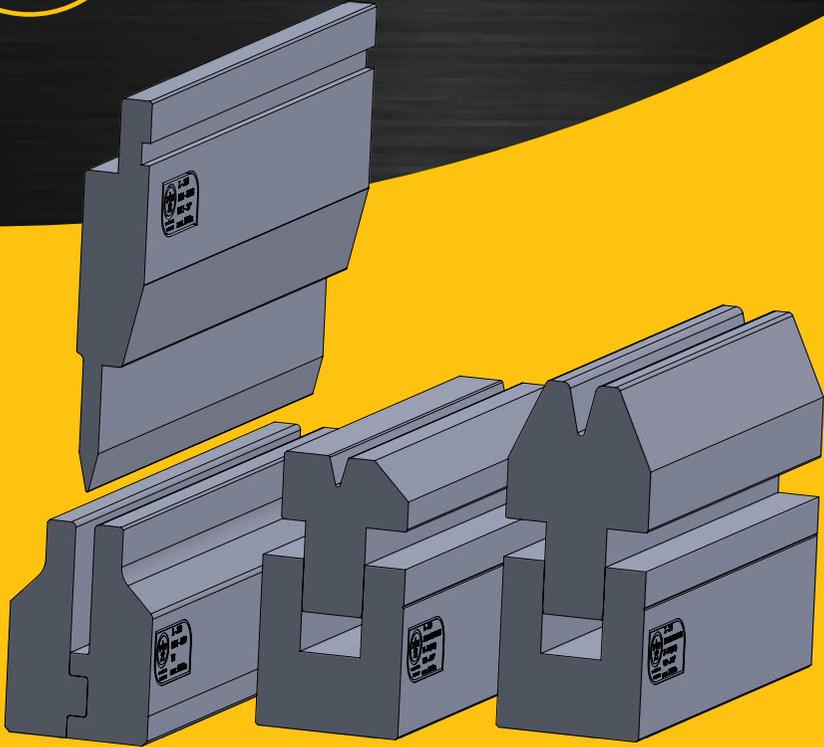


Manufacturers of : Press Brake tools, Panel Bending Tools, Hardened and ground liner Plates.
AN ISO 9001 : 2015 CERTIFIED



FARO HAR ENGINEERING



HEMMING DIE



■ PRESS BRAKE TOOLS



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.

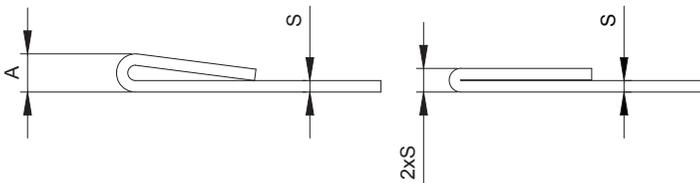
BENDING CHART

Flattening Load Mild Steel 45kg/mm²

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/mm²

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



HEMMING DIE



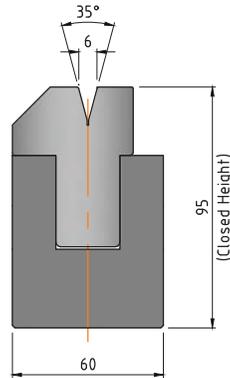
Spring Loaded Hemming Die for faster Hemming operation.

No tool change over required.

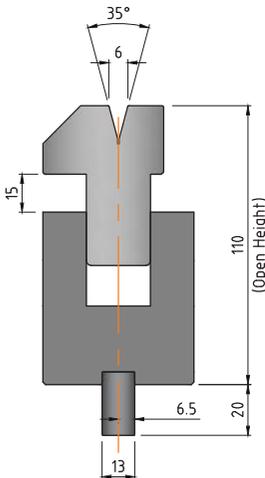
V6 Die suitable for flattening of M.S and S.S

Max 1 mm thick refer table.

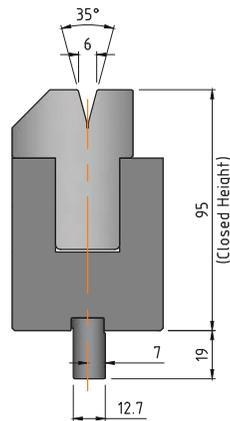
To suit all types of machine base.



(Amada Type)
SPHD AV6



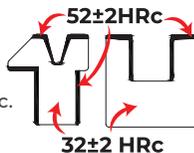
(Trumpf - Wila Type)
SPHD T/WV6



(LVD-type)
SPHD LV6

Material

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



SPHD6

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

6
1
0.8
50
7
35°

HEMMING DIE

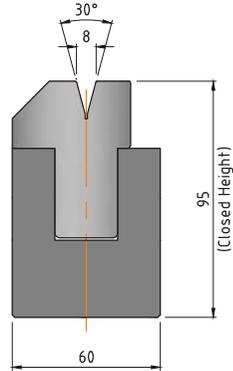
Spring Loaded Hemming Die for faster Hemming operation.

No tool change over required.

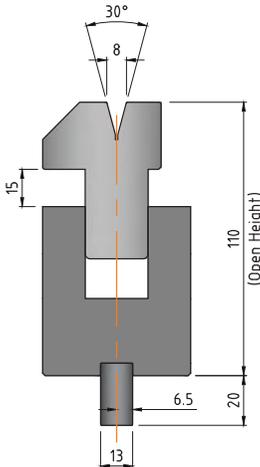
V8 Die suitable for flattening of M.S and S.S

Max 1.6 mm thick refer table.

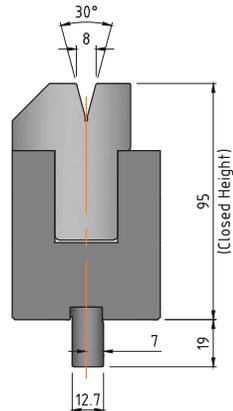
To suit all types of machine base.



(Amada Type)
SPHD AV8



(Trumpf - Wila Type)
SPHD T/WV8



(LVD-type)
SPHD LV8

Material

M0-1 Performance grade.
Cr'Mn'Mo 900-1100 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°

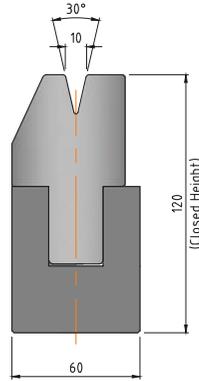
HEMMING DIE



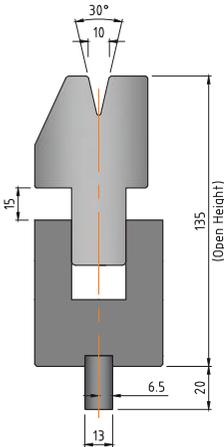
Heavy Duty Hemming Die .

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

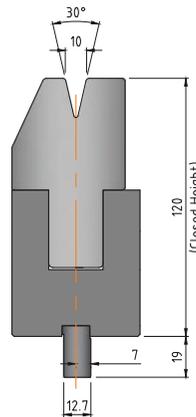
Added height and thickness for large flattening load.



(Amada Type)
SPHD AV10



(Trumpf - Wila Type)
SPHD T/WV10

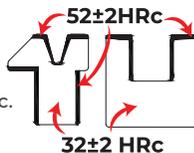


(LVD-type)
SPHD LV10

Material

M0-1 Performance grade.
Cr'Mn'Mo 900-1100 N/mm²
(Alloy steel)

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



SPHD10

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

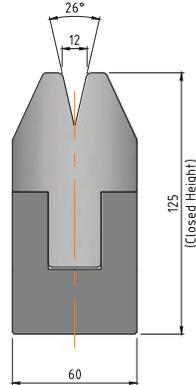
10
2
1.6
100
12
30°

HEMMING DIE

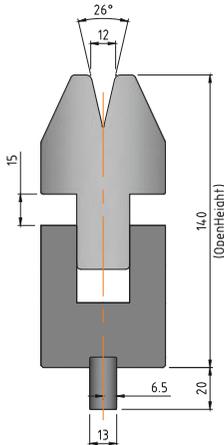
Heavy Duty Hemming Die .

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

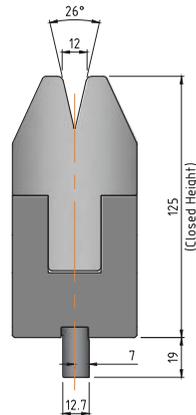
Added height and thickness for large flattening load.



(Amada Type)
SPHD AV12



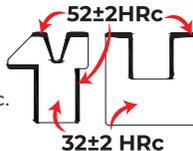
(Trumpf - Wila Type)
SPHD T/WV12



(LVD-type)
SPHD LV12

Material

M0-1 Performance grade.
Cr'Mn'Mo 900-1100 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°

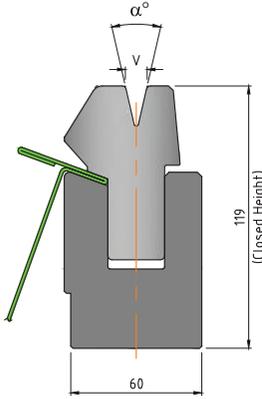
HEMMING DIE



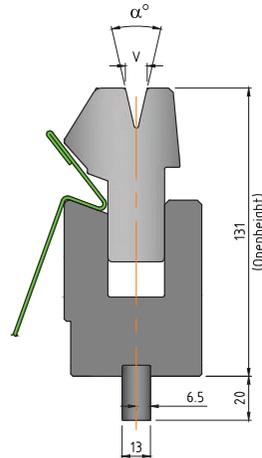
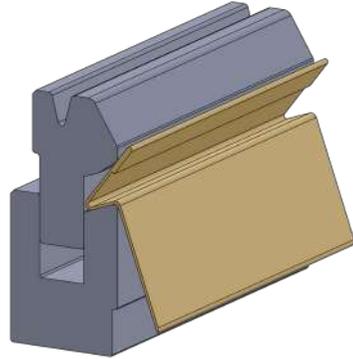
Customised to suit your component requirements.

Available for range of thickness upto 2.5 mm.

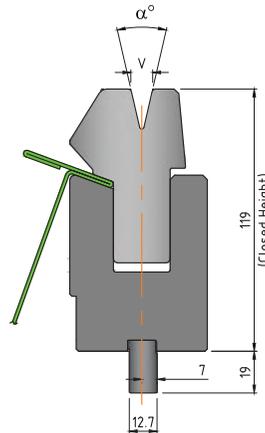
High Strength Tool Steel.



(Amada Type)
IHV AV



(Trumpf - Wila Type)
IHD T/WV

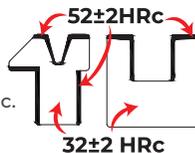


(LVD-type)
IHD LV

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.



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°

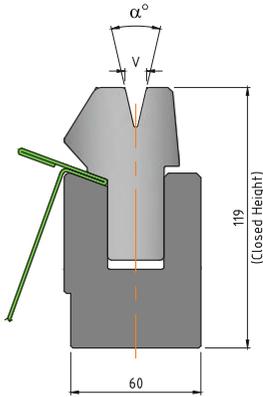
HEMMING DIE



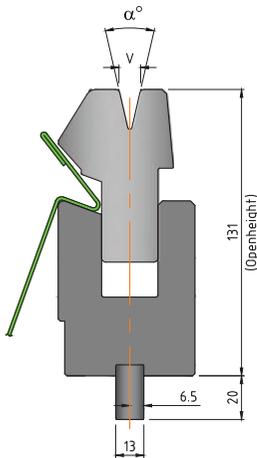
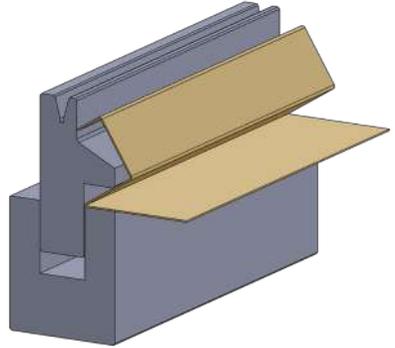
Customised to suit your component requirements.

Available for range of thickness upto 1.6mm.

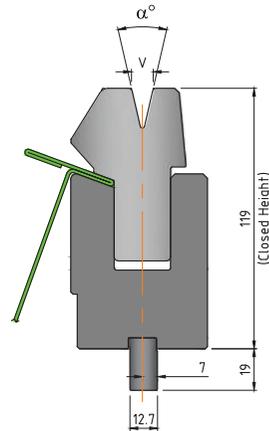
High Strength Tool Steel.



(Amada Type)
SHV AV



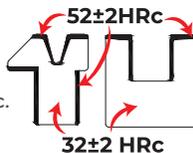
(Trumpf - Wila Type)
SHD T/WV



(LVD-type)
SHD LV

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.



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

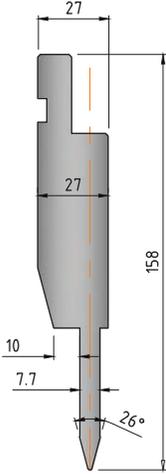
	SLHD6	SLHD8
V	6	8
Maximum thk. M.S.	1	1.6
Maximum thk. S.S.	0.8	1.2
Maximum Tonnage	50	80
Minimum Flange Length	7	10
α	35°	30°

HEMMING DIE

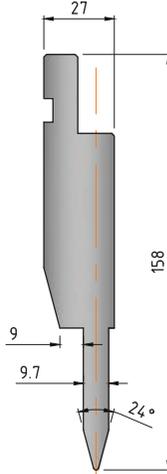


Economy Series of flattening tool.

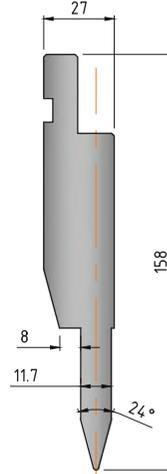
For flattening upto 2.5mm



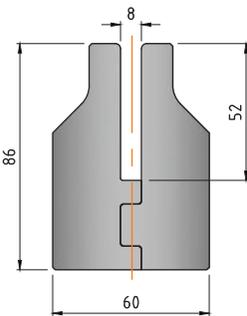
HP-1 Max T/m 80



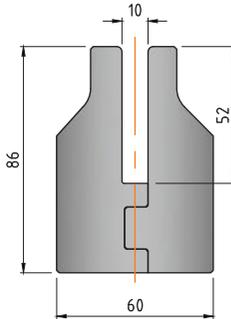
HP-2 Max T/m 80



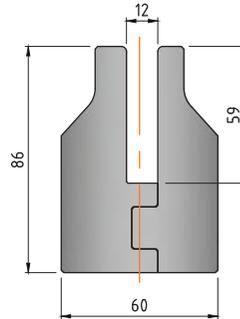
HP-3 Max T/m 80



HD-1 Max T/m 50



HD-2 Max T/m 60

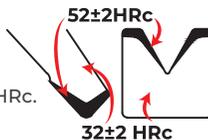


HD-3 Max T/m 60

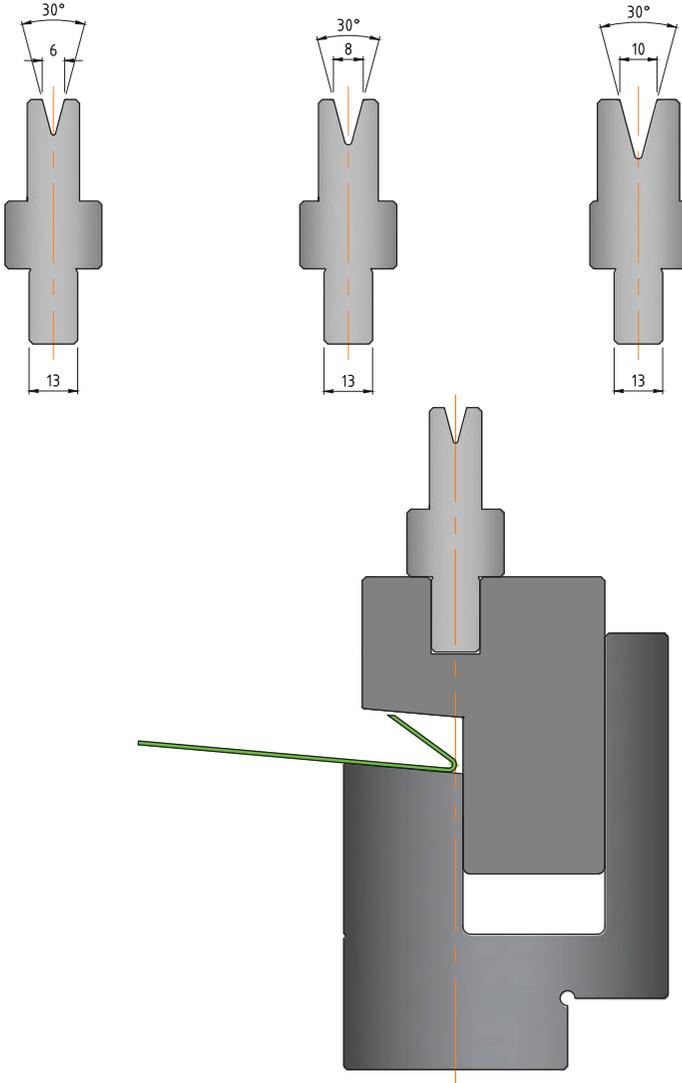
Material

M0-1 Performance grade.
Cr'Mn'Mo 900-1100 N/mm²
(Alloy steel)

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

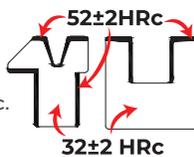


HEMMING DIE

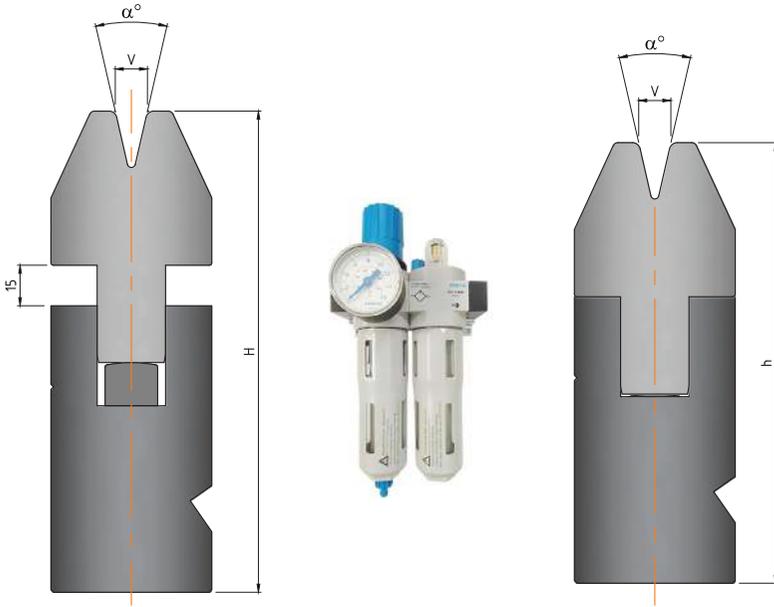


Material

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



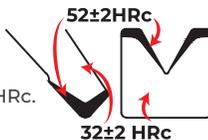
Pneumatic Hemming Die

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
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

M0-1 Performance grade.
Cr'Mn'Mo 900-1100 N/mm²
(Alloy steel)

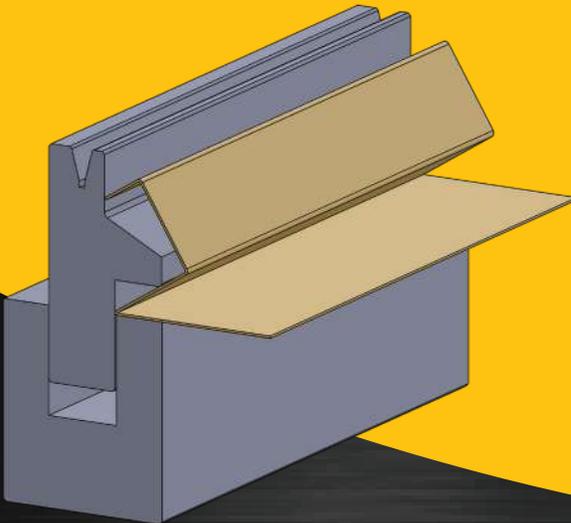
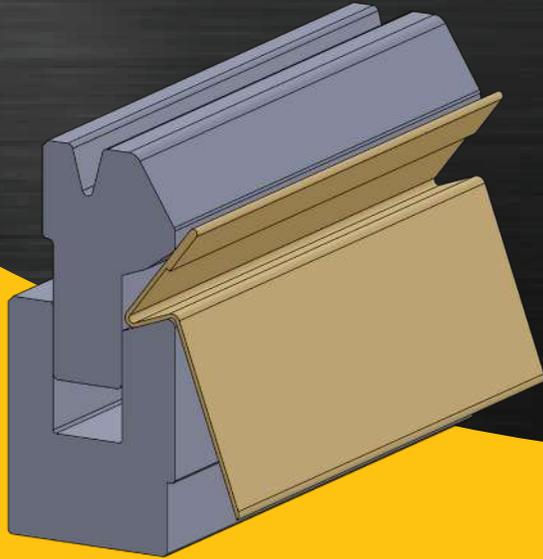
Quenched and tempered 30±2 HRc.
Tip Laser Hardened 52±2HRc.





E- CATALOGUE

HEMMING INCLINE



HEMMING SLENDER TYPE

FAROHAR ENGINEERING

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