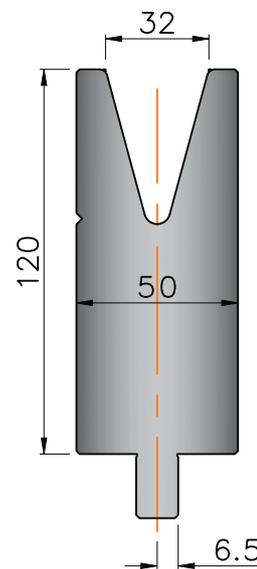
SVD07 H90 V24A30°
Max.T/m. 60



SVD07 H120 V24A30°
Max.T/m. 60



SVD08 H90 V32A30°
Max.T/m. 60



SVD08 H120 V32A30°
Max.T/m. 60

Material Option

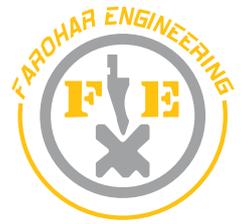
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

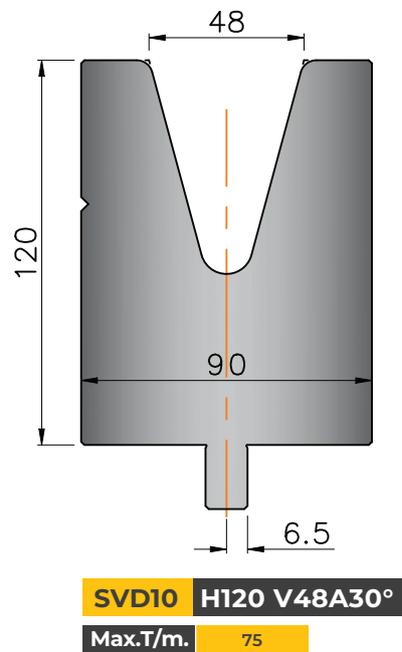
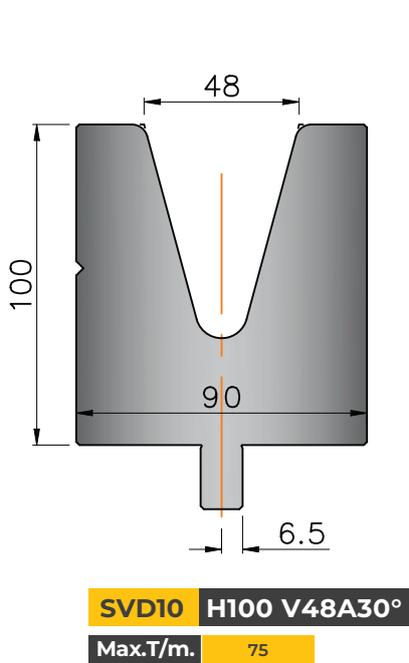
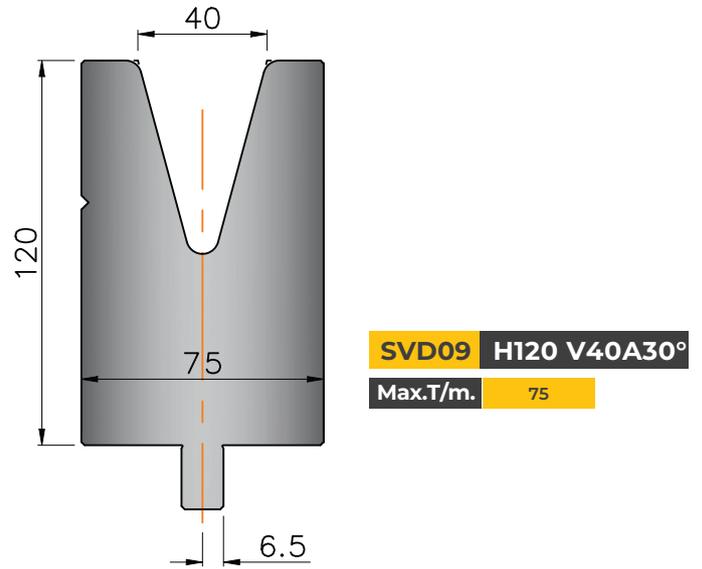
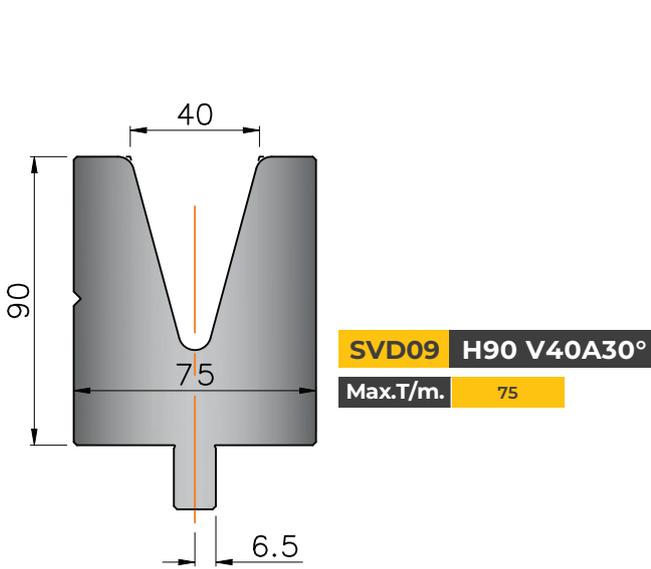
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

3:C:v | SVD A30° V40, V48



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



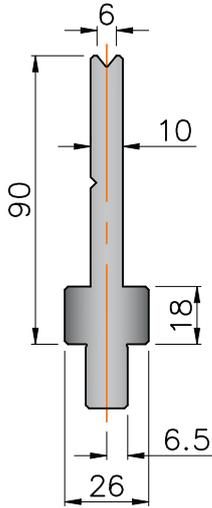
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

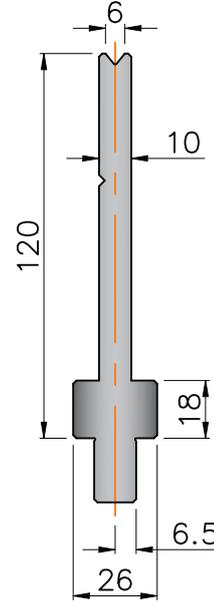


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

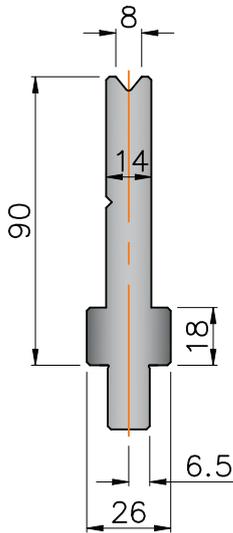
3:C:vi | SVD A78° V6, V8



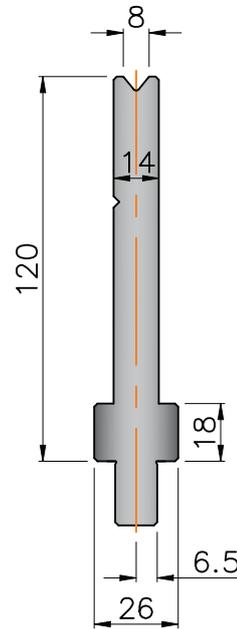
SVD11 H90 V6A78°
Max.T/m. 30



SVD11 H120 V6A78°
Max.T/m. 30



SVD12 H90 V8A78°
Max.T/m. 30



SVD12 H120 V8A78°
Max.T/m. 30

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

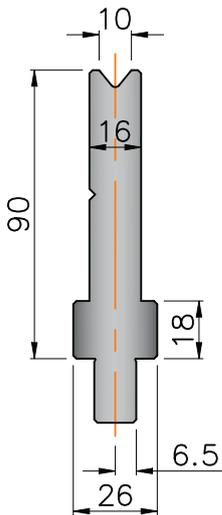
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



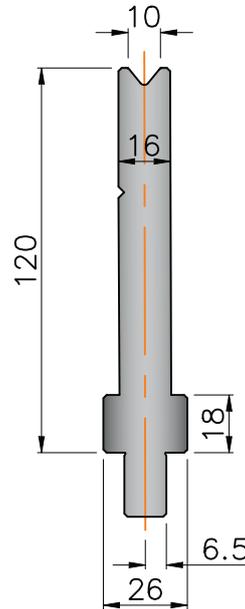


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

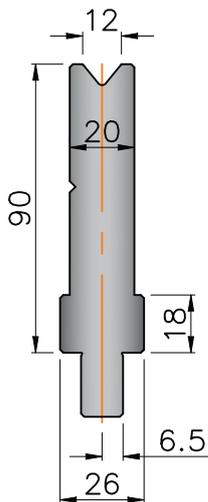
3:C:vii | SVD A78° V10, V12



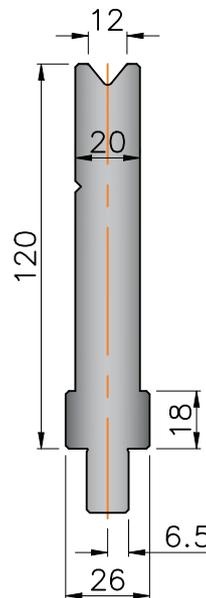
SVD13 H90 V10A78°
Max.T/m. 40



SVD13 H120 V10A78°
Max.T/m. 40



SVD14 H90 V12A78°
Max.T/m. 40



SVD14 H120 V12A78°
Max.T/m. 40

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



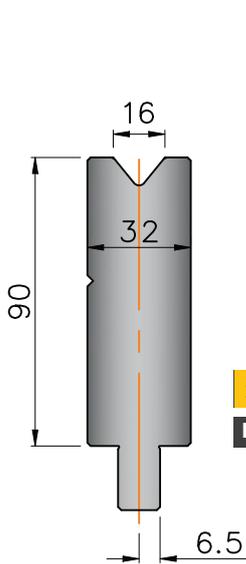
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

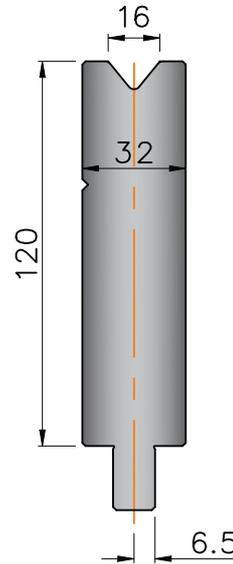


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

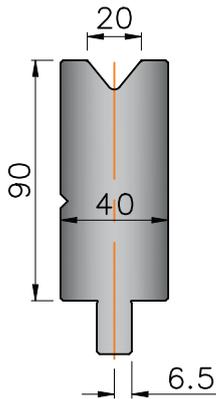
3:C:viii | SVD A78° V16, V20



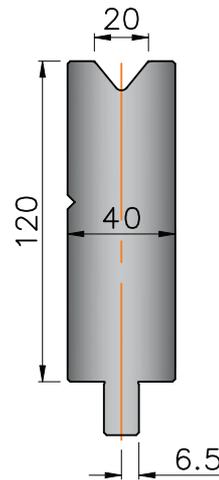
SVD15 H90 V16A78°
Max.T/m. 50



SVD15 H120 V16A78°
Max.T/m. 50



SVD16 H90 V20A78°
Max.T/m. 60



SVD16 H120 V20A78°
Max.T/m. 60

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

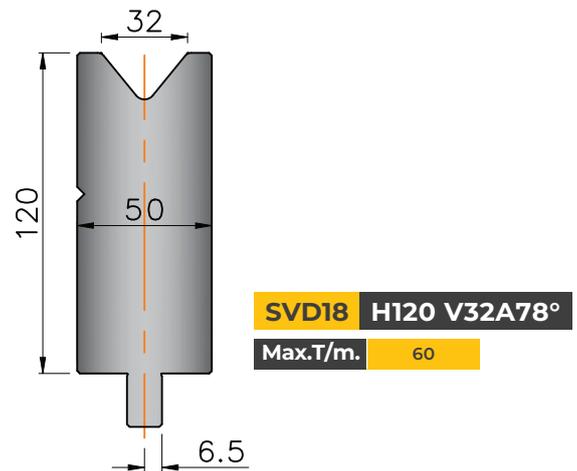
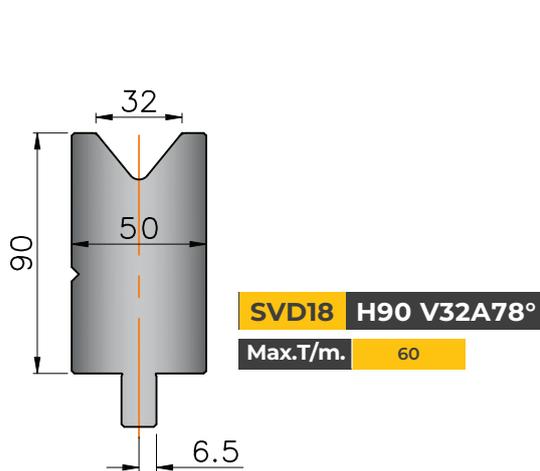
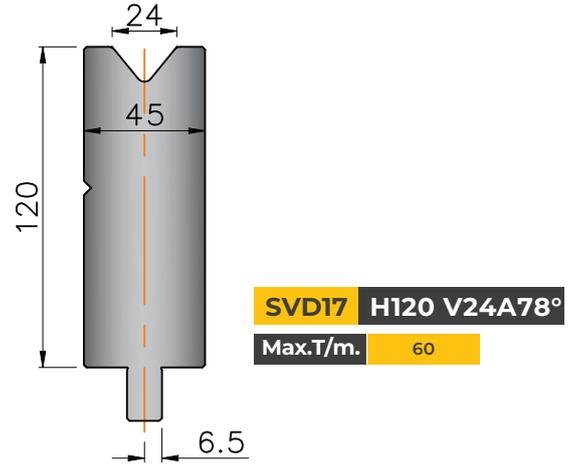
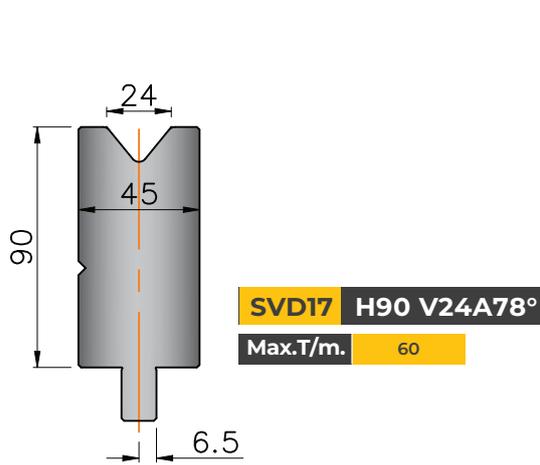
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

3:C:iX | SVD A78° V24, V32



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



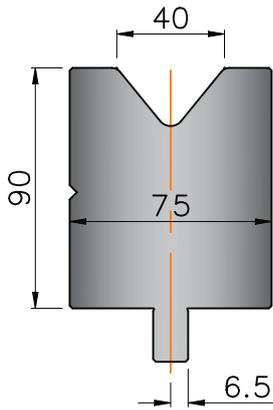
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

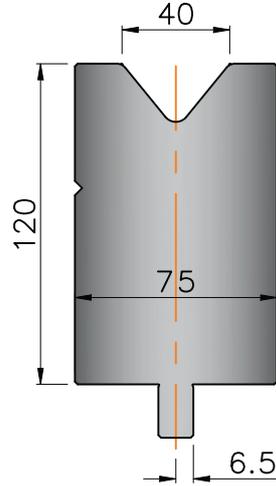


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

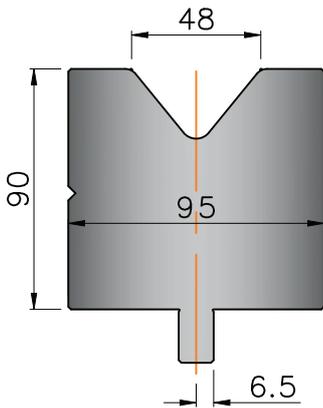
3:C:x | SVD A78° V40, V48



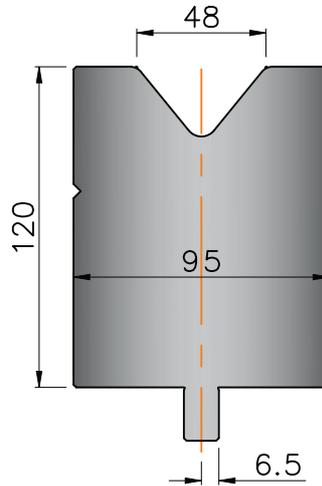
SVD19 H90 V40A78°
Max.T/m. 60



SVD19 H120 V40A78°
Max.T/m. 60



SVD20 H90 V48A78°
Max.T/m. 80



SVD20 H120 V48A78°
Max.T/m. 80

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

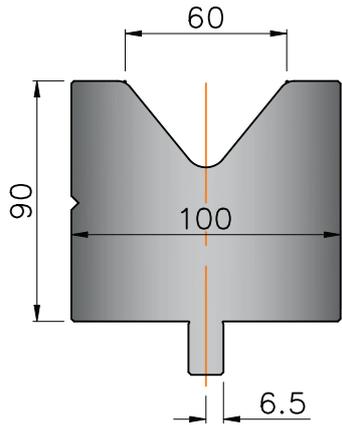
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



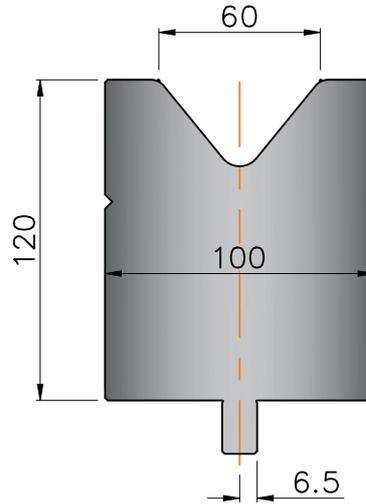


DIE | TRUMPF / WILA - TYPE SINGLE VEE DIE

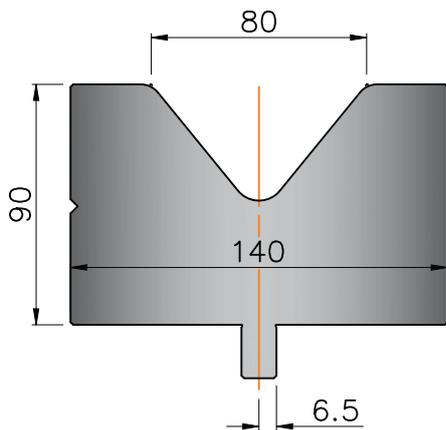
3:C:xi | SVD A78° V60, V80



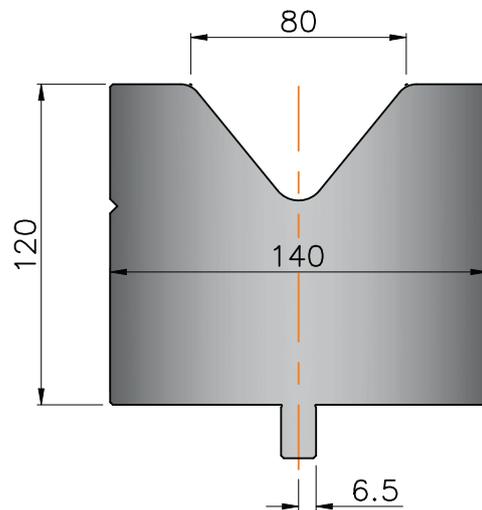
SVD21 H90 V60A78°
Max.T/m. 100



SVD21 H120 V60A78°
Max.T/m. 100



SVD22 H90 V80A78°
Max.T/m. 100



SVD22 H120 V80A78°
Max.T/m. 100

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



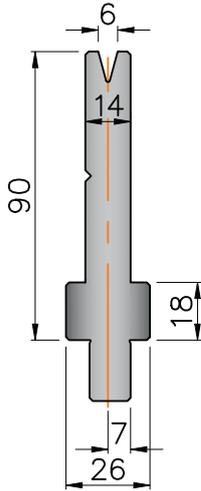
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

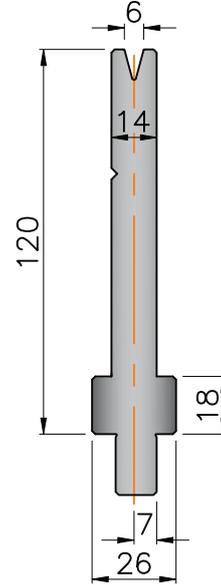


DIE | LVD - TYPE SINGLE VEE DIE

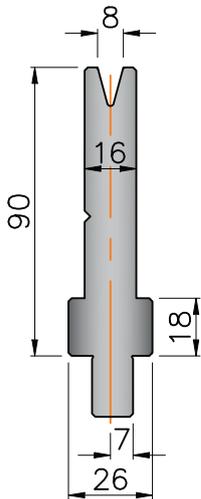
3:D:i | SVD A30° V6, V8



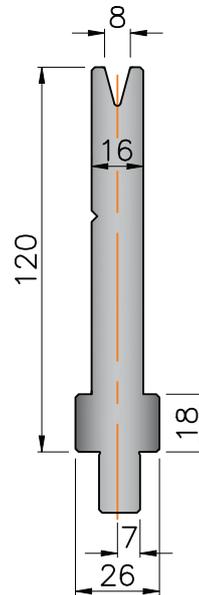
SVD01 H90 V6A30°
Max.T/m. 25



SVD01 H120 V6A30°
Max.T/m. 25



SVD02 H90 V8A30°
Max.T/m. 25



SVD02 H120 V8A30°
Max.T/m. 25

Material Option

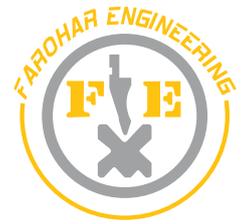
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

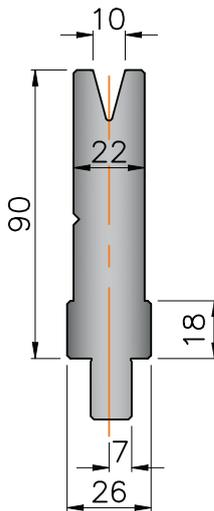
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



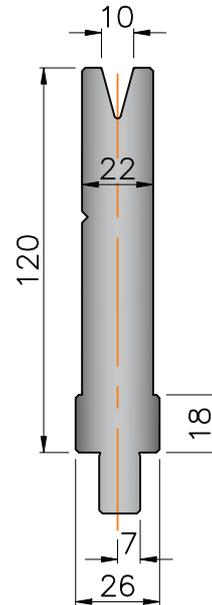


DIE | LVD - TYPE SINGLE VEE DIE

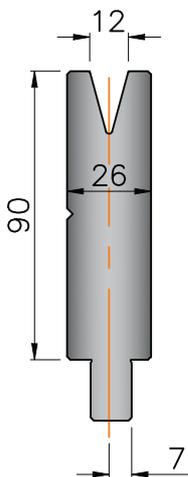
3:D:ii | SVD A30° V10, V12



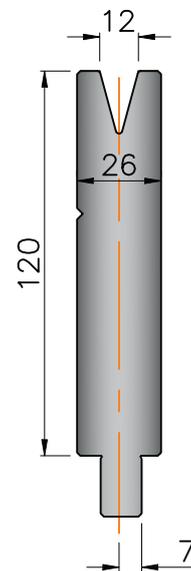
SVD03 H90 V10A30°
Max.T/m. 35



SVD03 H120 V10A30°
Max.T/m. 35



SVD04 H90 V12A30°
Max.T/m. 40



SVD04 H120 V12A30°
Max.T/m. 40

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



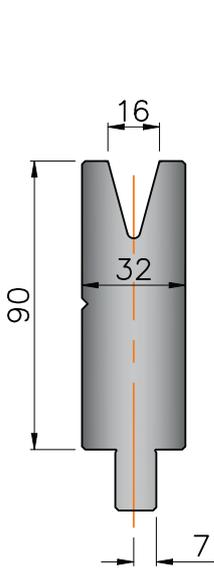
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.

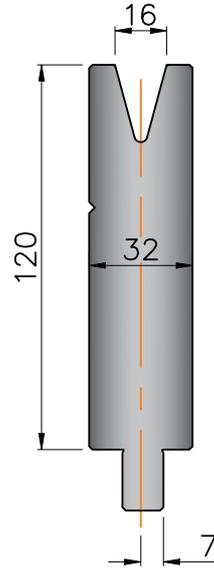


DIE | LVD - TYPE SINGLE VEE DIE

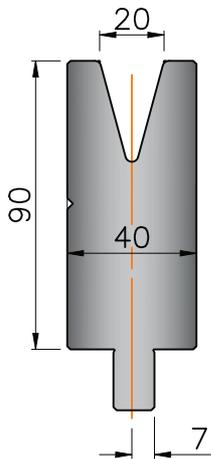
3:D:iii | SVD A30° V16, V20



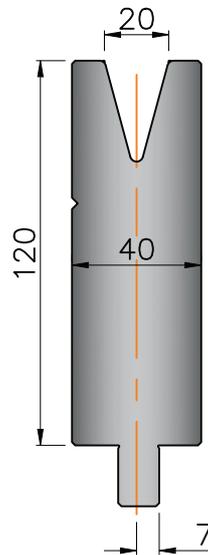
SVD05 H90 V16A30°
Max.T/m. 50



SVD05 H120 V16A30°
Max.T/m. 50



SVD06 H90 V20A30°
Max.T/m. 60



SVD06 H120 V20A30°
Max.T/m. 60

Material Option

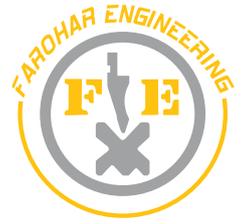
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

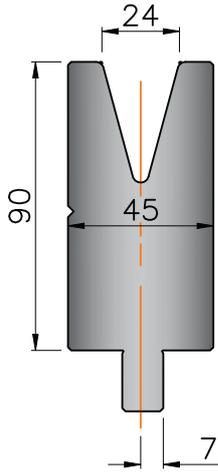
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



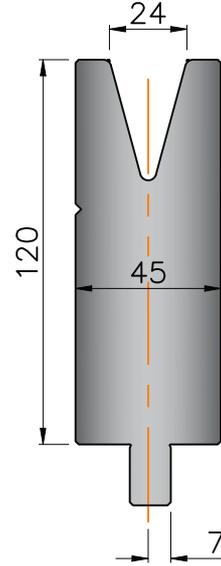


DIE | LVD - TYPE SINGLE VEE DIE

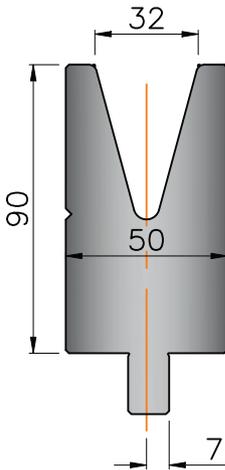
3:D:iV | SVD A30° V24, V32



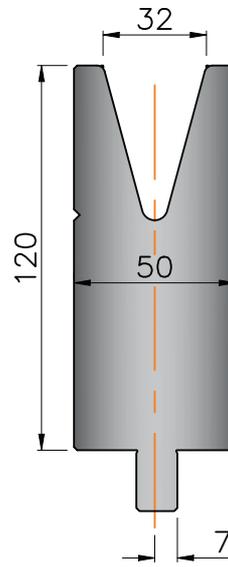
SVD07 H90 V24A30°
Max.T/m. 60



SVD07 H120 V24A30°
Max.T/m. 60



SVD08 H90 V32A30°
Max.T/m. 60



SVD08 H120 V32A30°
Max.T/m. 60

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



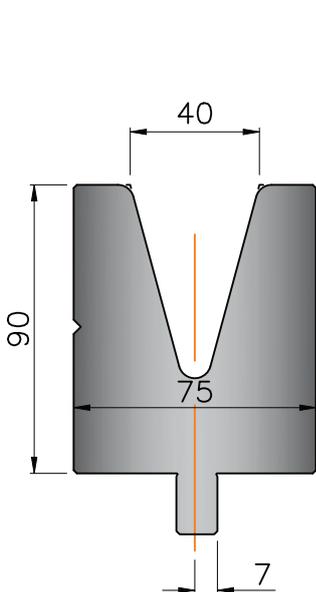
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

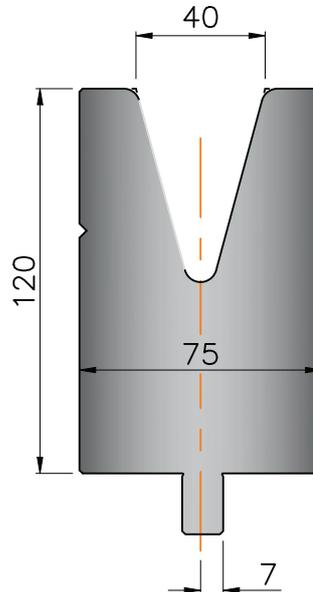


DIE | LVD - TYPE SINGLE VEE DIE

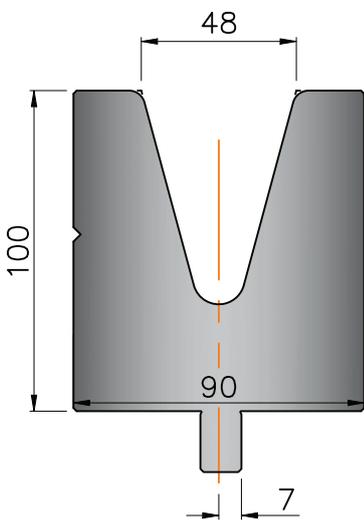
3:D:v | SVD A30° V40, V48



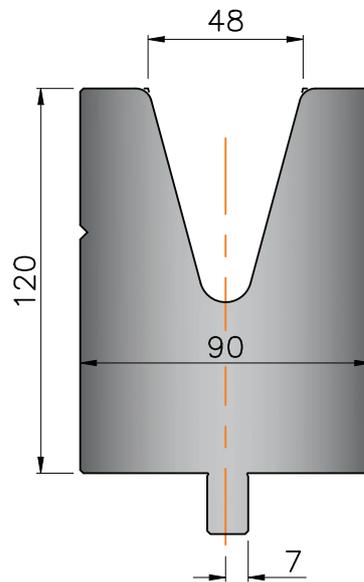
SVD09 H90 V40A30°
Max.T/m. 75



SVD09 H120 V40A30°
Max.T/m. 75



SVD10 H90 V48A30°
Max.T/m. 75



SVD10 H120 V48A30°
Max.T/m. 75

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

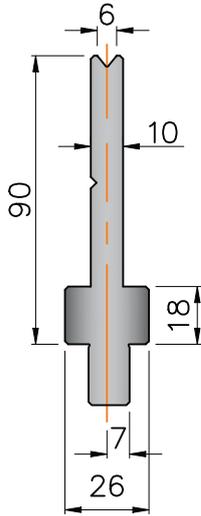
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



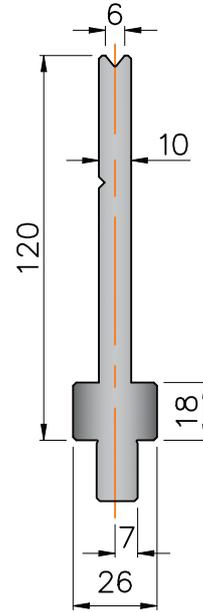


DIE | LVD - TYPE SINGLE VEE DIE

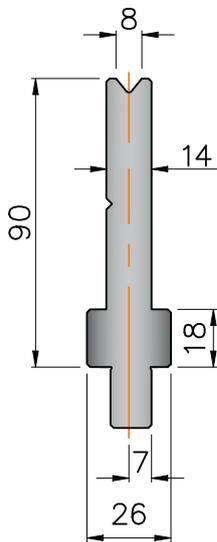
3:D:vi | SVD A78° V6, V8



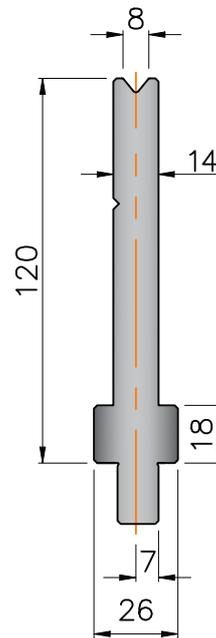
SVD11 H90 V6A78°
Max.T/m. 30



SVD11 H120 V6A78°
Max.T/m. 30



SVD12 H90 V8A78°
Max.T/m. 30



SVD12 H120 V8A78°
Max.T/m. 30

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



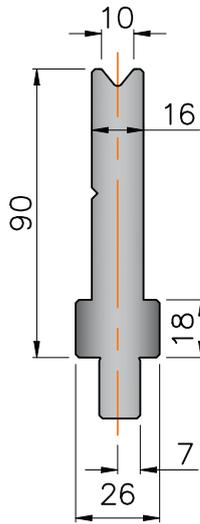
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

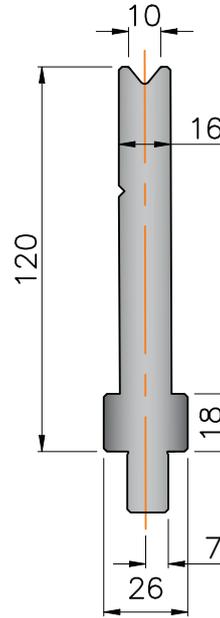


DIE | LVD - TYPE SINGLE VEE DIE

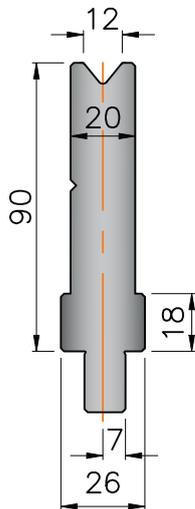
3:D:vii | SVD A78° V10, V12



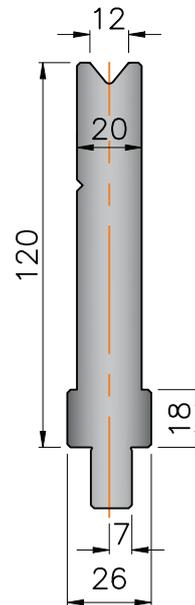
SVD13 H90 V10A78°
Max.T/m. 40



SVD13 H120 V10A78°
Max.T/m. 40



SVD14 H90 V12A78°
Max.T/m. 40



SVD14 H120 V12A78°
Max.T/m. 40

Material Option

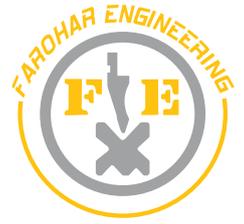
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

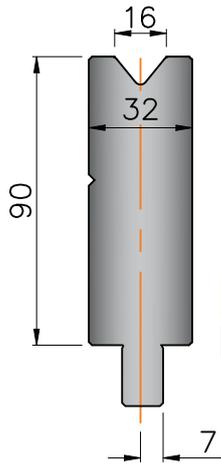
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



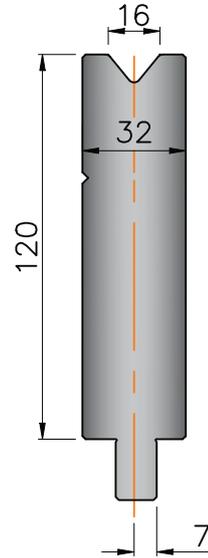


DIE | LVD - TYPE SINGLE VEE DIE

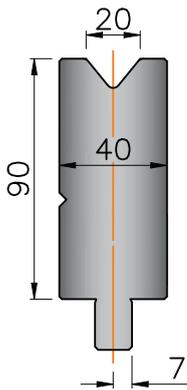
3:D:viii | SVD A78° V16, V20



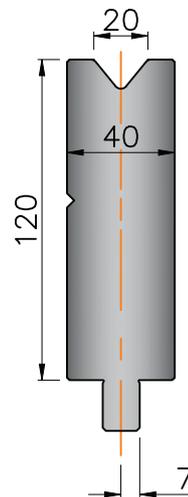
SVD15 H90 V16A78°
Max.T/m. 50



SVD15 H120 V16A78°
Max.T/m. 50



SVD16 H90 V20A78°
Max.T/m. 60



SVD16 H120 V20A78°
Max.T/m. 60

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



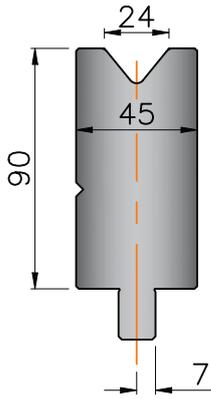
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

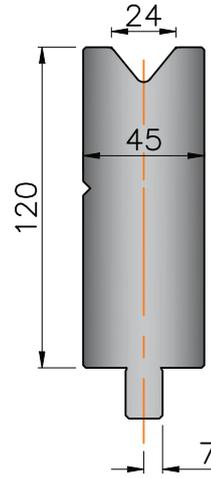


DIE | LVD - TYPE SINGLE VEE DIE

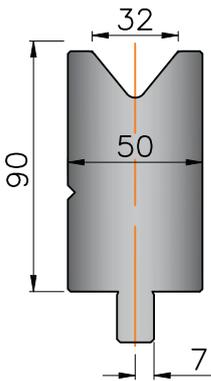
3:D:ix | SVD A78° V24, V32



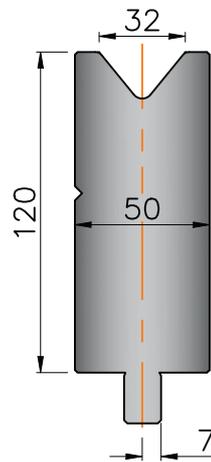
SVD17 H90 V24A78°
Max.T/m. 60



SVD17 H120 V24A78°
Max.T/m. 60



SVD18 H90 V32A78°
Max.T/m. 60



SVD18 H120 V32A78°
Max.T/m. 60

Material Option

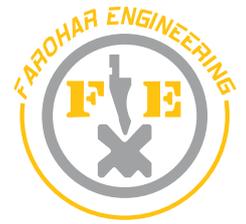
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

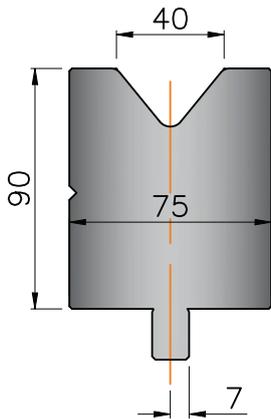
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





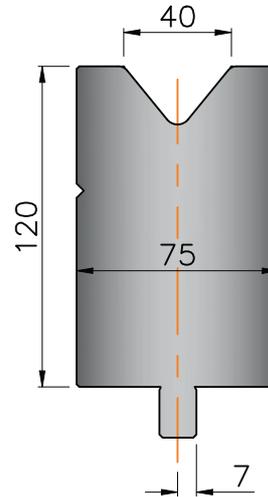
DIE | LVD - TYPE SINGLE VEE DIE

3:D:x | SVD A78° V40, V48



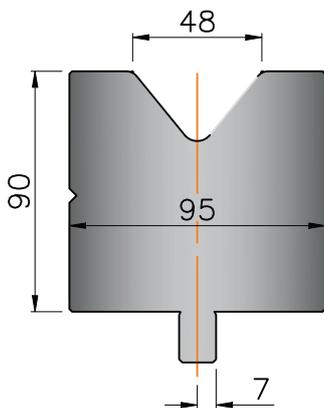
SVD18 H90 V40A78°

Max.T/m. 60



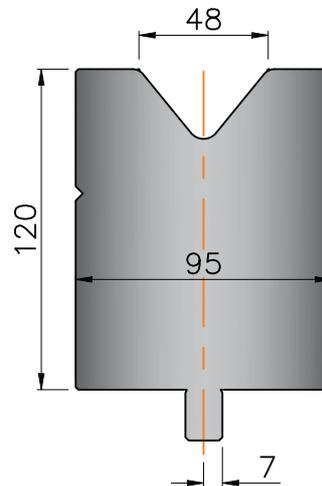
SVD18 H120 V40A78°

Max.T/m. 60



SVD20 H90 V48A78°

Max.T/m. 80



SVD20 H120 V48A78°

Max.T/m. 80

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



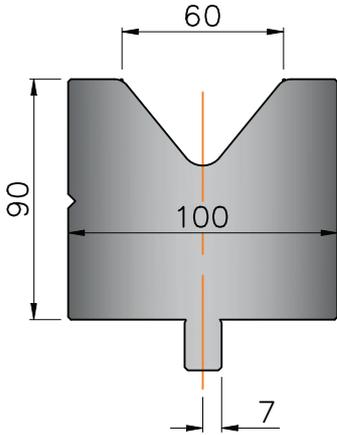
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



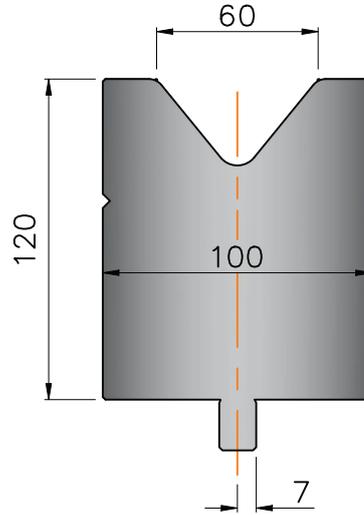
DIE | LVD - TYPE SINGLE VEE DIE

3:D:xi | SVD A78° V60, V80



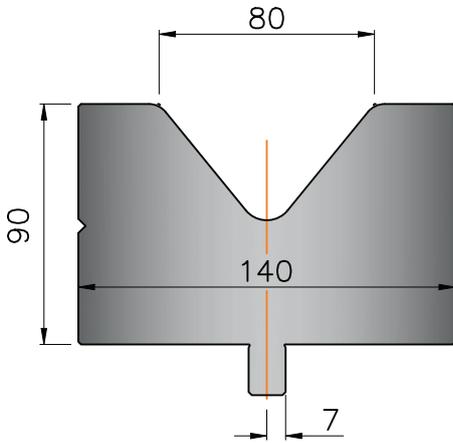
SVD21 H90 V60A78°

Max.T/m. 100



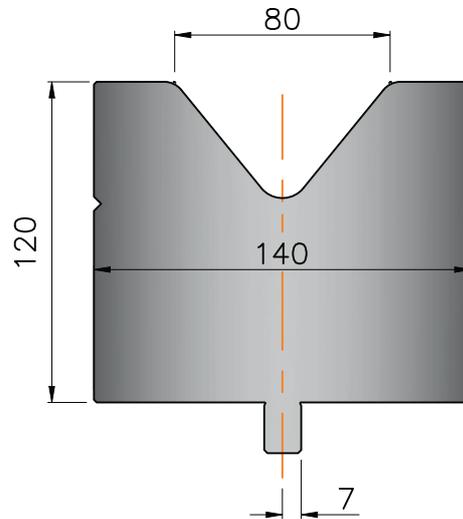
SVD21 H120 V60A78°

Max.T/m. 100



SVD22 H90 V80A78°

Max.T/m. 100



SVD22 H120 V80A78°

Max.T/m. 100

Material Option

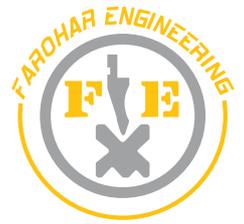
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

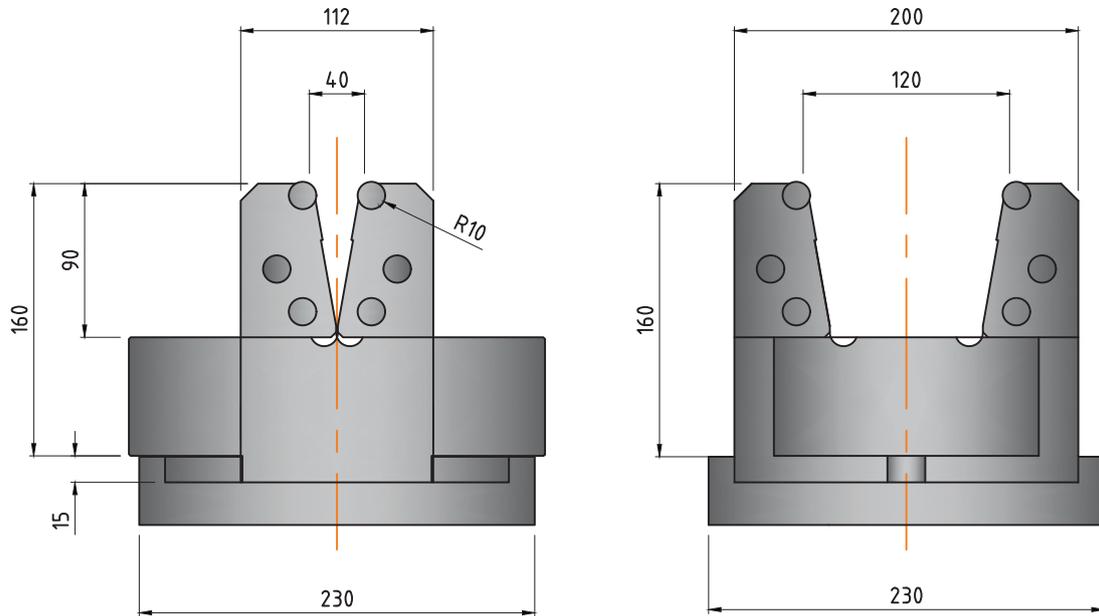
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



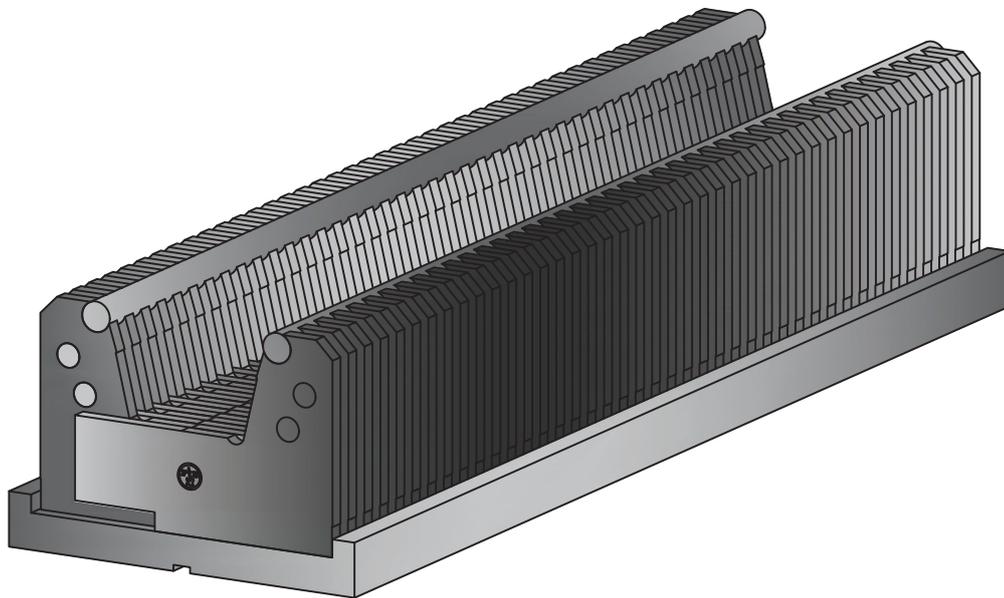


DIE | LVD - TYPE SINGLE VEE DIE

3:E:i | ADAPTIVE VEE DIE-1



Range from 40 to 120



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



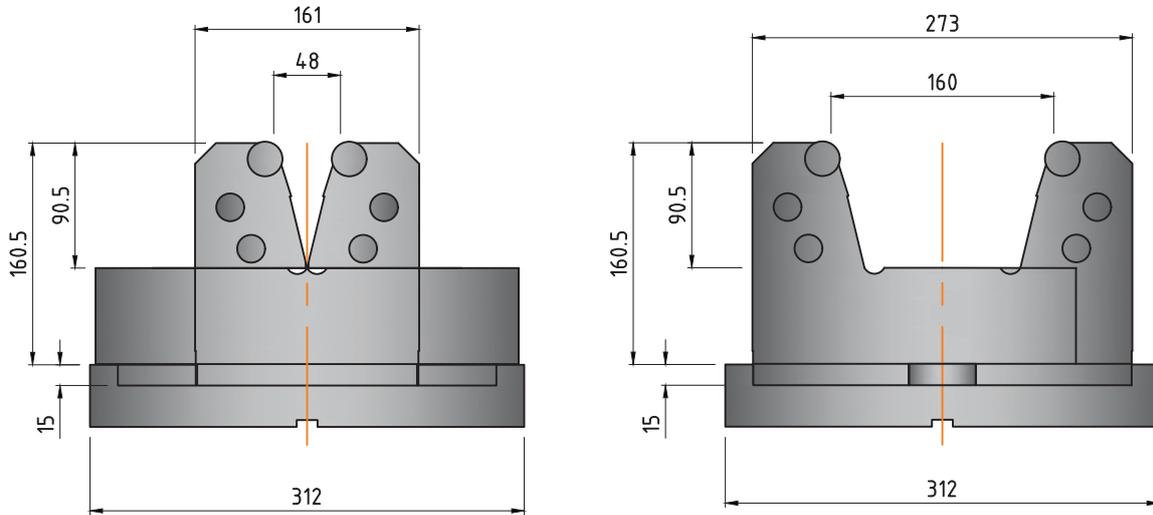
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

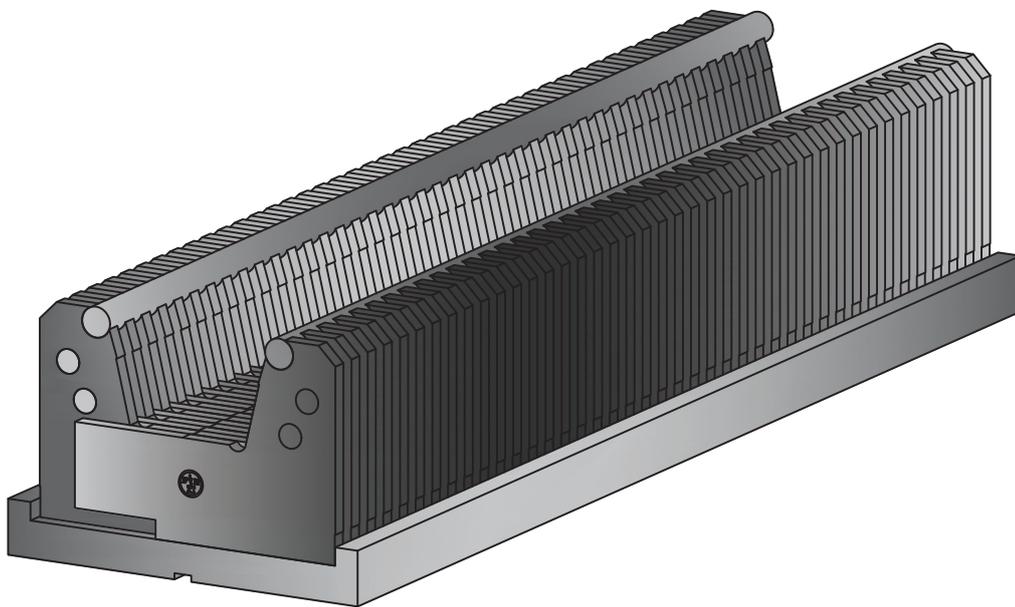


DIE | LVD - TYPE SINGLE VEE DIE

3:E:ii | ADAPTIVE VEE DIE-2



Range from 48 to 160



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

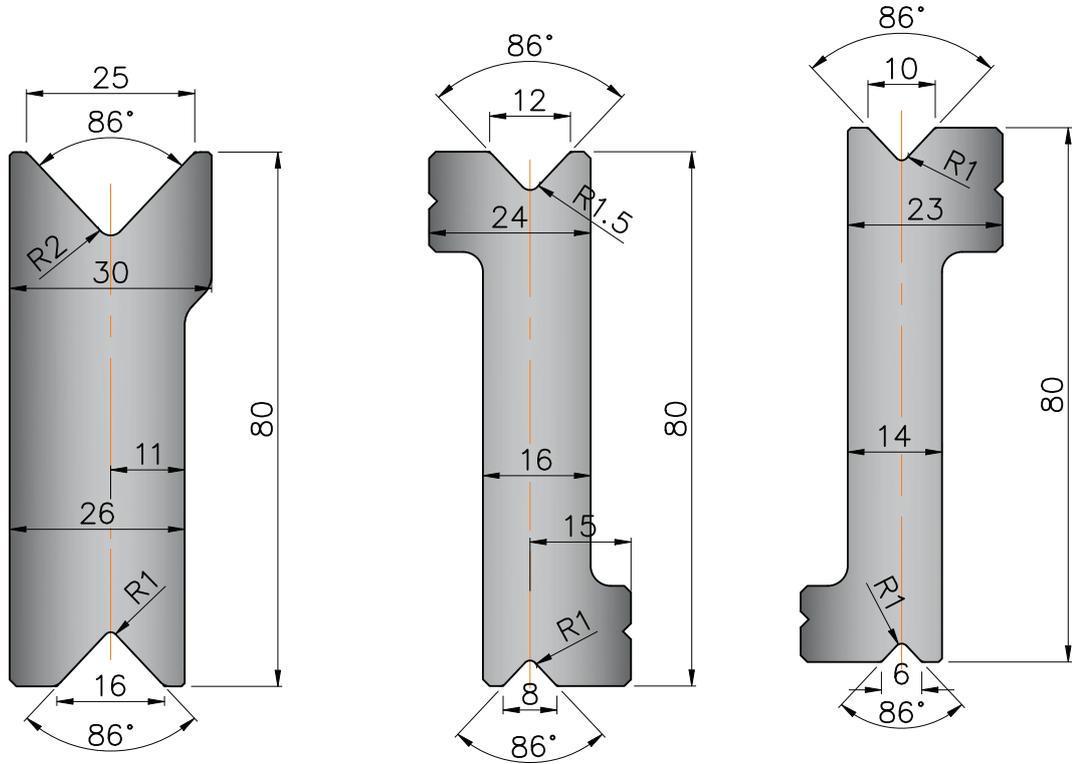
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





DIE | SELF CENTERING 2 VEE DIE

3:F:i | F.E. I-Type 2 VEE DIE



I2V 01H80V16 25A86°

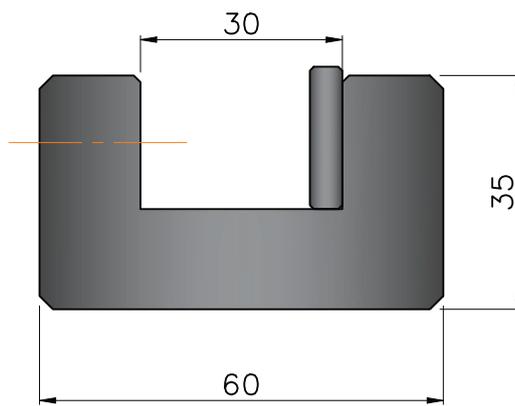
Max.T/m. 60

I2V 02H80V8 16A86°

Max.T/m. 60

I2V 03H80V6 10A86°

Max.T/m. 60



C Type Base for I Type 2 Vee Die

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



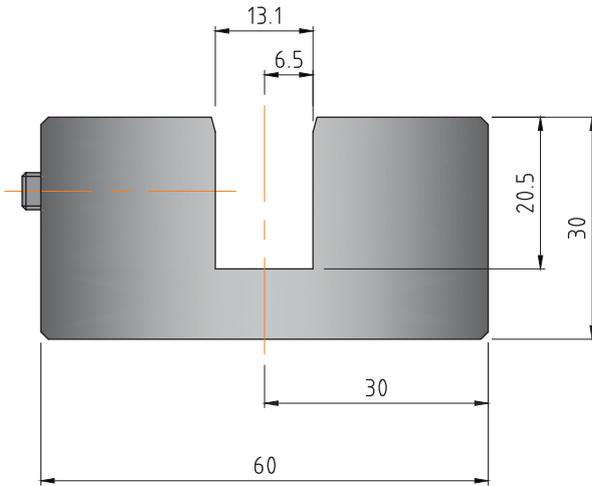
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



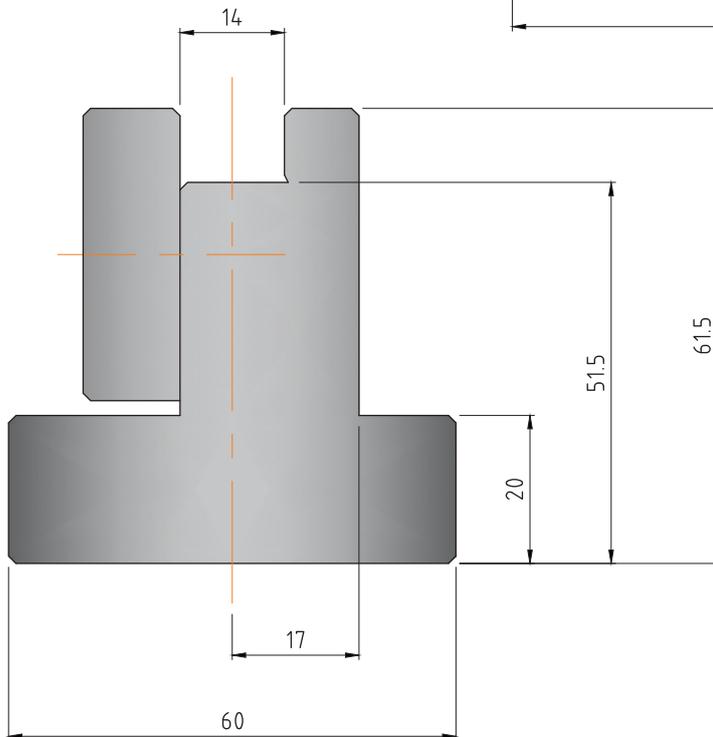
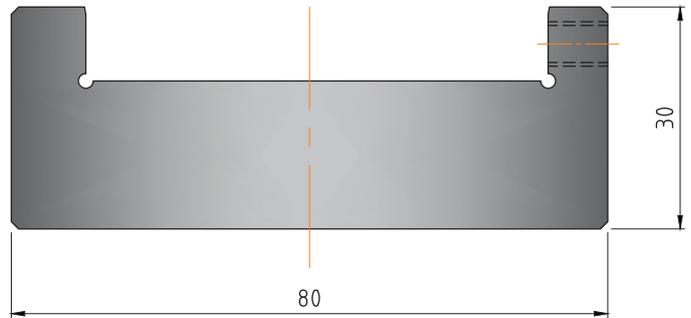
DIE | SELF CENTERING 2 VEE DIE

3:F:ii | F.E. DIE HOLDER



C-type Base for I- type Die

C-Type Die Base



Standard Die Holder For SVD

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

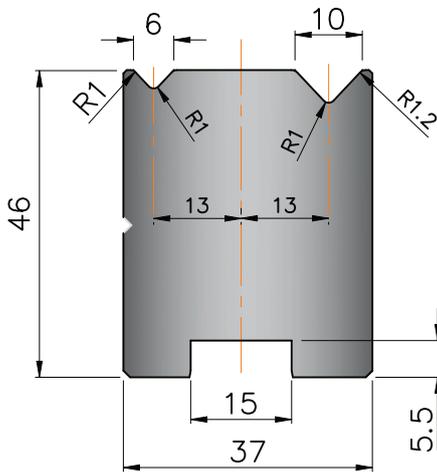
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





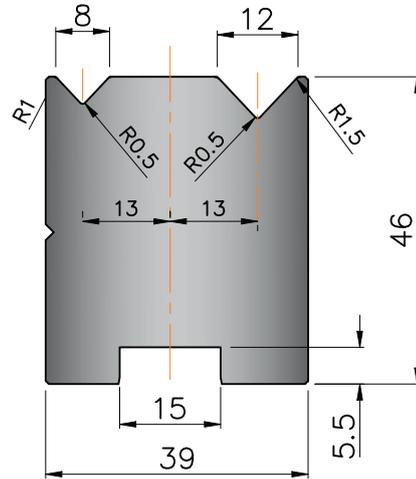
DIE | SELF CENTERING 2 VEE DIE

3:G:i | SC2VD A86°



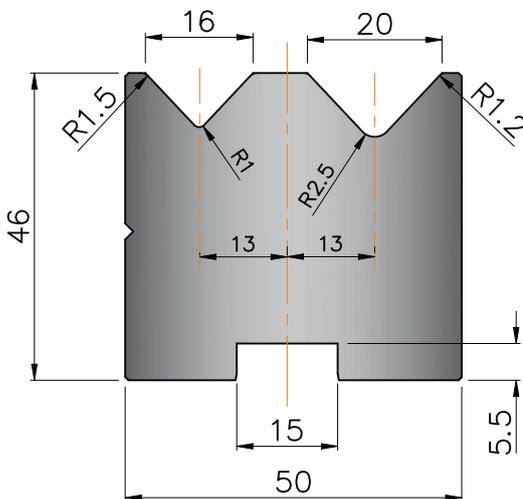
SC2VD 01H46V6-10A86°

Max.T/m. 80



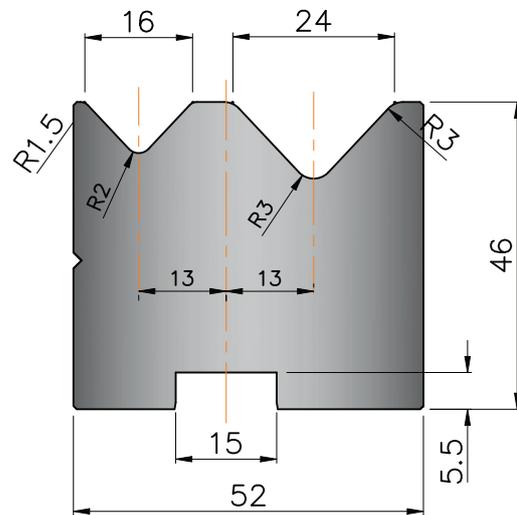
SC2VD 02H46V8-12A86°

Max.T/m. 80



SC2VD 03H46V16-20A86°

Max.T/m. 100



SC2VD 04H46V16-24A86°

Max.T/m. 100

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



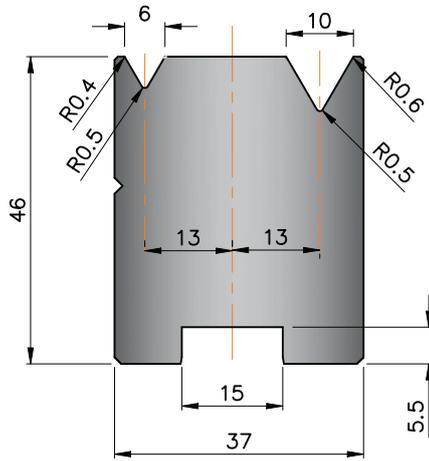
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

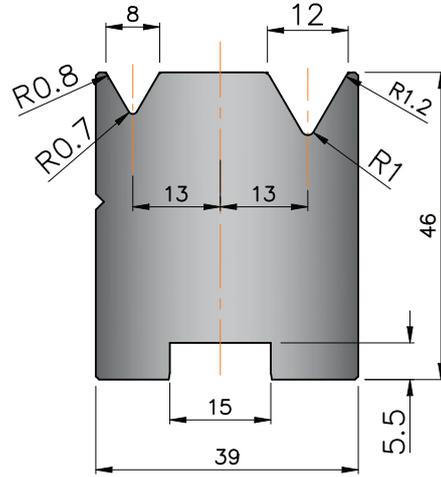


DIE | SELF CENTERING 2 VEE DIE

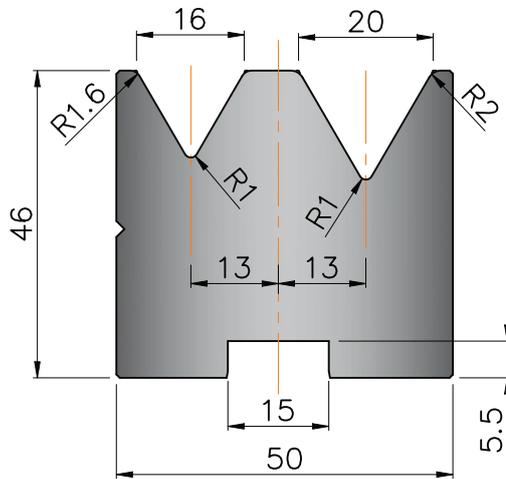
3:G:ii | SC2VD 60°



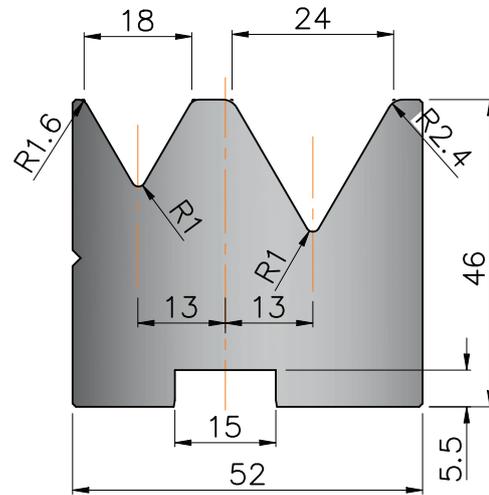
SC2VD 01H46V6-10A60°
Max.T/m. 60



SC2VD 02H46V8-12A60°
Max.T/m. 80



SC2VD 03H46V16-20A60°
Max.T/m. 100



SC2VD 04H46V18-24A60°
Max.T/m. 100

Material Option

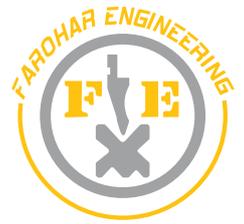
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

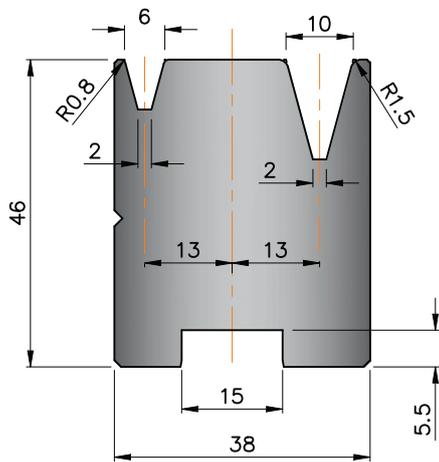
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



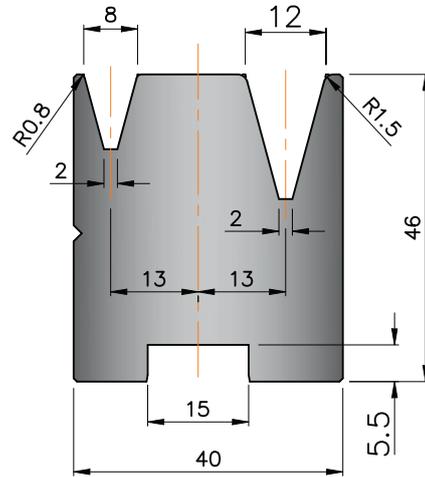


DIE | SELF CENTERING 2 VEE DIE

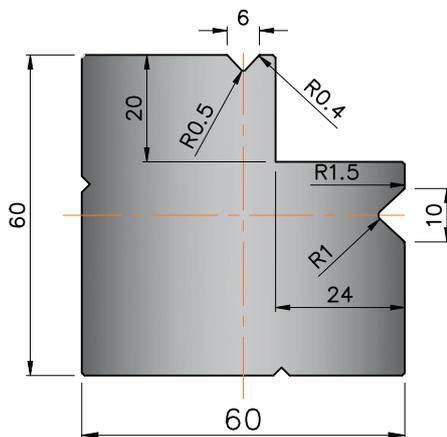
3:G:iii | SC2VD A30° & L - TYPE 2V DIE A86°



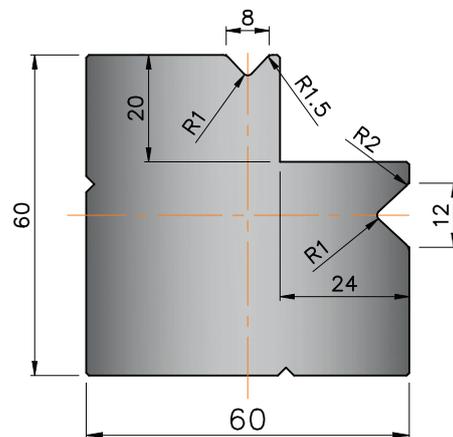
SC2VD 01H46V6-10A30°
Max.T/m. 80



SC2VD 02H46V8-12A30°
Max.T/m. 80



L2VD 01H60V6-10A86°
Max.T/m. 80



L2VD 01H60V8-12A86°
Max.T/m. 80

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



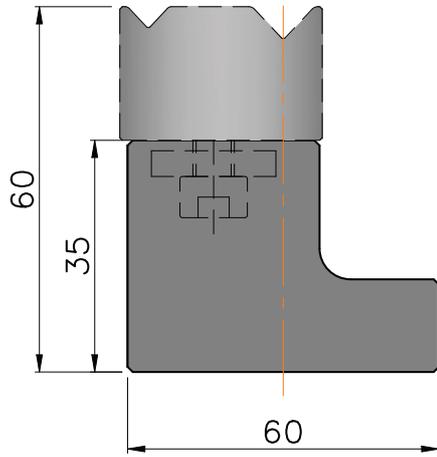
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.

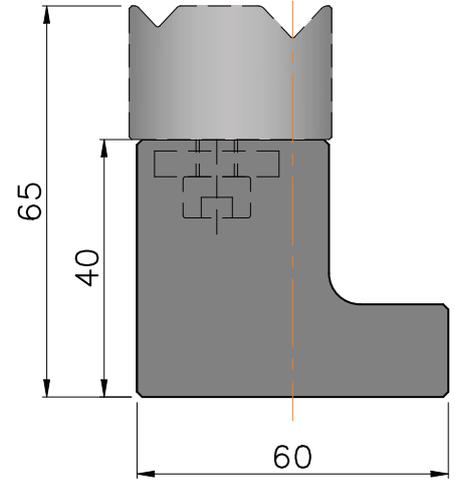


DIE | 2 VEE DIE

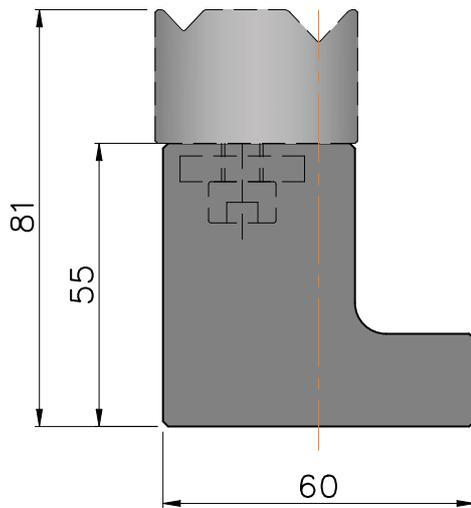
3:H | 2V DIE BOLTED TYPE



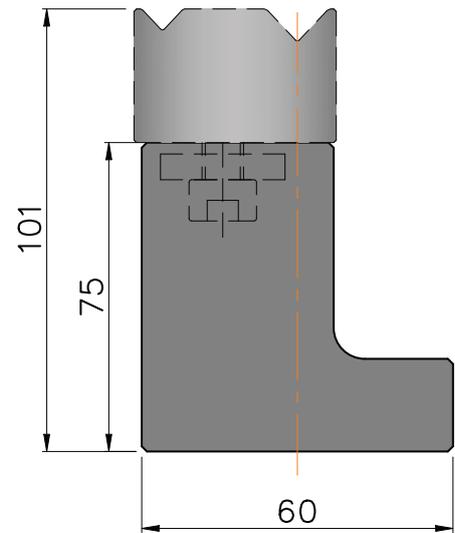
LDB1 H35



LDB2 H40



LDB3 H55



LDB4 H75

Material Specification

Cr'Mn'Mo 900-1020 N/mm²
Base 30±2HRc

C45:-600-710N/mm²

L Type Die Base for 2V Die Bolck & Self Centering Die Block when used with Rail
(die block supplied with standerd bolt spring & washer)

Material Option

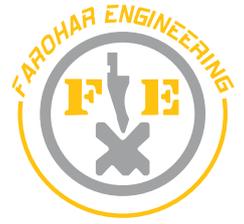
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

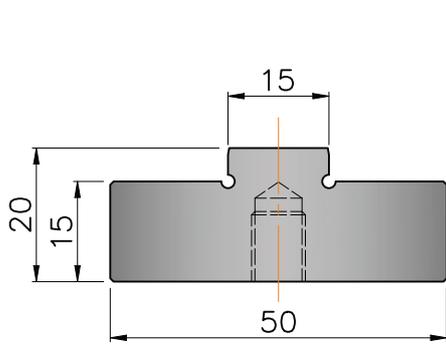
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



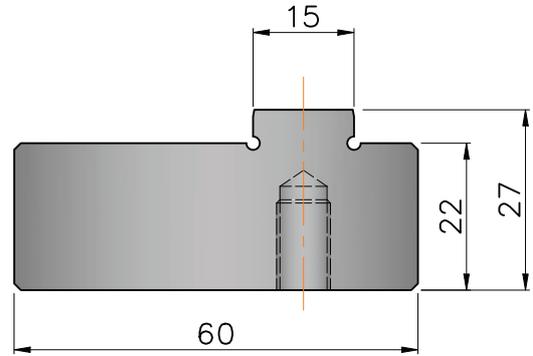


DIE | RAIL

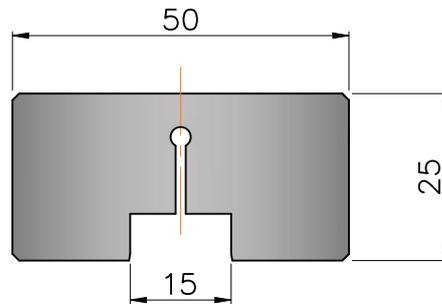
3:1 | SELF CENTERING RAIL



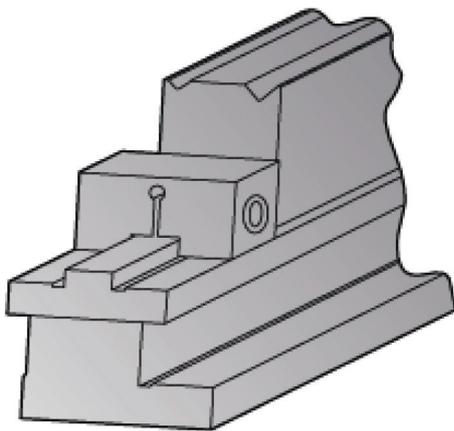
SCR 835, 415



OTSCR 835



DieLock



Material Specification

Cr'Mn'Mo 900-1020 N/mm²
Base 30±2HRc

C45:-600-710N/mm²

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

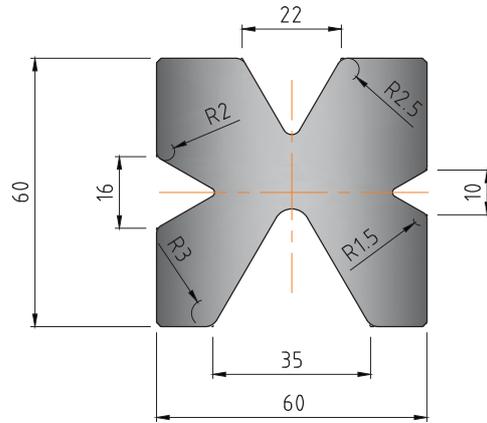
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



DIE | MULTI VEE DIE

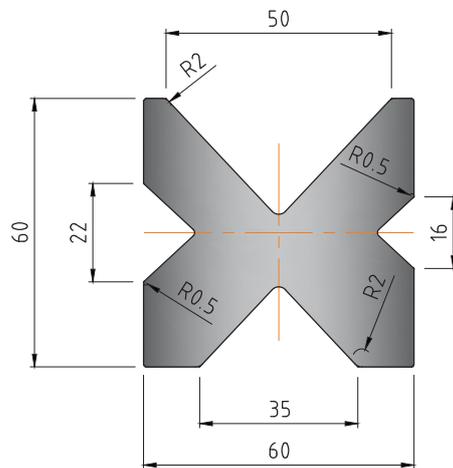
3:J | MULTI VEE DIE A60°, A80°, A86°

Angle A60°



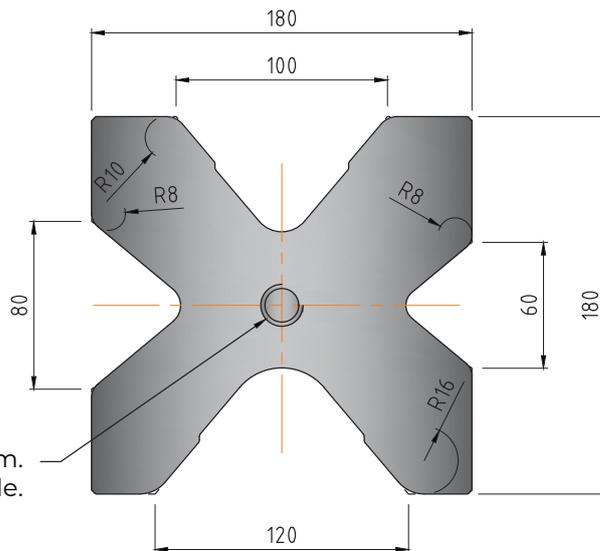
MVD 01H60	
Open V	Max.T/m.
10	60
16	60
22	80
35	80

Angle A86°



MVD 02H60	
Open V	Max.T/m.
16	80
22	80
35	100
50	100

Angle A80°



MVD 03H180	
Open V	Max.T/m.
60	140
80	140
100	140
120	140

M20x40mm.
for Lifting on both side.

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

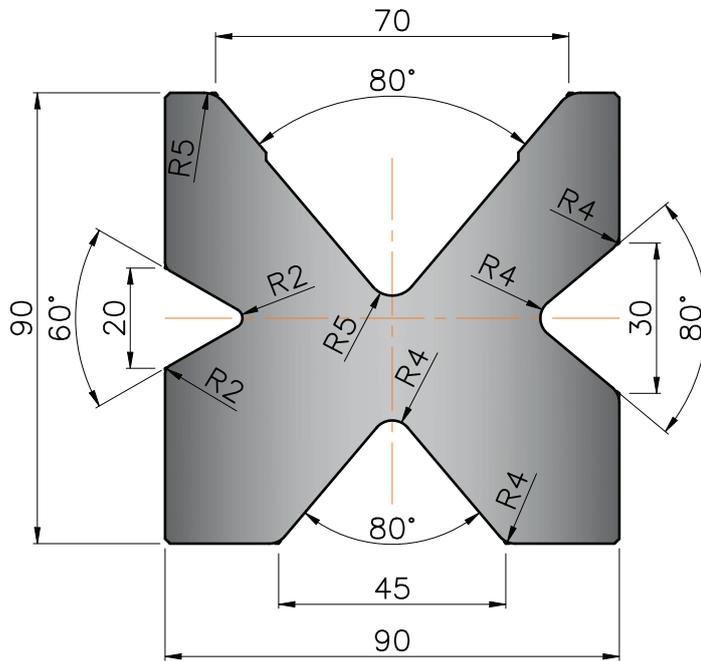
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



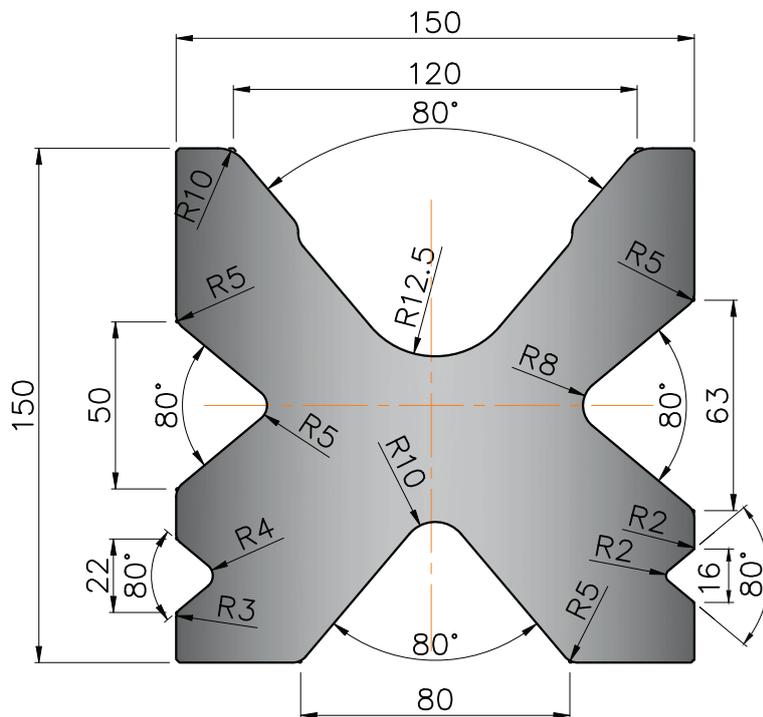


DIE | MULTI VEE DIE

3:J | MULTI VEE DIE A80°



MVD 04H90	
Open V	Max.T/m.
20	40
30	50
45	80
70	100



MVD 05H150	
Open V	Max.T/m.
16	30
22	40
50	80
63	100
80	120
120	150

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



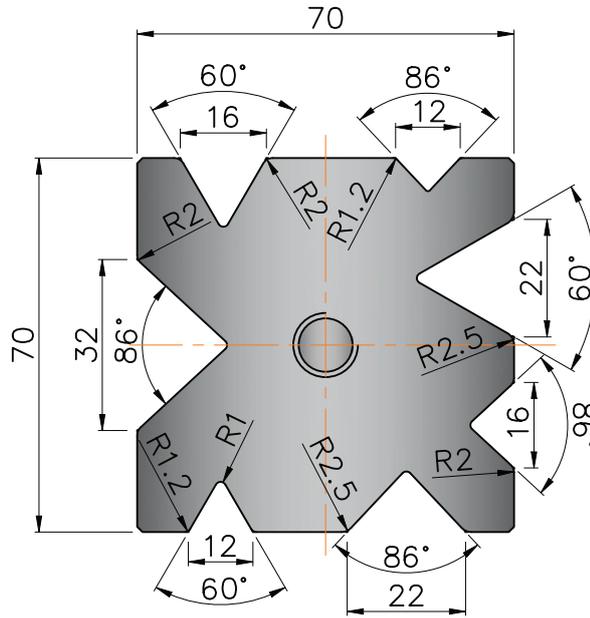
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.

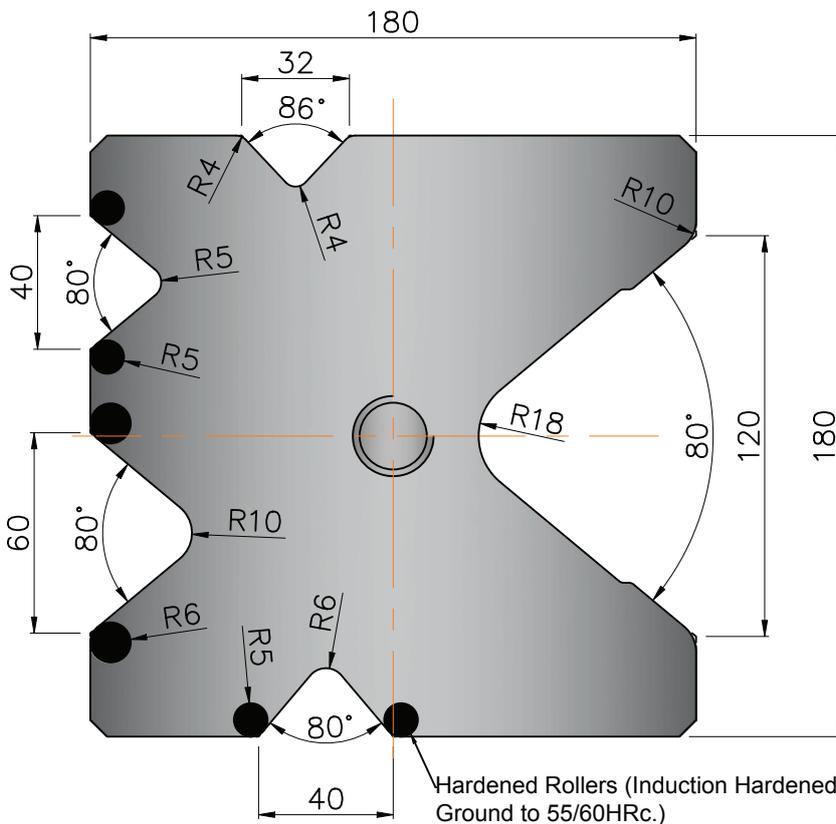


DIE | MULTI VEE DIE

3:J | MULTI VEE DIE 60°, 80° & 86°



MVD 06H70	
Open V	Max.T/m.
12	40
16	50
22	60



MVD 07H180	
Open V	Max.T/m.
32	100
40	100
60	120
120	150

Material Option

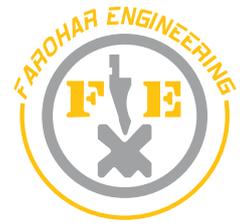
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

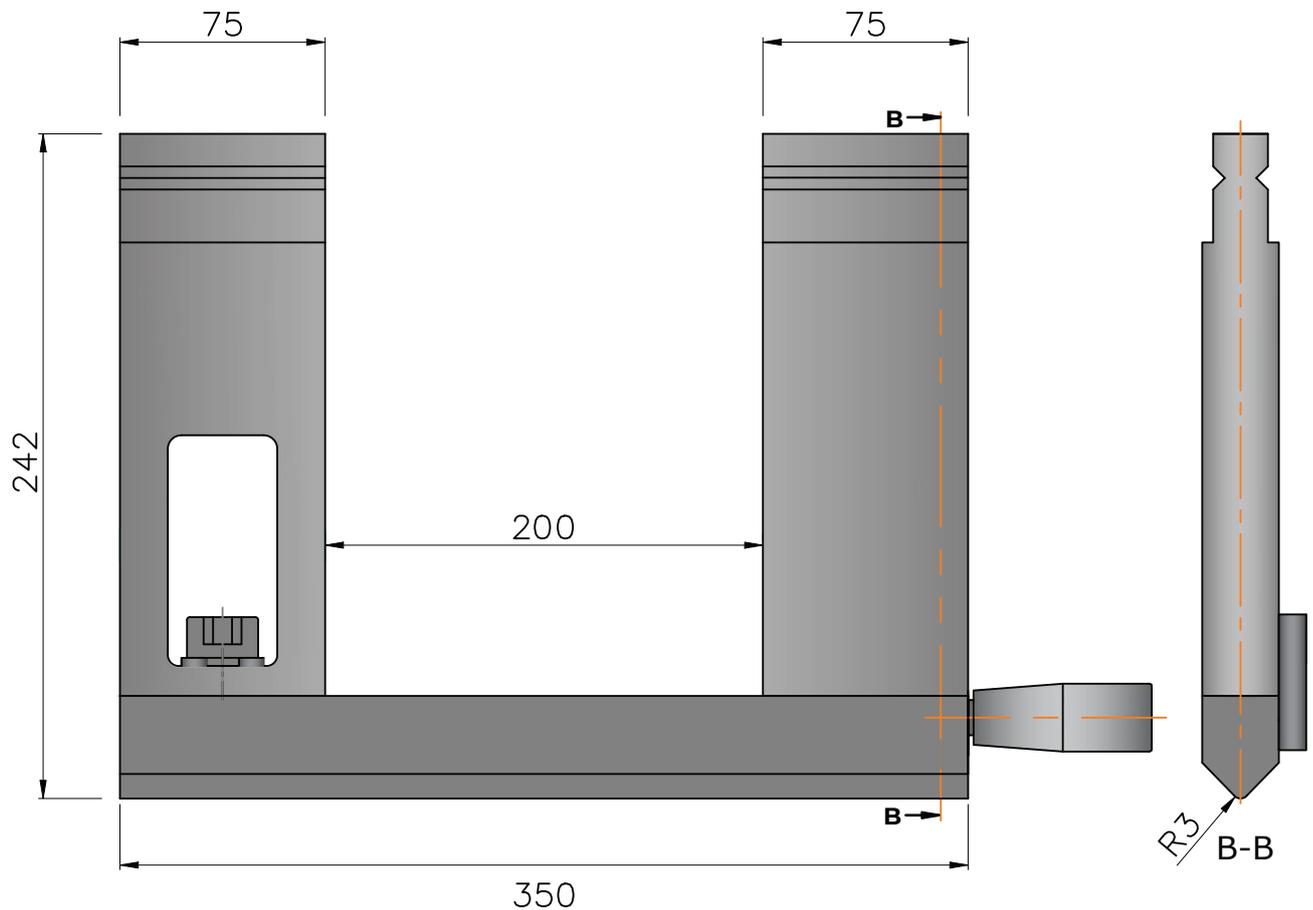
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





PUNCH | WINDOW PUNCH

4:A | WP SWIVEL TYPE



Advantages

- 1 Bending Close Profile
- 2 High U-Profiles
- 3 Easy remove Component

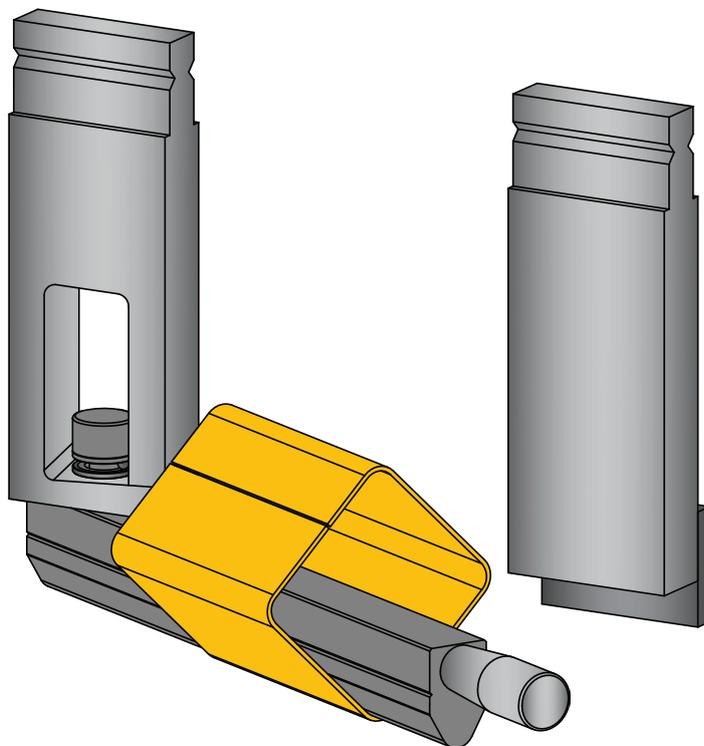
Material Option

Chrome Nickel Grade tool Steel - Toughened $38\pm 2\text{HRC}$ and Working Area Laser Hardened $55/56\text{HRC}$.
 Rocker Material : Chrome Vanadium Steel
 Vacuum Hardness 58HRC .

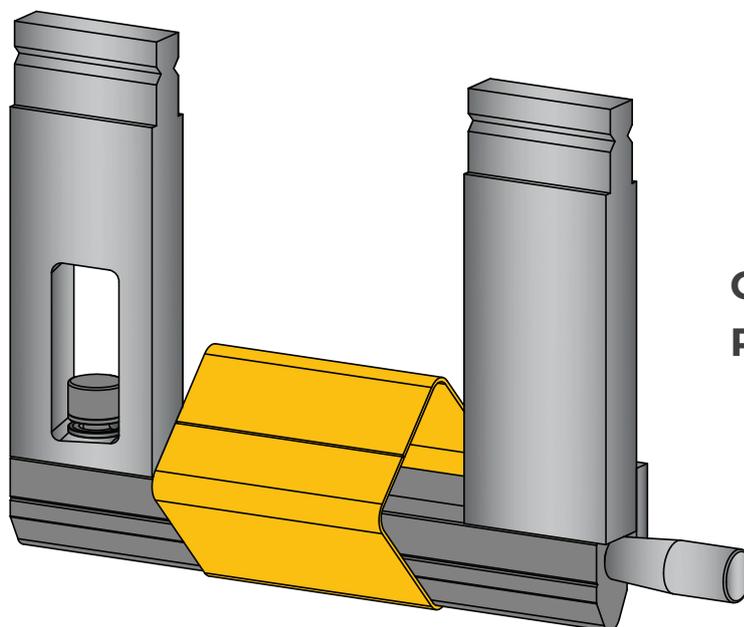


PUNCH | WINDOW PUNCH

4:A | WP SWIVEL TYPE



Open Window Punch

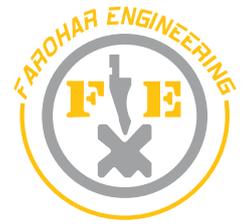


Close Window Punch

Material Option

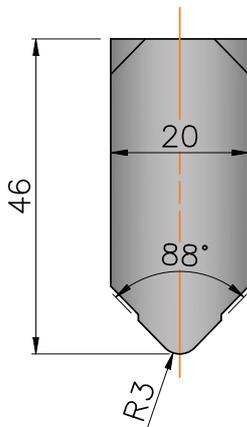
Chrome Nickel Grade tool Steel - Toughened $38\pm 2\text{HRc}$ and Working Area Laser Hardened $55/56\text{HRc}$.
Rocker Material : Chrome Vanadium Steel
Vacuum Hardness 58HRc .



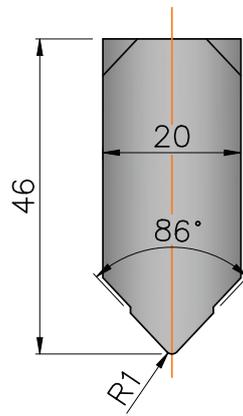


PUNCH | WINDOW PUNCH

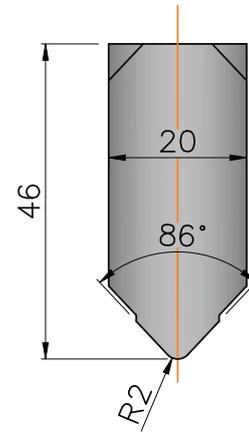
4:B | WINDOW PUNCH INSERT



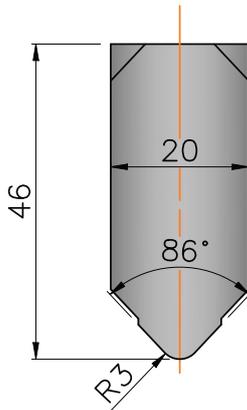
WI 01H46A88°R_



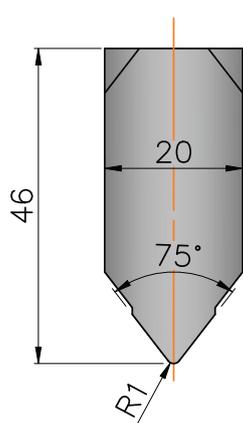
WI 02H46A86°R_



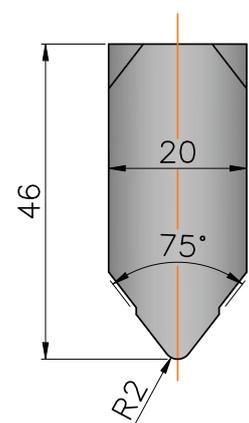
WI 03H46A86°R_



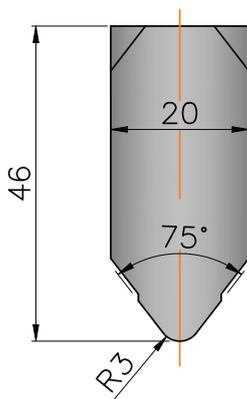
WI 04H46A86°R_



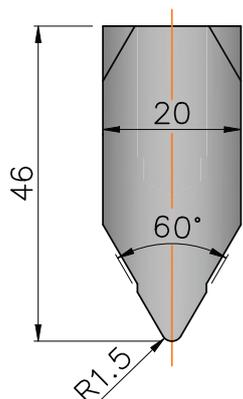
WI 05H46A75°R_



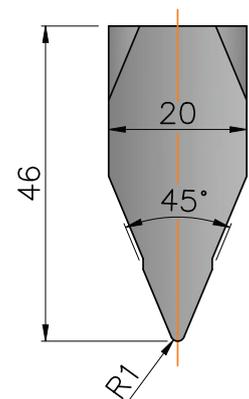
WI 06H46A75°R_



WI 07H46A75°R_



WI 08H46A60°R_



WI 09H46A45°R_

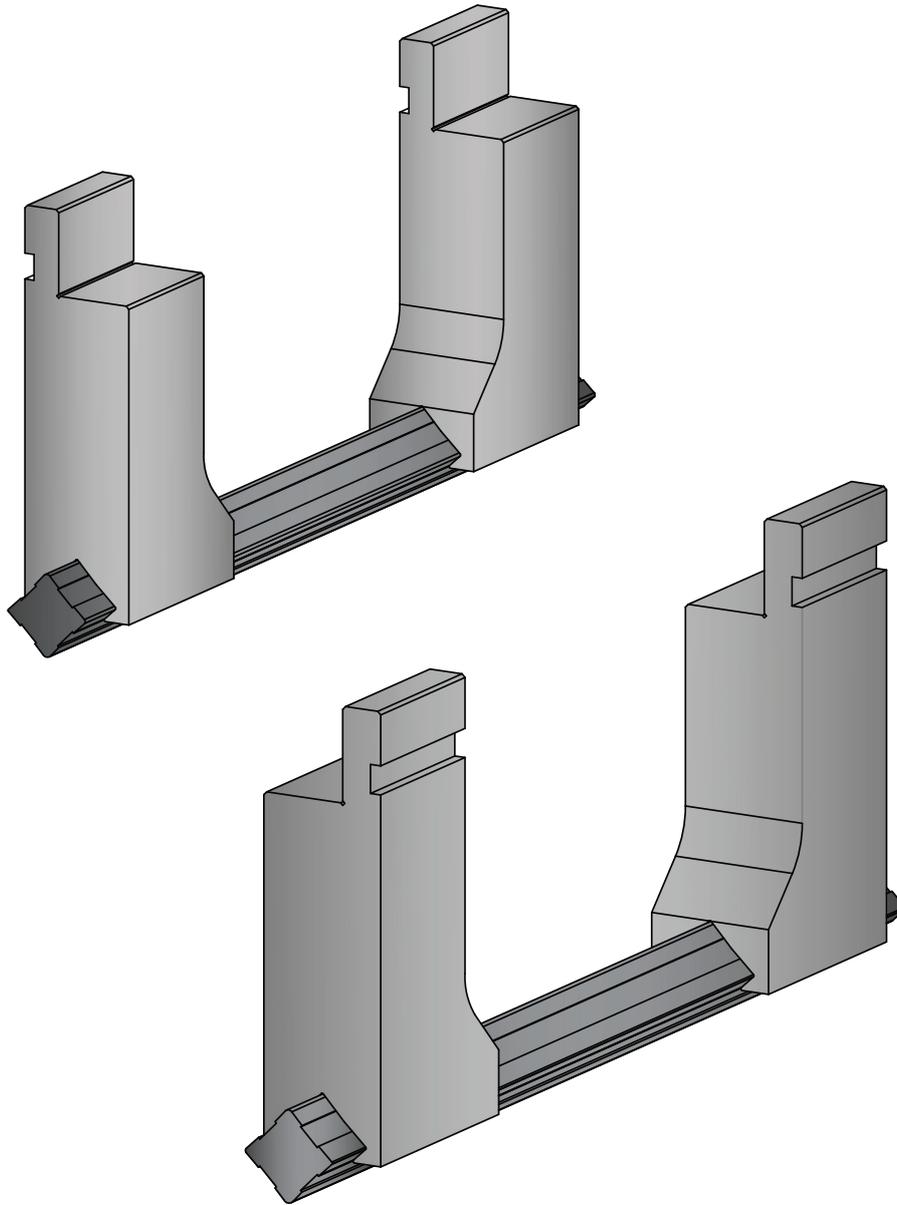
Material Option

Chrome Nickel Grade tool Steel - Toughened 38±2HRc and Working Area Laser
Hardened 55/56HRc.
Rocker Material : Chrome Vanadium Steel
Vacuum Hardness 58HRc.



PUNCH | WINDOW PUNCH

4:C | VARIABLE WP WITH VARIABLE RADIUS



- 1 Variable window punch for components ranging from 50 to 300 mm
- 2 Variable radius options: R1, R1.5, R2, R3
- 3 Decreasing the distance between two insert holders results in increased load
- 4 Increasing the distance between two insert holders results in decreased load

Material Option

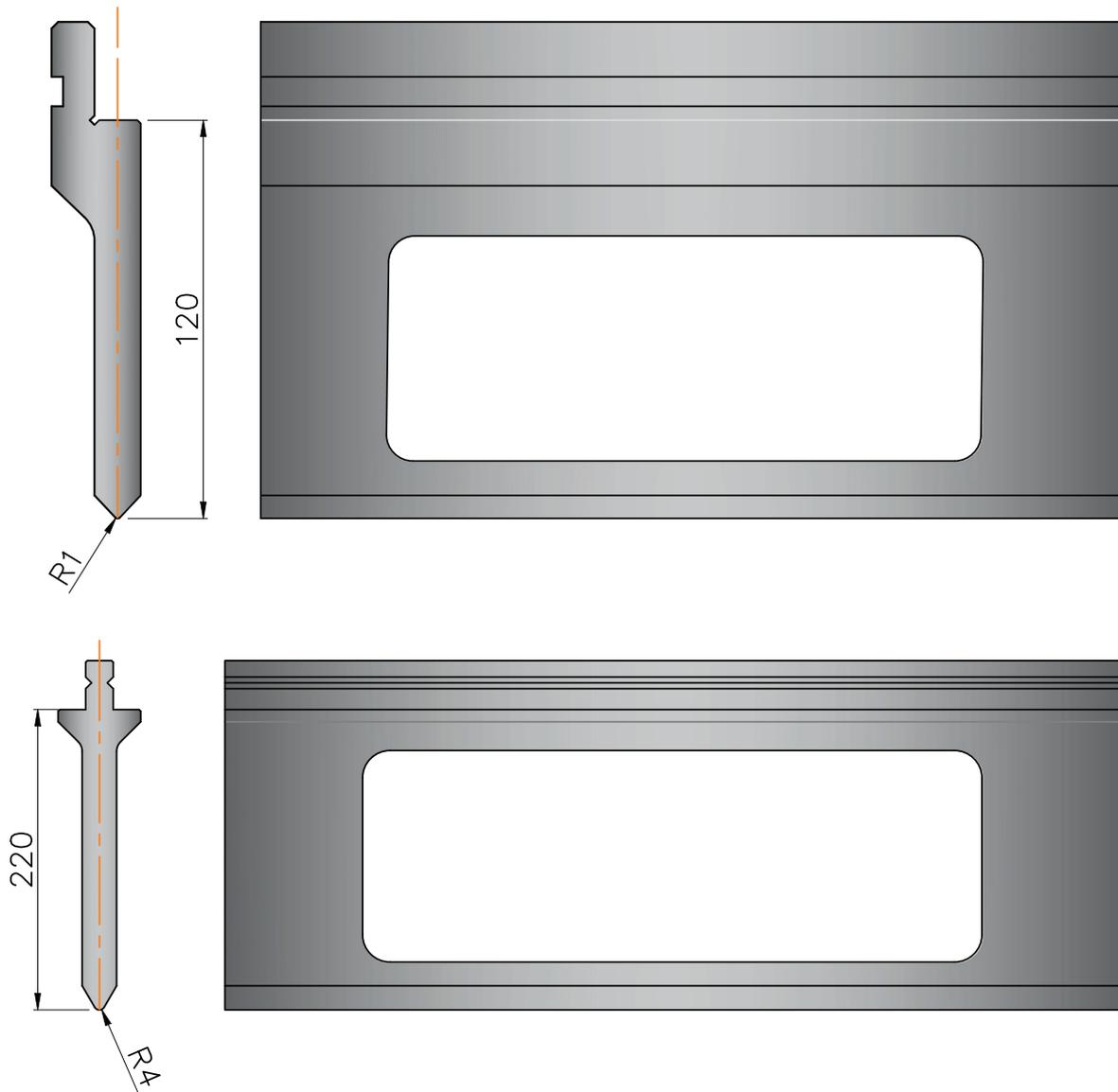
Chrome Nickel Grade tool Steel - Toughened $38\pm 2\text{HRC}$ and Working Area Laser Hardened $55/56\text{HRC}$.
 Rocker Material : Chrome Vanadium Steel
 Vacuum Hardness 58Hrc .





PUNCH | WINDOW PUNCH

4:D | WP POCKET TYPE



- 1 Variable window punch for components ranging from 50 to 300 mm
- 2 Variable radius options: R1, R1.5, R2, R3
- 3 Decreasing the distance between two insert holders results in increased load
- 4 Increasing the distance between two insert holders results in decreased load

Material Option

Chrome Nickel Grade tool Steel - Toughened 38±2HRc and Working Area Laser
 Hardened 55/56HRc.
 Rocker Material : Chrome Vanadium Steel
 Vacuum Hardness 58Hrc.



HEMMING DIE

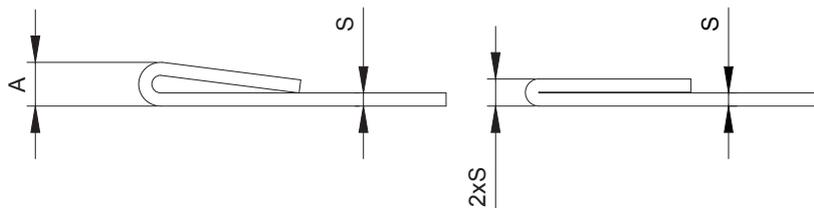
5:A | INTRODUCTION

- ◆ Hemming dies ensure precise and consistent folding of sheet metal edges, resulting in accurate finished products.
- ◆ Streamlines Flattening, cuts labour, boosts efficiency.
- ◆ Available in spring loaded and standard.
- ◆ Constructed from Chrome-Moly alloy steel, hemming dies are durable and long-lasting.
- ◆ Lockable Hemming insert option for usage as regular Vee die, reducing changeover time.
- ◆ Reach out for custom-designed solutions tailored to your component needs.

BENDING CHART

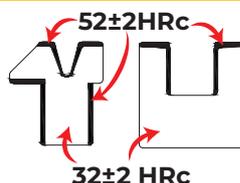
Flattening Load Mild Steel 45kg/mm ²				
Smm	Amm	Ton/M	2xS	Ton/M
0.8	3	12	1.6	32
1	3.5	15	2	40
1.2	3.4	16	2.4	50
1.6	4.8	28	3.2	65
2	5.5	30	4	80
2.5	6.5	55	5	90

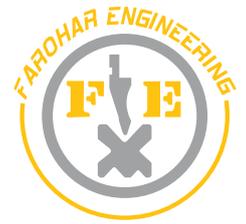
Flattening Load Stainless Steel 70kg/mm ²				
Smm	Amm	Ton/M	2xS	Ton/M
0.8	3	20	1.6	50
1	3.5	25	2	60
1.2	3.4	26	2.4	80
1.6	4.8	38	3.2	100
2	5.5	50	4	130



Material

M0-1 Performance grade.
 Cr'Mn'Mo 900-1100 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRc.
 Tip Laser Hardened 52±2HRc.





HEMMING DIE | SPRING LOADED

5:A:i | SPRING LOADED HEMMING DIE V6

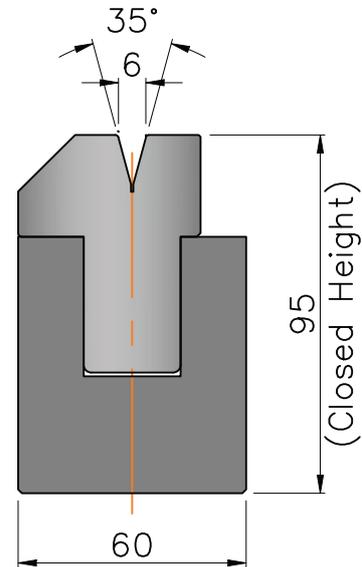
Spring Loaded Hemming Die for faster Hemming operation.

No tool change over required.

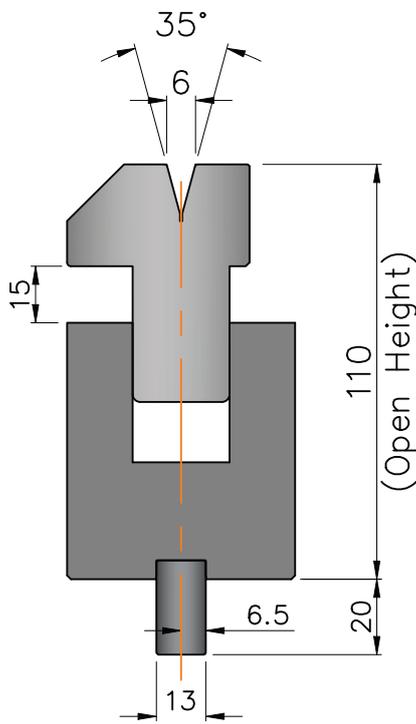
V6 Die suitable for flattening of M.S and S.S

Max 1 mm thick refer table.

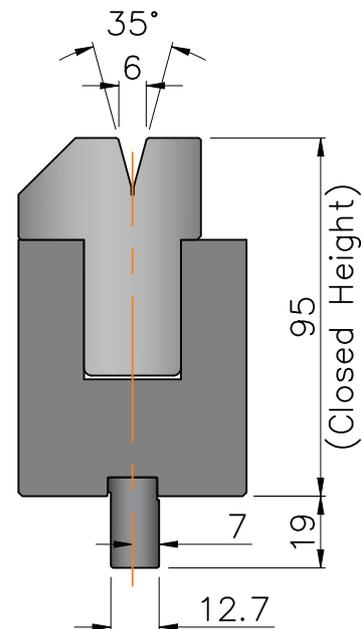
To suit all types of machine base.



(Amada Type)
SPHD AV6



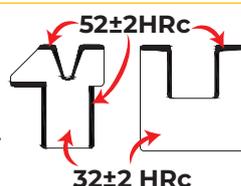
(Trumpf - Wila Type)
SPHD T/WV6



(LVD-type)
SPHD LV6

Material

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



SPHD6

V	6
Maximum thk. M.S.	1
Maximum thk. S.S.	0.8
Maximum Tonnage	50
Minimum Flange Length	7
α	35°

HEMMING DIE | SPRING LOADED

5:B:ii | SPRING LOADED HEMMING DIE V8

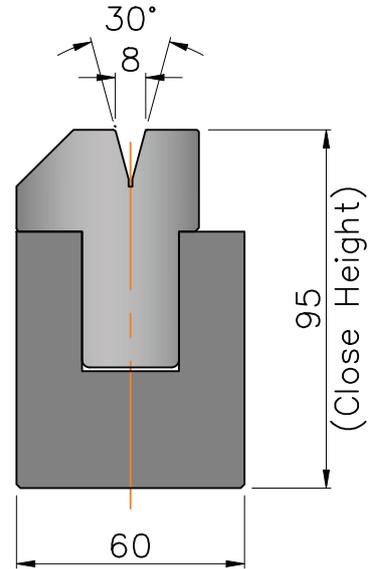
Spring Loaded Hemming Die for faster Hemming operation.

No tool change over required.

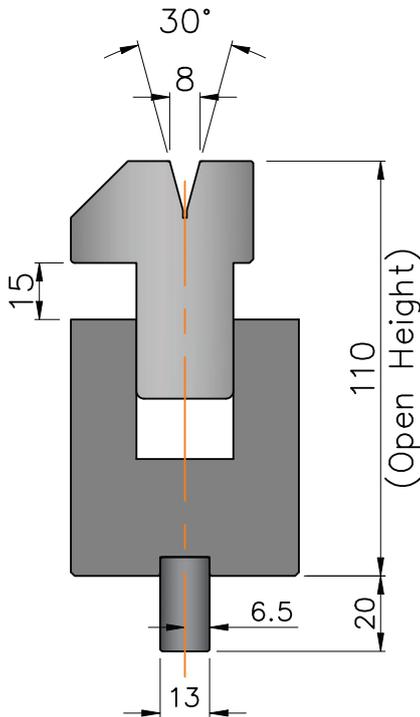
V8 Die suitable for flattening of M.S and S.S

Max 1.6 mm thick refer table.

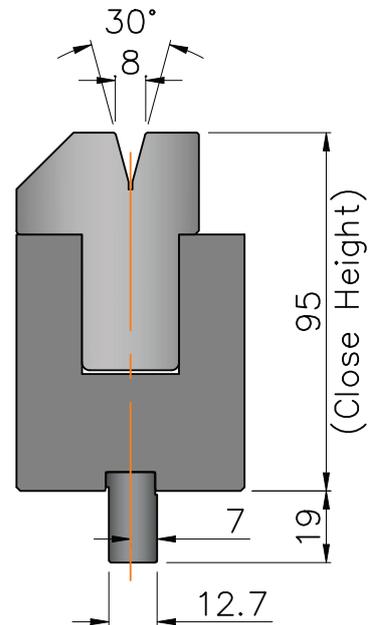
To suit all types of machine base.



(Amada Type)
SPHD AV8



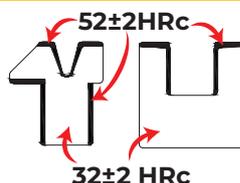
(Trumpf - Wila Type)
SPHD T/WV8



(LVD-type)
SPHD LV8

Material

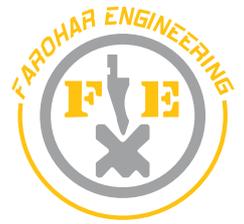
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



SPHD8

V
Maximum thk. M.S.
Maximum thk. S.S.
Maximum Tonnage
Minimum Flange Length
α

8
1.6
1.2
80
10
30°



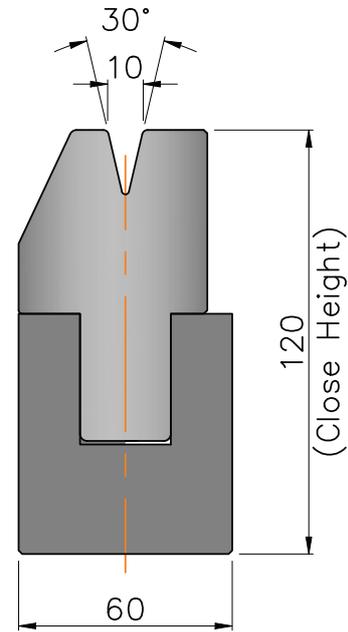
HEMMING DIE | SPRING LOADED

5:B:iii | SPRING LOADED HEMMING DIE V10

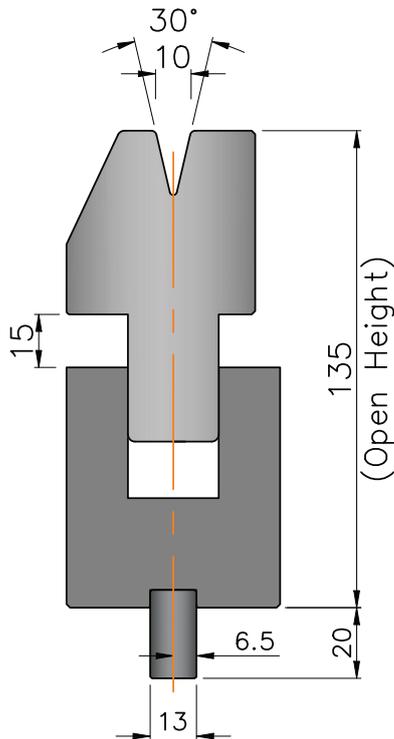
Heavy Duty Hemming Die .

Flatten upto 2mm thick M.S and 1.6mm S.S

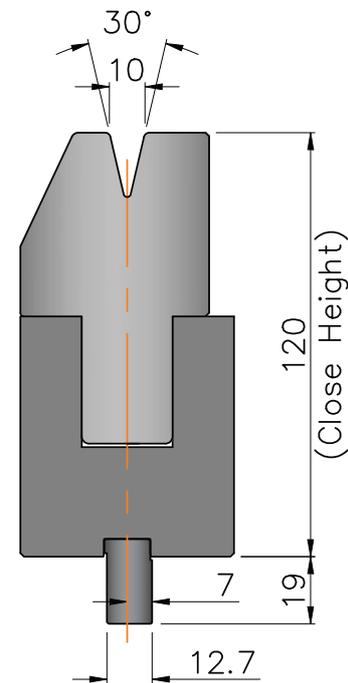
Added height and thickness for large flattening load.



(Amada Type)
SPHD AV10



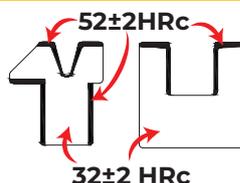
(Trumpf - Wila Type)
SPHD T/WV10



(LVD-type)
SPHD LV10

Material

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



SPHD10

V	10
Maximum thk. M.S.	2
Maximum thk. S.S.	1.6
Maximum Tonnage	100
Minimum Flange Length	12
α	30°

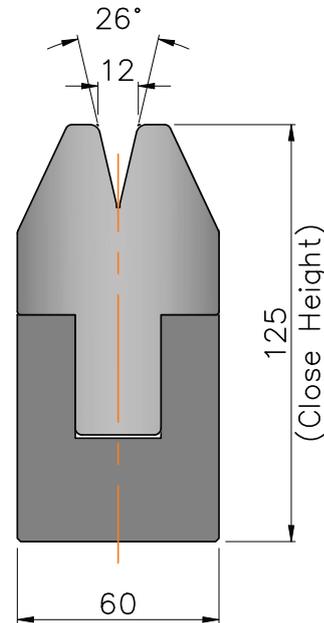
HEMMING DIE | SPRING LOADED

5:B:iv | SPRING LOADED HEMMING DIE V12

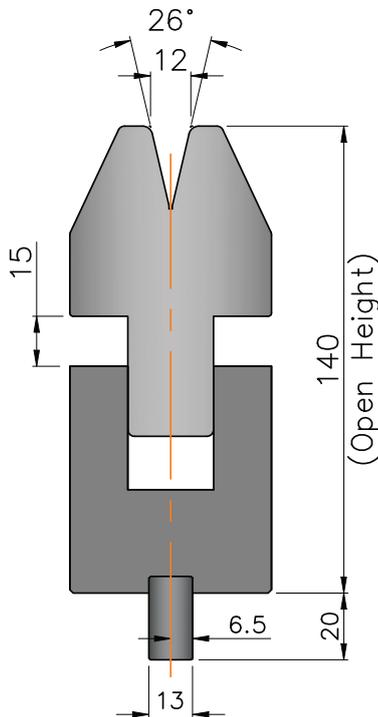
Heavy Duty Hemming Die .

Flatten upto 2.5mm thick M.S and 2.0mm S.S

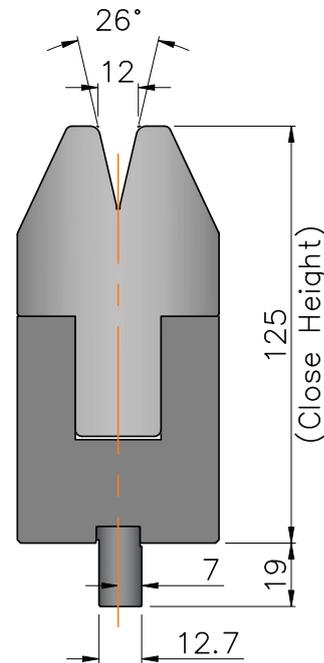
Added height and thickness for large flattening load.



(Amada Type)
SPHD AV12



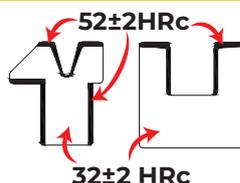
(Trumpf - Wila Type)
SPHD T/WV12



(LVD-type)
SPHD LV12

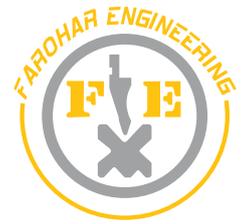
Material

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



SPHD12

V	12
Maximum thk. M.S.	2.5
Maximum thk. S.S.	2
Maximum Tonnage	130
Minimum Flange Length	15
α	26°



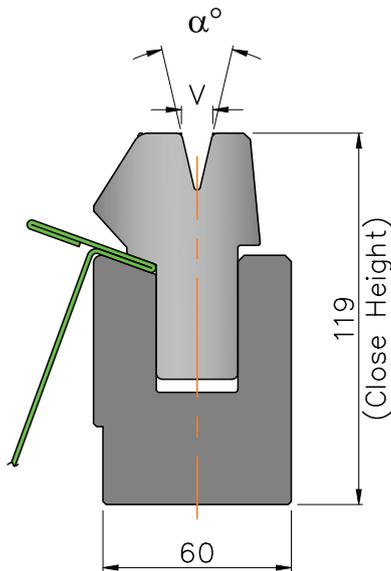
HEMMING DIE

5:C | INCLINE HEMMING DIE

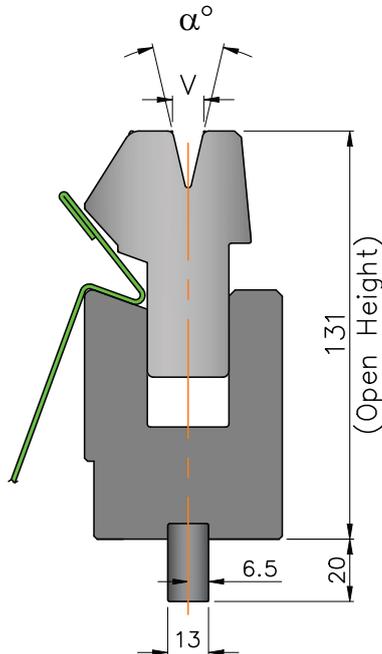
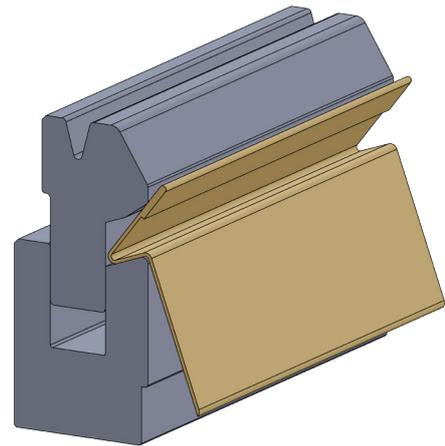
Customised to suit your component requirements.

Available for range of thickness upto 2.5 mm.

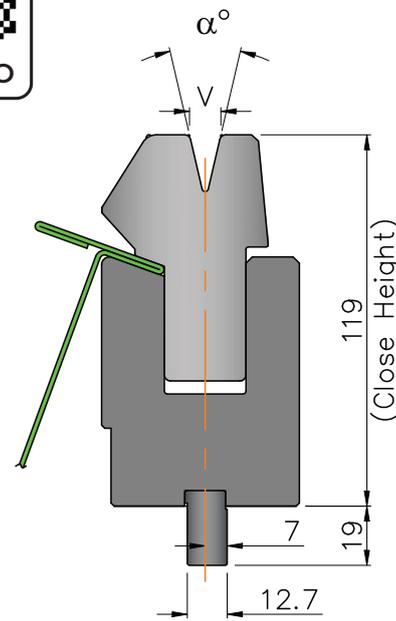
High Strength Tool Steel.



(Amada Type)
IHD AV



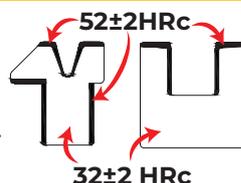
(Trumpf - Wila Type)
IHD T/WV



(LVD-type)
IHD LV

Material

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



V
Maximum thk. M.S.
Maximum thk. S.S.
Maximum Tonnage
Minimum Flange Length
 α

IHD6 IHD8

V	6	8
Maximum thk. M.S.	1	1.6
Maximum thk. S.S.	0.8	1.2
Maximum Tonnage	50	80
Minimum Flange Length	7	10
α	35°	30°

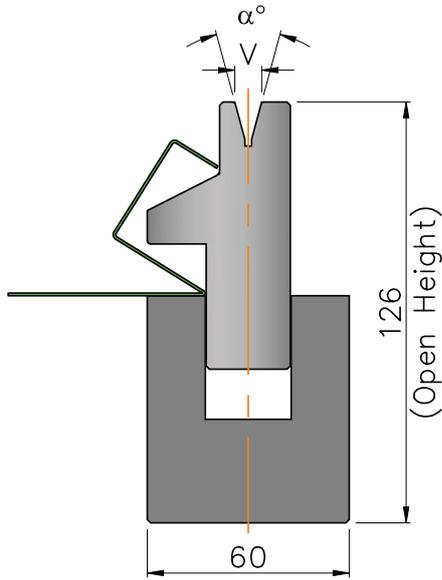
HEMMING DIE

5:D | SLENDER HEMMING DIE

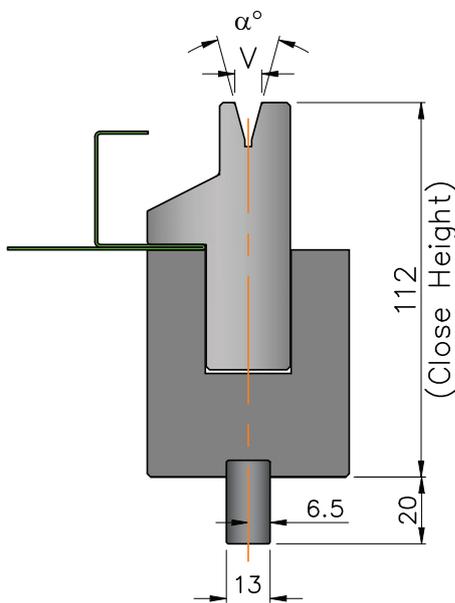
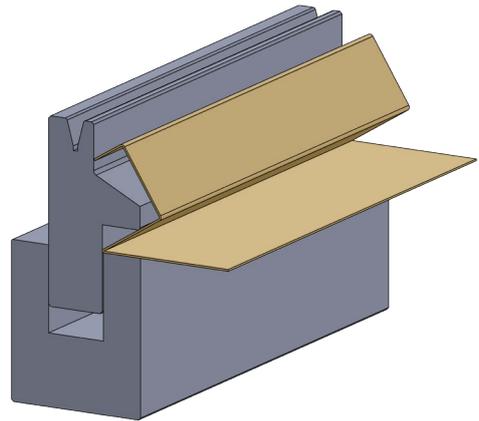
Customised to suit your component requirements.

Available for range of thickness upto 1.6mm.

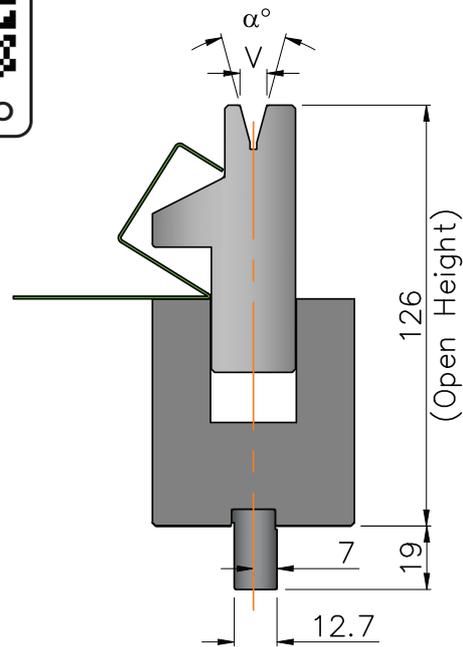
High Strength Tool Steel.



(Amada Type)
SHD AV



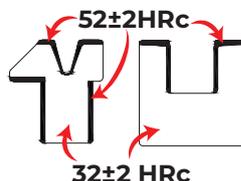
(Trumpf - Wila Type)
SHD T/WV



(LVD-type)
SHD LV

Material

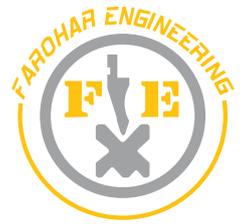
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



V	6	8
Maximum thk. M.S.	1	1.6
Maximum thk. S.S.	0.8	1.2
Maximum Tonnage	50	80
Minimum Flange Length	7	10
α	35°	30°

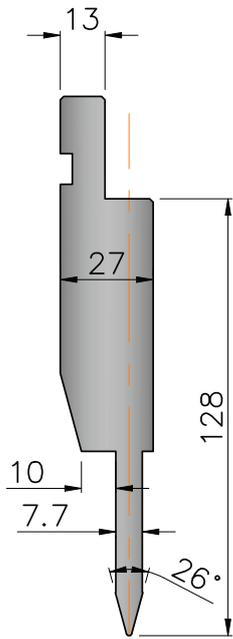
SLHD6

SLHD8

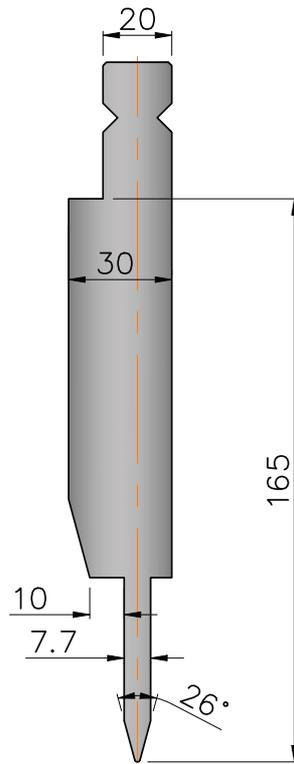


5:E:i | FIXED HEMMING DIE V8

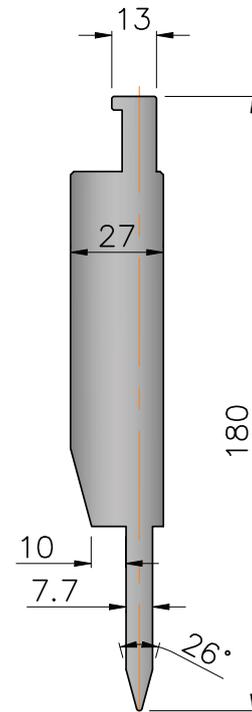
HEMMING DIE | Fixed Hemming DIE



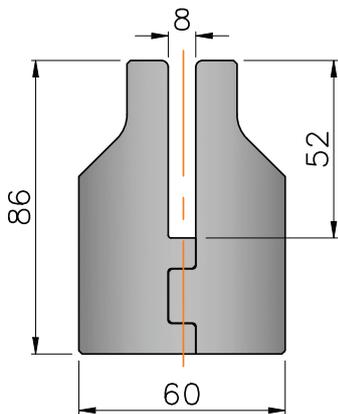
HP1 Max T/m 80
(Amada Type)



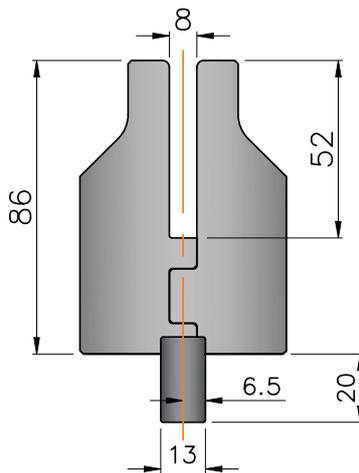
HP1 Max T/m 80
(Trumpf - Wila Type)



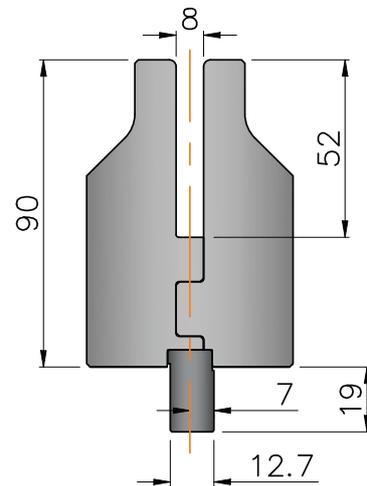
HP1 Max T/m 80
(LVD-type)



HD1 Max T/m 50
(Amada Type)



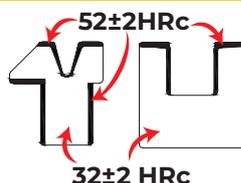
HD1 Max T/m 50
(Trumpf - Wila Type)



HD1 Max T/m 50
(LVD-type)

Material

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



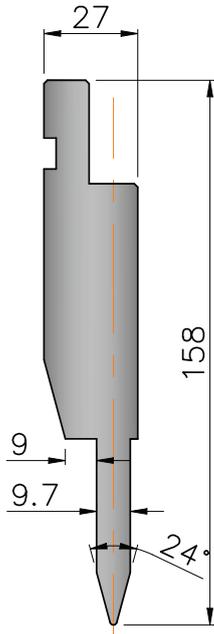
Economy Series
of flattening tool.
For flattening
upto 1.2mm



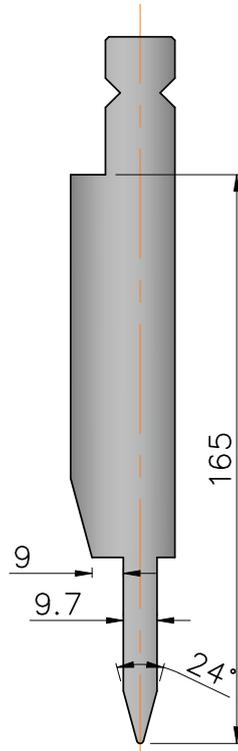
TRIAL VIDEO

HEMMING DIE | Fixed Hemming DIE

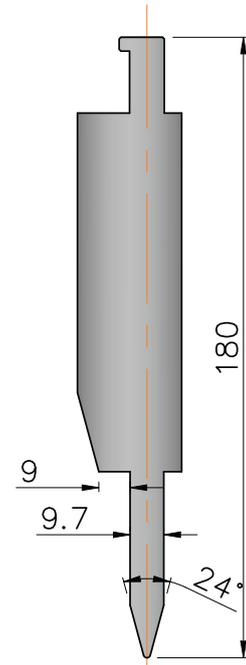
5:E:ii | FIXED HEMMING DIE V10



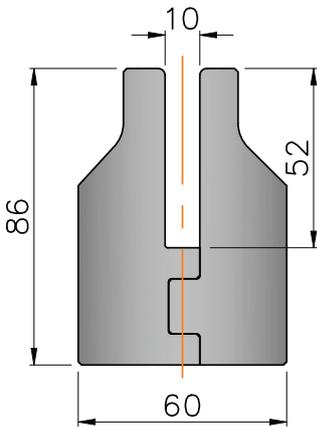
HP2 Max T/m 80
(Amada Type)



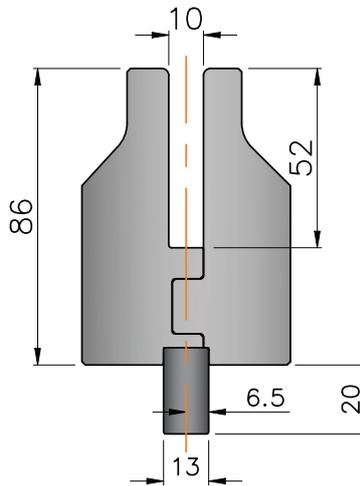
HP2 Max T/m 80
(Trumpf - Wila Type)



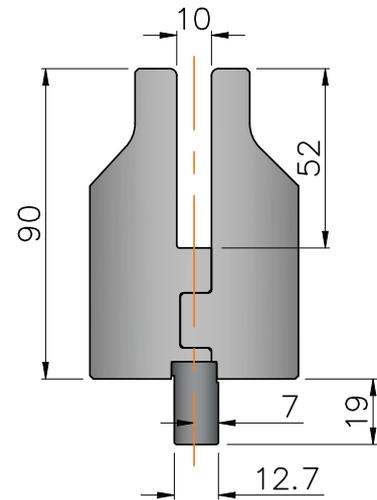
HP2 Max T/m 80
(LVD-type)



HP2 Max T/m 60
(Amada Type)



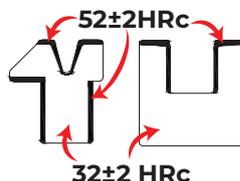
HP2 Max T/m 60
(Trumpf - Wila Type)



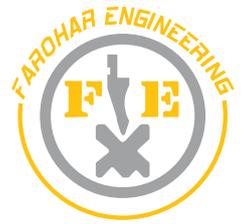
HP2 Max T/m 60
(LVD-type)

Material

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.

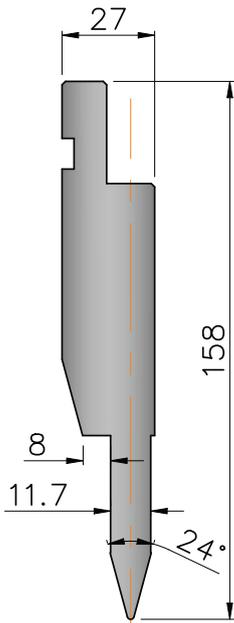


Economy Series of flattening tool.
For flattening upto 1.6mm

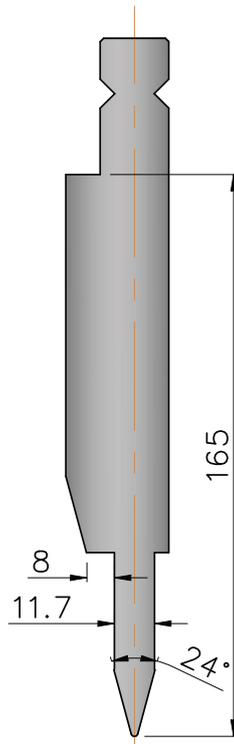


HEMMING DIE | Fixed Hemming DIE

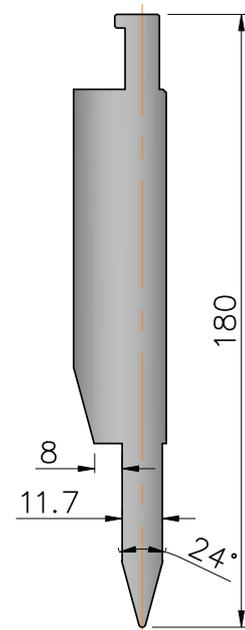
5:E:iii | FIXED HEMMING DIE V12



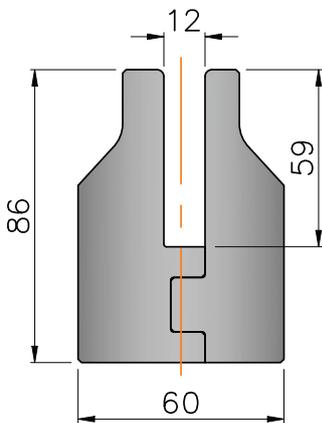
HP3 Max T/m 80
(Amada Type)



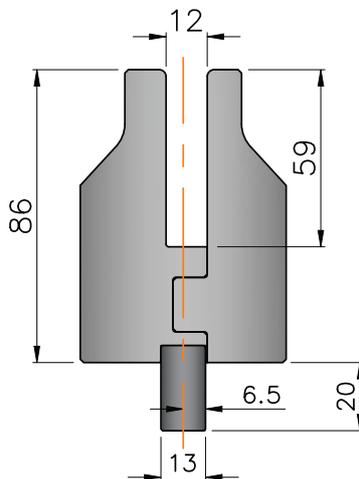
HP3 Max T/m 80
(Trumpf - Wila Type)



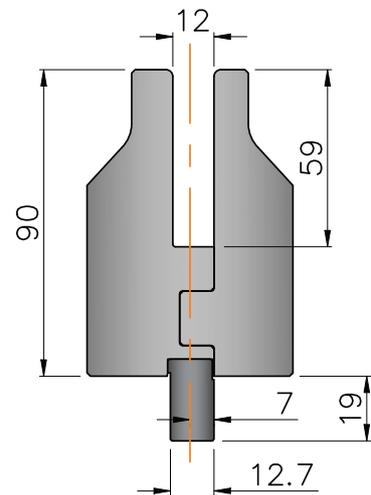
HP3 Max T/m 80
(LVD-type)



HP3 Max T/m 60
(Amada Type)



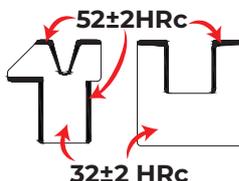
HP3 Max T/m 60
(Trumpf - Wila Type)



HP3 Max T/m 60
(LVD-type)

Material

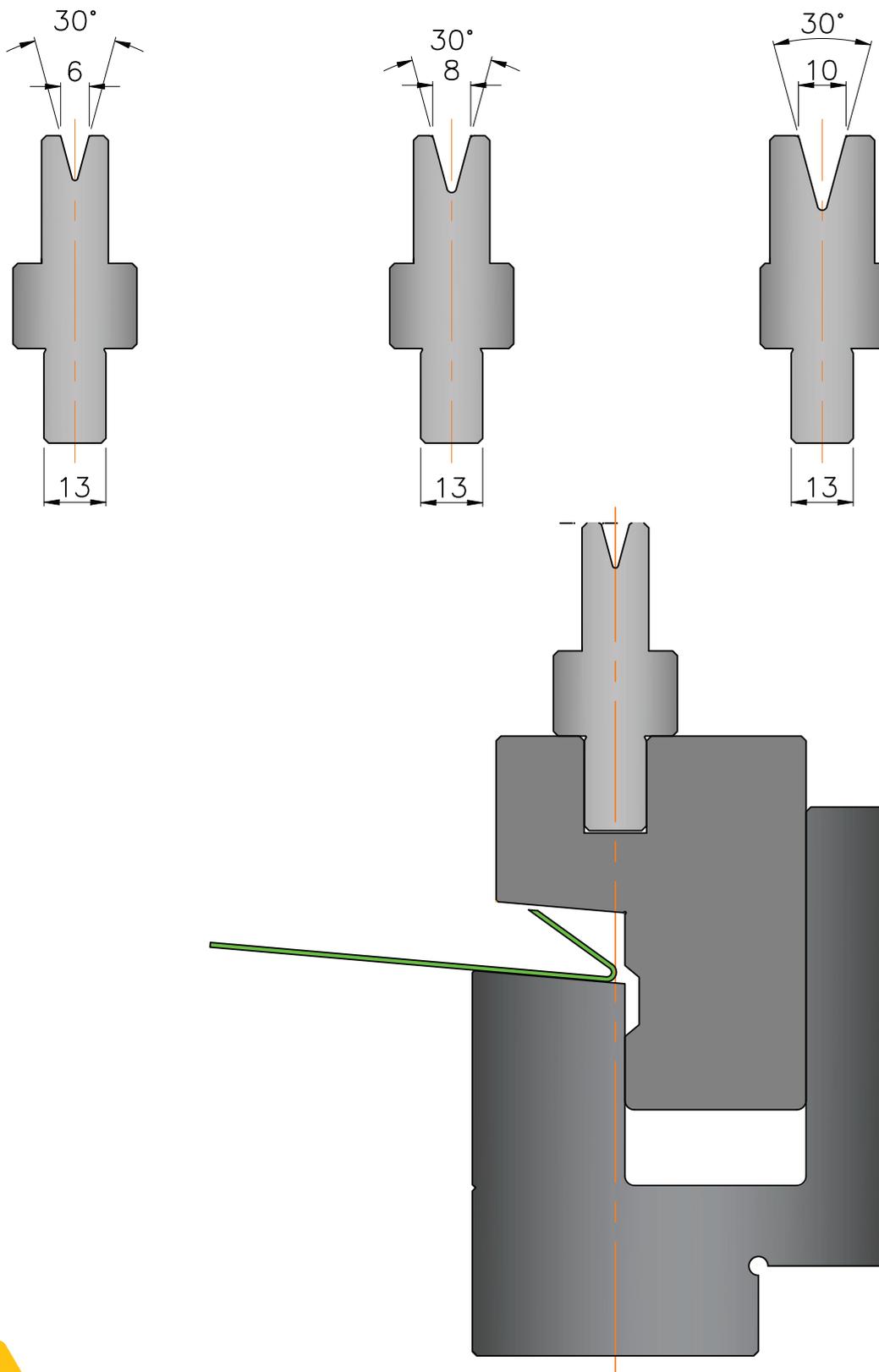
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.



Economy Series of flattening tool.
For flattening upto 2.5mm

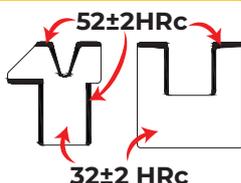
HEMMING DIE

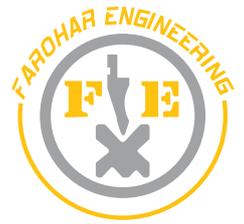
5:F | VARIABLE INSERT HEMMING DIE



Material

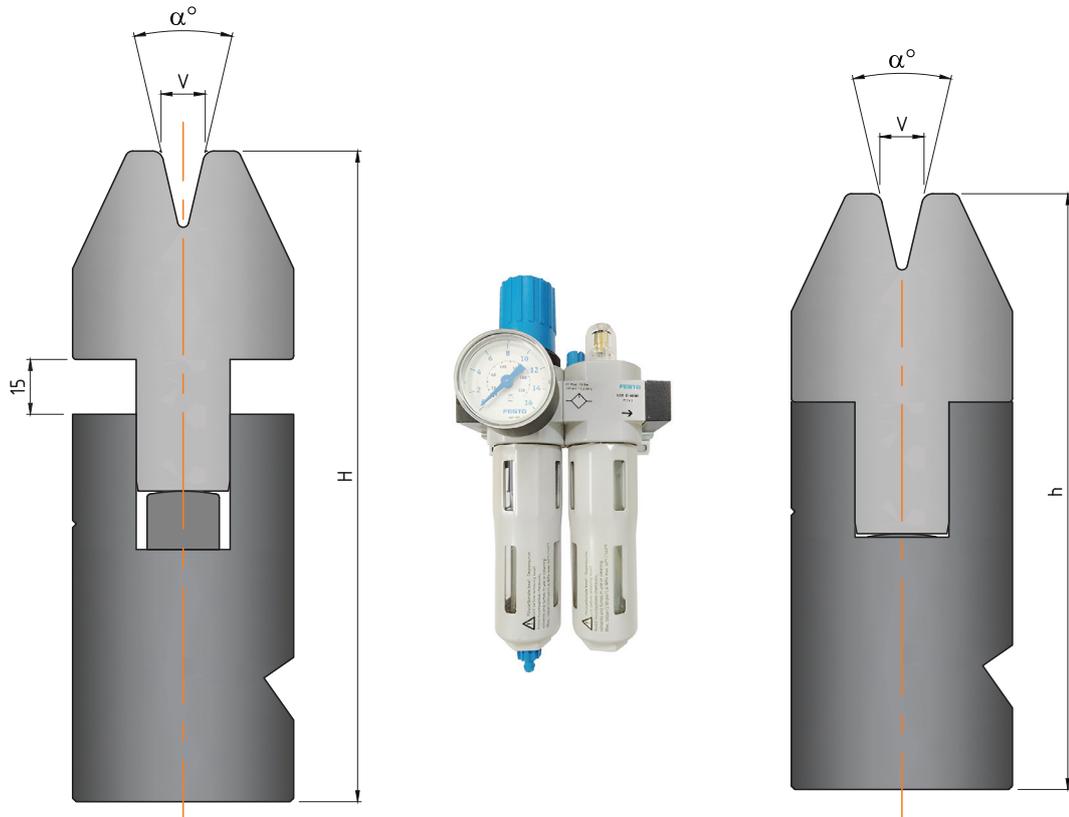
M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRC.
 Tip Laser Hardened 52±2HRC.





HEMMING DIE

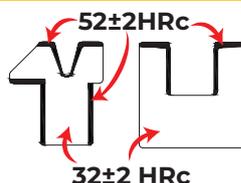
5:G | PNEUMATIC HEMMING DIE



Pneumatic Hemming Die									
Vee Opening (V)	Angle (α)	Max Sheet Thk.(S)		Open Height (H)	Closed Height (h)	Hemming (Ton/m)		Hemming (Ton/m)	
		MS	SS						
		MS	SS			MS	SS	MS	SS
6	35	1	0.8	148	133	15	20	40	50
8	30	1.6	1.2	148	133	28	26	65	80
10	30	2	1.6	173	158	30	38	80	100
12	26	2.5	2	178	148	55	50	90	130

Material

M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRc.
 Tip Laser Hardened 52±2HRc.



ROCKER DIE

6:A | INTRODUCTION

Design

- ◆ 4 models of Rocker Dies for Upto 4mm thickness.
- ◆ Options available to suit all machine bases.
- ◆ Adaptive Rocker Die for heavy thicknesses.
- ◆ Single-stroke channel forming achievable by swapping rockers of Adaptive Rocker Bending Die.
- ◆ Adaptive Joggle Tool enables variable offset bending with minimum changeover.
- ◆ Rocker Wiping Tool enables extended sheet bending without lifting sheet.

Advantages

- ◆ Achieving minimal flange bending.
- ◆ Bend tapered flanges without bulging
- ◆ Bend aesthetic materials mark-free
- ◆ Dodging deformation, bend perforated, chequered plates.
- ◆ Form short, tapered flanges with finesse.
- ◆ Bend adjacent to holes, slots without distortion
- ◆ Reduce tool changeovers to boost efficiency.

MOULDED FOR LONG LASTING

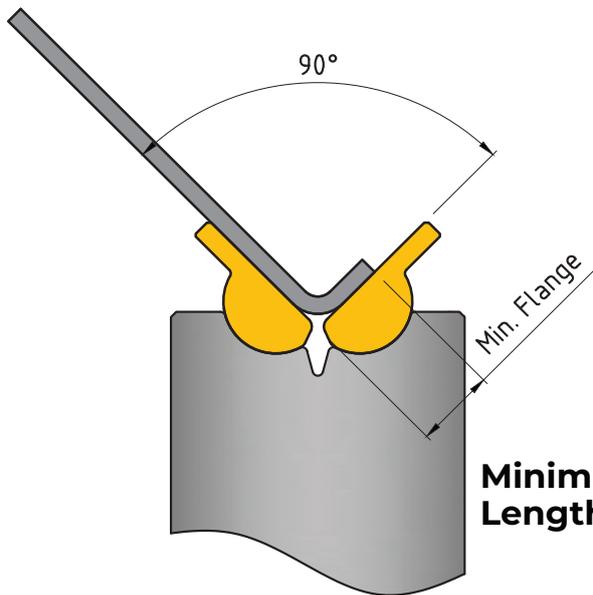
- ◆ Rockers engineered with chrome vanadium steel, max. robustness vacuum hardened 58 HRc.
- ◆ Rocker die base manufactured using Chrome Nickel Grade tool steel- Toughened 38±2HRc and Working Area Laser Hardened 55/56Hrc.

Model No.	RD6	RD8	RD13	RD18	RD22	ARD-1	ARD-2
Max. Tonnage	30T/m	40T/m	80T/m	120T/m	150T/m	150T/m	200T/m
Equivalent VEE@90°	5.29mm	6.59mm	10.88mm	15.17mm	19.17mm	24-60 mm	40-120 mm
Max. Mat. Thk.- M.S./S.S. (mm)	1.2/1	1.6/1.2	2.5/2	4/3	5/4	12/10	16/12
Min. Flange for 90°	3.7	4.6	7.7	11	14	15-40.4	20.2-76.8
Min. Bend Angle	58	58	58	60	60	60	58
Max. Outside Radius	R2.1	R3	R6	R8	R10	R12-R35	R15-R60

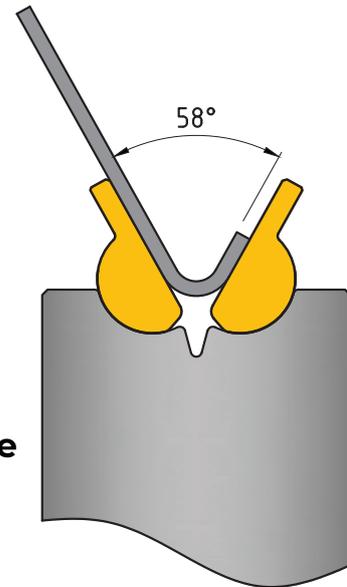


ROCKER DIE

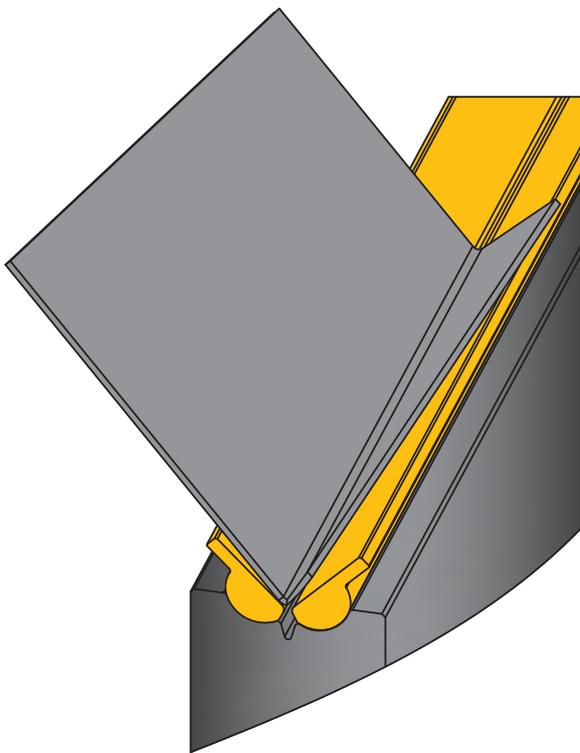
6:B | ADVANTAGES OF ROCKER DIE



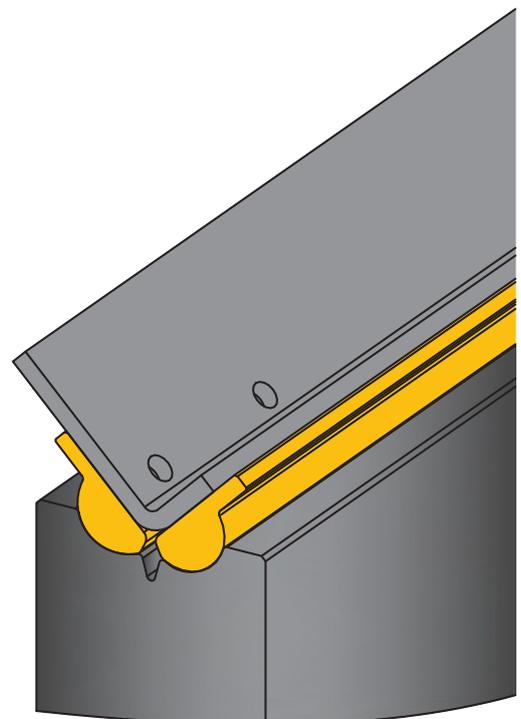
Minimum Flange Length



Minimum Angle



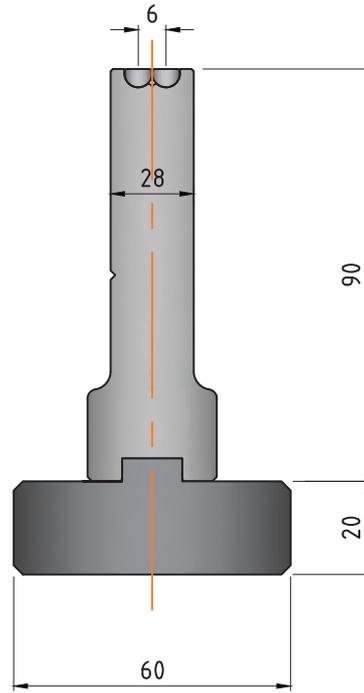
Tapered Flange without Bulging



Hole without Distortion

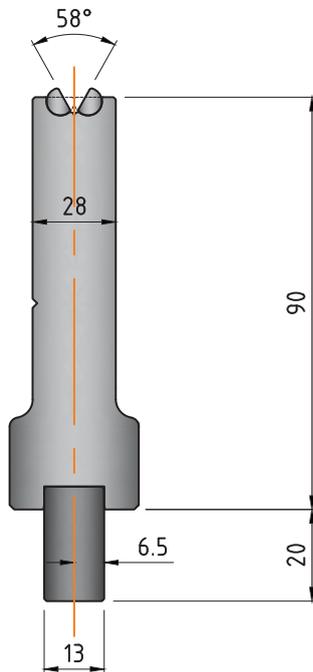
ROCKER DIE

6:C:i | ROCKER DIE 6CD



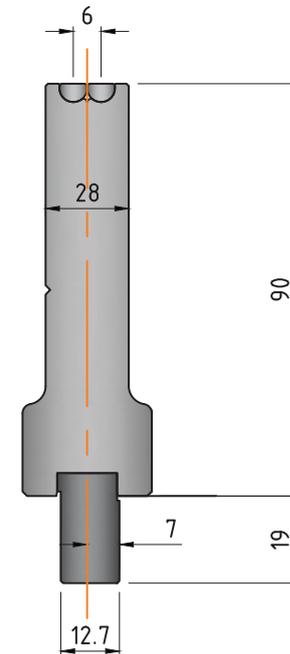
RDA 06

(Amada Type)



RDT 06

(Trumpf - Wila Type)

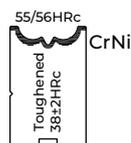


RDT 06

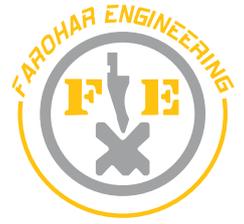
(LVD Type)

Material

Chrome Nickel Grade tool steel- Toughened 38±2HRC and Working Area Laser Hardened 55/56HRC.
Rocker Material : Chrome Vanadium Steel Vacuum Hardened 58±2HRC.

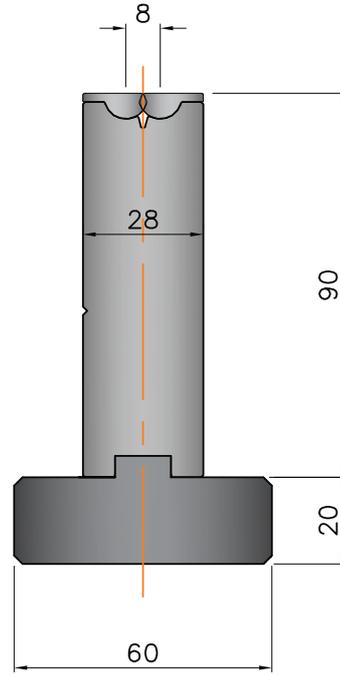


- Tonnage Capacity **80T/m**
- Minimum bend angle **58°**
- Max. Material Thk. **M.S. 2.5mm - S.S. 2mm**
- Maximum Outside Radius **R6**
- Minimum Possible Flange Length. **7.7mm**



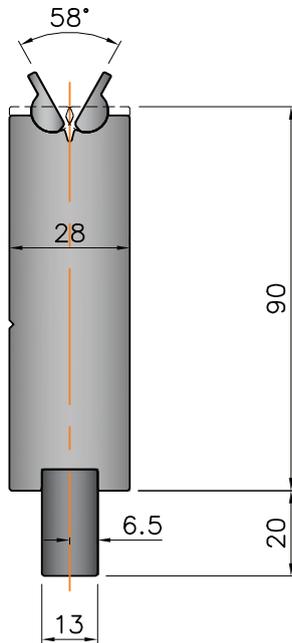
ROCKER DIE

6:C:ii | ROCKER DIE 8CD



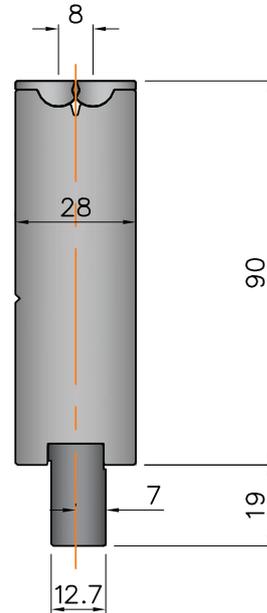
RDA 08

(Amada Type)



RDT 08

(Trumpf - Wila Type)

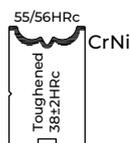


RDL 08

(LVD Type)

Material

Chrome Nickel Grade tool steel-
Toughened 38±2HRc
and Working Area Laser
Hardened 55/56HRc.
Rocker Material :
Chrome Vanadium Steel
Vacuum Hardened 58±2HRc.



Tonnage Capacity **40T/m**

Minimum bend angle **58°**

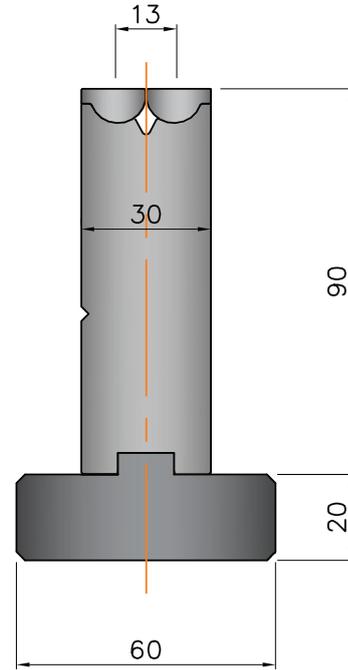
Max. Material Thk. **M.S. 1.6mm - S.S. 1.2mm**

Maximum Outside Radius **R3**

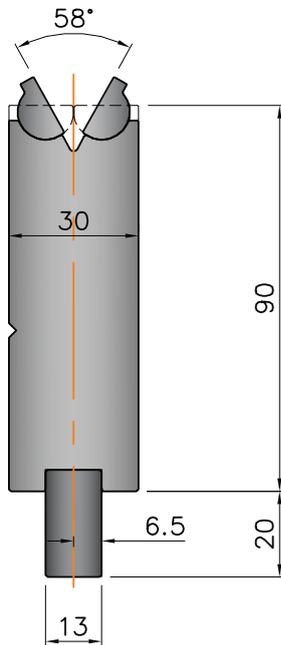
Minimum Possible Flange Length. **4.6mm**

ROCKER DIE

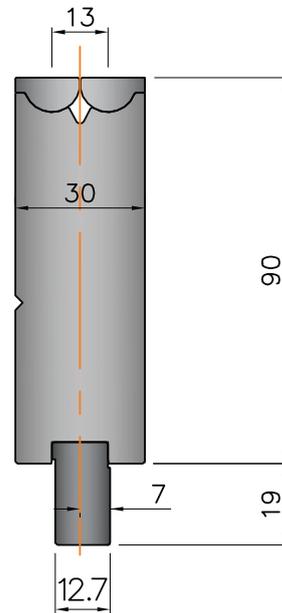
6:C:iii | ROCKER DIE 13CD



RDA 13
(Amada Type)



RDT 13
(Trumpf - Wila Type)



RDL 13
(LVD Type)

Material

Chrome Nickel Grade tool steel- Toughened 38±2HRC and Working Area Laser Hardened 55/56HRC.
Rocker Material : Chrome Vanadium Steel Vacuum Hardened 58±2HRC.

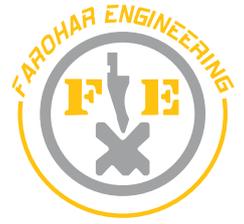


Chrome Vanadium Steel (Cr-V) (58±2HRC)



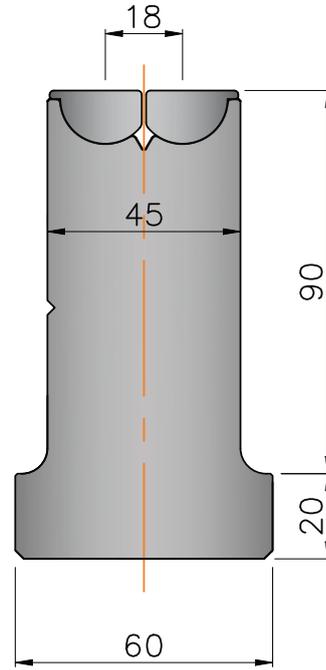
55/56HRC CrNi

- Tonnage Capacity **80T/m**
- Minimum bend angle **58°**
- Max. Material Thk. **M.S. 2.5mm - S.S. 2mm**
- Maximum Outside Radius **R6**
- Minimum Possible Flange Length. **7.7mm**



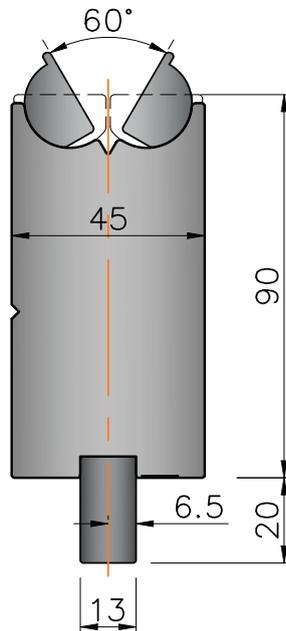
ROCKER DIE

6:C:iv | ROCKER DIE T8CD



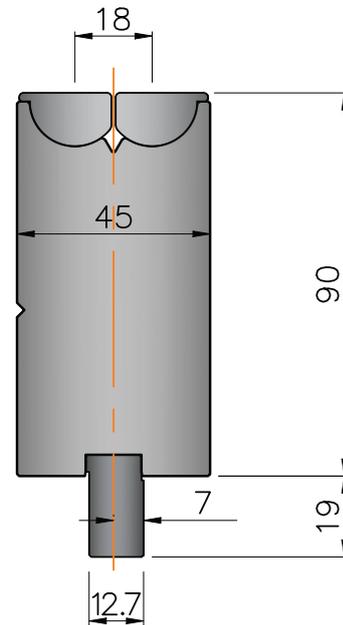
RDA 18

(Amada Type)



RDT 18

(Trumpf - Wila Type)

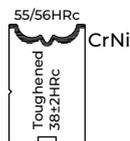


RDL 18

(LVD Type)

Material

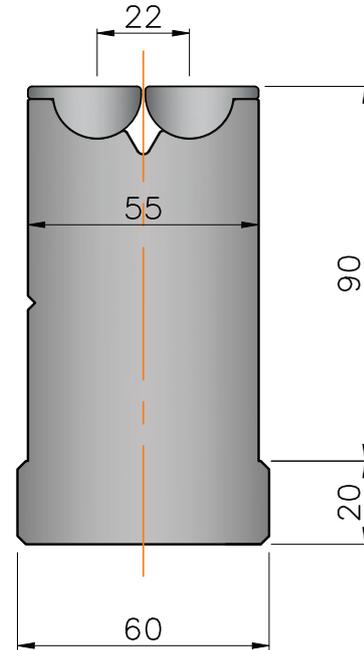
Chrome Nickel Grade tool steel-
Toughened 38±2HRC
and Working Area Laser
Hardened 55/56HRC.
Rocker Material :
Chrome Vanadium Steel
Vacuum Hardened 58±2HRC.



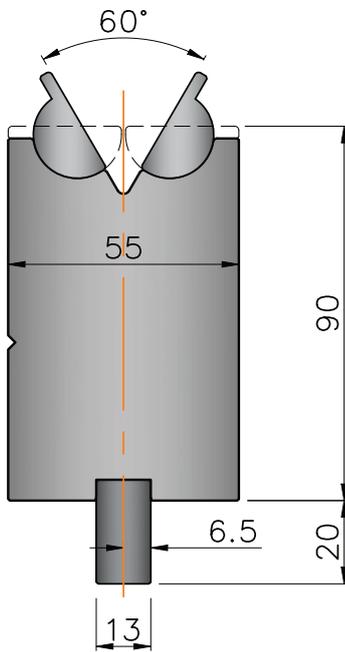
- Tonnage Capacity **120T/m**
- Minimum bend angle **60°**
- Max. Material Thk. **M.S. 4mm - S.S. 3mm**
- Maximum Outside Radius **R8**
- Minimum Possible Flange Length **11mm**

ROCKER DIE

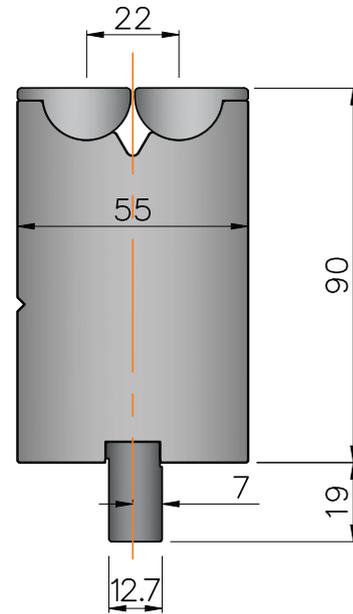
6:C:v | ROCKER DIE 22CD



RDA 22
(Amada Type)



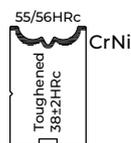
RDT 22
(Trumpf - Wila Type)



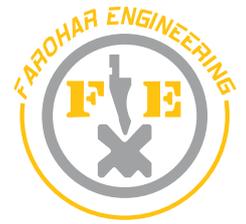
RDL 22
(LVD Type)

Material

Chrome Nickel Grade tool steel-
Toughened 38±2HRC
and Working Area Laser
Hardened 55/56HRC.
Rocker Material :
Chrome Vanadium Steel
Vacuum Hardened 58±2HRC.



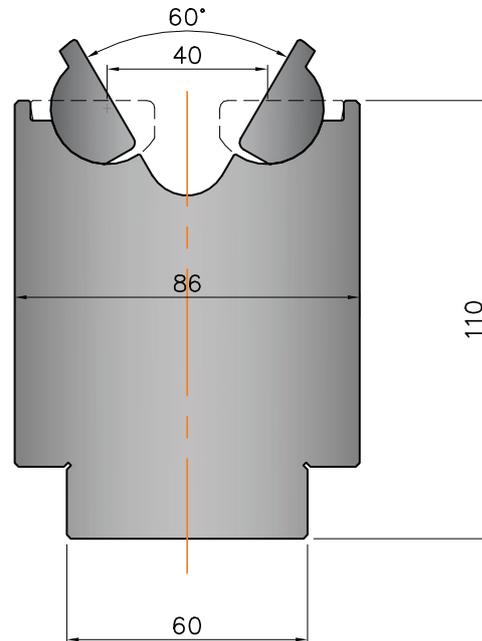
- Tonnage Capacity **150T/m**
- Minimum bend angle **60°**
- Max. Material Thk. **M.S. 5mm - S.S. 4mm**
- Maximum Outside Radius **R10**
- Minimum Possible Flange Length **13.5mm**



ROCKER DIE

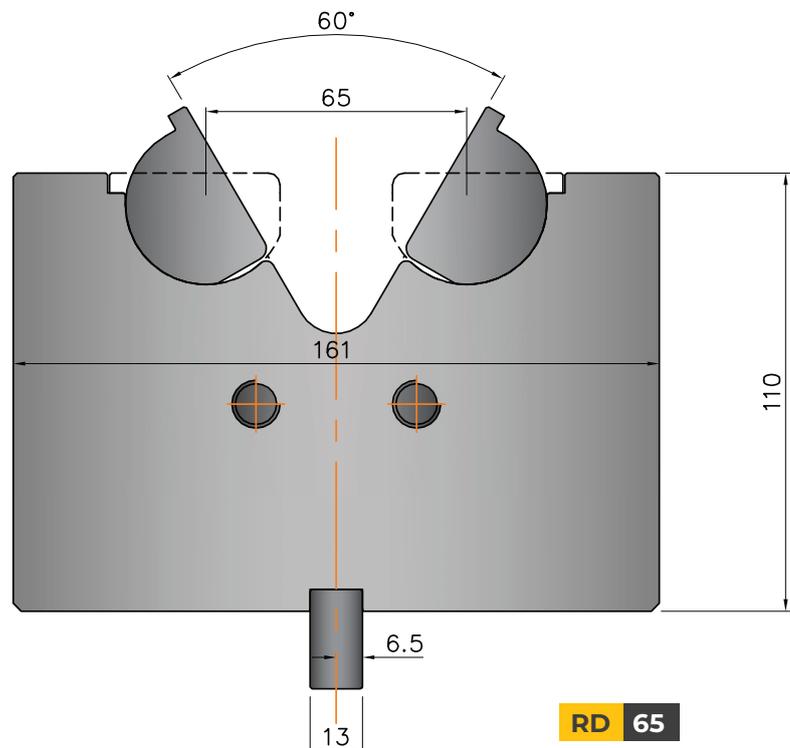
6:D | CUSTOMIZED ROCKER DIE

Rocker Die Can be customized and vary between RD8 to RD120 and other variants



RD 40

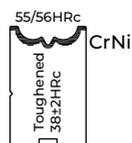
Die Mounting can be interchanged between Amada type, Self Centering type, Trumpf-Wila type, LVD type or to suit your machine



RD 65

Material

Chrome Nickel Grade tool steel- Toughened 38±2HRc and Working Area Laser Hardened 55/56HRc.
Rocker Material : Chrome Vanadium Steel Vacuum Hardened 58±2HRc.



Tonnage Capacity **150T/m**

Minimum bend angle **60°**

Max. Material Thk. **M.S. 5mm - S.S. 4mm**

Maximum Outside Radius **R10**

Minimum Possible Flange Length **13.5mm**

ROCKER DIE

6:E | ADAPTIVE ROCKER DIE - 1

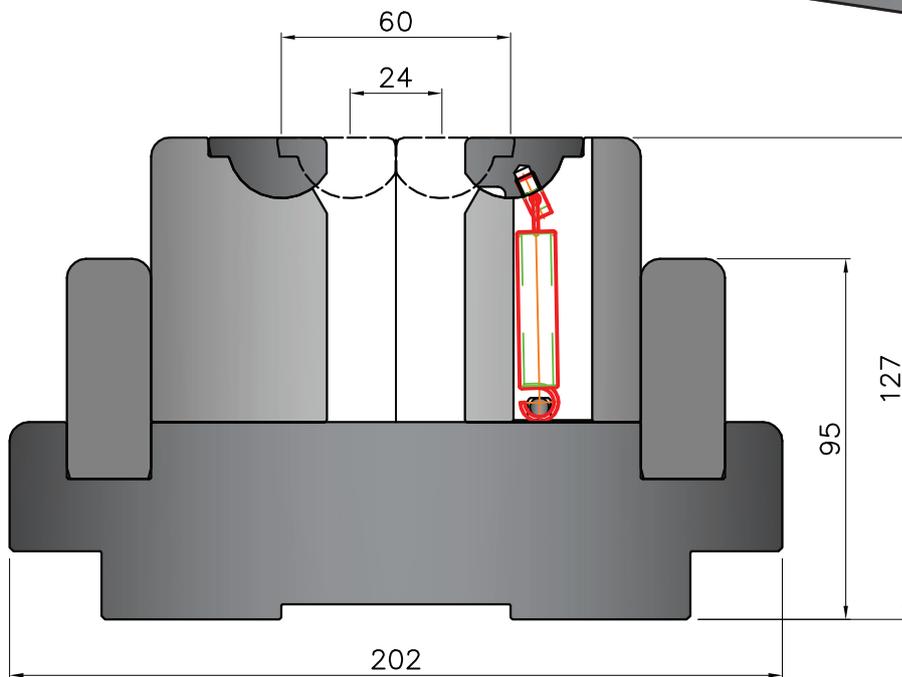
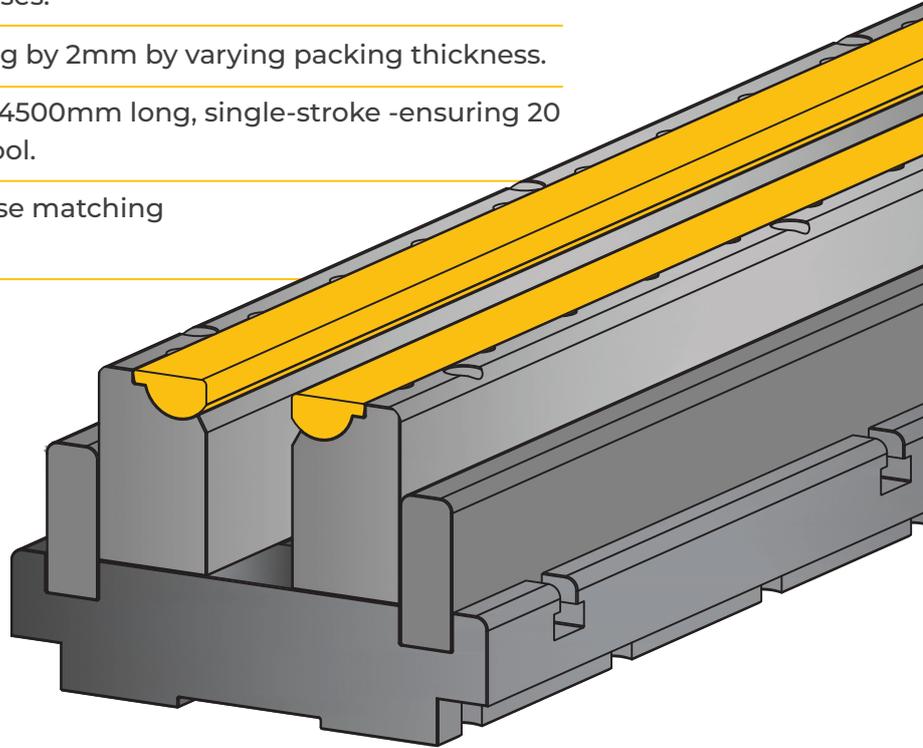
The Adaptive Rocker die is designed to meet diverse sheet metal needs.

Tool accommodates various combinations of minimum flange length and large radius in different thicknesses.

Freedom to increase Vee opening by 2mm by varying packing thickness.

In-house surface grinding up to 4500mm long, single-stroke -ensuring 20 microns accuracy through out tool.

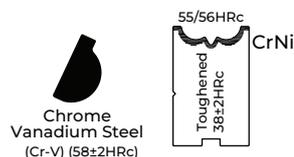
CNC machined cavities for precise matching and interchangeability.



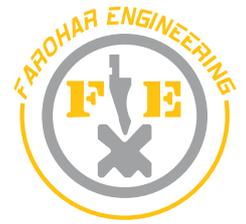
Japanese Spring

Material

Chrome Nickel Grade tool steel- Toughened 38±2HRC and Working Area Laser Hardened 55/56HRC.
Rocker Material : Chrome Vanadium Steel Vacuum Hardened 58±2HRC.

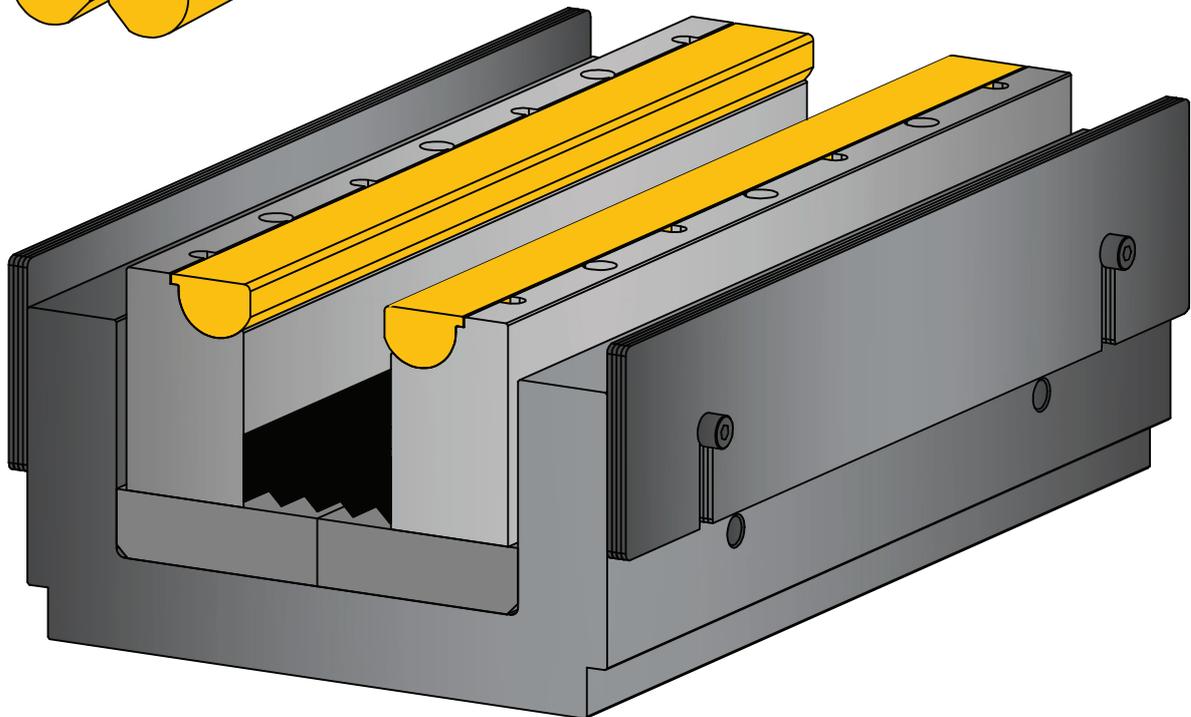
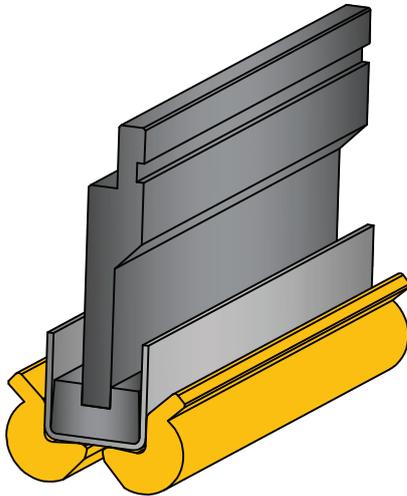


- Tonnage Capacity **150T/m**
- Minimum bend angle **60°**
- Max. Material Thk. **M.S. 5mm - S.S. 4mm**
- Maximum Outside Radius **R10**
- Minimum Possible Flange Length **13.5mm**



ROCKER DIE

6:F | ADAPTIVE ROCKER DIE - 2

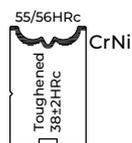


Max. Tonnage capacity 200T/m.

Outside channel Range 45~120- ARD2

Material

Chrome Nickel Grade tool steel-
Toughened 38±2HRC
and Working Area Laser
Hardened 55/56HRC.
Rocker Material :
Chrome Vanadium Steel
Vacuum Hardened 58±2HRC.



Tonnage Capacity **200T/m**

Minimum bend angle **58°**

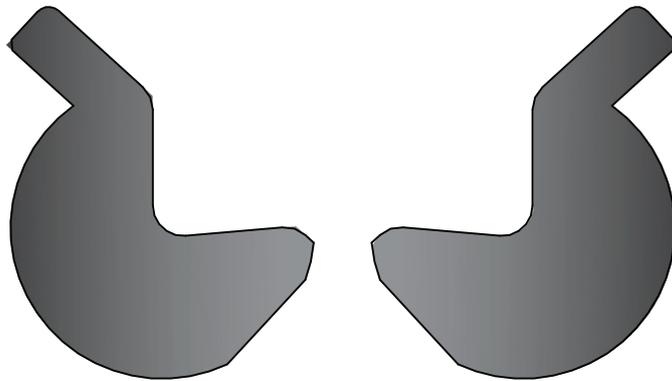
Max. Material Thk. **M.S. 16mm - S.S. 12mm**

Maximum Outside Radius **R15/R60**

Minimum Possible Flange Length **20.2/76.8**

ROCKER DIE

6:G | TYPES OF ROCKER INSERT



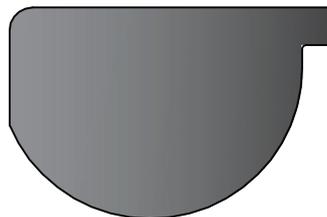
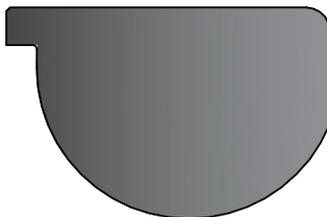
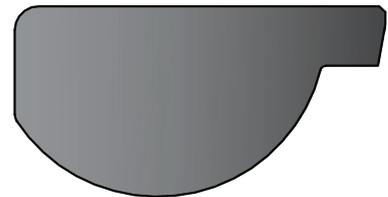
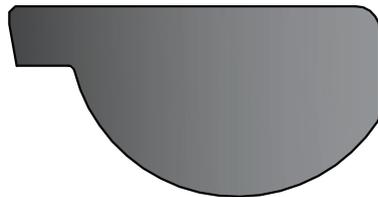
CHANNEL BENDING

28~60 ARD1

45~120 ARD2

Outside Channel Range

ARD 01
24 ~ 60CD
Max. 60°



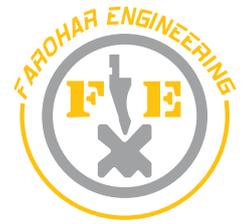
ARD 02
42 ~ 120CD
Max. 60°

Material

Rocker Material :
Chrome Vanadium Steel Vacuum
Hardened 58±2HRC.

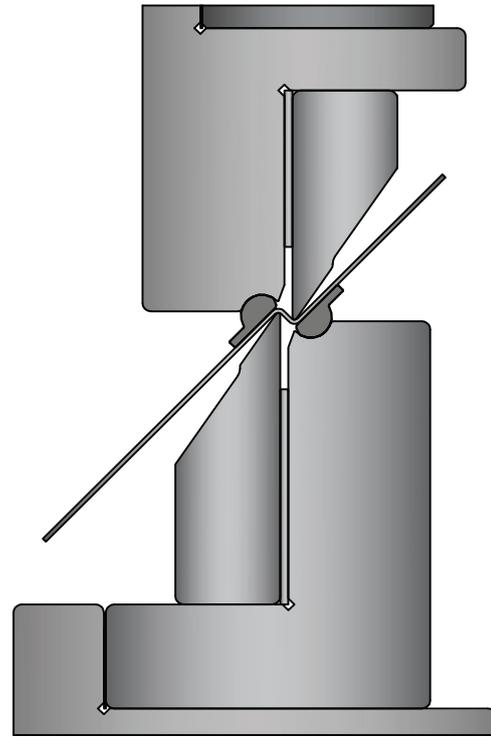
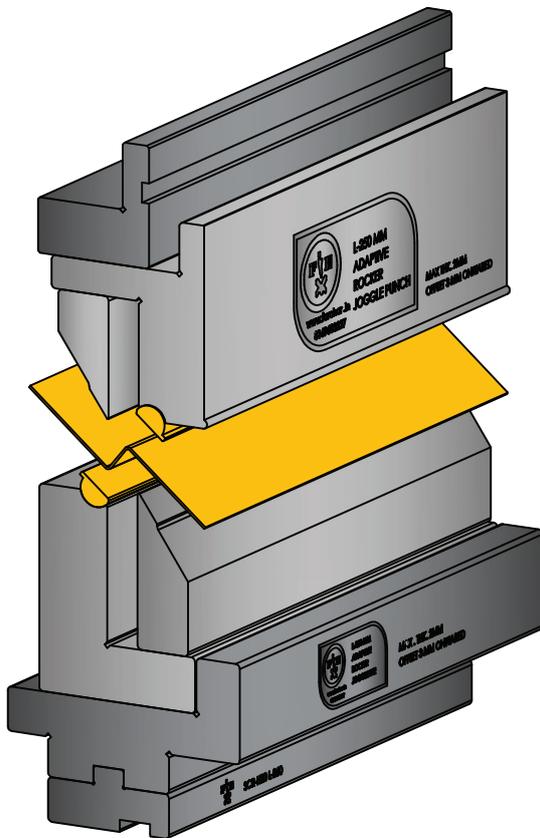


Chrome Vanadium Steel Vacuum
Hardened 58±2HRC.



ROCKER DIE

6:H | ADAPTIVE JOGGLE TOOL



ADVANTAGES

Versatility: Rocker Joggle dies offer versatility in bending operations, accommodating various materials and thickness.

Durability: Rockers Engineered with Chrome Vanadium Steel max. Robustness 58HRc. Rocker Holder-Chrome Nickel Steel Toughened 38HRc, Laser Hardened 52HRc.

Precision: They provide precise bending angles and dimensions, ensuring accurate and consistent results.

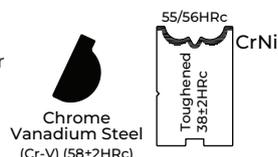
Efficiency: Rocker Joggle dies streamline the bending process, allowing for faster production and reduced setup times.

Flexibility: With adjustable settings and interchangeable components, Rocker Joggle dies offer flexibility to meet different bending requirements and adapt to change.

Material

Chrome Nickel Grade tool steel-
Toughened 38±2HRc and Working Area Laser
Hardened 55/56Hrc.

Rocker Material : Chrome Vanadium Steel
Vacuum Hardened 58±2HRc.



For more details refer page No.

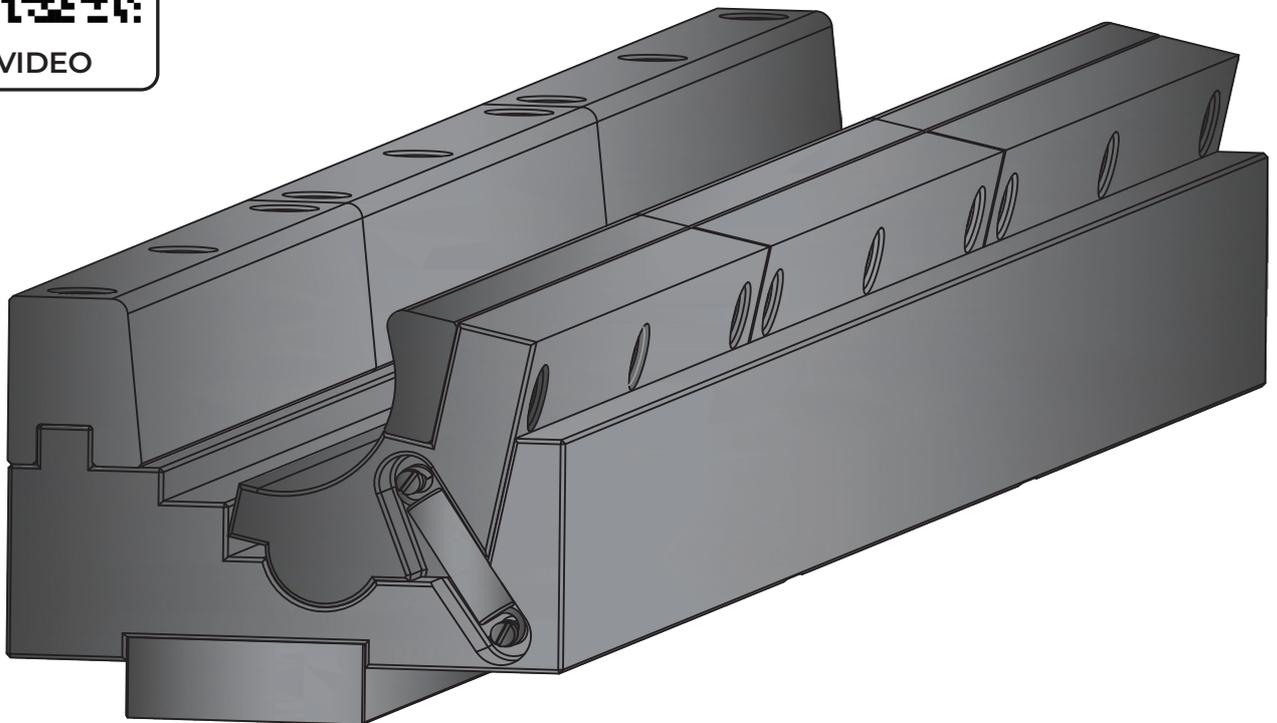
141

ROCKER DIE

6:1 | U-BEND ROCKER DIE

Advantages of a U-Bend Rocker Die

- 1. Decreased Forming Load**
 The oscillating motion during deformation distributes the forming stresses more evenly over the material, resulting in a reduction of the required pressing force and tonnage.
- 2. Allow large radius and parallel bends**
 The tool's design lets you adjust the machine stroke to compensate for spring-back, ensuring you hit the exact bend angle every time.
- 3. Superior Surface Finish in formed component**
 Reduced sliding friction and more uniform material flow result in fewer surface imperfections on visible or critical components.
 Increased Die Life Through Distributed Wear



Material

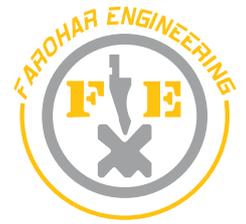
Chrome Nickel Grade tool steel-
 Toughened $38\pm 2\text{HRC}$ and Working Area Laser
 Hardened $55/56\text{Hrc}$.
 Rocker Material : Chrome Vanadium Steel
 Vacuum Hardened $58\pm 2\text{HRC}$.



Chrome
 Vanadium Steel
 (Cr-V) ($58\pm 2\text{HRC}$)



$55/56\text{HRC}$
 CrNi
 Toughened
 $38\pm 2\text{HRC}$



ROCKER DIE

6:J | ROCKER WIPING TOOL

Extended sheet bending prevents sheet lifting.

Robust Rocker

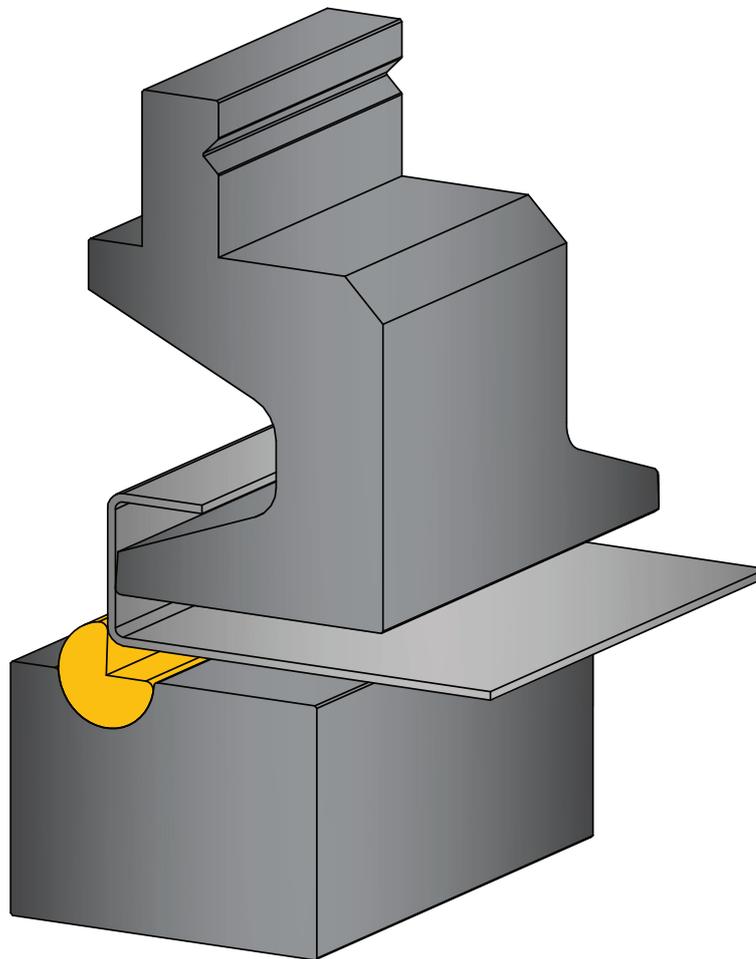
Precise over-bending to counter spring back.

For long panel bend.

Customised to your bending requirement.

With horn hold down tool both ends to form complete panel.

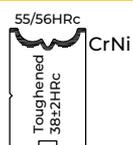
Max. Thickness **3mm**



Material

Chrome Nickel Grade tool steel-
Toughened $38\pm 2\text{HRC}$ and Working Area Laser
Hardened $55/56\text{Hrc}$.

Rocker Material : Chrome Vanadium Steel
Vacuum Hardened $58\pm 2\text{HRC}$.



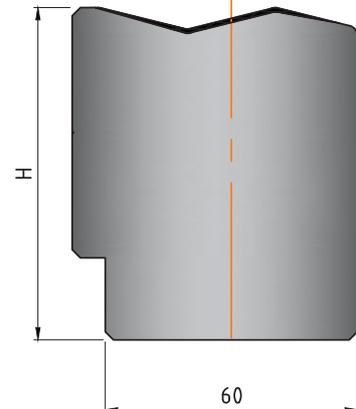
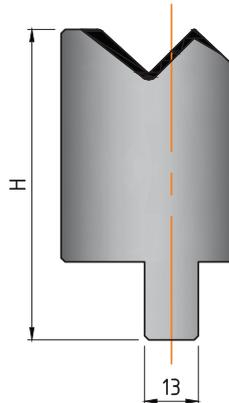
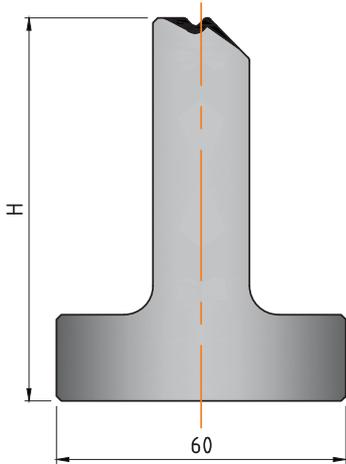
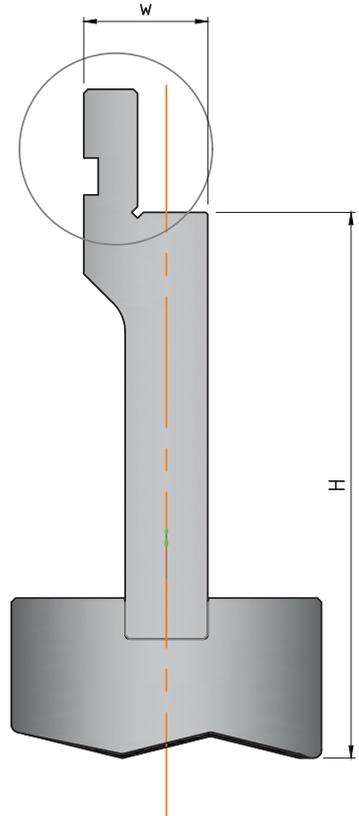
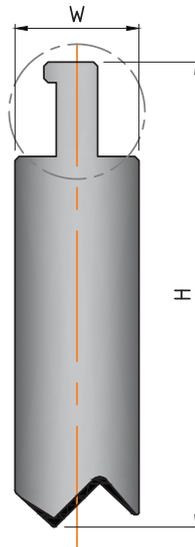
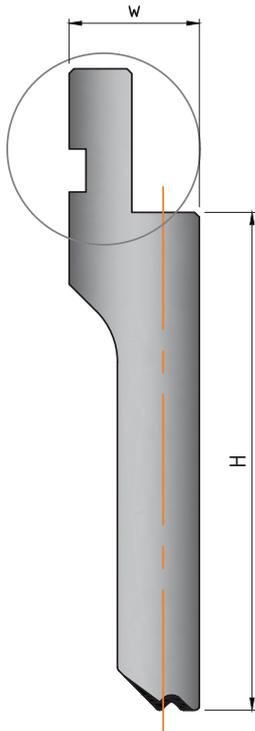
Z-BEND

7:A | FIXED TYPE Z - BEND TOOL

NECK HOLDING AVAILABLE IN

- N01 EUROPEAN/AMADA TYPE
- N02 ONE TOUCH/AMADA TYPE
- N03 WILLA TYPE TYPE
- N06 AMERICAN SAFETY TYPE
- N07 DARLEY TYPE
- N08 BYSTRONIC TYPE
- N09 GASPARINI TYPE

NOTE:- NECK HOLDING DETAIL IS GIVEN IN MAIN CATALOG PAGE NO. 09



Material Option

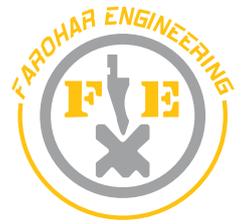
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





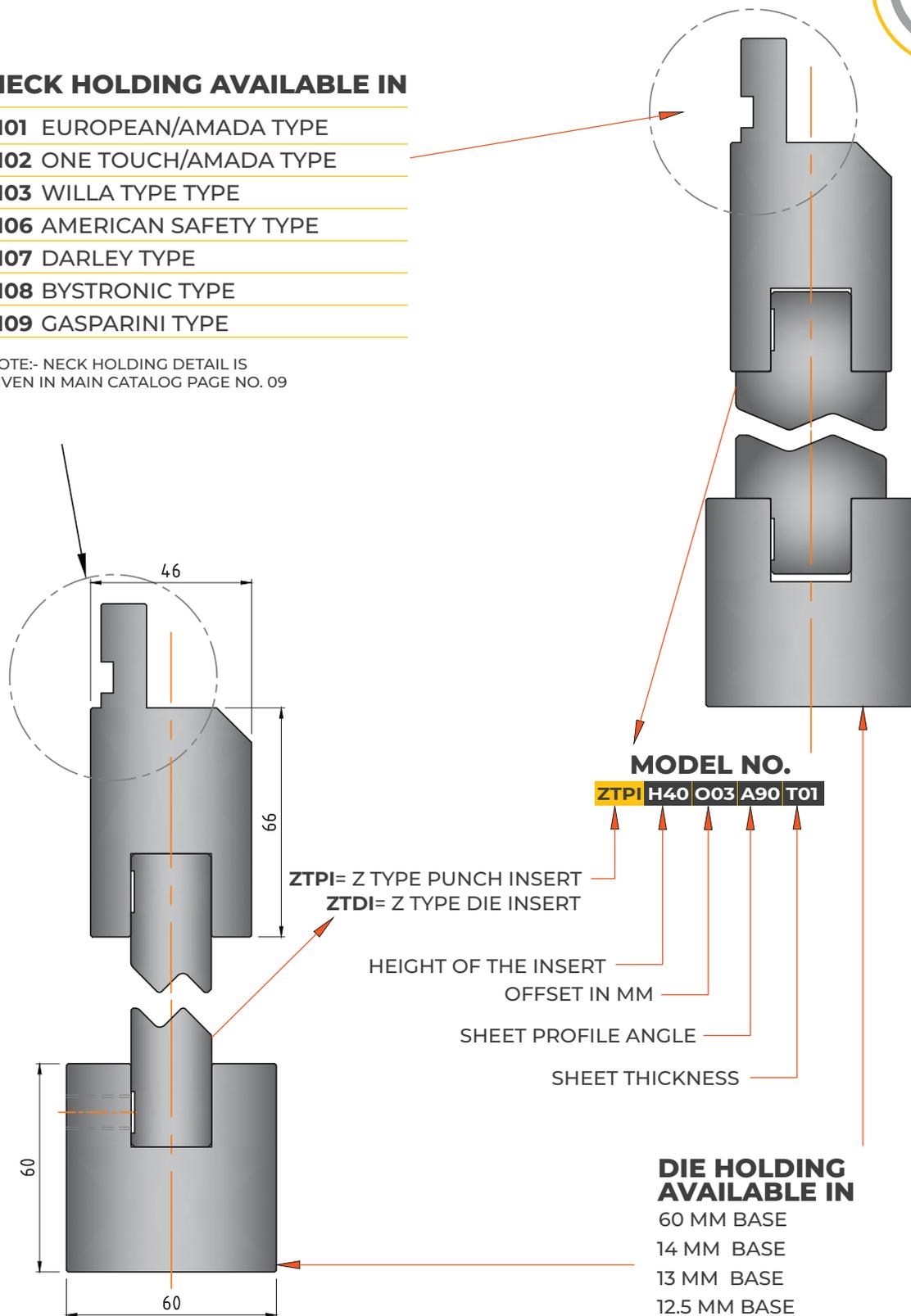
Z-BEND

7:B | Z - BEND INSERT HOLDER

NECK HOLDING AVAILABLE IN

- N01 EUROPEAN/AMADA TYPE
- N02 ONE TOUCH/AMADA TYPE
- N03 WILLA TYPE TYPE
- N06 AMERICAN SAFETY TYPE
- N07 DARLEY TYPE
- N08 BYSTRONIC TYPE
- N09 GASPARINI TYPE

NOTE:- NECK HOLDING DETAIL IS GIVEN IN MAIN CATALOG PAGE NO. 09



Material Option

M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRc.
 Tip Induction Hardened 52±2HRc.



Material Option

M-02 Economy grade.
 C45 : 570-680 N/mm²
 (Plain Carbon Steel)
 Tip Induction Hardened 52±2HRc.



Z-BEND

7:C | Z - BEND INSERT TOOL

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 60 23	ZTIP H60 O03_A90° T01 <table border="1"> <tr><td>Sheet Thickness</td><td>1 MM</td></tr> <tr><td>Offset Z</td><td>3 MM</td></tr> <tr><td>Angle</td><td>90°</td></tr> <tr><td>Max. Tonnage</td><td>100 T/m</td></tr> </table>	Sheet Thickness	1 MM	Offset Z	3 MM	Angle	90°	Max. Tonnage	100 T/m	 60 23	ZTIP H60 O05_A90° T01 <table border="1"> <tr><td>Sheet Thickness</td><td>1 MM</td></tr> <tr><td>Offset Z</td><td>5 MM</td></tr> <tr><td>Angle</td><td>90°</td></tr> <tr><td>Max. Tonnage</td><td>100 T/m</td></tr> </table>	Sheet Thickness	1 MM	Offset Z	5 MM	Angle	90°	Max. Tonnage	100 T/m
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Offset Z	3 MM																		
Angle	90°																		
Max. Tonnage	100 T/m																		
Sheet Thickness	1 MM																		
Offset Z	5 MM																		
Angle	90°																		
Max. Tonnage	100 T/m																		
 23 60	ZTIP H60 O10_A90° T01	 23 4.0	ZTIP H40 O05_A135° T01																
 60 23	ZTIP H60 O10_A90° T01 <table border="1"> <tr><td>Sheet Thickness</td><td>1 MM</td></tr> <tr><td>Offset Z</td><td>10 MM</td></tr> <tr><td>Angle</td><td>90°</td></tr> <tr><td>Max. Tonnage</td><td>100 T/m</td></tr> </table>	Sheet Thickness	1 MM	Offset Z	10 MM	Angle	90°	Max. Tonnage	100 T/m	 4.0 23	ZTIP H60 O05_A135° T01 <table border="1"> <tr><td>Sheet Thickness</td><td>1 MM</td></tr> <tr><td>Offset Z</td><td>5 MM</td></tr> <tr><td>Angle</td><td>135°</td></tr> <tr><td>Max. Tonnage</td><td>100 T/m</td></tr> </table>	Sheet Thickness	1 MM	Offset Z	5 MM	Angle	135°	Max. Tonnage	100 T/m
Sheet Thickness	1 MM																		
Offset Z	10 MM																		
Angle	90°																		
Max. Tonnage	100 T/m																		
Sheet Thickness	1 MM																		
Offset Z	5 MM																		
Angle	135°																		
Max. Tonnage	100 T/m																		

Material Option

M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRc.
 Tip Induction Hardened 52±2HRc.



Material Option

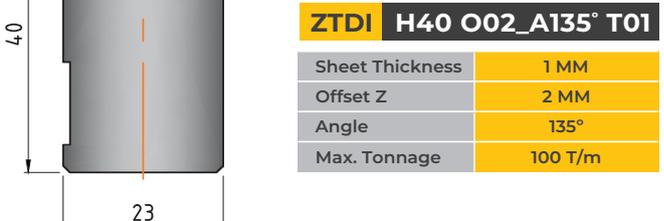
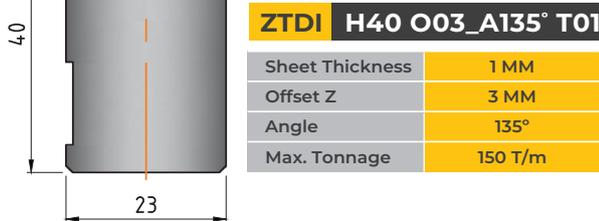
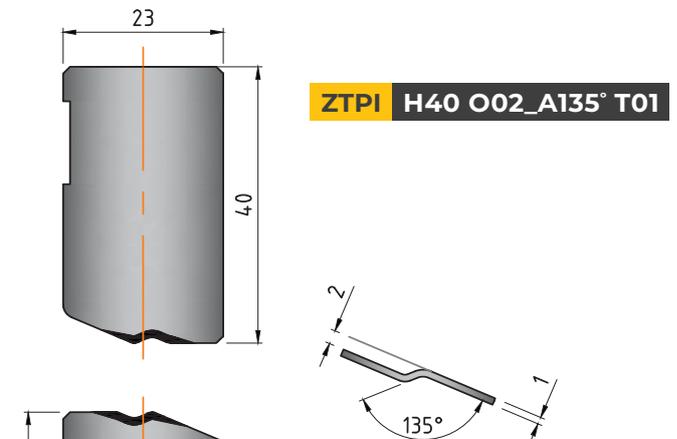
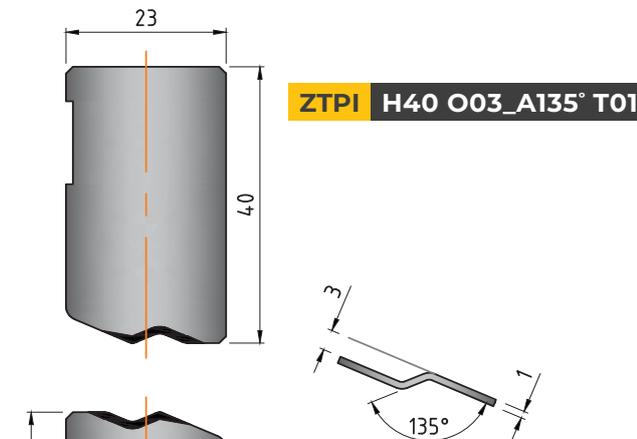
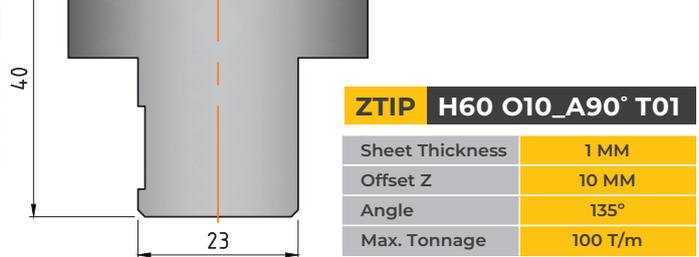
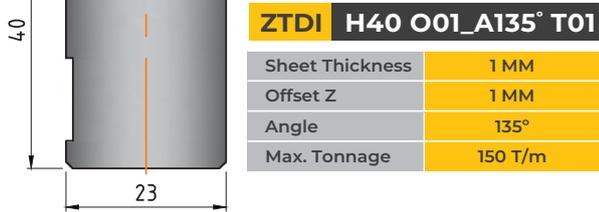
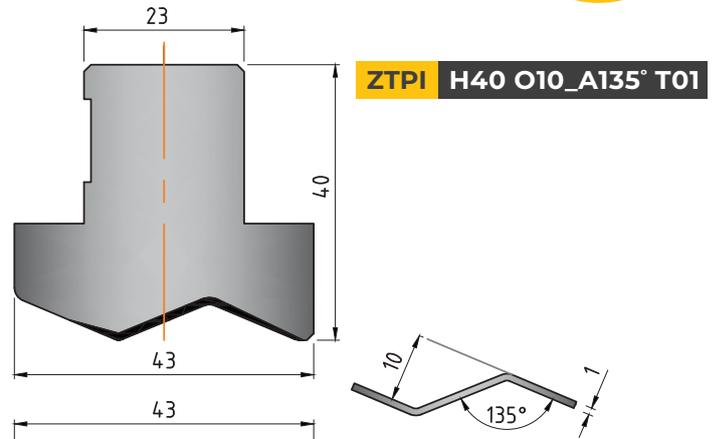
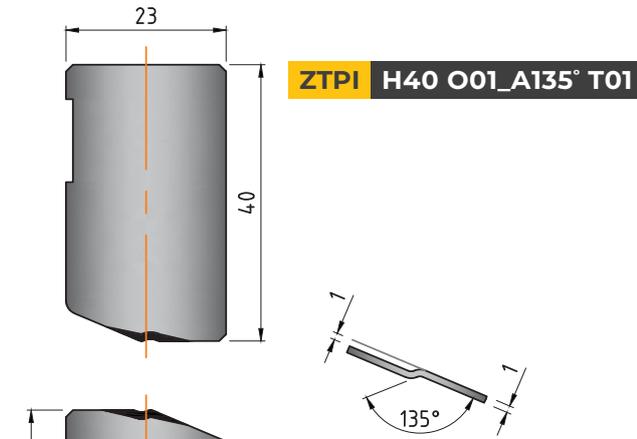
M-02 Economy grade.
 C45 : 570-680 N/mm²
 (Plain Carbon Steel)
 Tip Induction Hardened 52±2HRc.





Z-BEND

7:C | Z - BEND INSERT TOOL



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



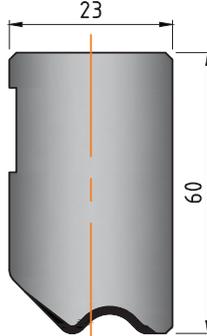
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



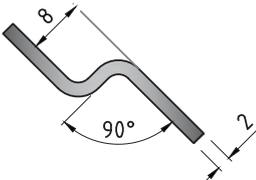
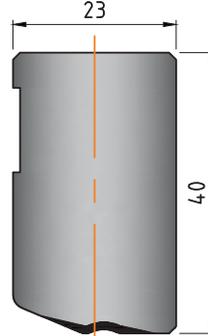
Z-BEND

7:C | Z - BEND INSERT TOOL



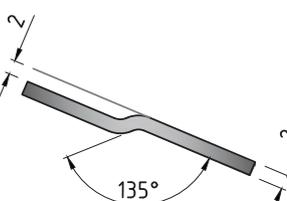
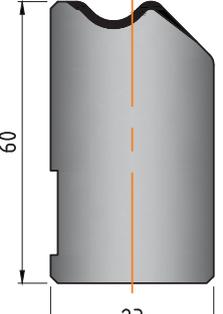
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MODEL NO.
ZTPI-H60-O08-A90-T02

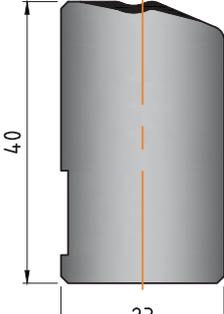
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MODEL NO.
ZTPI-H40-O02-A135-T02

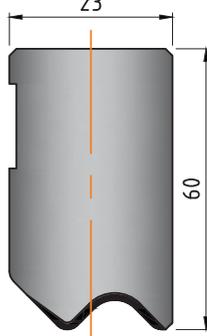
ZTDI H60 O08_A90° T02

Sheet Thickness	2 MM
Offset Z	8 MM
Angle	90°
Max. Tonnage	100 T/m

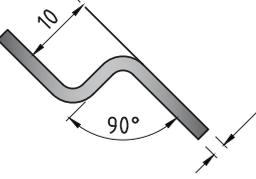


ZTIP H40 O02_A135° T02

Sheet Thickness	2 MM
Offset Z	2 MM
Angle	135°
Max. Tonnage	150 T/m

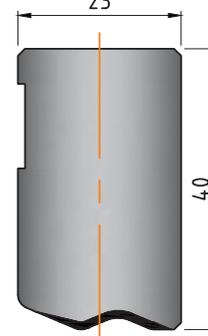


ZTPI H60 O10_A90° T02

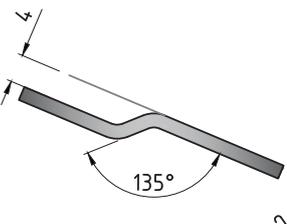


ZTDI H60 O10_A90° T02

Sheet Thickness	2 MM
Offset Z	10 MM
Angle	90°
Max. Tonnage	100 T/m



ZTPI H40 O04_A135° T02



ZTDI H40 O04_A135° T02

Sheet Thickness	2 MM
Offset Z	4 MM
Angle	135°
Max. Tonnage	100 T/m

Material Option

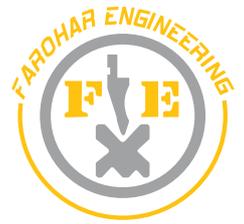
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

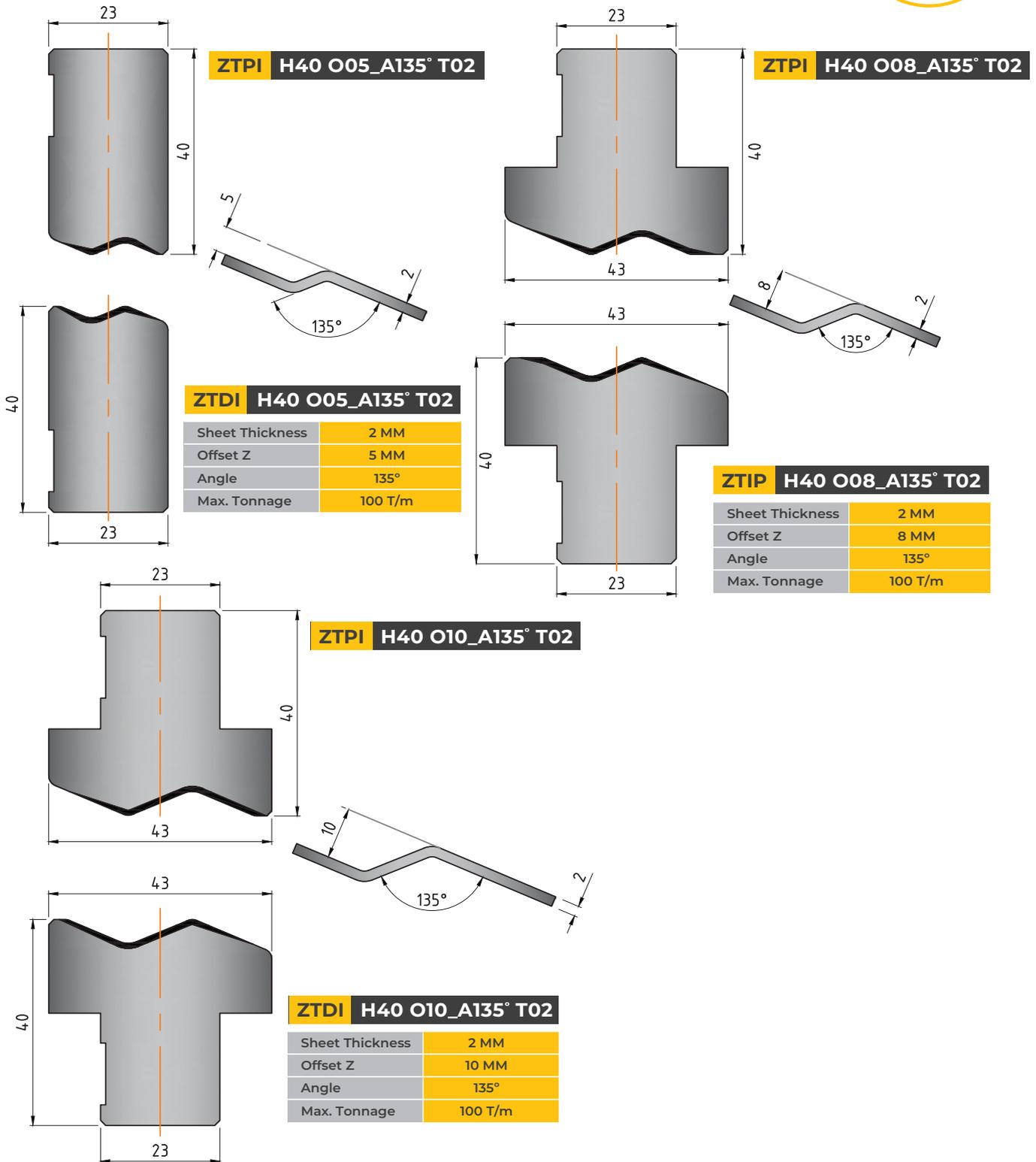
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





Z-BEND

7:C | Z - BEND INSERT TOOL



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



7:C | Z - BEND INSERT TOOL

Z-BEND

ZTPI H60 O09_A90° T03

ZTDI H60 O09_A90° T03

Sheet Thickness	3 MM
Offset Z	9 MM
Angle	90°
Max. Tonnage	100 T/m

ZTPI H40 O03_A135° T03

ZTIP H40 O03_A135° T03

Sheet Thickness	3 MM
Offset Z	3 MM
Angle	135°
Max. Tonnage	150 T/m

ZTPI H60 O10_A90° T03

ZTDI H60 O10_A90° T03

Sheet Thickness	3 MM
Offset Z	10 MM
Angle	90°
Max. Tonnage	100 T/m

ZTPI H40 O05_A135° T03

ZTDI H40 O05_A135° T03

Sheet Thickness	3 MM
Offset Z	5 MM
Angle	135°
Max. Tonnage	150 T/m

Material Option

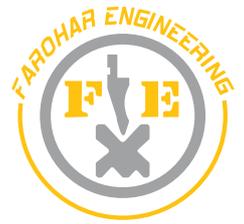
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

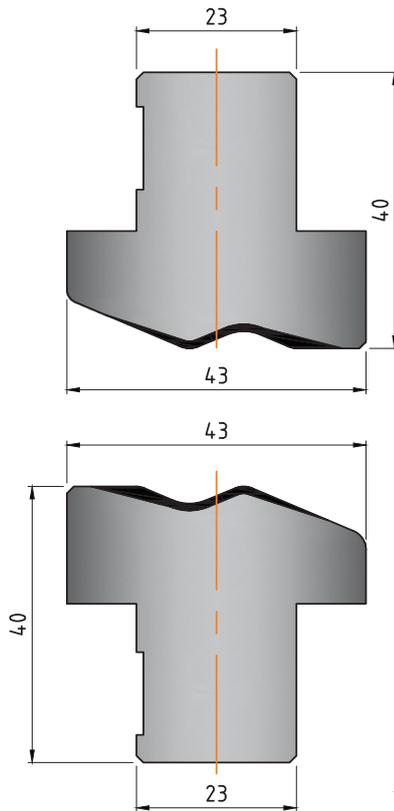
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



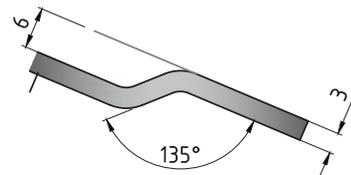


Z-BEND

7:C | Z - BEND INSERT TOOL

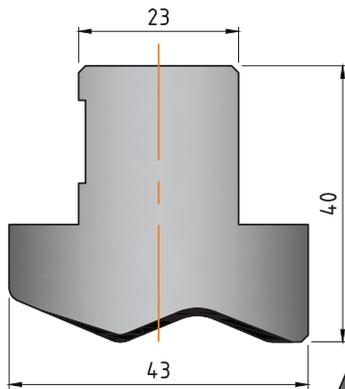


ZTPI H40 O06_A135° T03

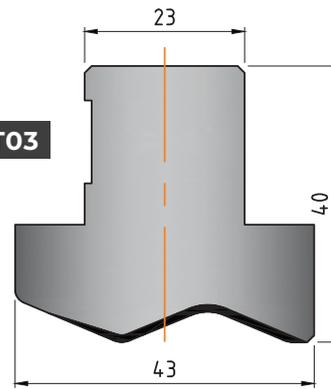
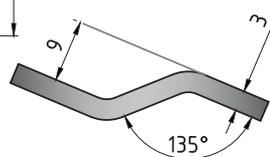


ZTIP H40 O06_A135° T03

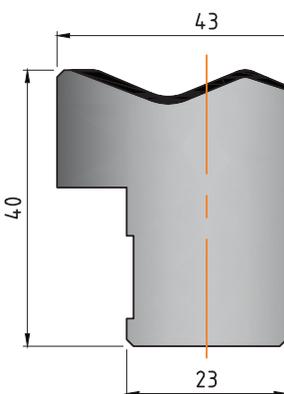
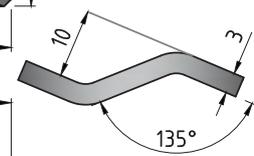
Sheet Thickness	3 MM
Offset Z	6 MM
Angle	135°
Max. Tonnage	100 T/m



ZTPI H40 O09_A135° T03

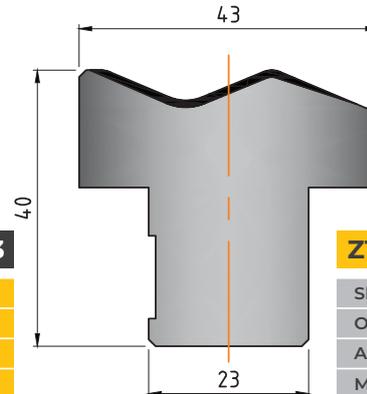


ZTPI H40 O10_A135° T03



ZTDI H40 O09_A135° T03

Sheet Thickness	3 MM
Offset Z	9 MM
Angle	135°
Max. Tonnage	100 T/m



ZTDI H40 O10_A135° T03

Sheet Thickness	3 MM
Offset Z	10 MM
Angle	135°
Max. Tonnage	100 T/m

Material Option

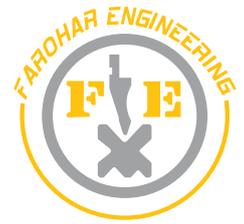
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

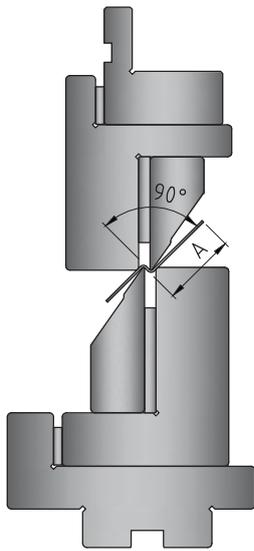
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



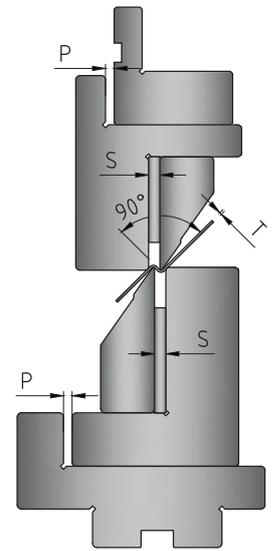


Z-BEND

7:D | ADAPTIVE JOGGLE TOOL

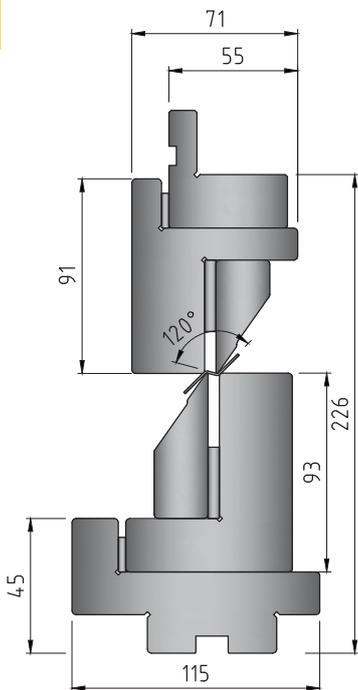


ADAPTIVE JOGGLE TOOL SHIM AND OFFSET SIZE								
SR NO.	ANGLE	OFFSET	SHEET THICKNESS (T)					
			1		2		3	
			SHIM P	SHIM S	SHIM P	SHIM S	SHIM P	SHIM S
1	90°	2	0.99	1.2				
2	90°	4	3.16	4.08	3.16	4.07		
3	90°	6	5.07	6.69	5.28	6.9	5.28	6.9
4	90°	8	7.19	9.52	7.4	9.73	7.4	9.73
5	90°	10	9.31	12.35	9.52	12.56	9.52	12.56
6	90°	12	11.44	15.18	11.64	15.38	11.64	15.38
7	90°	14	13.56	18.01	13.76	18.21	13.76	18.21



ADAPTIVE PROPERTIES OF TOOL

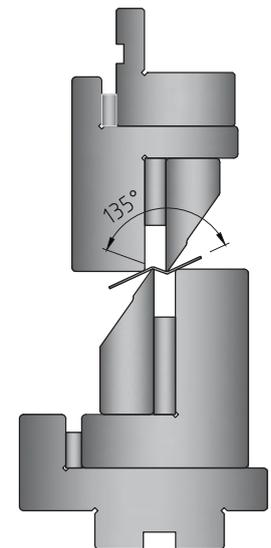
- 1) FLEXIBLE FOR SHEET THICKNESS 1 MM, 2MM, 3MM
- 2) USED TO OBTAIN VARIES ANGLE & RESPECTIVE OFFSET BY CHANGING SHIM



MODEL NO.- ARJT-01

ANGLE	SHEET OFFSET RANGE WITH 0.5 INCREMENT
90°	6.5 MM TO 18 MM
120°	4.8 MM TO 13 MM
135°	2.8 MM TO 10 MM

AVAILABLE WITH CUSTOMIZED OFFSET RANGE & TOOL HOLDING TYPE



Material Option

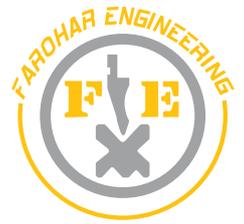
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

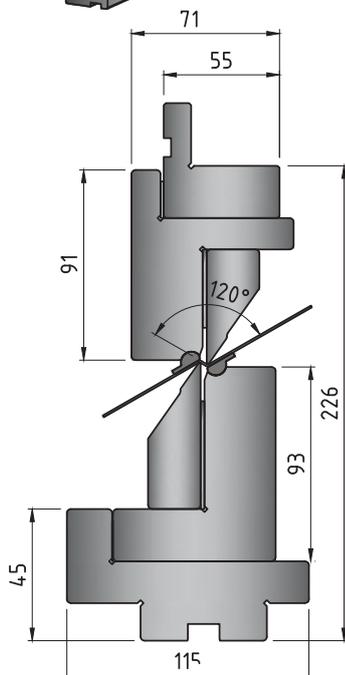
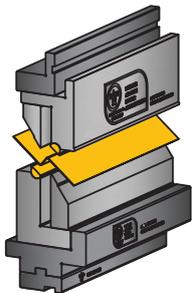
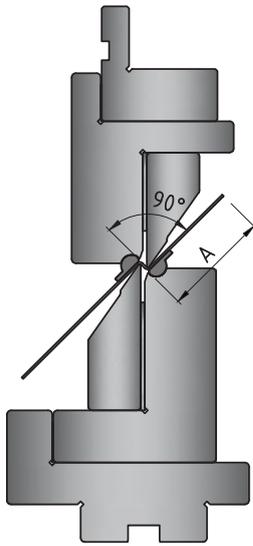
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





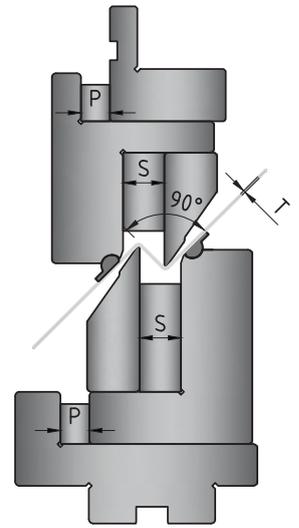
Z-BEND

7:E | ADAPTIVE ROCKER JOGGLE TOOL



ADAPTIVE JOGGLE TOOL SHIM AND OFFSET SIZE

SR NO.	SHEET THK	ANGLE	OFFSET (B)	MIN. FLANGE A	SHIM S	SHIM P
1	1~3	90°	6	8.41	2.64	1.02
2	1~3	90°	8	11.41	5.47	3.14
3	1~3	90°	10	14.41	8.3	5.26
4	1~3	90°	12	17.41	11.12	7.38
5	1~3	90°	14	20.41	13.95	9.5
6	1~3	90°	16	23.4	16.78	11.62
7	1~3	90°	17	24.9	18.19	12.68
8	1~3	120°	5	8.6	2.82	1.15
9	1~3	120°	6	10.43	4.55	2.45
10	1~3	120°	8	14.11	8.01	5.05
11	1~3	120°	10	17.78	11.48	7.65
12	1~3	120°	12	21.45	14.94	10.24
13	1~3	135°	4	7.25	1.55	0.2
14	1~3	135°	6	11.17	5.24	2.97
15	1~3	135°	8	15.09	8.94	5.74
16	1~3	135°	10	19.01	12.63	8.51



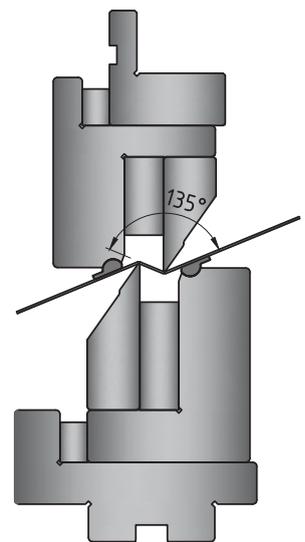
ADAPTIVE PROPERTIES OF TOOL

- 1) FLEXIBLE FOR SHEET THICKNESS 1 MM, 2MM, 3MM
- 2) OBTAIN VARIES ANGLE & RESPECTIVE OFFSET IN THE SAME TOOL FOR MORE VARIATION CONTACT US

MODEL NO.- ARJT-01

ANGLE	SHEET OFFSET RANGE WITH 0.5 INCREMENT
90°	6.5 MM TO 18 MM
120°	4.8 MM TO 13 MM
135°	2.8 MM TO 10 MM

AVAILABLE WITH CUSTOMIZED OFFSET RANGE & TOOL HOLDING TYPE



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



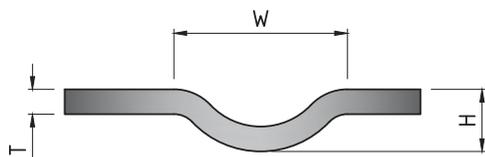
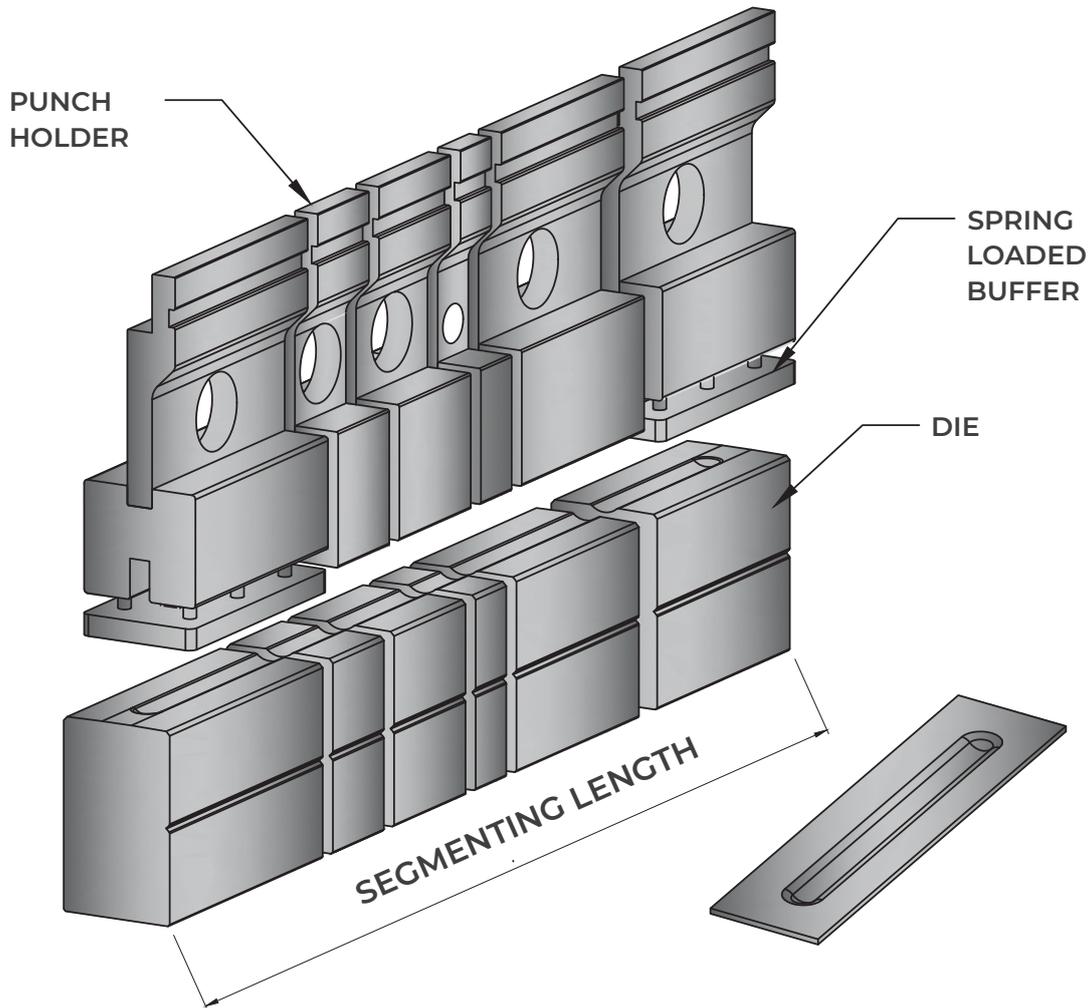
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



BEADING PUNCH AND DIE

8:A | CLOSED PROFILE BEADING



BEADING PROFILE DETAIL		
THICKNESS IN MM	H	W
0.5	5	2.5
1	6	3
1.2	7	3
1.6	8	3
2	10	5
CUSTOM MFG AS PER REQUIRED		

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

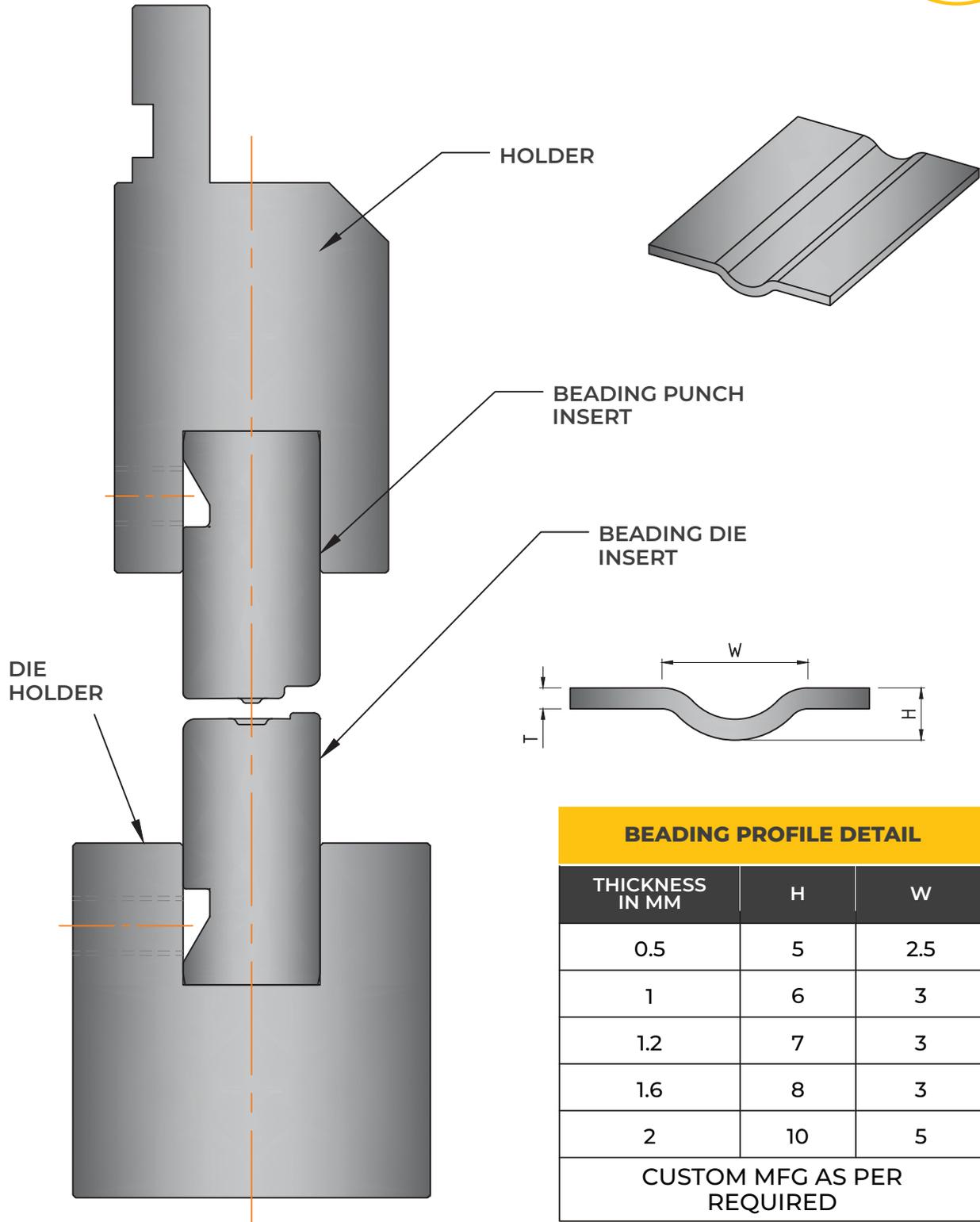
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





BEADING PUNCH AND DIE

8:B | OPEN PROFILE BEADING INSERT TYPE



BEADING PROFILE DETAIL		
THICKNESS IN MM	H	W
0.5	5	2.5
1	6	3
1.2	7	3
1.6	8	3
2	10	5
CUSTOM MFG AS PER REQUIRED		

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

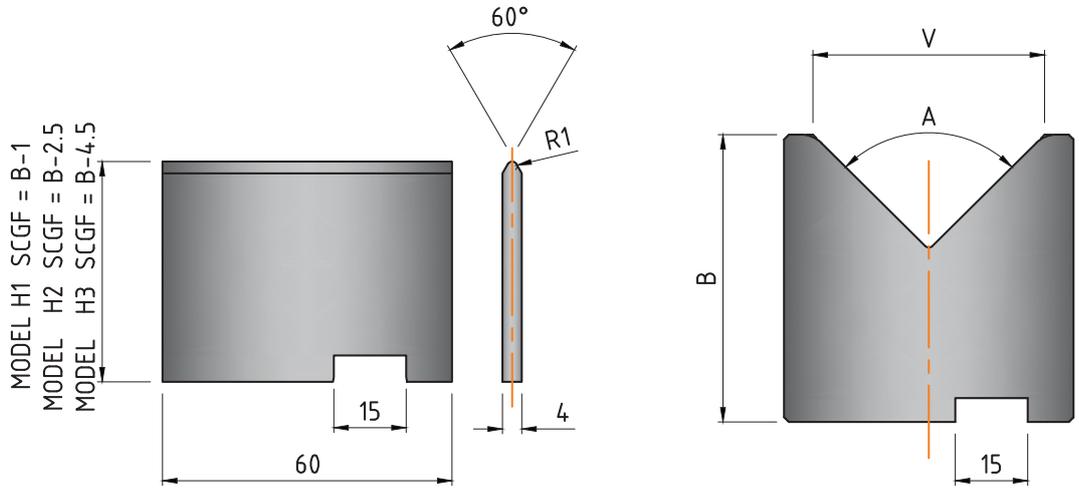
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



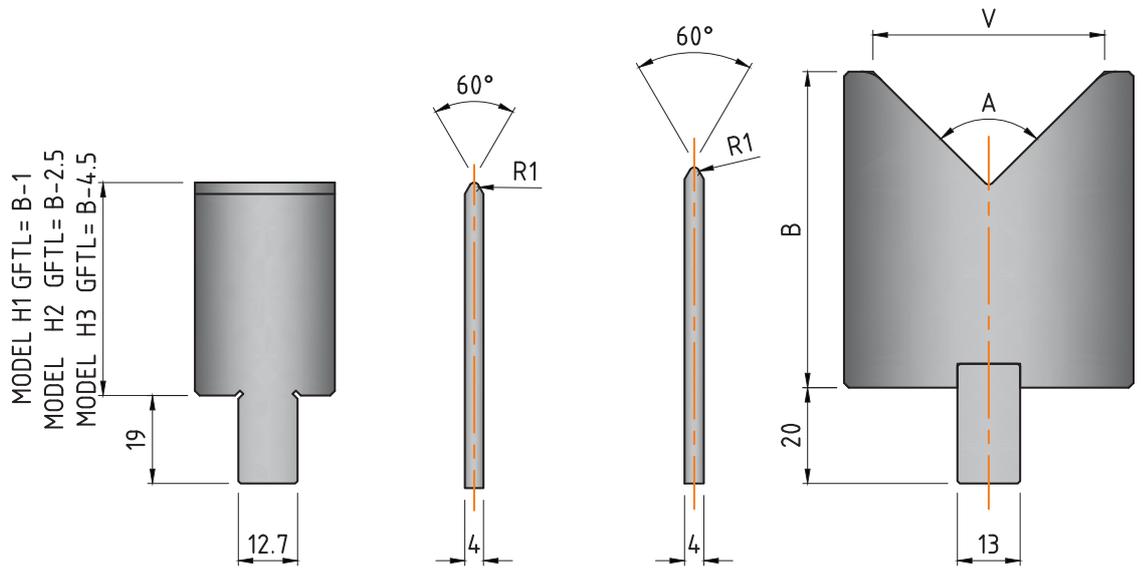
GUSSET BENDING

9:A | GUSSET INSERT

SCGB
(AMADA TYPE)



GFTL
(TRUMF-WILA
TYPE)
(LVD TYPE)



Material Option

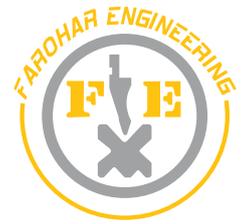
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

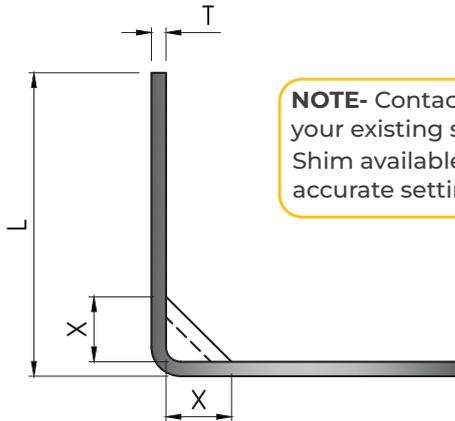
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





GUSSET BENDING

9:B | GUSSET INSERT SELECTION



NOTE- Contact for customization of gusset forming insert to suit your existing segmented die.

Shim available for punch gap setting & positioning of punch for accurate setting of tool during gusset forming setup.

T=0.8 MM

	Die Opening	Gap in punch	Gusset Forming insert model No.
X			
3.5	V6A86	10	H1
5	V8A86	12	H1
6	V10A86	14	H1

T=1 MM

	Die Opening	Gap in punch	Gusset Forming insert model No.
X			
4	V10A86	10	H2
4.5	V8A86	12	H1
5.5	V12A86	10	H2
6	V10A86	14	H1
7.5	V12A86	16	H1

T=2.5 MM

	Die Opening	Gap in punch	Gusset Forming insert model No.
X			
5	V16A86	18	H3
7.5	V16A86	18	H2
8.5	V20A86	20	H3
10.5	V20A86	20	H2
11.5	V24A86	20	H3
13	V24A86	18	H2

T=2 MM

	Die Opening	Gap in punch	Gusset Forming insert model No.
X			
3	V10A86	14	H2
5	V12A86	16	H2
5.5	V16A86	14	H3
6	V10A86	16	H1
7.5	V12A86	18	H1
8	V16A86	16	H2
9	V20A86	20	H3
10	V16A86	22	H1
11	V20A86	18	H2

T=1.5 MM

	Die Opening	Gap in punch	Gusset Forming insert model No.
X			
3.5	V10A86	12	H2
5	V12A86	12	H2
6.5	V10A86	15	H1
7.5	V12A86	17	H1
8	V16A86	12	H2
10.5	V16A86	21	H1

T=3 MM

	Die Opening	Gap in punch	Gusset Forming insert model No.
X			
8	V20A86	20	H3
10.5	V20A86	22	H2
11	V24A86	20	H3
13	V24A86	22	H2

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)

Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

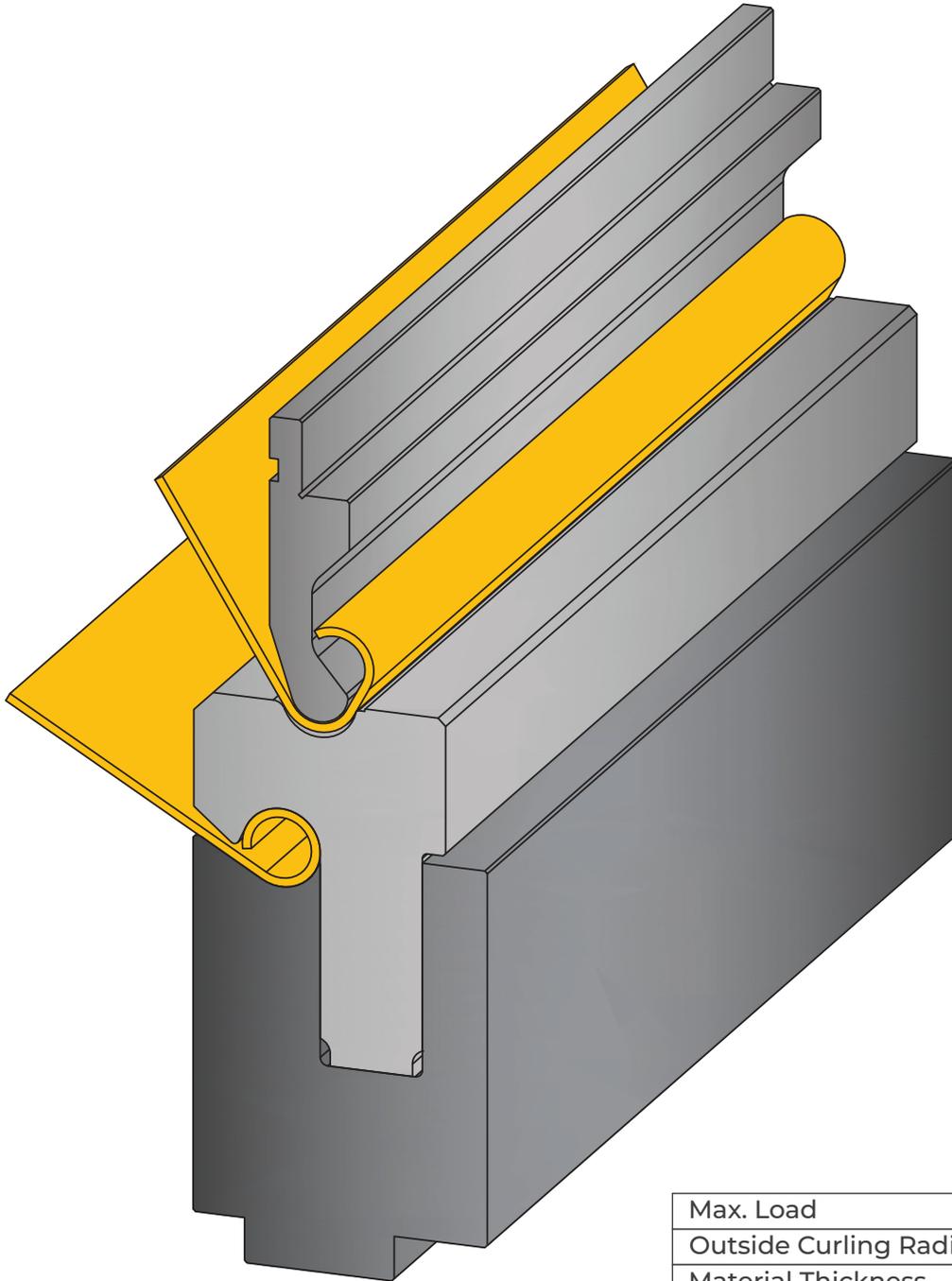
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)

Tip Induction Hardened 52±2HRc.



CURLING DIE

10 | CURLING DIE AND PUNCH



Max. Load	232T/m
Outside Curling Radius	R15
Material Thickness	3mm
Material	S.S

*Custom Designed as per Component

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



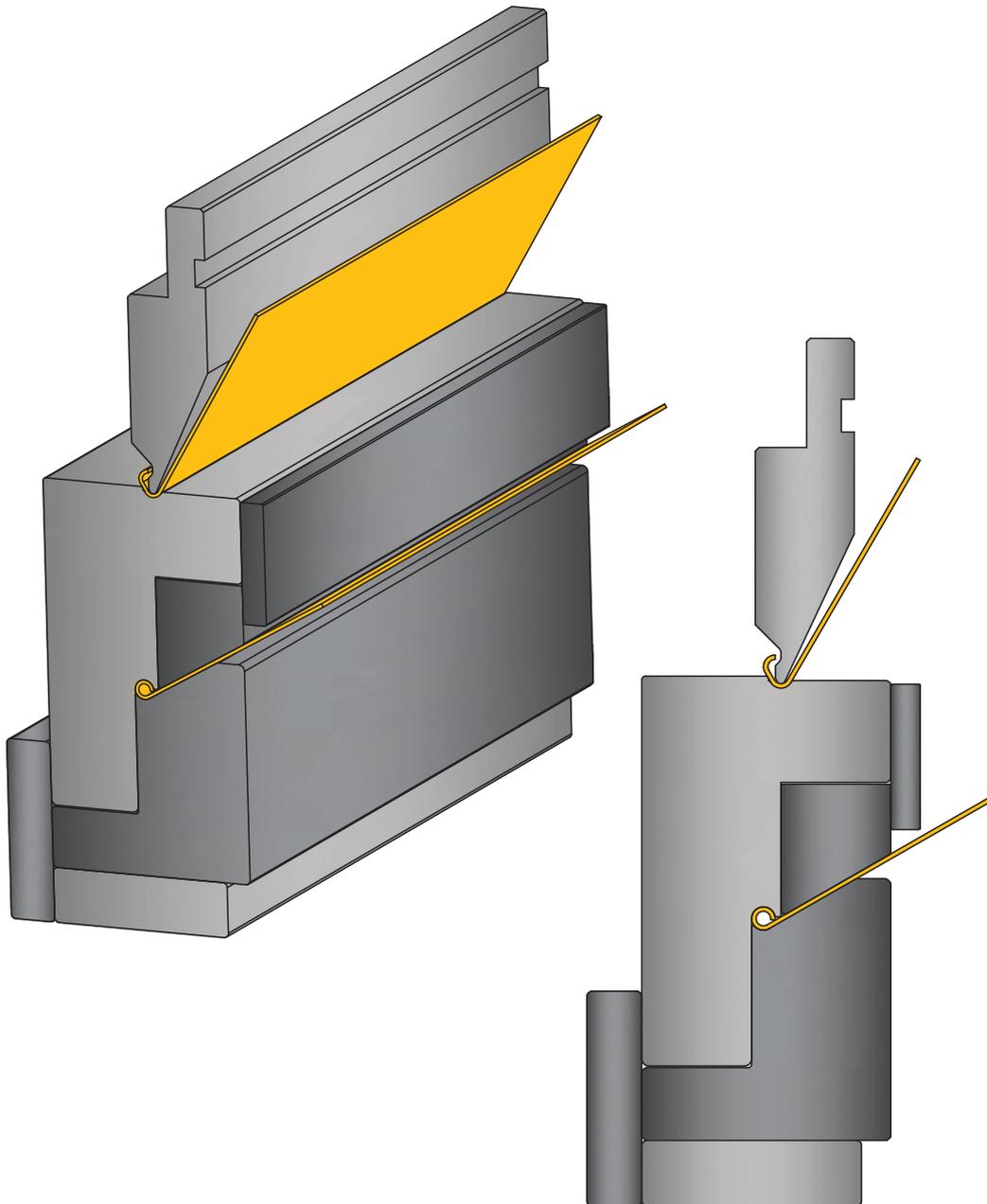
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



CURLING DIE

10 | CURLING DIE AND PUNCH



Max. Load	232T/m
Outside Curling Radius	R5
Material Thickness	3mm
Material	S.S

*Custom Designed as per Component

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)

Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)

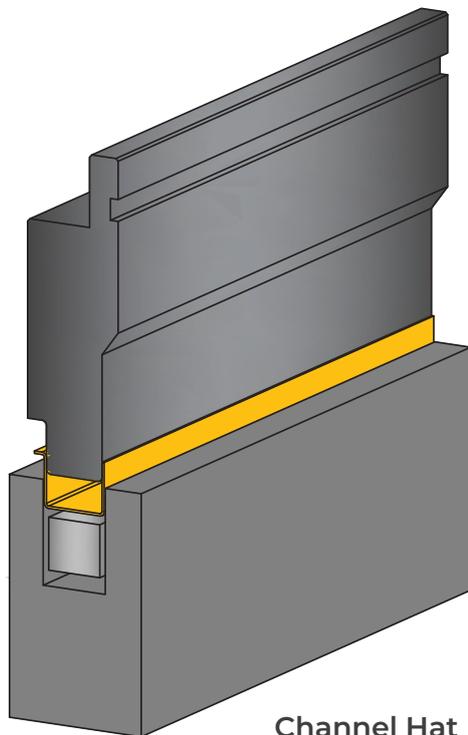
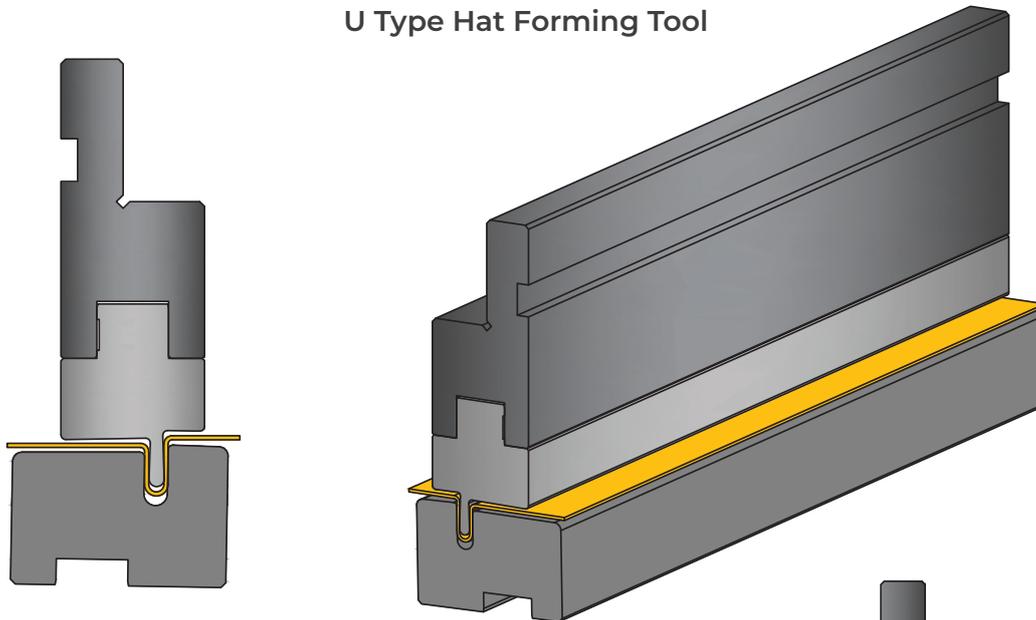
Tip Induction Hardened 52±2HRc.



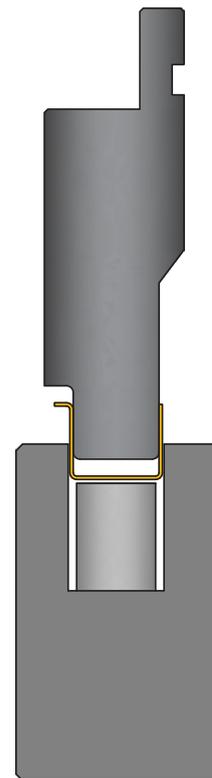
FORMING TOOL

11:A | HAT FORMING

U Type Hat Forming Tool



Channel Hat Forming Tool



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

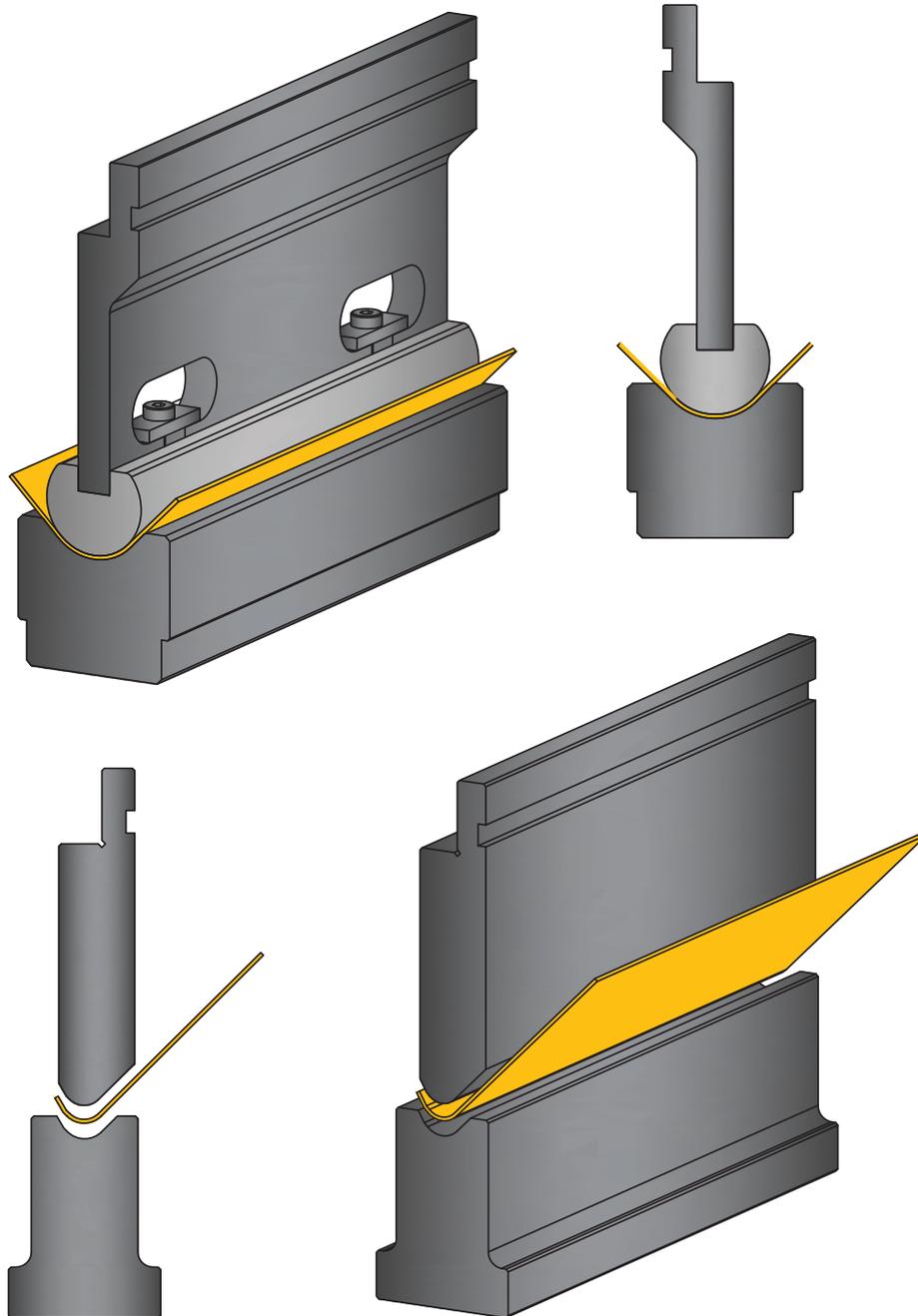
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



FORMING TOOL

11:B | RADIUS FORMING TOOL

Radius Forming Insert Type



Radius Forming Tool Fixed Type

Material Option

M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRc.
 Tip Induction Hardened 52±2HRc.



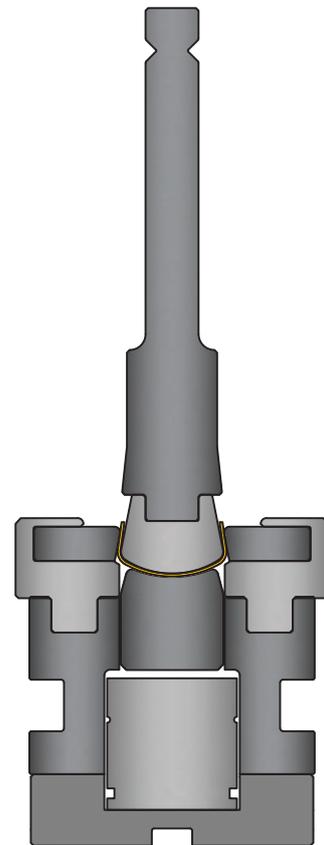
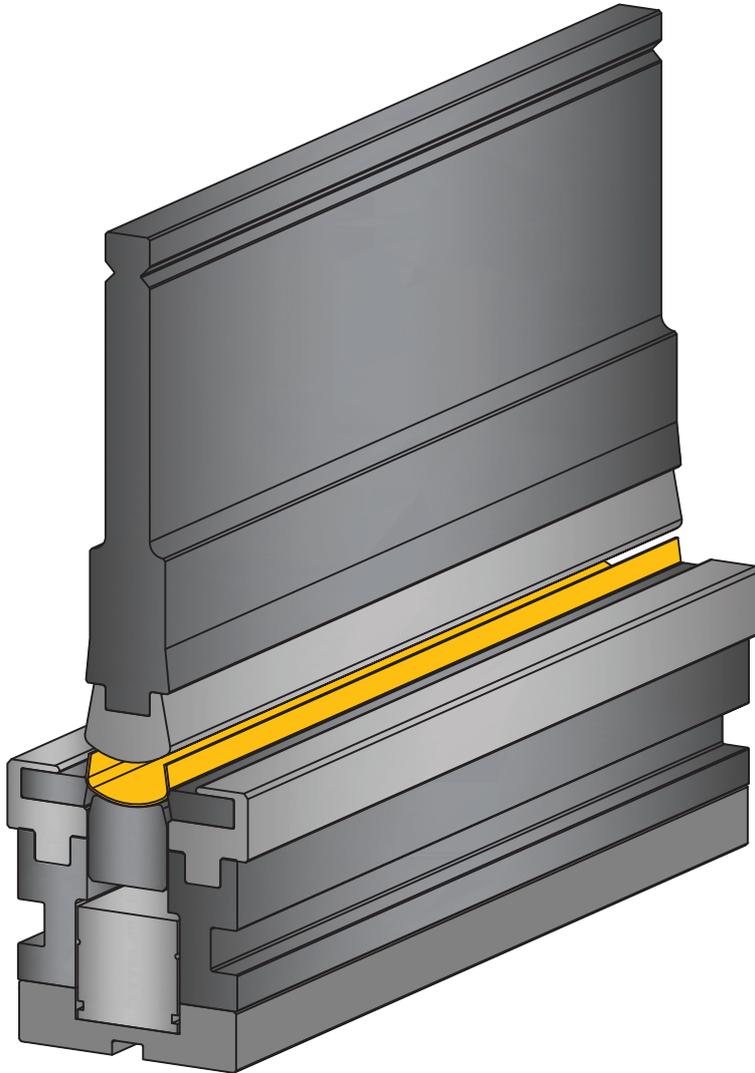
Material Option

M-02 Economy grade.
 C45 : 570-680 N/mm²
 (Plain Carbon Steel)
 Tip Induction Hardened 52±2HRc.



FORMING TOOL

11:C | CONDUIT BENDING



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

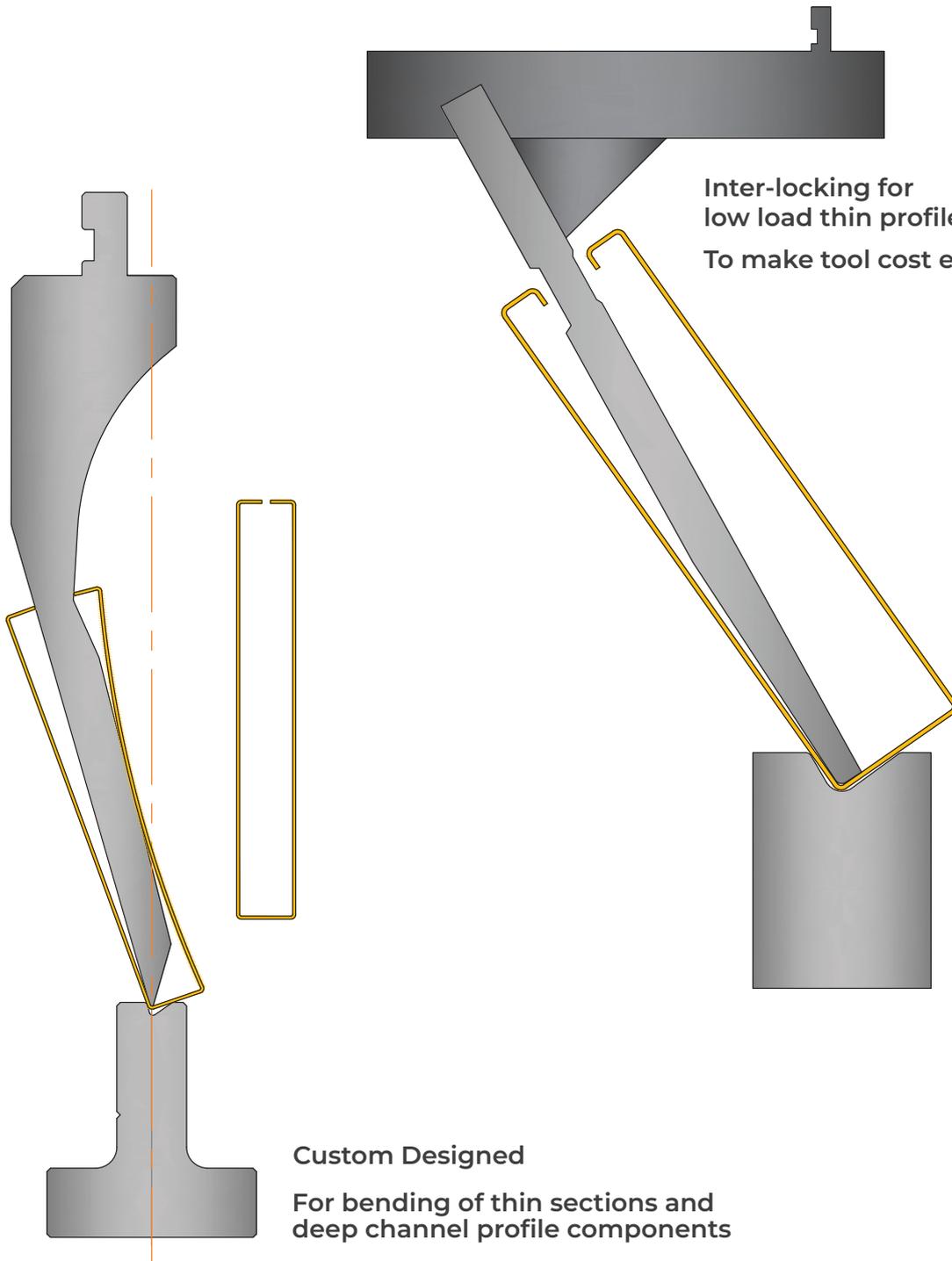
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





FORMING TOOL

11:D | UNEQUAL BENDING PUNCH & DIE



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



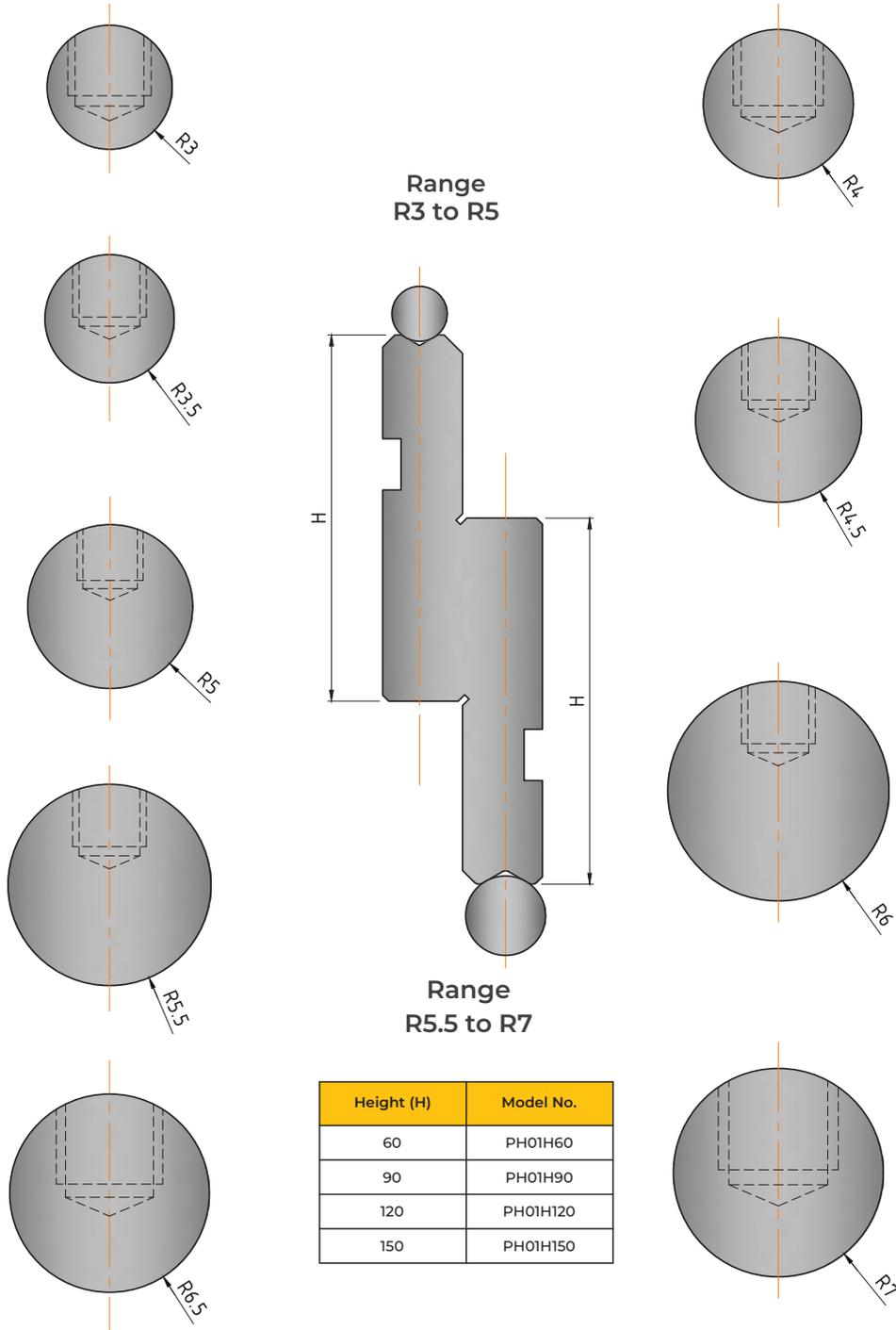
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH HOLDER AND RADIUS INSERT

12:A | PH & RI R3 - R7



Height (H)	Model No.
60	PH01H60
90	PH01H90
120	PH01H120
150	PH01H150

Material Option

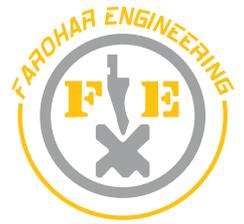
M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRc.
 Tip Induction Hardened 52±2HRc.



Material Option

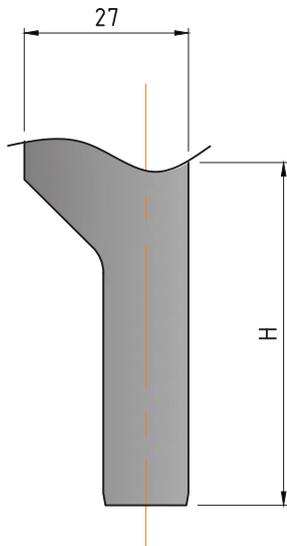
M-02 Economy grade.
 C45 : 570-680 N/mm²
 (Plain Carbon Steel)
 Tip Induction Hardened 52±2HRc.



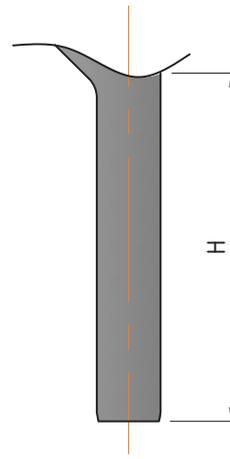


PUNCH HOLDER AND RADIUS INSERT

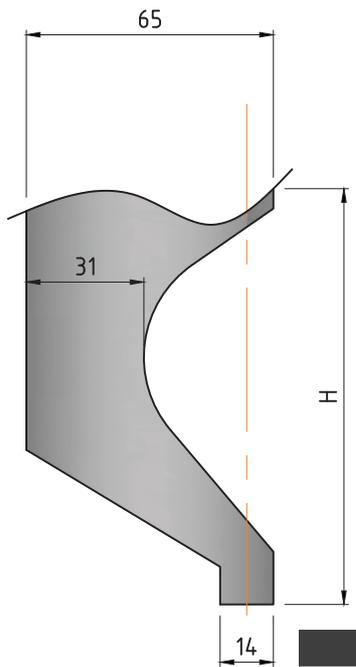
12:B | PH ADAPTOR FOR QUICK CLAMP



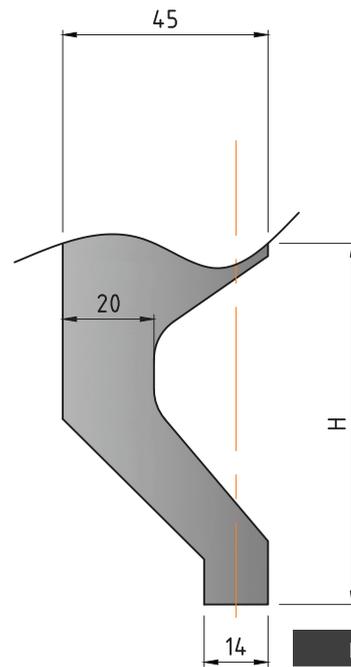
PH-03H67	
Height	Max.T/m.
67	100



PH-03H100	
Height	Max.T/m.
100	100



PH-04H115	
Height	Max.T/m.
115	50



PH-04H90	
Height	Max.T/m.
90	50

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



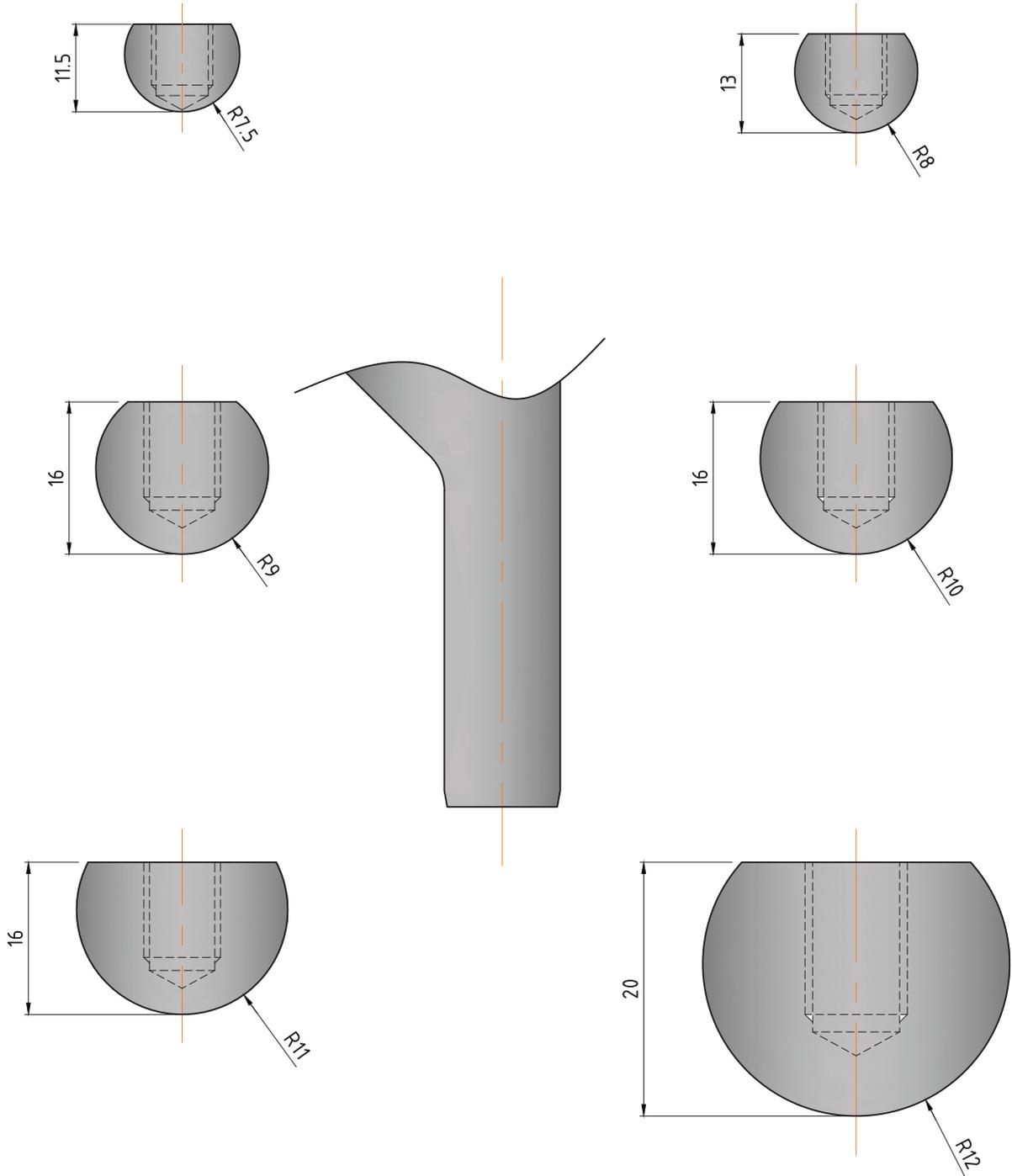
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH HOLDER AND RADIUS INSERT

12:C:i | PH & RI R7.5 - R12



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



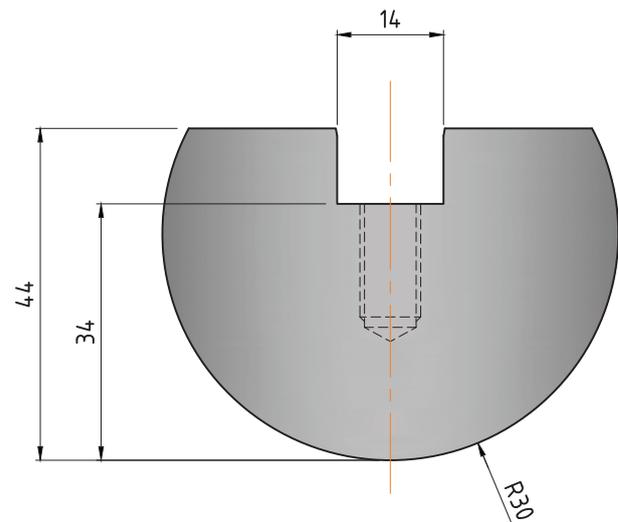
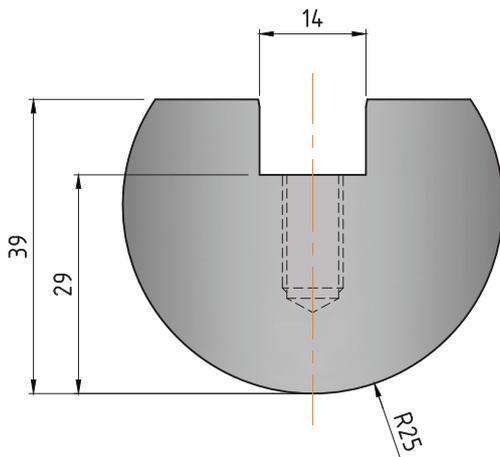
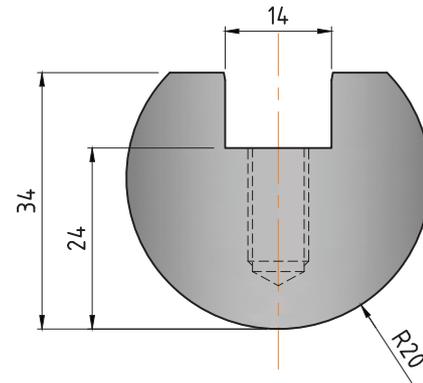
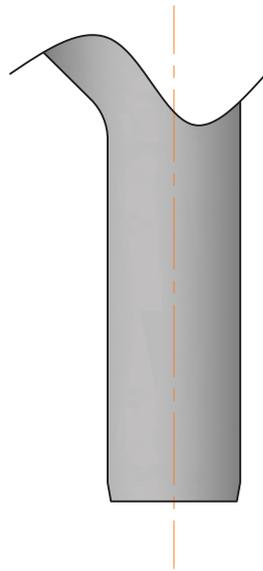
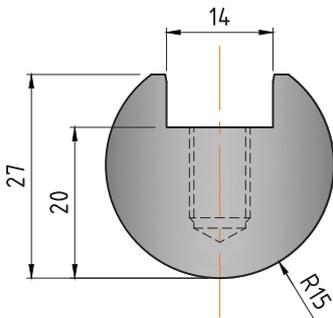
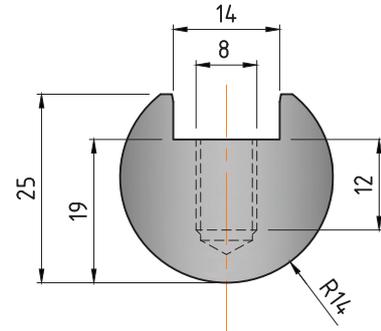
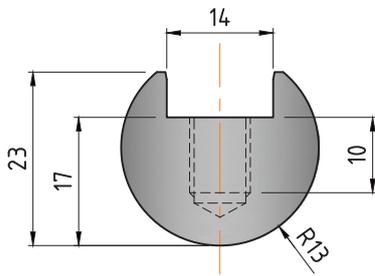
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



PUNCH HOLDER AND RADIUS INSERT

12:C:ii | PH & RI R13 - R30



Material Option

M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRc.
 Tip Induction Hardened 52±2HRc.



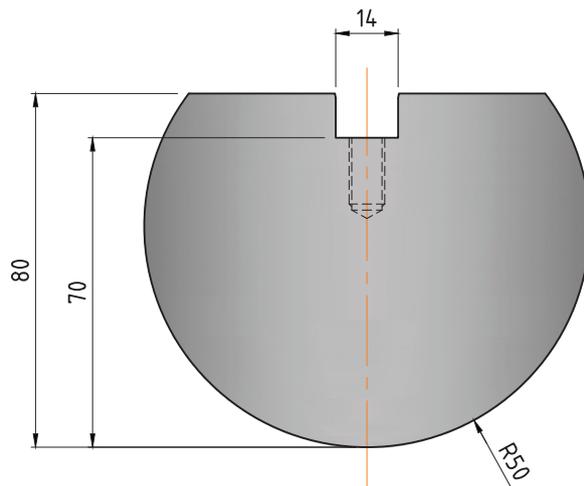
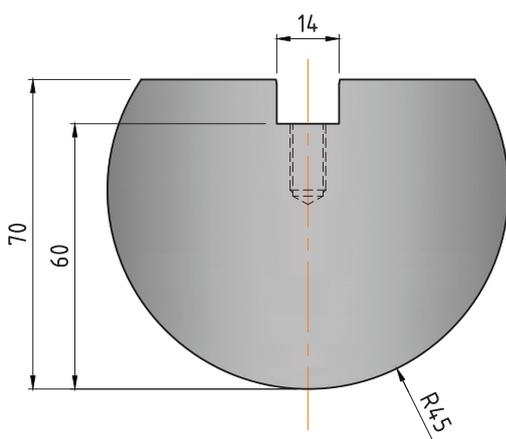
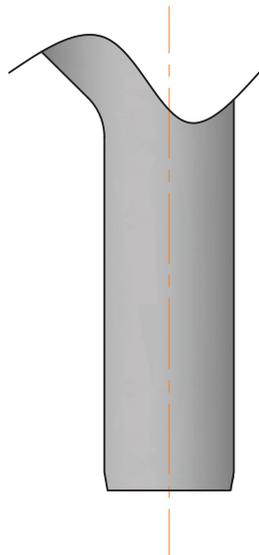
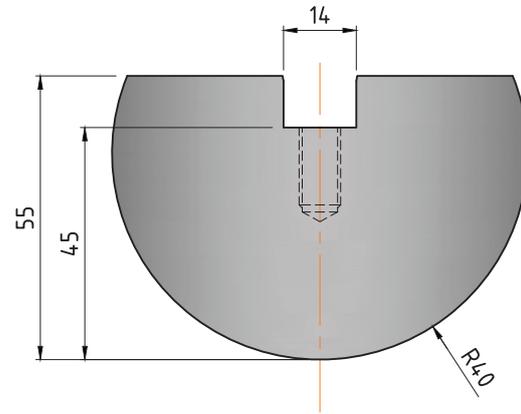
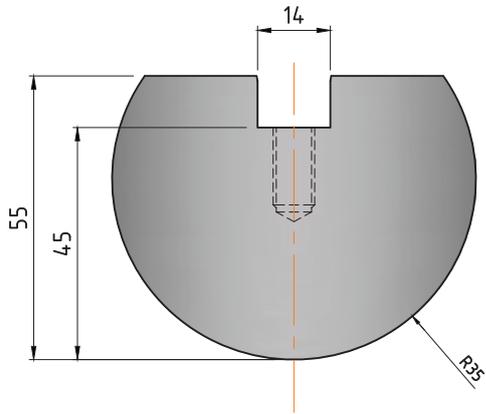
Material Option

M-02 Economy grade.
 C45 : 570-680 N/mm²
 (Plain Carbon Steel)
 Tip Induction Hardened 52±2HRc.



PUNCH HOLDER AND RADIUS INSERT

12:C:iii | PH & RI R35 - R50



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

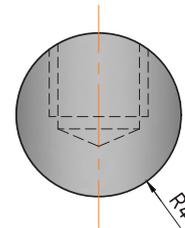
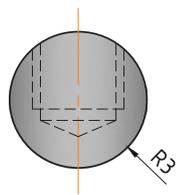
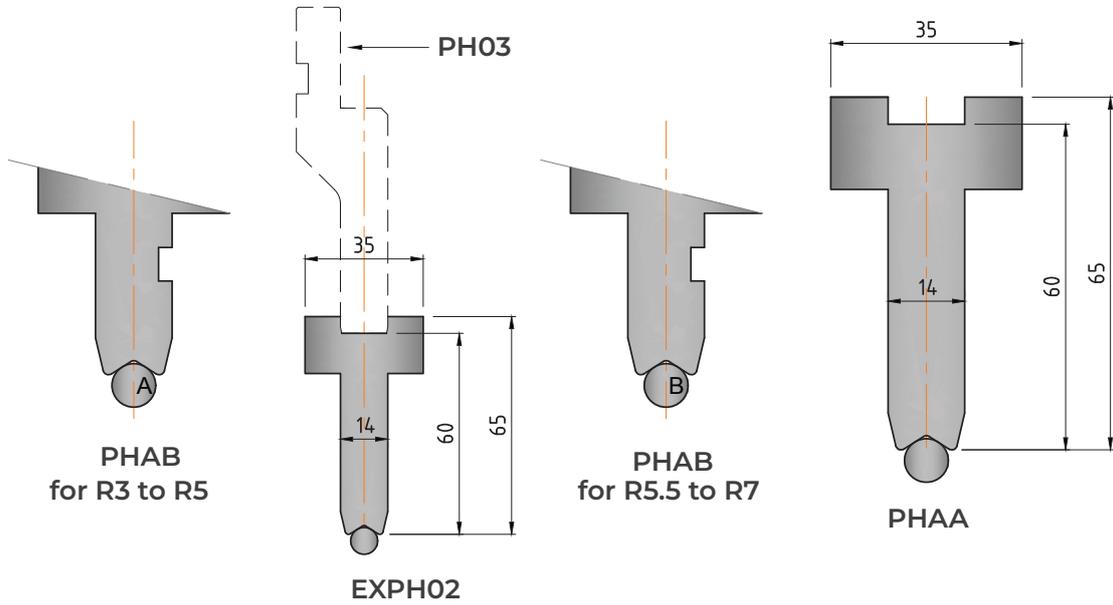
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



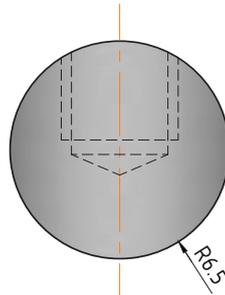
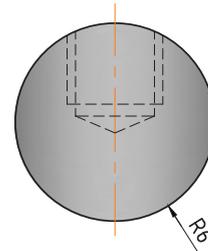
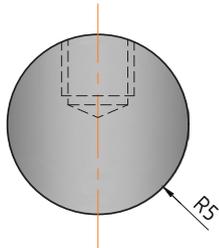


PUNCH HOLDER AND RADIUS INSERT

12:D | PH ADAPTOR R3 - R7



from R3 to R6.5



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



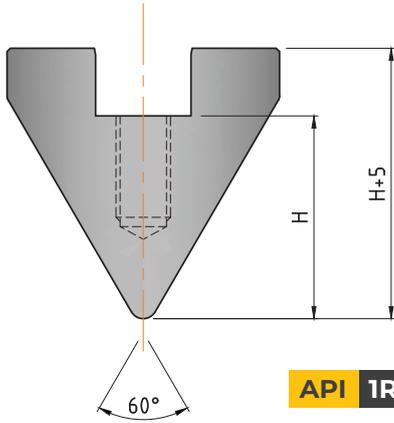
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

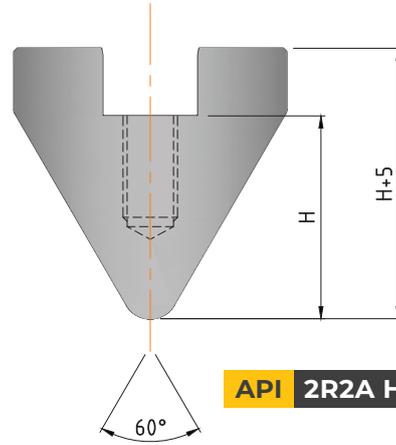


PUNCH HOLDER AND RADIUS INSERT

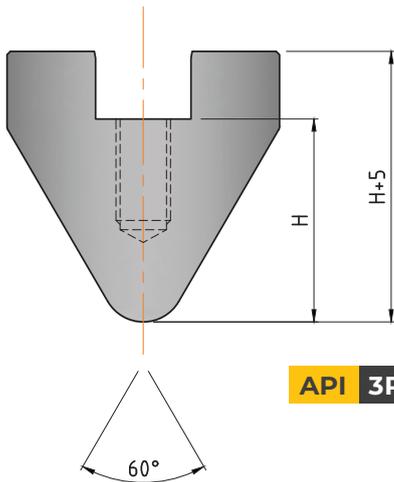
12:E | ANGULAR PUNCH INSERT



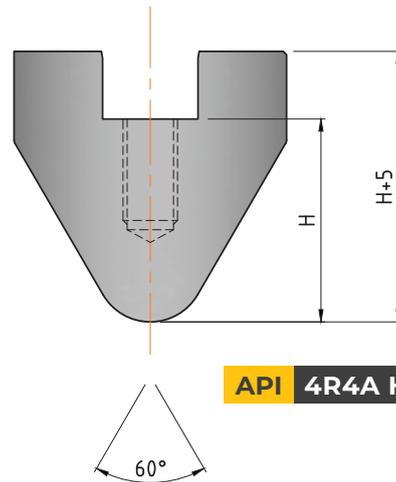
API 1R1A H



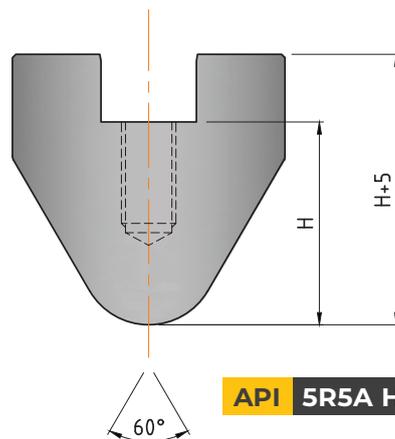
API 2R2A H



API 3R3A H



API 4R4A H



API 5R5A H

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



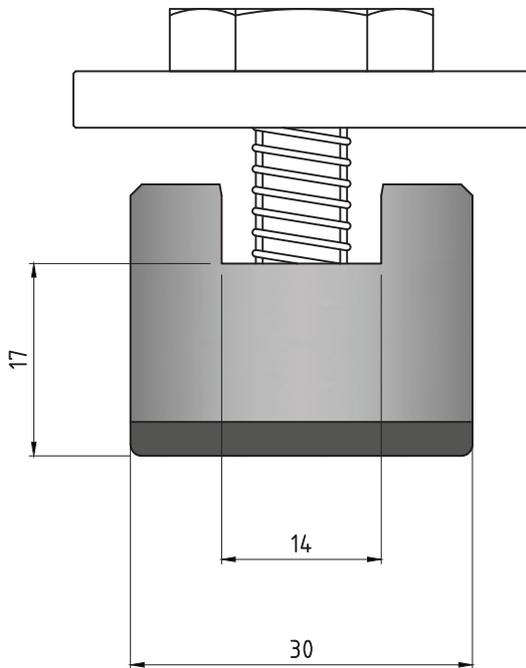
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.

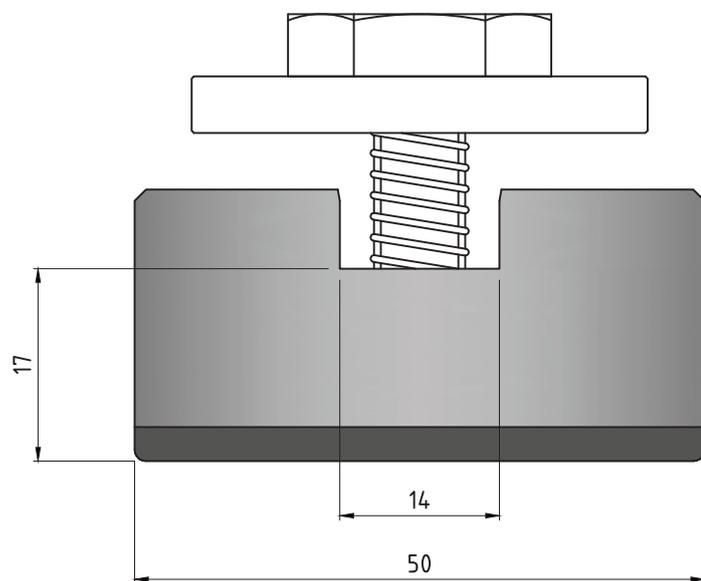


PUNCH HOLDER AND RADIUS INSERT

12:F | FLATTENING INSERT



FPI1



FPI2

Material Option

M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRC.
 Tip Induction Hardened 52±2HRC.



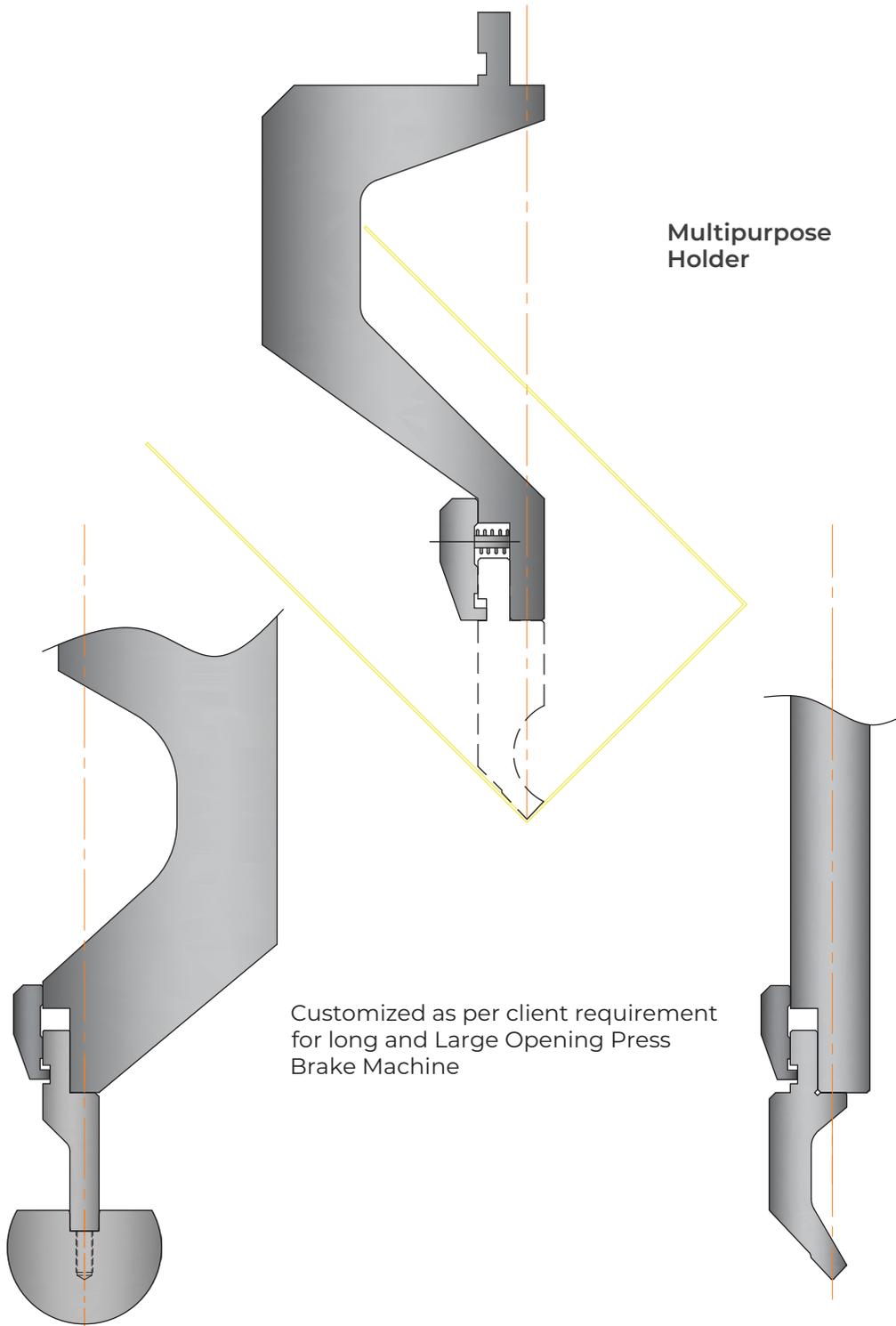
Material Option

M-02 Economy grade.
 C45 : 570-680 N/mm²
 (Plain Carbon Steel)
 Tip Induction Hardened 52±2HRC.



PUNCH HOLDER AND RADIUS INSERT

12:G | EXTENDED HOLDER



Multipurpose Holder

Customized as per client requirement for long and Large Opening Press Brake Machine

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



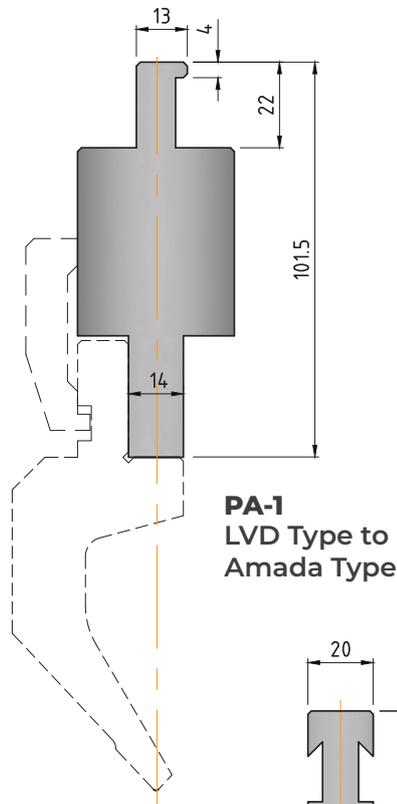
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.

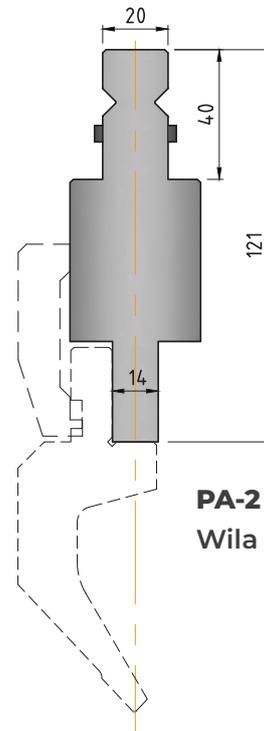


ACCESSORIES | PUNCH ADAPTORS

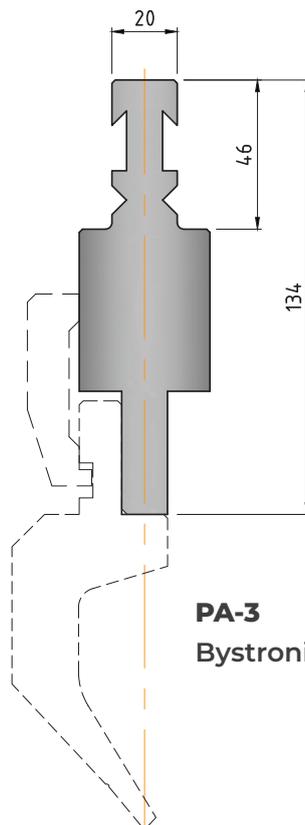
13:A:i | CONVERSION PUNCH ADAPTOR



PA-1
LVD Type to
Amada Type



PA-2
Wila Type to Amada Type



PA-3
Bystronic Type to Amada Type

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)

Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

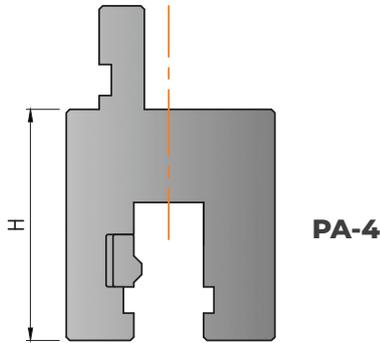
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)

Tip Induction Hardened 52±2HRc.



ACCESSORIES | PUNCH ADAPTORS

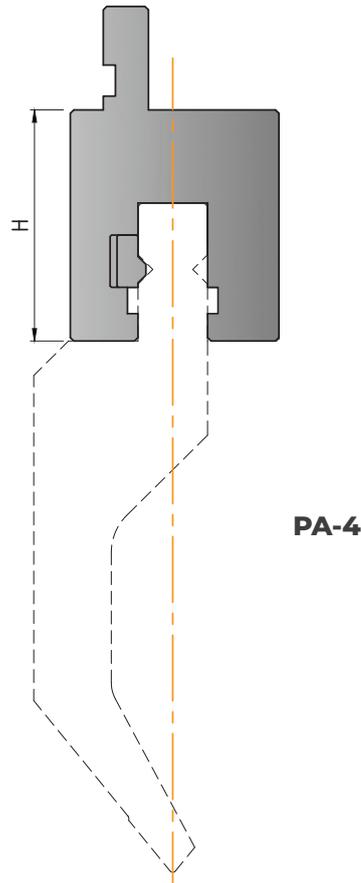
13:A:i | CONVERSION PUNCH ADAPTOR



*Conversion of Amada to Wila type for front tool loading

Model	Height (H)
PA4-65	65
PA4-100	100

2 IN 1
Amada Type to
Wila & LVD Type



Material Option

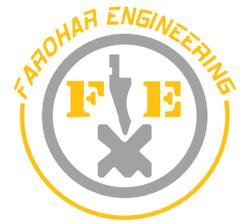
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

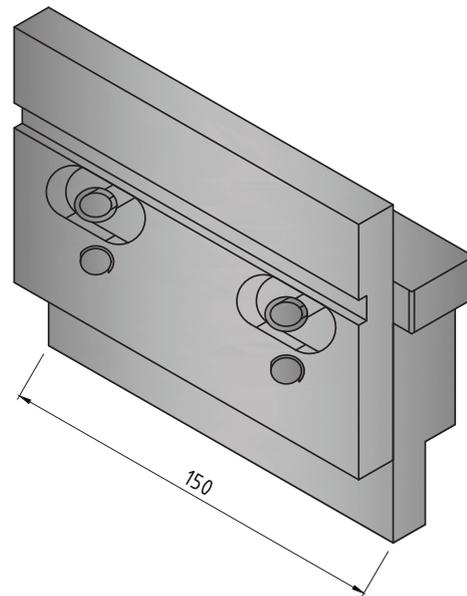
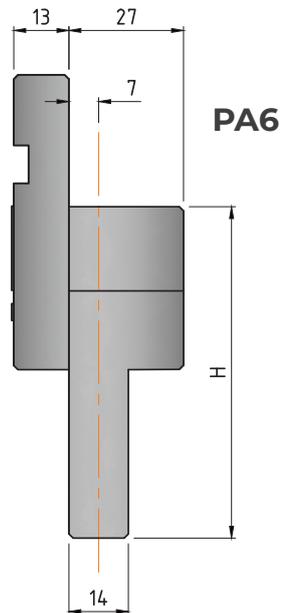
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



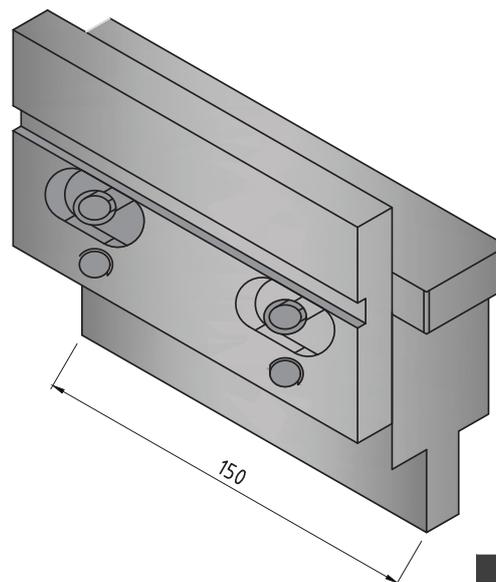
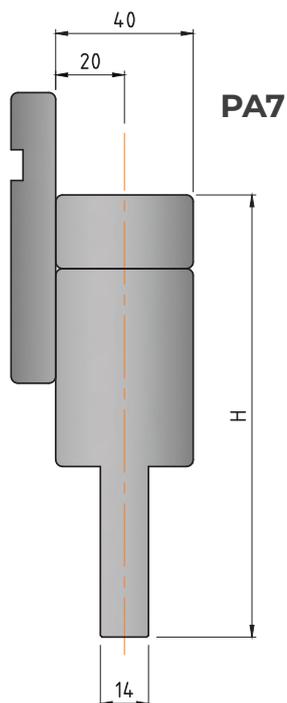


ACCESSORIES | PUNCH ADAPTORS

13:A:ii | ADJUSTABLE PUNCH ADAPTOR



Model	Height (H)
PA6	100
PA6	120
PA6	150



Model	Height (H)
PA7	100
PA7	120
PA7	150

Subject to availability, intermediates could be provided:
 1) with a solid body and wedge.
 2) as a bolted construction with a bolted tang and body.

Material Option

M-01 Performance grade.
 Cr'Mn'Mo 900-1020 N/mm²
 (Alloy steel)
 Quenched and tempered 30±2 HRC.
 Tip Induction Hardened 52±2HRC.



Material Option

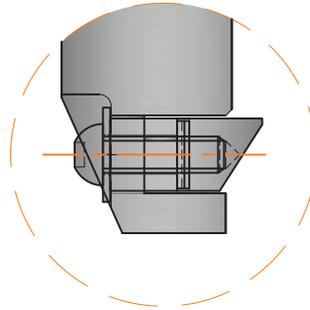
M-02 Economy grade.
 C45 : 570-680 N/mm²
 (Plain Carbon Steel)
 Tip Induction Hardened 52±2HRC.



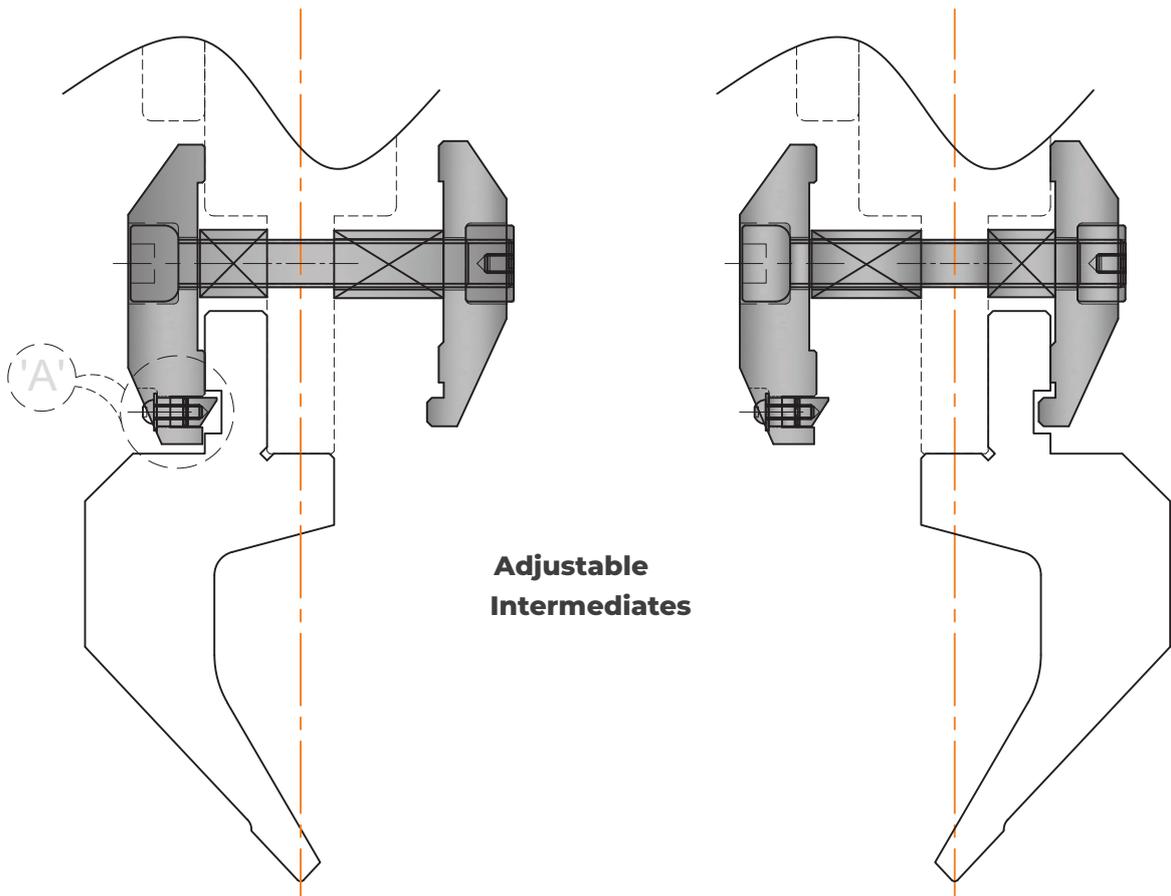
ACCESSORIES | PUNCH ADAPTORS

13:A:iii | STANDARD PUNCH ADAPTOR

Double Side Clamping



Spring Loaded Clamp
View-'A'



Adjustable
Intermediates

Material Option

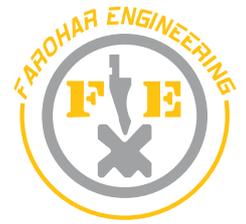
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

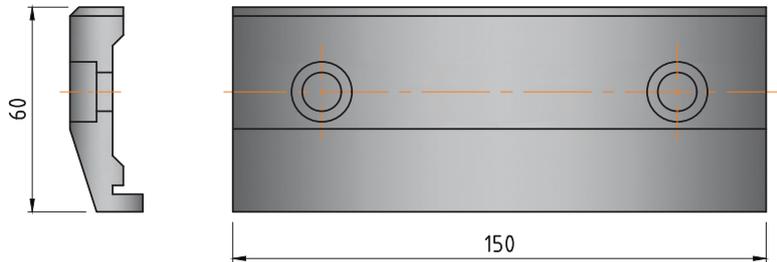
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.



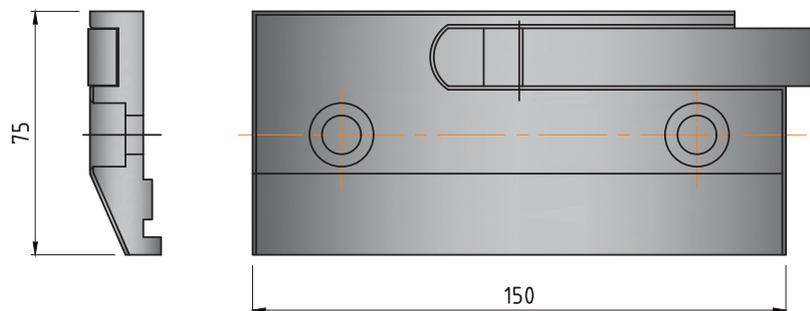


ACCESSORIES | PUNCH CLAMP

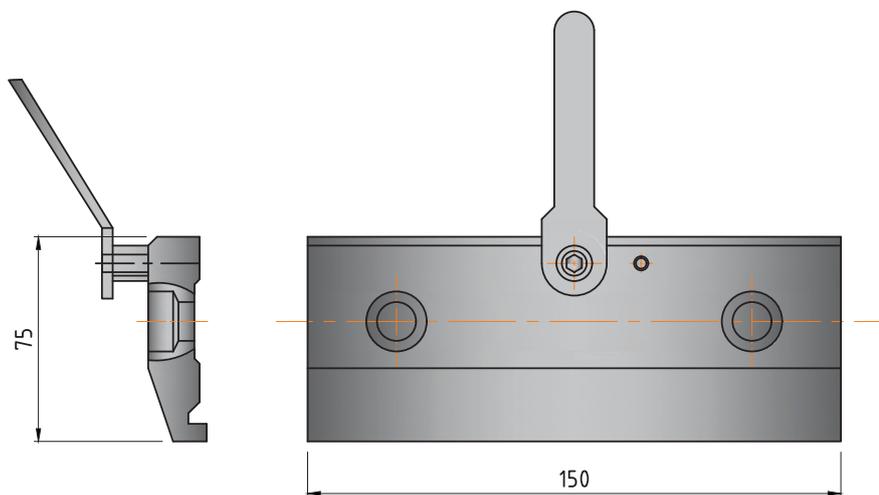
13:B:i | BOLTED & LEVER TYPE CLAMP



Bolt Type Clamp Plate



Horizontal Lever Type Clamp



Rotary Lever Type Clamp

*Screws included only with the purchase of the intermediates

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



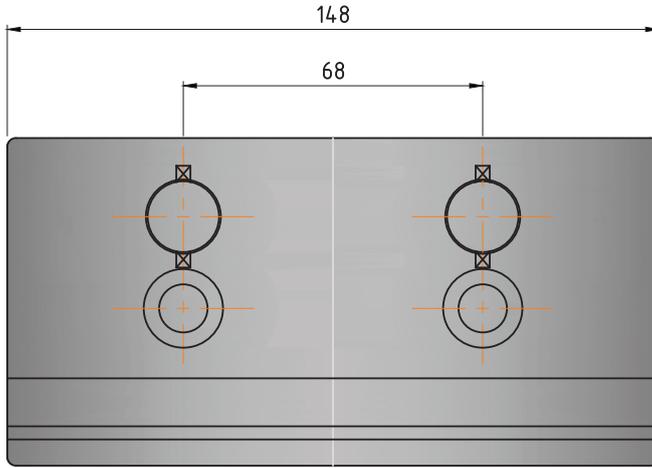
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

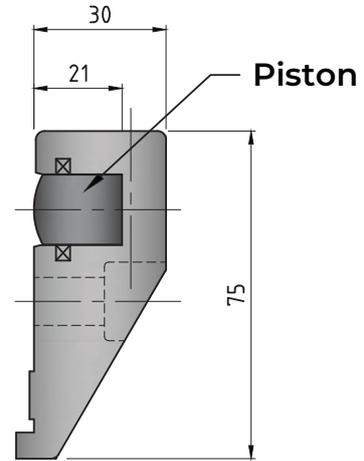


ACCESSORIES | PUNCH CLAMP

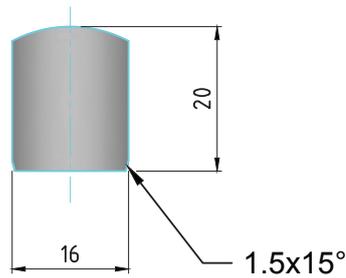
13:B:ii | PNEUMATIC TYPE CLAMP



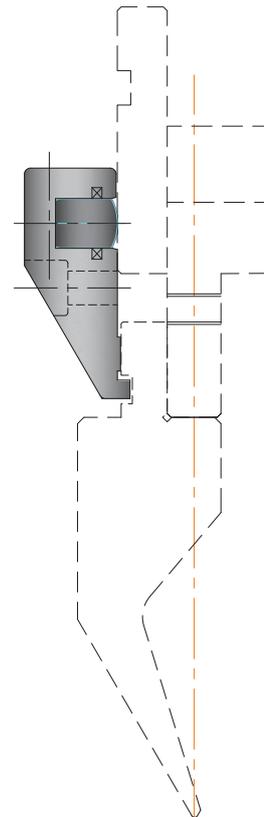
Side View



Front View



Large Piston
80.4N Clamping Force



Material Option

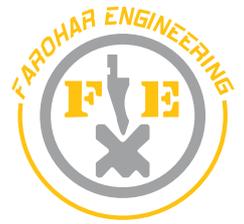
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

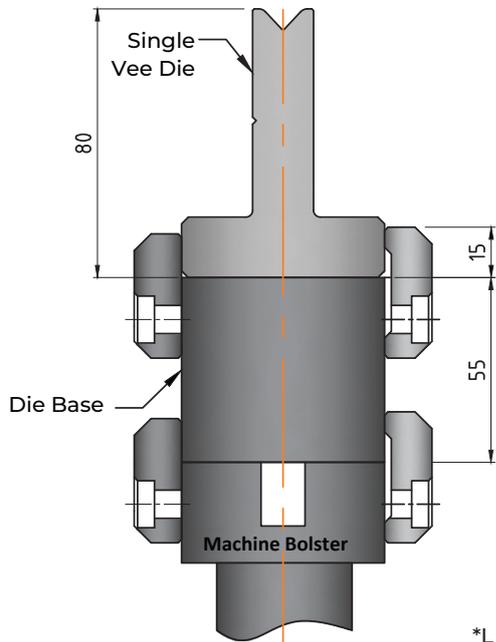
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.



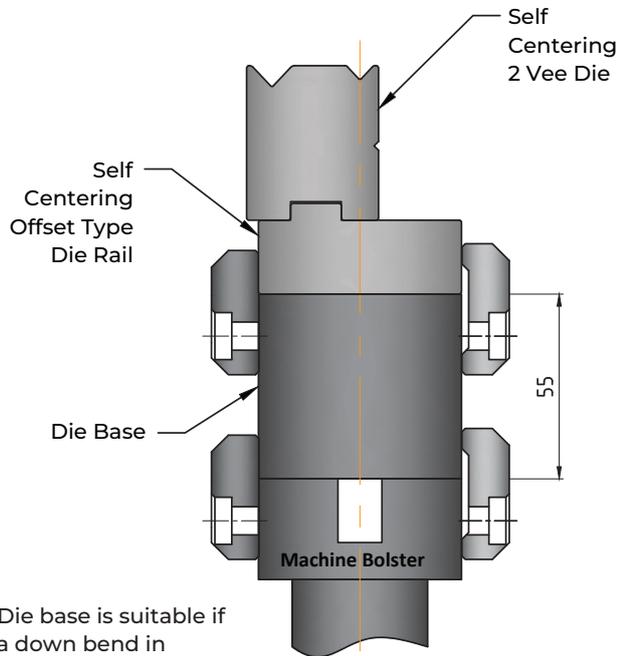


ACCESSORIES | DIE CLAMPING

13:C:i | DIE CLAMPING STYLE - 1

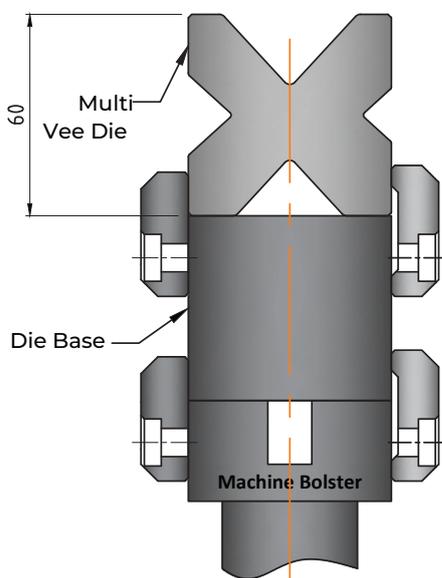


Single Vee Die

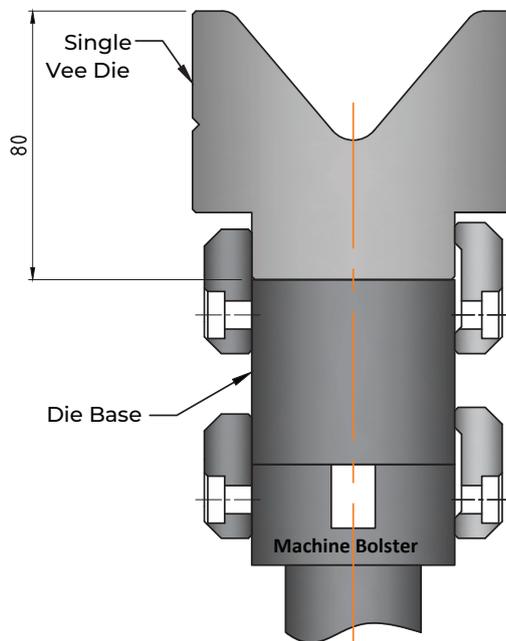


2Vee Die

*L type Die base is suitable if there is a down bend in component as shown.



Multi Vee die



Single Vee Die

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



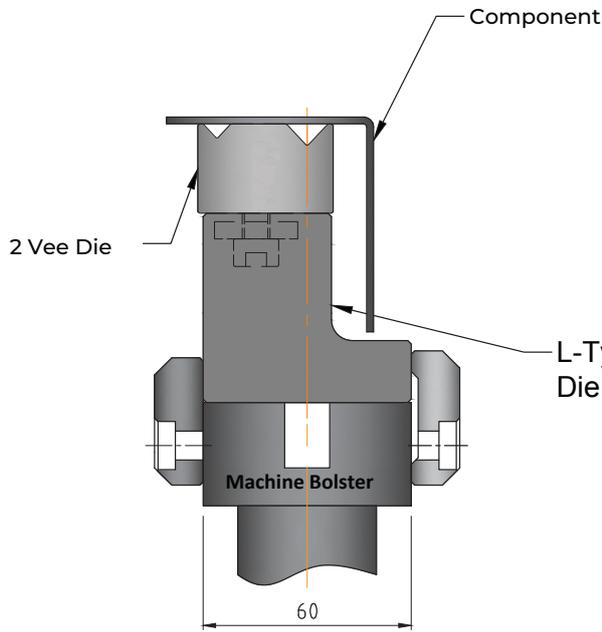
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.

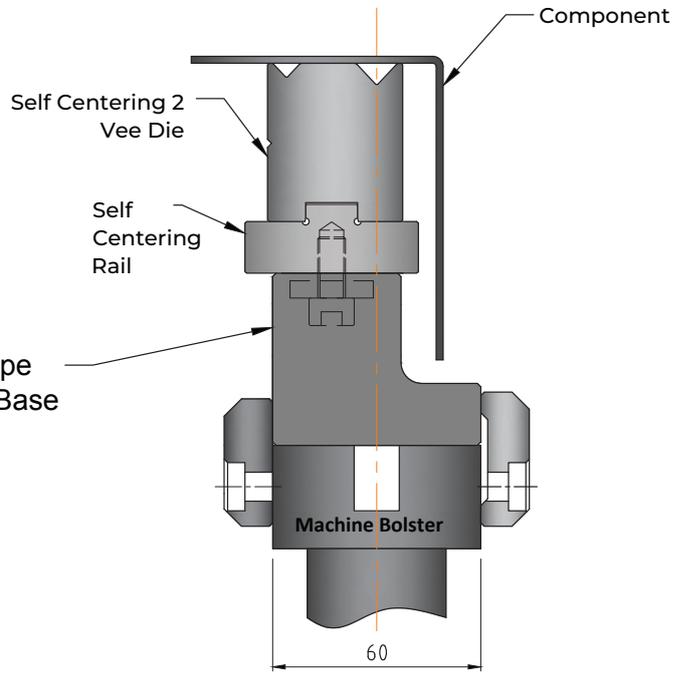


ACCESSORIES | DIE CLAMPING

13:C:ii | DIE CLAMPING STYLE - 2

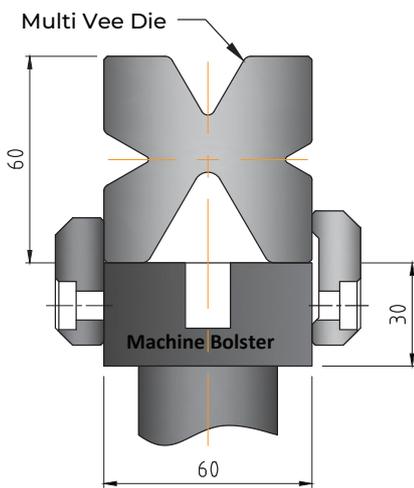


L - type Base & Bolt Type 2 Vee Die

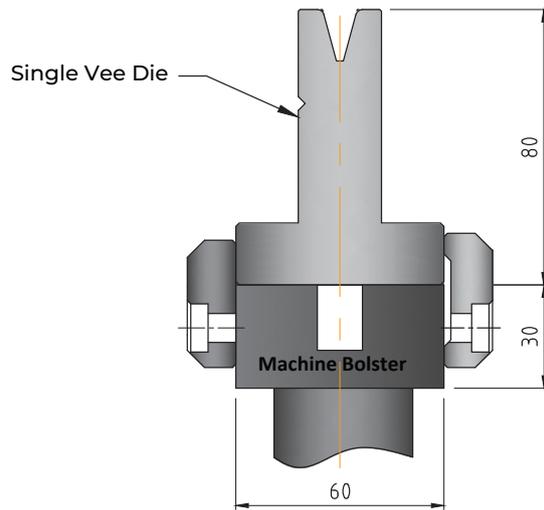


2Vee Die - Self Centering

*L Type Die Base is suitable if there is a down bend in component



Multi Vee Die



Single Vee Die

Material Option

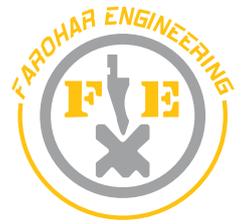
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

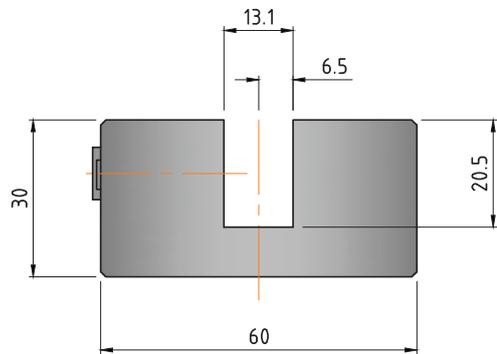
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





ACCESSORIES | DIE CLAMPING

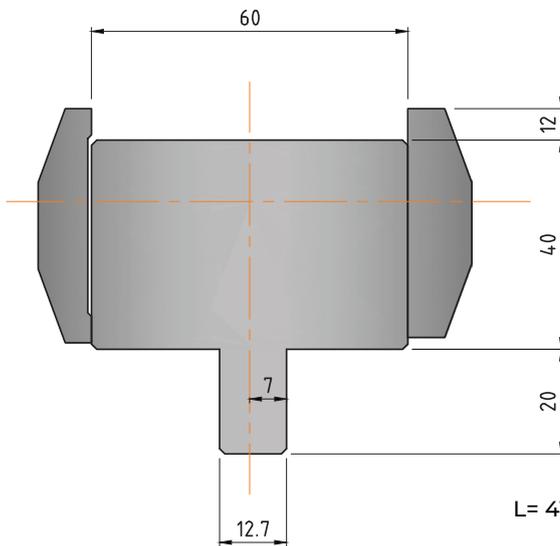
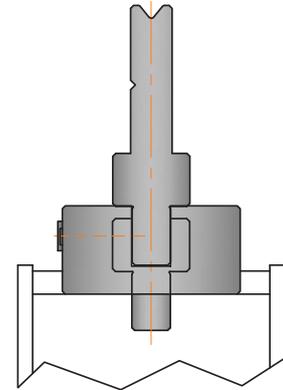
13:C:iii | LOWER ADAPTOR



**DB4
DieBase 4**

L= 500mm.- L= 835mm.

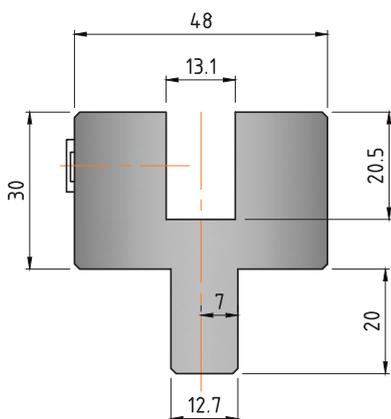
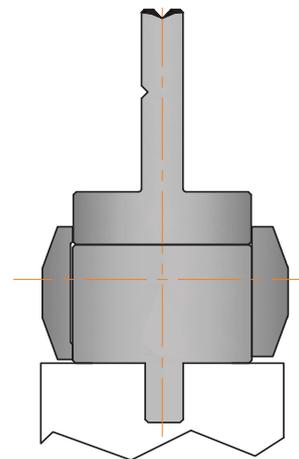
(Die Base Standard 60mm to Trumpf / Wila Type)



**DB5
DieBase 5**

L= 415mm.- L= 835mm.

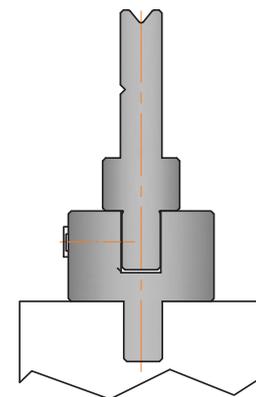
(Die Base LVD Type to 60mm Standard)



**DB6
DieBase 6**

L= 500mm.- L= 835mm.

(Die Base LVD to Trumpf / Wila Type)



Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



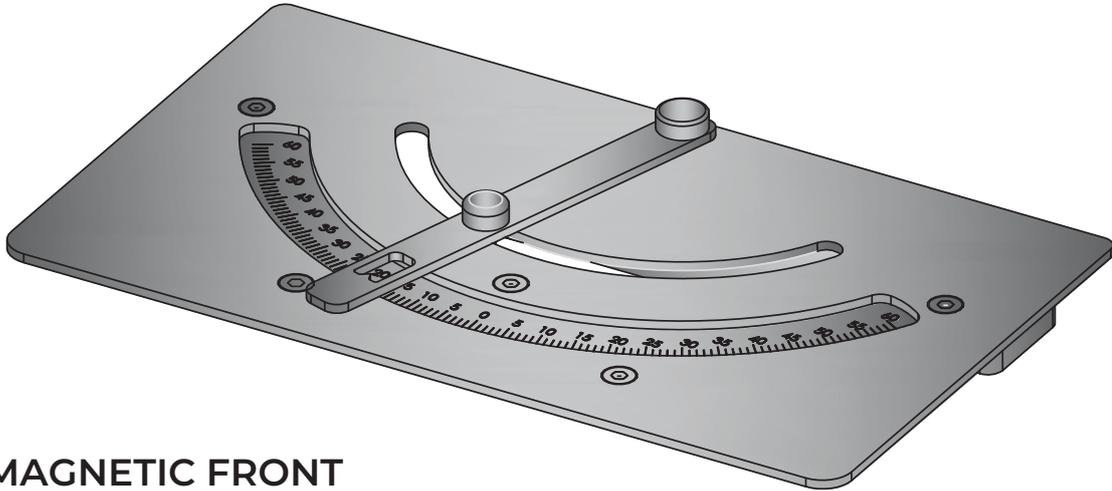
Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.

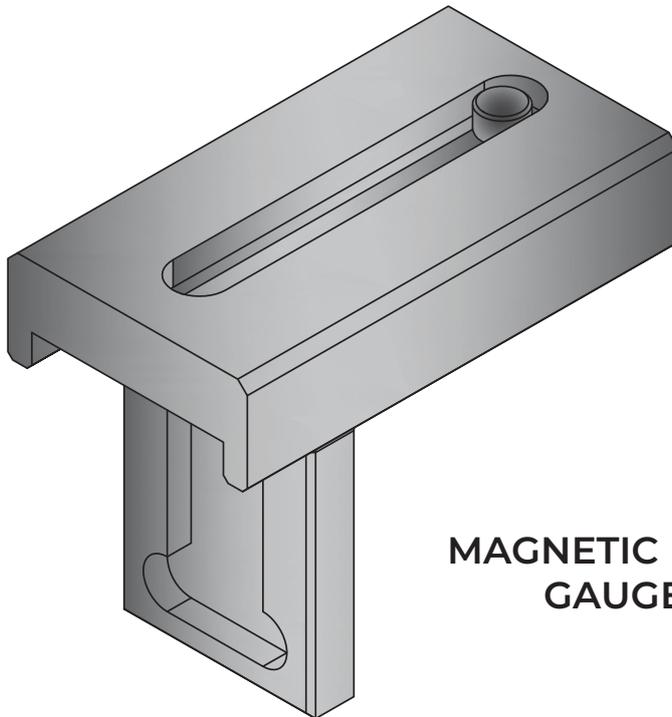


ACCESSORIES | GAUGE

13:D:i | MAGNETIC GAUGE



MAGNETIC FRONT GAUGE



MAGNETIC BACK GAUGE

Material Option

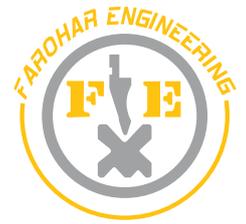
M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRC.
Tip Induction Hardened 52±2HRC.



Material Option

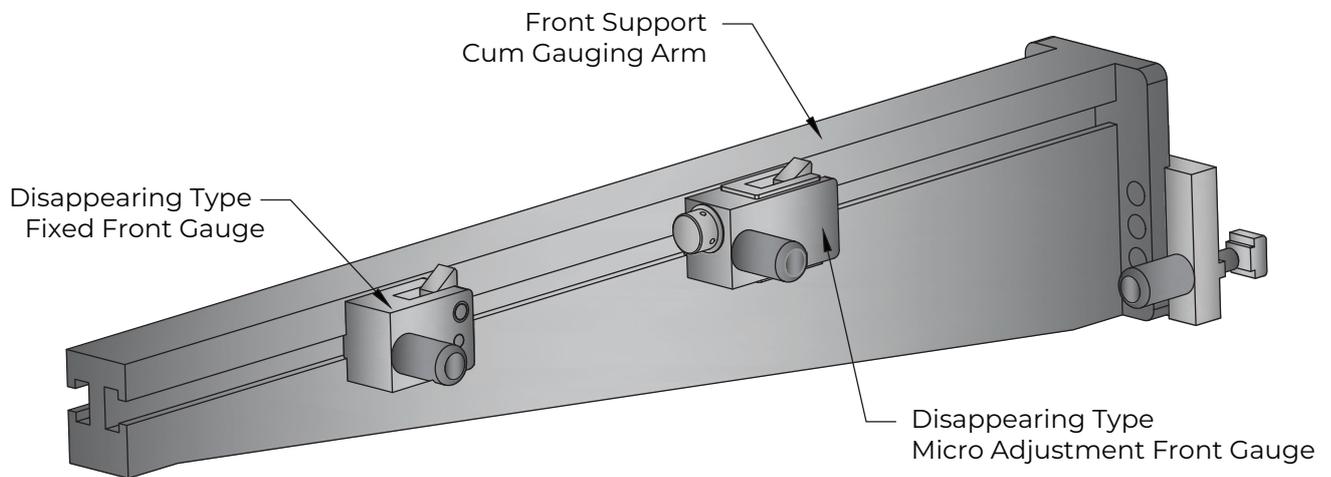
M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRC.





ACCESSORIES | GAUGE

13:D:ii | FRONT SUPPORT BLANKING TYPE GAUGE



Front Support Arm

Material Option

M-01 Performance grade.
Cr'Mn'Mo 900-1020 N/mm²
(Alloy steel)
Quenched and tempered 30±2 HRc.
Tip Induction Hardened 52±2HRc.



Material Option

M-02 Economy grade.
C45 : 570-680 N/mm²
(Plain Carbon Steel)
Tip Induction Hardened 52±2HRc.





E- CATALOGUE



CONTACT

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