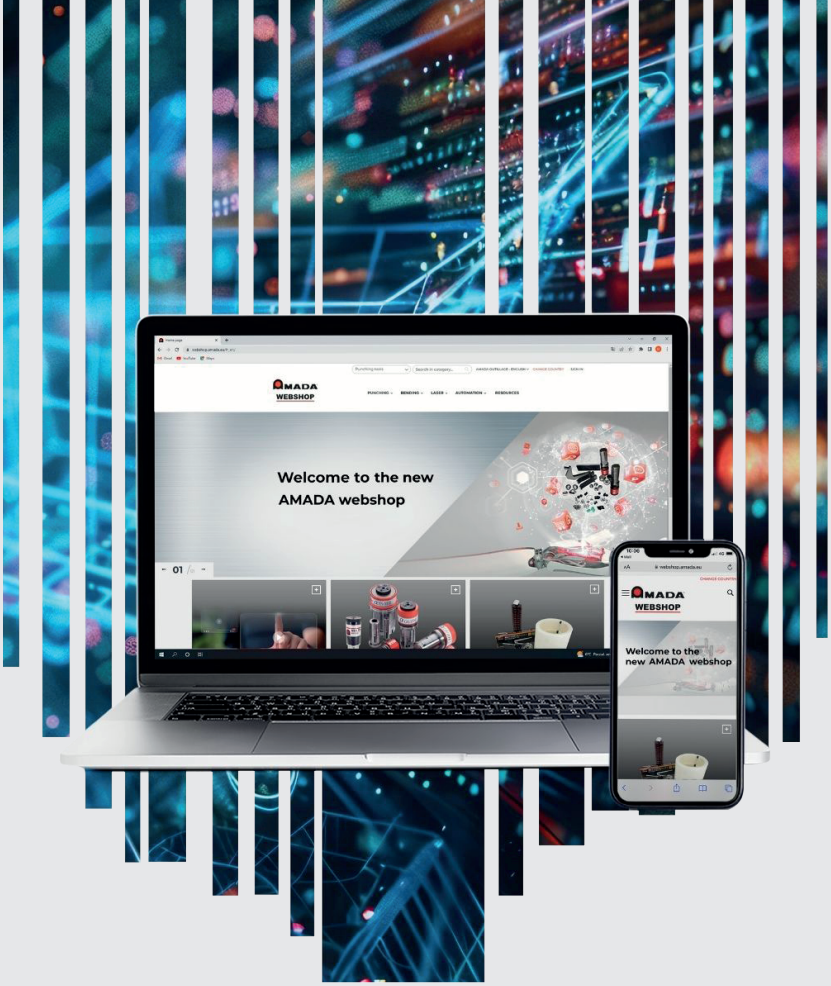


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TOOLING MAINTENANCE & SOLUTION WEBINARS













Discover valuable hints and tips to get the best out of your tools and boost production!

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Press Brake Tooling

AMADA Quality Tooling

AMADA has been the leader in the production of Precision Press Brakes for over 40 years and we have installed more than 80,000 machines worldwide. The knowledge gained from this experience has confirmed our conviction that the use of superior tooling ensures optimum performance each and every time the Press Brake is used. Using AMADA Press Brake Tooling guarantees you the edge in productivity, putting you ahead of the competition.

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Pressbrake Tooling

Punch Quality

AMADA punches are through hardened from hot formed steel:

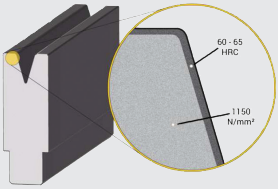
- Through hardened 47 HRC
- For long lasting high precision
- Surface hardness: 45~50 HRC
- Body strength: **1500 N/mm²**



Die Quality

AMADA dies are AMANIT®, providing:

- Highest wear resistance on tool surface: HRC 60-65
- Low friction on the shoulder radii
- Highest strength of the body - **1150 N/mm²**
- Corrosion resistance

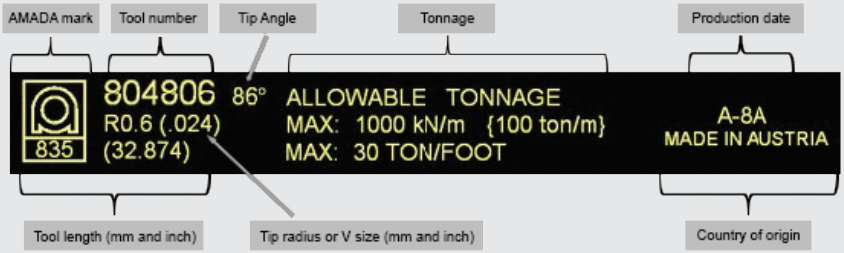


Tooling Features

With innovative heat treatment strategies and special testing techniques we are giving best durability to the steel, not only against failure caused by dead loads but also against fatigue caused by an infinite number of repeated loads.

Complete Laser Marking

All AMADA pressbrake tools are completely marked by laser. Essential information like tooling type, angle, tonnage, length and radius are marked even on the sectional parts.

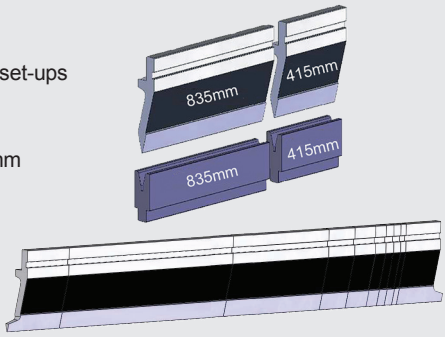


Tooling Lengths

Available in solid 835mm, solid 415 mm and
Sectionalized (sec) lengths for easy one-operator set-ups

Sectionalized Punch (100mm are ears):
100, 10, 15, 15, 20, 40, 50, 150, 300, 100 = 800 mm

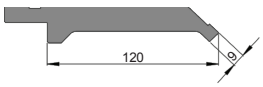
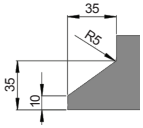
Sectionalized Die:
100, 10, 15, 15, 20, 40, 50, 150, 400 = 800 mm



How to use this section

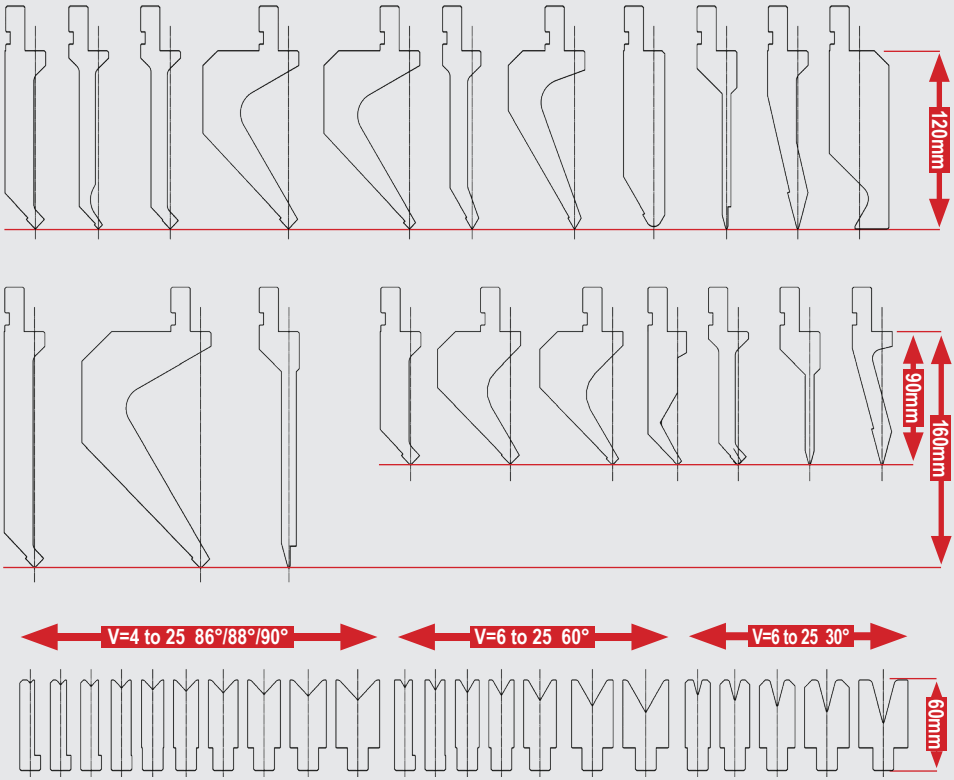
This section should be read as follows:

Example: #804 Punch

1 Angle	2 Radii	3 Code	4 Length	Price	Tool #804 - 100 t/m
86°	R0.6	8048061	835 mm	£362	 9 mm tip  7 Was # 8 Ear tonnage = 45 t/m
		8048062	415 mm	£204	
		8048063	Sec	£519	
	R1.5	8048151	835 mm	£407	
		8048152	415 mm	£231	
		8048153	Sec	£549	
	R3.0	8048301	835 mm	£432	
		8048302	415 mm	£247	
		8048303	Sec	£584	
88°	R0.6	8047061	835 mm	£362	
		8047062	415 mm	£204	
		8047063	Sec	£519	

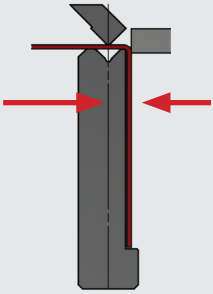
1. Tool Angle (colour coded)
2. Punch Tip Radius available - highlighted colour is the standard radius
3. Code number for radii specified
4. Tool length
5. Tool number
6. Allowable tonnage – tonnage per metre
7. Previous tool number (if applicable)
8. Ear tonnage – tonnage per metre

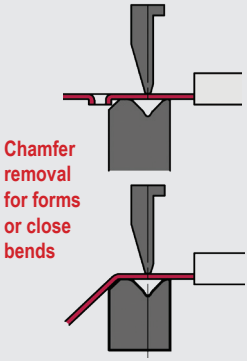
AFH - AMADA Fixed Height



Advantages of AFH

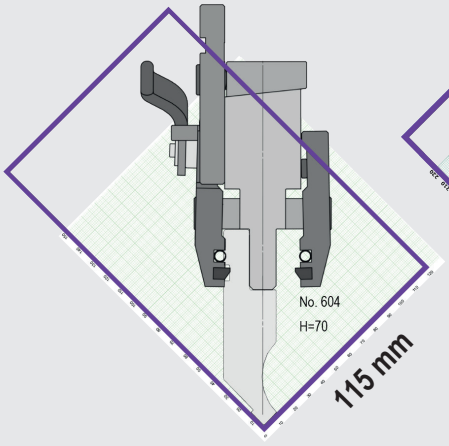
Single V Dies



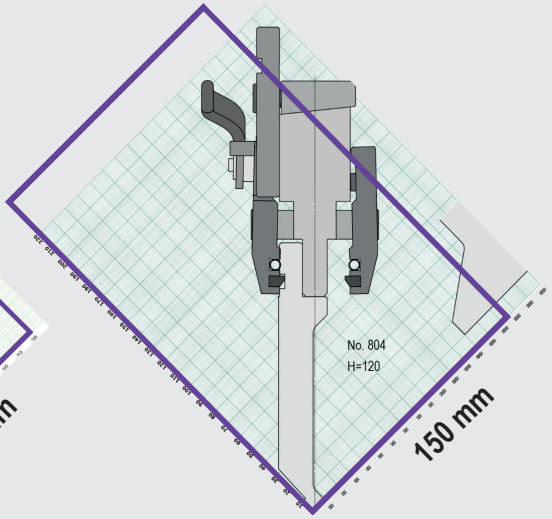


Advantages of AFH

Deeper box bending capability and enlarged bend return area

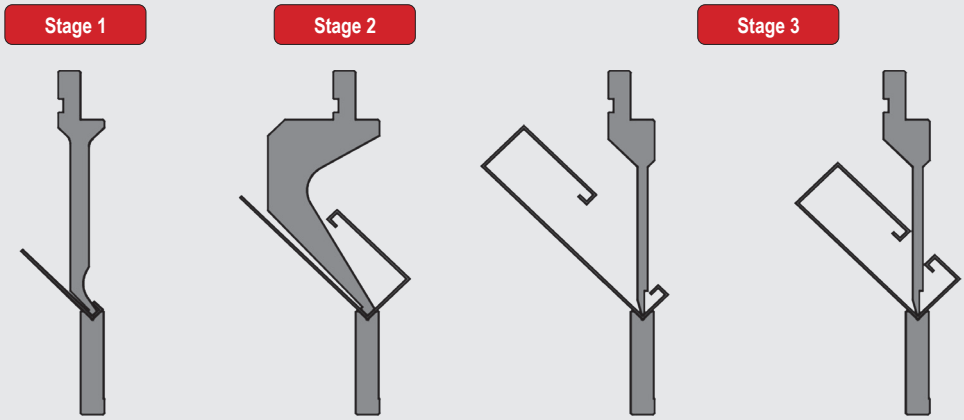


Old Standard Tool



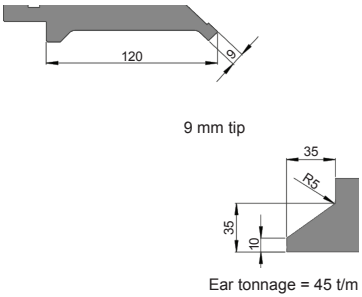
New AFH (H=120 mm) Tool

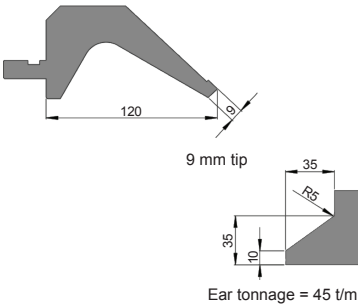
Multiple punch and die profiles have a common height making pressbrake set-ups fast and stage bending easy.



This example shows 3 different profiles in one machine bed set-up

AFH Punches H=120

Angle	Radii	Code	Length	Price	Tool #804 AFH - 100 t/m
86°	R0.6	8048061	835 mm	£362	
		8048062	415 mm	£204	
		8048063	Sec	£519	
	R1.5	8048151	835 mm	£407	
		8048152	415 mm	£231	
		8048153	Sec	£549	
	R3.0	8048301	835 mm	£432	
		8048302	415 mm	£247	
		8048303	Sec	£584	
88°	R0.6	8047061	835 mm	£362	
		8047062	415 mm	£204	
		8047063	Sec	£519	

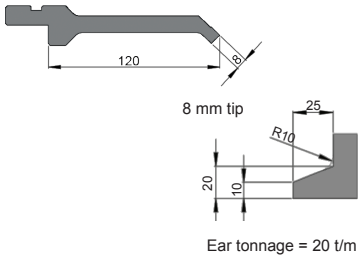
Angle	Radii	Code	Length	Price	Tool #847 AFH - 50 t/m
86°	R0.6	8478061	835 mm	£889	
		8478062	415 mm	£532	
		8478063	Sec	£1,363	
	R1.5	8478151	835 mm	£999	
		8478152	415 mm	£576	
		8478153	Sec	£1,472	
	R3.0	8478301	835 mm	£1,065	
		8478302	415 mm	£591	
		8478303	Sec	£1,434	
88°	R0.6	8477061	835 mm	£889	
		8477062	415 mm	£532	
		8477063	Sec	£1,363	

Note: 90° Punches are available on request

AFH Punches H=120

Angle	Radii	Code	Length	Price
86°	R0.6	8208061	835 mm	£588
		8208062	415 mm	£349
		8208063	Sec	£912
	R1.5	8208151	835 mm	£636
		8208152	415 mm	£369
		8208153	Sec	£985
88°	R0.6	8207061	835 mm	£588
		8207062	415 mm	£349
		8207063	Sec	£912

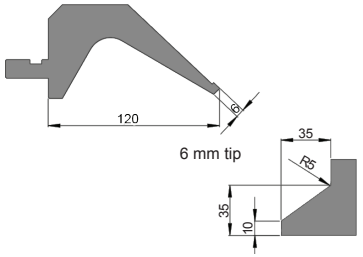
Tool #820 AFH - 50 t/m



Ear tonnage = 20 t/m

Angle	Radii	Code	Length	Price
86°	R0.6	8468061	835 mm	£907
		8468062	415 mm	£542
		8468063	Sec	£1,389
88°		8467061	835 mm	£907
		8467062	415 mm	£542
		8467063	Sec	£1,389

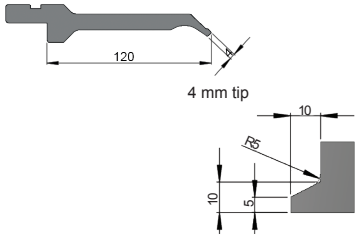
Tool #846 AFH - 45 t/m



Ear tonnage = 35 t/m

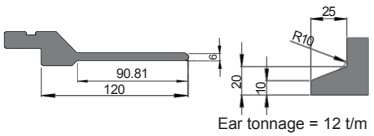
Angle	Radii	Code	Length	Price
86°	R0.6	8178061	835 mm	£562
		8178062	415 mm	£338
		8178063	Sec	£865
88°		8177061	835 mm	£562
		8177062	415 mm	£338
		8177063	Sec	£865

Tool #817 AFH - 30 t/m

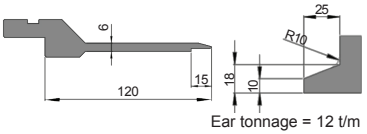


Ear tonnage = 15 t/m

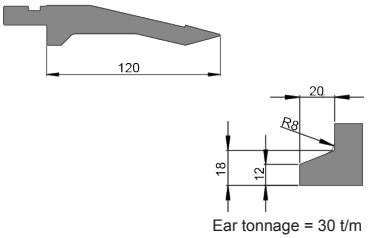
AFH Punches H=120

Angle	Radii	Code	Length	Price	Tool #813 AFH - 45 t/m
86°	R0.6	8138061	835 mm	£779	
		8138062	415 mm	£518	
		8138063	Sec	£1,061	

Ear tonnage = 12 t/m

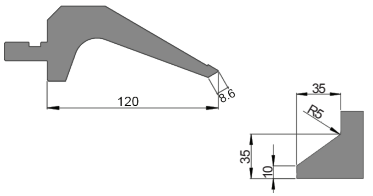
Angle	Radii	Code	Length	Price	Tool #814 AFH - 45 t/m
30°	R0.6	8143061	835 mm	£551	
		8143062	415 mm	£382	
		8143063	Sec	£799	

Ear tonnage = 12 t/m

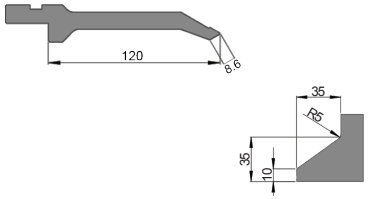
Angle	Radii	Code	Length	Price	Tool #831 AFH - 100 t/m
26°	R0.6	8312061	835 mm	£631	
		8312062	415 mm	£324	
		8312063	Sec	£828	
30°	R0.6	8313061	835 mm	£563	
		8313062	415 mm	£289	
		8313063	Sec	£739	
	R1.5	8313151	835 mm	£631	
		8313152	415 mm	£324	
		8313153	Sec	£828	
	R3.0	8313301	835 mm	£676	
		8313302	415 mm	£348	
		8313303	Sec	£887	
	R4.0	8313401	835 mm	£720	
		8313402	415 mm	£370	
		8313403	Sec	£946	

Ear tonnage = 30 t/m

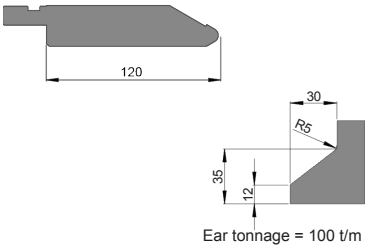
AFH Punches H=120

Angle	Radii	Code	Length	Price	Tool #841 AFH - 70 t/m
60°	R0.6	8416061	835 mm	£741	
		8416062	415 mm	£414	
		8416063	Sec	£1,032	
	R1.5	8416151	835 mm	£831	
		8416152	415 mm	£463	
		8416153	Sec	£1,156	

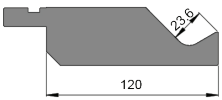
Ear tonnage = 30 t/m

Angle	Radii	Code	Length	Price	Tool #840 AFH - 70 t/m
60°	R0.6	8406061	835 mm	£462	
		8406062	415 mm	£275	
		8406063	Sec	£680	
	R1.5	8406151	835 mm	£517	
		8406152	415 mm	£296	
		8406153	Sec	£761	

Ear tonnage = 30 t/m

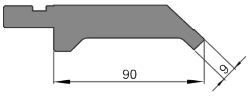
Angle	Radii	Code	Length	Price	Tool #803 AFH - 100 t/m
60°	R6.0	8036601	835 mm	£490	
		8036602	415 mm	£271	
		8036603	Sec	£690	
	R5.0	8036501	835 mm	£613	
		8036502	415 mm	£340	
		8036503	Sec	£862	

Ear tonnage = 100 t/m

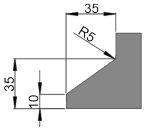
Angle	Radii	Code	Length	Price	Tool #822 AFH - 100 t/m
Flattening		8220001	835 mm	£578	
		8220002	415 mm	£330	
		8220003	Sec (no ears)	£862	

AFH Punches H=90

Angle	Radii	Code	Length	Price	Tool #704 AFH - 100 t/m
86°	R0.6	7048061	835 mm	£370	
		7048062	415 mm	£215	
		7048063	Sec	£513	
	R1.5	7048151	835 mm	£374	
		7048152	415 mm	£220	
		7048153	Sec	£521	
	R3.0	7048301	835 mm	£395	
		7048302	415 mm	£229	
		7048303	Sec	£556	
88°	R0.6	7047061	835 mm	£370	
		7047062	415 mm	£215	
		7047063	Sec	£513	



9 mm tip



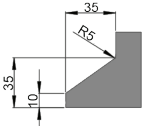
Ear tonnage = 45 t/m

Was #0S01 (86°)
Was #0S02 (90°)

Angle	Radii	Code	Length	Price	Tool #747 AFH - 80 t/m
86°	R0.6	7478061	835 mm	£494	
		7478062	415 mm	£261	
		7478063	Sec	£659	
	R1.5	7478151	835 mm	£541	
		7478152	415 mm	£297	
		7478153	Sec	£697	
	R3.0	7478301	835 mm	£598	
		7478302	415 mm	£331	
		7478303	Sec	£778	
88°	R0.6	7477061	835 mm	£494	
		7477062	415 mm	£261	
		7477063	Sec	£659	



9 mm tip

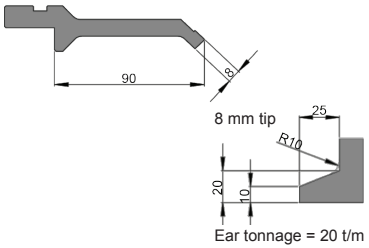


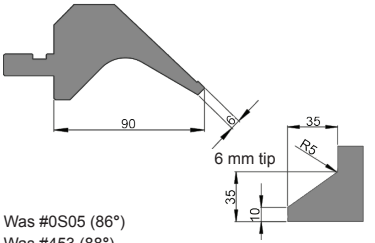
Ear tonnage = 45 t/m

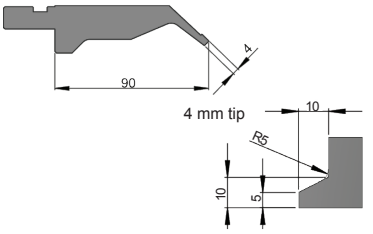
Was #452 (88°)

Note: 90° Punches are available on request

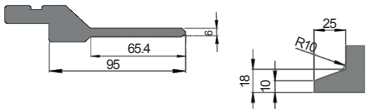
AFH Punches H=90

Angle	Radii	Code	Length	Price	Tool #720 AFH - 50 t/m
86°	R0.6	7208061	835 mm	£553	
		7208062	415 mm	£328	
		7208063	Sec	£881	
	R1.5	7208151	835 mm	£553	
		7208152	415 mm	£328	
		7208153	Sec	£881	
88°	R0.6	7207061	835 mm	£553	
		7207062	415 mm	£328	
		7207063	Sec	£881	Was #0S03 (86°)

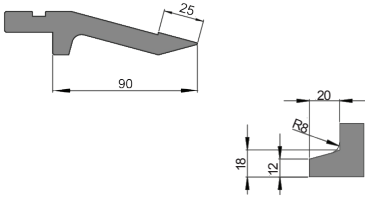
Angle	Radii	Code	Length	Price	Tool #746 AFH - 55 t/m
86°	R0.6	7468061	835 mm	£560	
		7468062	415 mm	£303	
		7468063	Sec	£714	
88°		7467061	835 mm	£560	
		7467062	415 mm	£303	
		7467063	Sec	£714	Was #0S05 (86°) Was #453 (88°)

Angle	Radii	Code	Length	Price	Tool #717 AFH - 20 t/m
86°	R0.6	7178061	835 mm	£566	
		7178062	415 mm	£329	
		7178063	Sec	£771	
88°		7177061	835 mm	£566	
		7177062	415 mm	£329	
		7177063	Sec	£771	

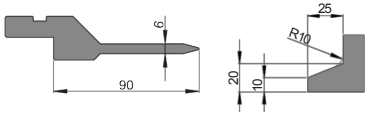
AFH Punches H=90

Angle	Radii	Code	Length	Price	Tool #109 AFH - 50 t/m
88°	R0.6	109061	835 mm	£397	
		109062	415 mm	£233	
		107061	Sec	£709	

Ear tonnage = 12 t/m

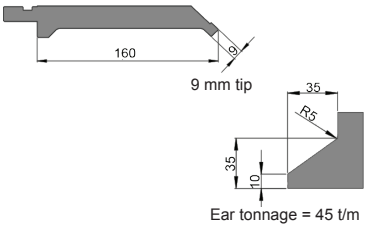
Angle	Radii	Code	Length	Price	Tool #731 AFH - 100 t/m
30°	R0.6	7313061	835 mm	£479	
		7313062	415 mm	£273	
		7313063	Sec	£611	
	R1.5	7313151	835 mm	£526	
		7313152	415 mm	£310	
		7313153	Sec	£734	
	R3.0	7313301	835 mm	£573	
		7313302	415 mm	£340	
		7313303	Sec	£806	

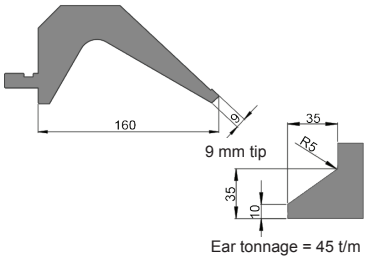
Ear tonnage = 30 t/m

Angle	Radii	Code	Length	Price	Tool #713 AFH - 45 t/m
30°	R0.6	7133061	835 mm	£510	
		7133062	415 mm	£294	
		7133063	Sec	£763	

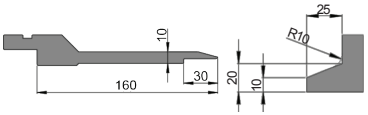
Ear tonnage = 12 t/m

AFH Punches H=160

Angle	Radii	Code	Length	Price	Tool #904 AFH - 100 t/m
86°	R0.6	9048061	835 mm	£1,093	
		9048062	415 mm	£653	
		9048063	Sec	£1,334	
	R1.5	9048151	835 mm	£1,114	
		9048152	415 mm	£664	
		9048153	Sec	£1,356	
	R3.0	9048301	835 mm	£1,137	
		9048302	415 mm	£674	
		9048303	Sec	£1,381	
88°	R0.6	9047061	835 mm	£1,093	
		9047062	415 mm	£653	
		9047063	Sec	£1,334	

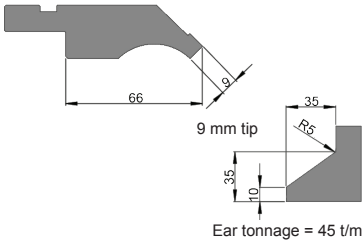
Angle	Radii	Code	Length	Price	Tool #947 AFH - 50 t/m
86°	R0.6	9478061	835 mm	£1,549	
		9478062	415 mm	£913	
		9478063	Sec	£1,967	
	R1.5	9478151	835 mm	£1,606	
		9478152	415 mm	£965	
		9478153	Sec	£2,028	
	R3.0	9478301	835 mm	£1,611	
		9478302	415 mm	£989	
		9478303	Sec	£2,081	
88°	R0.6	9477061	835 mm	£1,549	
		9477062	415 mm	£913	
		9477063	Sec	£1,967	Was #472 (88°)

AFH Punches H=160

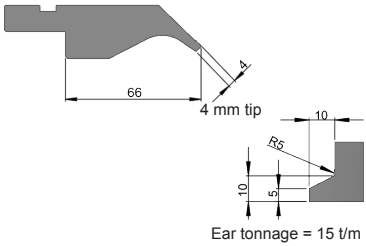
Angle	Radii	Code	Length	Price	Tool #914 AFH - 45 t/m
30°	R0.6	9143061	835 mm	£1,277	
		9143062	415 mm	£713	
		9143063	Sec	£1,609	

Ear tonnage = 12 t/m

AFH Punches H=70

Angle	Radii	Code	Length	Price	Tool #604 - 100 t/m
88°	R0.2	6047021	835 mm	£229	
		6047022	415 mm	£133	
		6047023	Sec	£344	
	R0.6	6047061	835 mm	£229	
		6047062	415 mm	£133	
		6047063	Sec	£344	
	R0.8	6047081	835 mm	£229	
		6047082	415 mm	£133	
		6047083	Sec	£344	
	R1.5	6047151	835 mm	£229	
		6047152	415 mm	£133	
		6047153	Sec	£344	
	R3.0	6047301	835 mm	£229	
		6047302	415 mm	£133	
		6047303	Sec	£344	

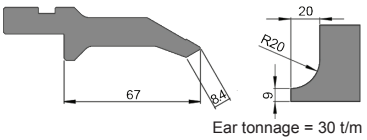
Was #4 (88°)
Was #16 (90°)

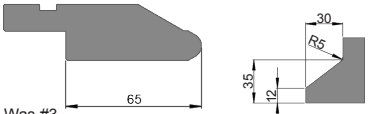
Angle	Radii	Code	Length	Price	Tool #617 - 30 t/m
88°	R0.2	6177021	835 mm	£432	
		6177022	415 mm	£248	
		6177023	Sec	£649	
	R0.6	6177061	835 mm	£432	
		6177062	415 mm	£248	
		6177063	Sec	£649	
	R0.8	6177081	835 mm	£432	
		6177082	415 mm	£248	
		6177083	Sec	£649	

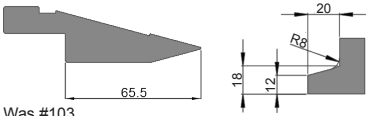
Was #117 (88°)
Was #116 (90°)

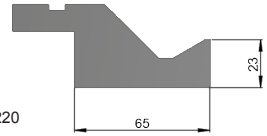
Note: 90° Punches are available on request

Punches H=70

Angle	Radii	Code	Length	Price	Tool #640 - 100 t/m
60°	R0.8	6406081	835 mm	£397	 Ear tonnage = 30 t/m
		6406082	415 mm	£282	
		6406083	Sec	£571	
	R2.0	6406201	835 mm	£397	
		6406202	415 mm	£282	
		6406203	Sec	£571	Was #704 or #705

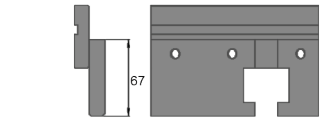
Angle	Radii	Code	Length	Price	Tool #603 - 100 t/m
60°	R6.0	6036601	835 mm	£417	 Was #3 Ear tonnage = 100 t/m
		6036602	415 mm	£235	
		6036603	Sec	£625	

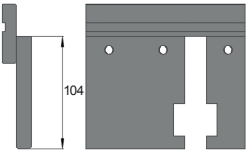
Angle	Radii	Code	Length	Price	Tool #631 - 100 t/m
30°	R0.52	6313051	835 mm	£316	 Was #103 Ear tonnage = 30 t/m
		6313052	415 mm	£187	
		6313053	Sec	£465	

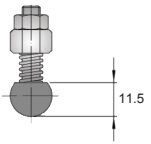
Angle	Radii	Code	Length	Price	Tool #622 - 100 t/m
Flattening		6220001	835 mm	£506	 Was #220
		6220002	415 mm	£283	

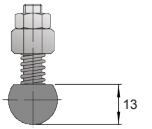

846001
86° R0.6(.024)
415
(16.339)
ALLOWABLE TONNAGE
MAX: 450 kN/m (45ton/m)
MAX: 14 TON/FOOT
MADE IN AUSTRIA
AMANIT

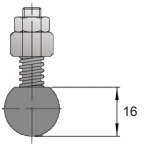
Radius Punches

	Radii	Code	Length	Price	Tool #0150 Holder - 100 t/m
		0150001	830 mm	£267	 Was #15
		0150002	412 mm	£160	

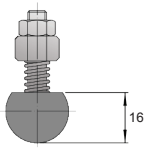
	Radii	Code	Length	Price	Tool #0160 Holder - 100 t/m
		0160001	830 mm	£348	
		0160002	412 mm	£228	

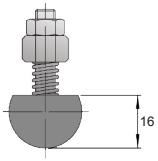
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R7.0	0170071	835 mm	£132	
		0170072	415 mm	£73	

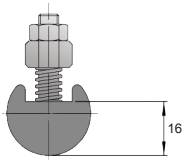
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R8.0	0170081	835 mm	£140	
		0170082	415 mm	£75	

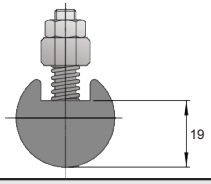
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R9.0	0170091	835 mm	£154	
		0170092	415 mm	£82	

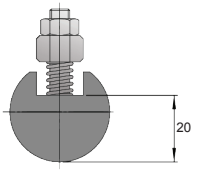
Radius Punches

	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R10.0	0170101	835 mm	£79	
		0170102	415 mm	£49	

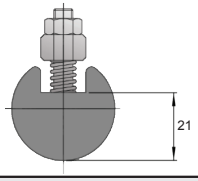
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R11.0	0170111	835 mm	£190	
		0170112	415 mm	£103	

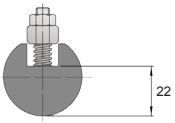
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R12.5	0170121	835 mm	£204	
		0170122	415 mm	£113	

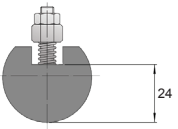
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R14.0	0170141	835 mm	£215	
		0170142	415 mm	£118	

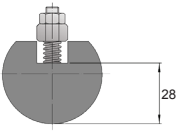
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R15.0	0170151	835 mm	£110	
		0170152	415 mm	£61	

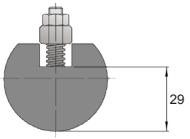
Radius Punches

	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R16.0	0170161	835 mm	£235	
		0170162	415 mm	£132	

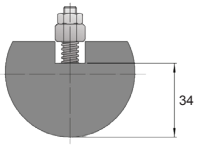
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R17.5	0170171	835 mm	£112	
		0170172	415 mm	£71	

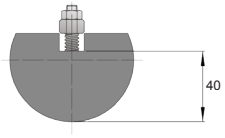
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R20.0	0170201	835 mm	£139	
		0170202	415 mm	£86	

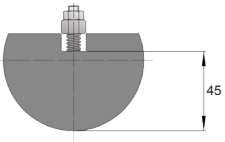
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R22.5	0170221	835 mm	£286	
		0170222	415 mm	£173	

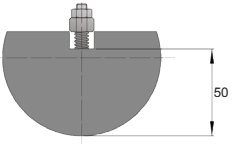
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R25.0	0170251	835 mm	£159	
		0170252	415 mm	£95	

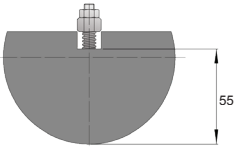
Radius Punches

	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R30.0	0170301	835 mm	£196	
		0170302	415 mm	£113	

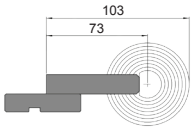
	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R35.0	0170351	835 mm	£477	
		0170352	415 mm	£286	

	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R40.0	0170401	835 mm	£517	
		0170402	415 mm	£306	

	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R45.0	0170451	835 mm	£588	
		0170452	415 mm	£340	

	Radii	Code	Length	Price	Tool #17 - 100 t/m
	R50.0	0170501	835 mm	£607	
		0170502	415 mm	£349	

Colour Radius Punches

	Radii	Code	Length	Price	Tool #CR30 - 50 t/m
		730001	835 mm	£947	
		730002	415 mm	£701	
		730801	Sec*	£1,455	

	Radii	Code	Length	Price	Yellow
	R12.5	03YE01	835 mm	£86	
		03YE02	415 mm	£69	
		03BYE1	Sec*	£120	

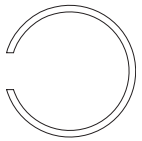
	Radii	Code	Length	Price	Red
	R15.0	03RE01	835 mm	£86	
		03RE02	415 mm	£69	
		03BRE1	Sec*	£120	

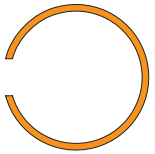
	Radii	Code	Length	Price	Black
	R17.5	03BR01	835 mm	£86	
		03BR02	415 mm	£69	
		03BBR1	Sec*	£120	

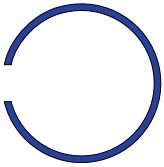
	Radii	Code	Length	Price	Light Blue
	R20.0	03SB01	835 mm	£86	
		03SB02	415 mm	£69	
		03BSB1	Sec*	£120	

Colour Radius Punches

	Radii	Code	Length	Price	Green
	R22.5	03GR01	835 mm	£86	
		03GR02	415 mm	£69	
		03BGR1	Sec*	£120	

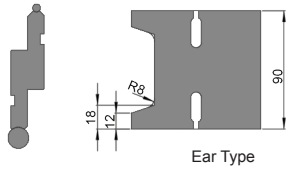
	Radii	Code	Length	Price	White
	R25.0	03HD01	835 mm	£86	
		03HD02	415 mm	£69	
		03BHD1	Sec*	£120	

	Radii	Code	Length	Price	Orange
	R27.5	03OR01	835 mm	£86	
		03OR02	415 mm	£69	
		03BOR1	Sec*	£120	

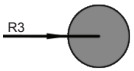
	Radii	Code	Length	Price	Dark Blue
	R30.0	03BU01	835 mm	£86	
		03BU02	415 mm	£69	
		03BBU1	Sec*	£120	

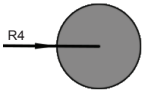
*** Sec length:** 25, 40, 50, 100, 120, 200, 300 = 835 mm

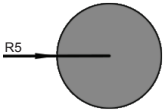
Multi-Radius Punches

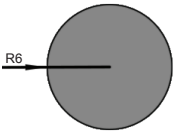
	Radii	Code	Length	Price	Tool #91 Holder
		691001	835 mm	£970	
		691002	415 mm	£652	
		691801	Sec*	£1,130	

Ear Type

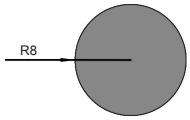
	Radii	Code	Length	Price	Tool #90
	R3.0	090301	835 mm	£213	
		090302	415 mm	£149	
		090831	Sec*	£233	

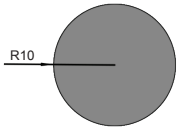
	Radii	Code	Length	Price	Tool #90
	R4.0	090401	835 mm	£213	
		090402	415 mm	£149	
		090841	Sec*	£233	

	Radii	Code	Length	Price	Tool #90
	R5.0	090501	835 mm	£213	
		090502	415 mm	£149	
		090851	Sec*	£233	

	Radii	Code	Length	Price	Tool #90
	R6.0	090601	835 mm	£213	
		090602	415 mm	£149	
		090861	Sec*	£233	

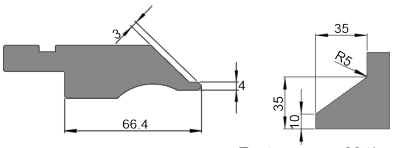
Multi-Radius Punches

	Radii	Code	Length	Price	Tool #90
	R8.0	090801	835 mm	£213	
		090802	415 mm	£149	
		090881	Sec*	£233	

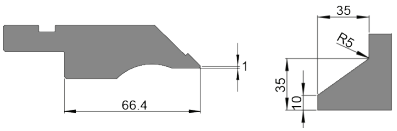
	Radii	Code	Length	Price	Tool #90
	R10.0	090101	835 mm	£213	
		090102	415 mm	£149	
		090811	Sec*	£233	

*** Sec length:** 100 (ear), 20, 25, 30, 35, 40, 50, 70, 165, 200, 100 (ear) = 835 mm

Burring Punches

Angle	Radii	Code	Length	Price	Tool #486 - 40 t/m
88°	R0.6	604861	835 mm	£453	
		604862	415 mm	£277	
		648861	Sec*	£624	

Ear tonnage = 20 t/m

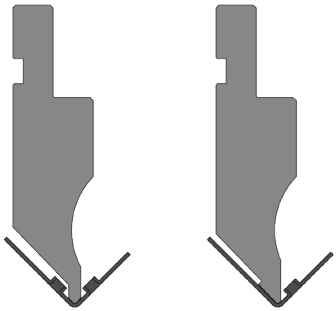
Angle	Radii	Code	Length	Price	Tool #496 - 80 t/m
88°	R0.6	604961	835 mm	£415	
		604962	415 mm	£241	
		648961	Sec*	£543	

Ear tonnage = 40 t/m

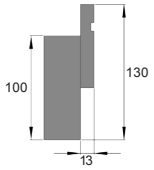
*** Sec length:** 100 (ear), 10, 15, 20, 40, 50, 200, 300, 100 (ear) = 835 mm

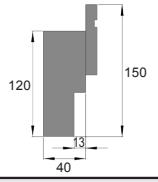
Burring Punches

Components with burred or extruded holes can be formed easily without interference



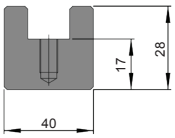
Special Punch Holders

Machine Type	Code	Length	Price	Tool #225
Machines with open height of 300 mm	225002	415 mm	£187	

Machine Type	Code	Length	Price	Tool #227
Machines with open height of 370 mm or more	227002	415 mm	£342	

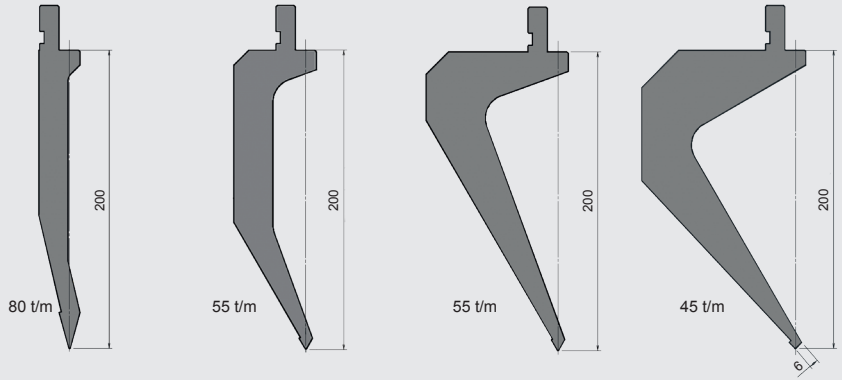
Above holders to be used in place of standard distance pieces when the required bend tonnage exceeds 100 t/m

Flattening

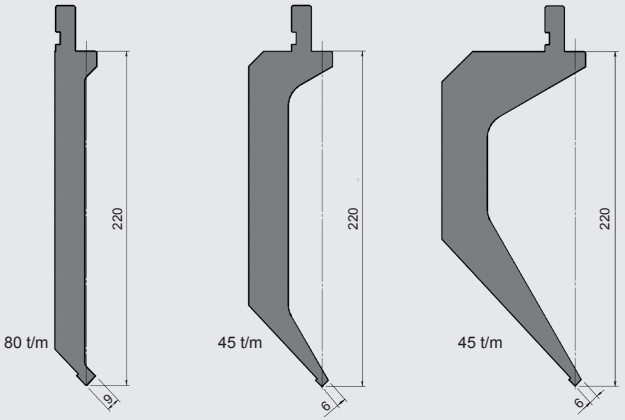
Angle	Radii	Code	Length	Price	Tool #020
Flattening		0200001	835 mm	£115	
		0200002	415 mm	£68	Was #20



Semi-Standard Tooling

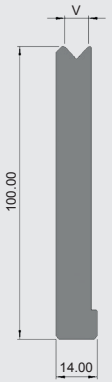


Type	831	841 W55	841 W95	846 W110
Angle	30°	60°	60°	86°
Radii	R0.6	R0.6	R0.6	R0.6
Height	200 mm	200 mm	200 mm	200 mm
Length	415 mm	415 mm	415 mm	415 mm



Type	804	846 W55	846 W95
Angle	86°	86°	86°
Radii	R0.6	R0.6	R0.6
Height	220 mm	220 mm	220 mm
Length	415 mm	415 mm	415 mm

Semi-Standard Dies



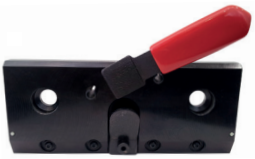
All AFH standard dies, up to V25, can be ordered with 100 mm special height.

1. Special tip radius, special sectionalized lengths and ear profiles available on request
2. See pages 105 to 111 for return bend area details
Price: POA

Clamps

Code	Price	AGRIP M
905200	£617	

Code	Price	SGRIP	SGRIP Rear Clamp Assy
903100 (SGRIP)	£406		
903300 (Rear Clamp)	£111		

Code	Price	Fast Clamp
980000	£98	

Note: Requires 2-off C10549 (Bolt) & 2-off C52487 (Spring) Please ask for prices

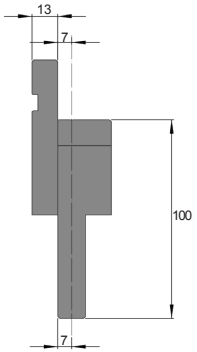
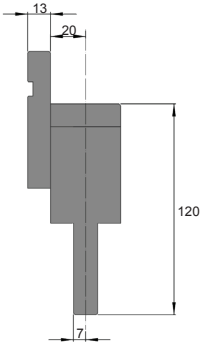
Code	Price	Quick Release
C58621	POA	

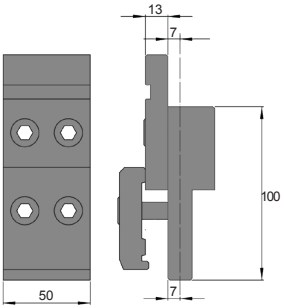
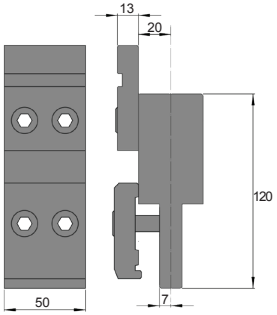
Note: Includes bolts and springs

Code	Price	Standard
961000	£39	

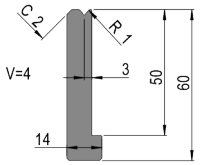
Note: Requires 2-off C10549 (Bolt) & 2-off C52487 (Spring) Please ask for prices

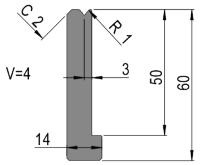
Distance Pieces

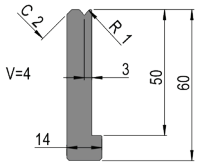
Code	Price	ZI Standard	ZII Standard
C58652 ZI	POA		
C58654 ZII	POA		

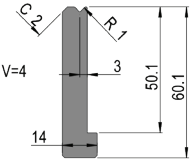
Code	Price	ZI Narrow	ZII Narrow
912000 ZI	£316		
913000 ZII	£316		

AFH 1V Dies V=4

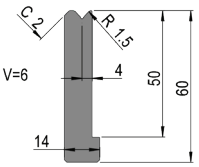
Angle	V-Size	Code	Length	Price	Tool #0848 AFH - 75 t/m
86°	V4	0848101	835 mm	£576	
		0848102	415 mm	£315	
		0848103	Sec	£699	

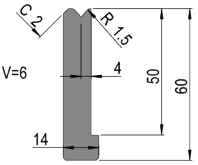
Angle	V-Size	Code	Length	Price	Tool #0847 AFH - 75 t/m
88°	V4	0847101	835 mm	£576	
		0847102	415 mm	£315	
		0847103	Sec	£699	

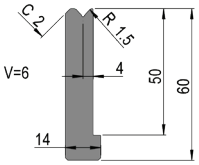
Angle	V-Size	Code	Length	Price	Tool #0849 AFH - 75 t/m
90°	V4	0849101	835 mm	£576	
		0849102	415 mm	£315	
		0849103	Sec	£699	

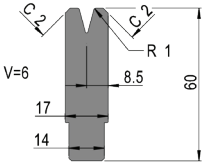
Angle	V-Size	Code	Length	Price	Tool #1848 STAGED - 75 t/m
86°	V4	1848101	835 mm	£576	
		1848102	415 mm	£315	
		1848103	Sec	£699	Was #OS84

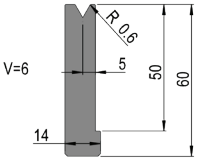
AFH 1V Dies V=6

Angle	V-Size	Code	Length	Price	Tool #0708 AFH - 80 t/m
86°	V6	0708151	835 mm	£360	
		0708152	415 mm	£202	
		0708153	Sec	£434	

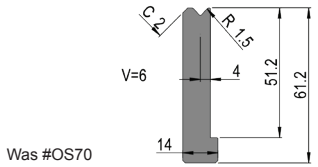
Angle	V-Size	Code	Length	Price	Tool #0707 AFH - 80 t/m
88°	V6	0707151	835 mm	£360	
		0707152	415 mm	£202	
		0707153	Sec	£434	

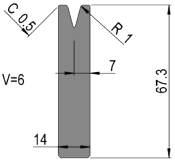
Angle	V-Size	Code	Length	Price	Tool #0709 AFH - 80 t/m
90°	V6	0709151	835 mm	£360	
		0709152	415 mm	£202	
		0709153	Sec	£434	Was #70

Angle	V-Size	Code	Length	Price	Tool #0703 AFH - 50 t/m
30°	V6	0703101	835 mm	£576	
		0703102	415 mm	£315	
		0703103	Sec	£699	Was #14006

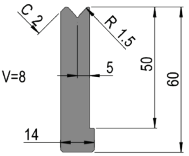
Angle	V-Size	Code	Length	Price	Tool #0706 AFH - 38 t/m
60°	V6	0706061	835 mm	£505	
		0706062	415 mm	£277	
		0706063	Sec	£610	Was #170

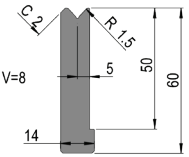
AFH 1V Dies V=6

Angle	V-Size	Code	Length	Price	Tool #1708 STAGED - 80 t/m
86°	V6	1708151	835 mm	£535	
		1708152	415 mm	£298	
		1708153	Sec	£756	Was #OS70

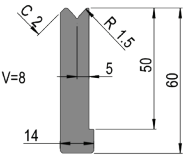
Angle	V-Size	Code	Length	Price	Tool #1703 STAGED - 40 t/m
30°	V6	1703101	835 mm	£683	
		1703102	415 mm	£382	
		1703103	Sec	£904	

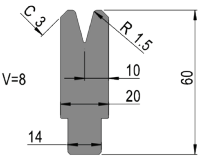
AFH 1V Dies V=8

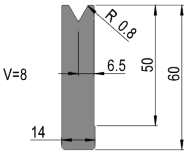
Angle	V-Size	Code	Length	Price	Tool #0718 AFH - 90 t/m
86°	V8	0718151	835 mm	£360	
		0718152	415 mm	£202	
		0718153	Sec	£434	

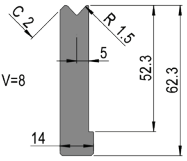
Angle	V-Size	Code	Length	Price	Tool #0717 AFH - 90 t/m
88°	V8	0717151	835 mm	£360	
		0717152	415 mm	£202	
		0717153	Sec	£434	

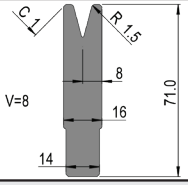
AFH 1V Dies V=8

Angle	V-Size	Code	Length	Price	Tool #0719 AFH - 90 t/m
90°	V8	0719151	835 mm	£360	
		0719152	415 mm	£202	
		0719153	Sec	£434	Was #71

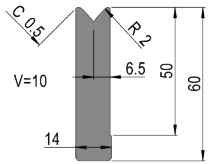
Angle	V-Size	Code	Length	Price	Tool #0713 AFH - 60 t/m
30°	V8	0713151	835 mm	£576	
		0713152	415 mm	£315	
		0713153	Sec	£699	

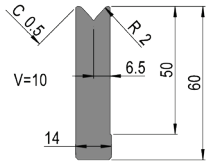
Angle	V-Size	Code	Length	Price	Tool #0716 AFH - 45 t/m
60°	V8	0716081	835 mm	£505	
		0716082	415 mm	£277	
		0716083	Sec	£610	Was #171

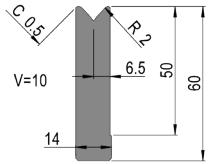
Angle	V-Size	Code	Length	Price	Tool #1718 STAGED - 90 t/m
86°	V8	1718151	835 mm	£535	
		1718152	415 mm	£298	
		1718153	Sec	£756	Was #OS71

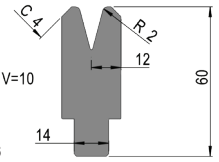
Angle	V-Size	Code	Length	Price	Tool #1713 STAGED - 50 t/m
30°	V8	1713151	835 mm	£683	
		1713152	415 mm	£382	
		1713153	Sec	£904	Was #OS713

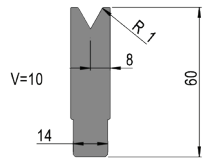
AFH 1V Dies V=10

Angle	V-Size	Code	Length	Price	Tool #0728 AFH - 100 t/m
86°	V10	0728201	835 mm	£360	
		0728202	415 mm	£202	
		0728203	Sec	£434	

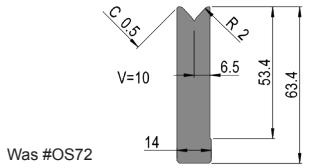
Angle	V-Size	Code	Length	Price	Tool #0727 AFH - 100 t/m
88°	V10	0727201	835 mm	£360	
		0727202	415 mm	£202	
		0727203	Sec	£434	Was #72

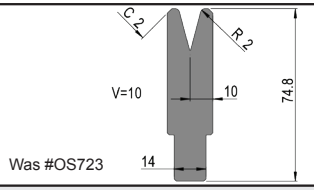
Angle	V-Size	Code	Length	Price	Tool #0729 AFH - 100 t/m
90°	V10	0729201	835 mm	£360	
		0729202	415 mm	£202	
		0729203	Sec	£434	Was #73

Angle	V-Size	Code	Length	Price	Tool #0723 AFH - 70 t/m
30°	V10	0723201	835 mm	£576	
		0723202	415 mm	£315	
		0723203	Sec	£699	Was #14106

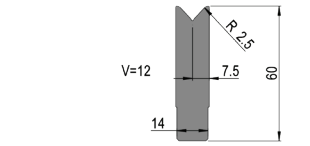
Angle	V-Size	Code	Length	Price	Tool #0726 AFH - 55 t/m
60°	V10	0726101	835 mm	£505	
		0726102	415 mm	£277	
		0726103	Sec	£610	Was #172

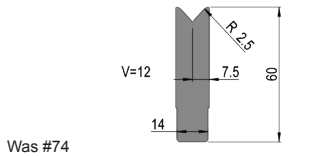
AFH 1V Dies V=10

Angle	V-Size	Code	Length	Price	Tool #1728 STAGED - 100 t/m
86°	V10	1728201	835 mm	£535	
		1728202	415 mm	£298	
		1728203	Sec	£756	Was #OS72

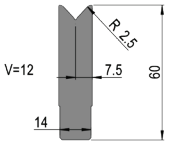
Angle	V-Size	Code	Length	Price	Tool #1723 STAGED - 60 t/m
30°	V10	1723201	835 mm	£711	
		1723202	415 mm	£398	
		1723203	Sec	£931	Was #OS723

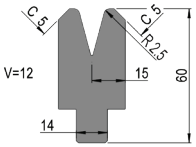
AFH 1V Dies V=12

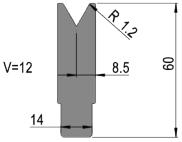
Angle	V-Size	Code	Length	Price	Tool #0748 AFH - 100 t/m
86°	V12	0748251	835 mm	£360	
		0748252	415 mm	£202	
		0748253	Sec	£434	

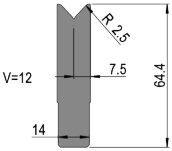
Angle	V-Size	Code	Length	Price	Tool #0747 AFH - 100 t/m
88°	V12	0747251	835 mm	£360	
		0747252	415 mm	£202	
		0747253	Sec	£434	Was #74

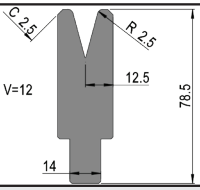
AFH 1V Dies V=12

Angle	V-Size	Code	Length	Price	Tool #0749 AFH - 100 t/m
90°	V12	0749251	835 mm	£360	
		0749252	415 mm	£202	
		0749253	Sec	£434	Was #75

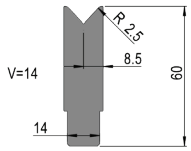
Angle	V-Size	Code	Length	Price	Tool #0743 AFH - 80 t/m
30°	V12	0743251	835 mm	£576	
		0743252	415 mm	£315	
		0743253	Sec	£699	Was #142

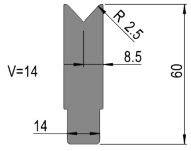
Angle	V-Size	Code	Length	Price	Tool #0746 AFH - 55 t/m
60°	V12	0746121	835 mm	£505	
		0746122	415 mm	£277	
		0746123	Sec	£610	Was #174

Angle	V-Size	Code	Length	Price	Tool #1748 STAGED - 100 t/m
86°	V12	1748251	835 mm	£579	
		1748252	415 mm	£325	
		1748253	Sec	£800	Was #OS74

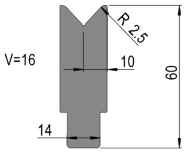
Angle	V-Size	Code	Length	Price	Tool #1743 STAGED - 70 t/m
30°	V12	1743251	835 mm	£711	
		1743252	415 mm	£398	
		1743253	Sec	£931	Was #OS743

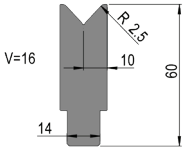
AFH 1V Dies V=14

Angle	V-Size	Code	Length	Price	Tool #0768 AFH - 100 t/m
86°	V14	0768251	835 mm	£436	
		0768252	415 mm	£239	
		0768253	Sec	£496	

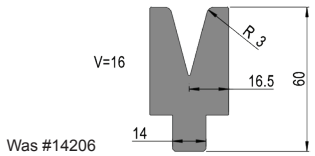
Angle	V-Size	Code	Length	Price	Tool #0767 AFH - 100 t/m
88°	V14	0767251	835 mm	£436	
		0767252	415 mm	£239	
		0767253	Sec	£496	Was #76

AFH 1V Dies V=16

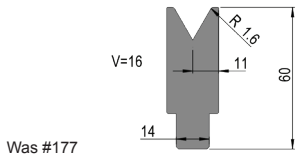
Angle	V-Size	Code	Length	Price	Tool #0778 AFH - 100 t/m
86°	V16	0778251	835 mm	£541	
		0778252	415 mm	£316	
		0778253	Sec	£636	

Angle	V-Size	Code	Length	Price	Tool #0777 AFH - 100 t/m
88°	V16	0777251	835 mm	£541	
		0777252	415 mm	£316	
		0777253	Sec	£636	Was #77

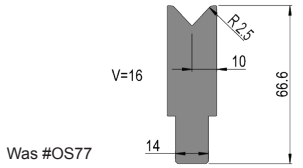
AFH 1V Dies V=16

Angle	V-Size	Code	Length	Price	Tool #0773 AFH - 60 t/m
30°	V16	0773301	835 mm	£705	
		0773302	415 mm	£416	
		0773303	Sec	£852	

Was #14206

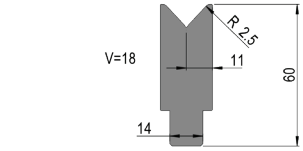
Angle	V-Size	Code	Length	Price	Tool #0776 AFH - 65 t/m
60°	V16	0776161	835 mm	£633	
		0776162	415 mm	£377	
		0776163	Sec	£764	

Was #177

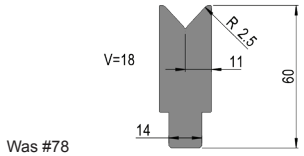
Angle	V-Size	Code	Length	Price	Tool #1778 STAGED - 100 t/m
86°	V16	1778251	835 mm	£643	
		1778252	415 mm	£360	
		1778253	Sec	£861	

Was #OS77

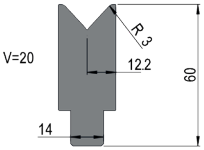
AFH 1V Dies V=18

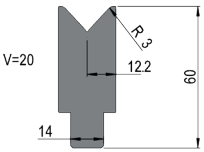
Angle	V-Size	Code	Length	Price	Tool #0788 AFH - 100 t/m
86°	V18	0788251	835 mm	£609	
		0788252	415 mm	£363	
		0788253	Sec	£734	

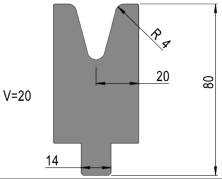
AFH 1V Dies V=18

Angle	V-Size	Code	Length	Price	Tool #0787 AFH - 100 t/m
88°	V18	0787251	835 mm	£609	
		0787252	415 mm	£363	
		0787253	Sec	£734	Was #78

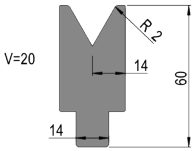
AFH 1V Dies V=20

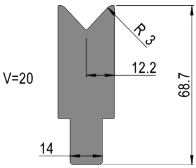
Angle	V-Size	Code	Length	Price	Tool #0798 AFH - 100 t/m
86°	V20	0798301	835 mm	£626	
		0798302	415 mm	£372	
		0798303	Sec	£757	

Angle	V-Size	Code	Length	Price	Tool #0797 AFH - 100 t/m
88°	V20	0797301	835 mm	£626	
		0797302	415 mm	£372	
		0797303	Sec	£757	Was #79

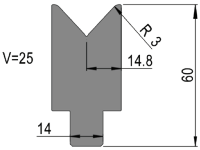
Angle	V-Size	Code	Length	Price	Tool #0793 - 60 t/m
30°	V20	0793401	835 mm	£739	
		0793402	415 mm	£435	
		0793403	Sec	£897	Was #143

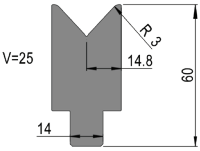
AFH 1V Dies V=20

Angle	V-Size	Code	Length	Price	Tool #0796 AFH – 85 t/m
60°	V20	0796201	835 mm	£671	
		0796202	415 mm	£397	
		0796203	Sec	£808	Was #179

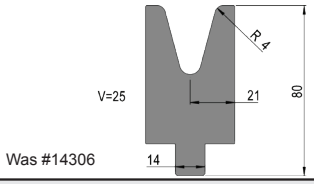
Angle	V-Size	Code	Length	Price	Tool #1798 STAGED - 100 t/m
86°	V20	1798301	835 mm	£658	
		1798302	415 mm	£394	
		1798303	Sec	£881	Was #OS79

AFH 1V Dies V=25

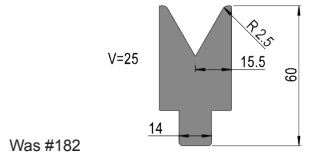
Angle	V-Size	Code	Length	Price	Tool #0828 AFH - 100 t/m
86°	V25	0828301	835 mm	£645	
		0828302	415 mm	£382	
		0828303	Sec	£778	

Angle	V-Size	Code	Length	Price	Tool #0827 AFH - 100 t/m
88°	V25	0827301	835 mm	£645	
		0827302	415 mm	£382	
		0827303	Sec	£778	Was #82

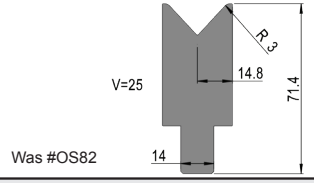
AFH 1V Dies V=25

Angle	V-Size	Code	Length	Price	Tool #0823 – 60 t/m
30°	V25	0823401	835 mm	£764	
		0823402	415 mm	£450	
		0823403	Sec	£927	

Was #14306

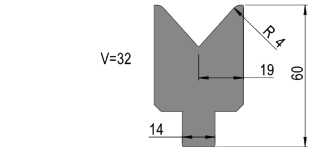
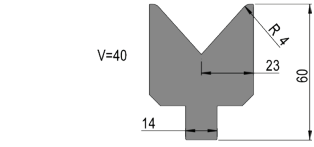
Angle	V-Size	Code	Length	Price	Tool #0826 AFH – 85 t/m
60°	V25	0826251	835 mm	£692	
		0826252	415 mm	£410	
		0826253	Sec	£839	

Was #182

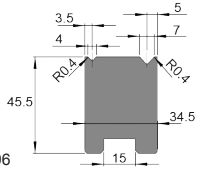
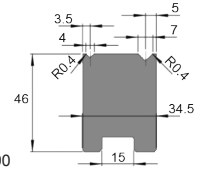
Angle	V-Size	Code	Length	Price	Tool #1828 STAGED – 100 t/m
86°	V25	1828301	835 mm	£705	
		1828302	415 mm	£395	
		1828303	Sec	£926	

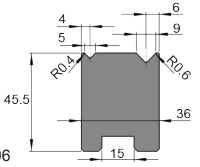
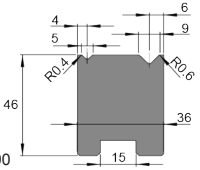
Was #OS82

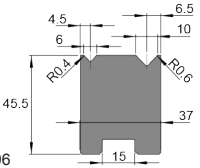
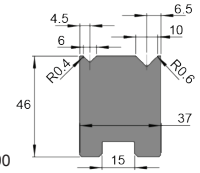
AFH 1V Dies V=32 & V=40

Angle	V-Size	Code	Length	Price	Tool #0874 (V32) & Tool #0884 (V40) – 100 t/m
84°	V32	0874401	835 mm	£817	
		0874402	415 mm	£484	
		0874403	Sec	£952	
	V40	0884401	835 mm	£914	
		0884402	415 mm	£593	
		0884403	Sec	£1,075	

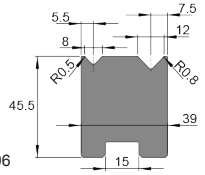
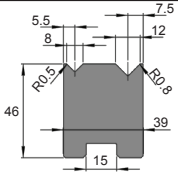
2V Dies Reversible 88°/90°

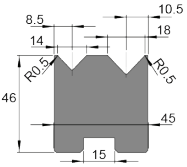
Angle	V-Size	Code	Length	Price	Tool #501704 / #501904 – 60 t/m
88°	V4 & V7	5017041	835 mm	£367	 Was #50196
		5017042	415 mm	£204	
		5017043	Sec	£494	
90°		5019041	835 mm	£367	 Was #50190
		5019042	415 mm	£204	
		5019043	Sec	£494	

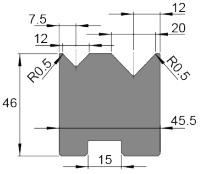
Angle	V-Size	Code	Length	Price	Tool #507704 / #507904 – 65 t/m
88°	V5 & V9	5077041	835 mm	£367	 Was #50796
		5077042	415 mm	£204	
		5077043	Sec	£494	
90°		5079041	835 mm	£367	 Was #50790
		5079042	415 mm	£204	
		5079043	Sec	£494	

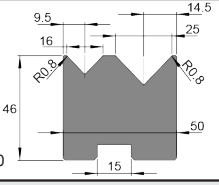
Angle	V-Size	Code	Length	Price	Tool #502704 / #502904 – 70 t/m
88°	V6 & V10	5027041	835 mm	£367	 Was #50296
		5027042	415 mm	£204	
		5027043	Sec	£494	
90°		5029041	835 mm	£367	 Was #50290
		5029042	415 mm	£204	
		5029043	Sec	£494	

2V Dies Reversible 88°/90°

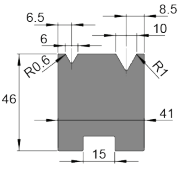
Angle	V-Size	Code	Length	Price	Tool #503705 / #503905 – 70 t/m
88°	V8 & V12	5037051	835 mm	£367	 Was #50396
		5037052	415 mm	£204	
		5037053	Sec	£494	
90°		5039051	835 mm	£367	 Was #50390
		5039052	415 mm	£204	
		5039053	Sec	£494	

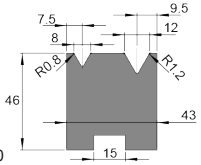
Angle	V-Size	Code	Length	Price	Tool #504705 – 100 t/m
88°	V14 & V18	5047051	835 mm	£367	 Was #50490
		5047052	415 mm	£204	
		5047053	Sec	£494	

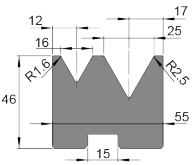
Angle	V-Size	Code	Length	Price	Tool #505705 – 100 t/m
88°	V12 & V20	5057051	835 mm	£367	 Was #50590
		5057052	415 mm	£204	
		5057053	Sec	£494	

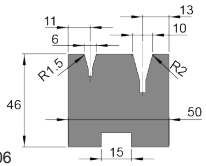
Angle	V-Size	Code	Length	Price	Tool #506708 – 100 t/m
88°	V16 & V25	5067081	835 mm	£367	 Was #50690
		5067082	415 mm	£204	
		5067083	Sec	£494	

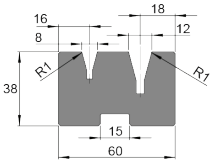
2V Dies Reversible 60°/30°

Angle	V-Size	Code	Length	Price	Tool #502606 – 60 t/m
60°	V6 & V10	5026061	835 mm	£479	
		5026062	415 mm	£267	
		5026063	Sec	£647	Was #50260

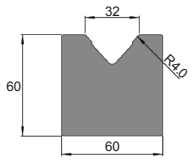
Angle	V-Size	Code	Length	Price	Tool #503608 – 60 t/m
60°	V8 & V12	5036081	835 mm	£521	
		5036082	415 mm	£293	
		5036083	Sec	£704	Was #50360

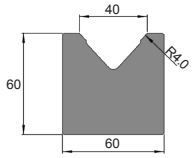
Angle	V-Size	Code	Length	Price	Tool #506616 – 60 t/m
60°	V16 & V25	5066161	835 mm	£624	
		5066162	415 mm	£350	
		5066163	Sec	£844	Was #50660

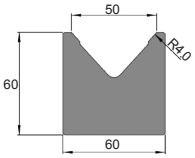
Angle	V-Size	Code	Length	Price	Tool #337315 – 26 t/m
30°	V6 & V10	3373151	835 mm	£624	
		3373152	415 mm	£350	
		3373153	Sec	£844	Was #33706

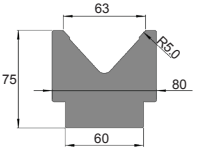
Angle	V-Size	Code	Length	Price	Tool #339310 – 40 t/m
30°	V8 & V12	3393101	835 mm	£481	
		3393102	415 mm	£317	
		3393103	Sec	£615	Was #339

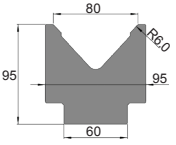
Heavy Duty 1V

Angle	V-Size	Code	Length	Price	Tool #35 – 100 t/m
85°	V32	035001	835 mm	£239	
		035002	415 mm	£161	

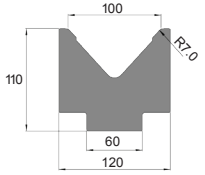
Angle	V-Size	Code	Length	Price	Tool #36 – 100 t/m
85°	V40	036001	835 mm	£245	
		036002	415 mm	£163	

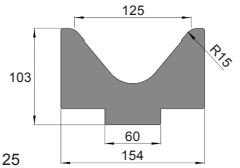
Angle	V-Size	Code	Length	Price	Tool #37 – 100 t/m
85°	V50	037001	835 mm	£257	
		037002	415 mm	£169	

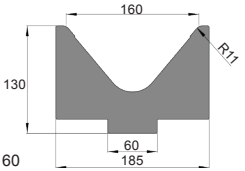
Angle	V-Size	Code	Length	Price	Tool #0385 – 100 t/m
85°	V63	0385501	835 mm	£593	
		0385502	415 mm	£333	Was #38

Angle	V-Size	Code	Length	Price	Tool #13 – 100 t/m
85°	V80	013601	835 mm	£705	
		013602	415 mm	£422	

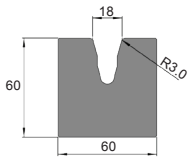
Heavy Duty 1V

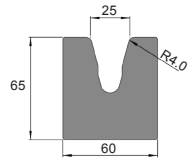
Angle	V-Size	Code	Length	Price	Tool #18 – 100 t/m
85°	V100	018601	835 mm	£941	
		018602	415 mm	£575	

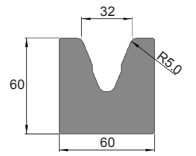
Angle	V-Size	Code	Length	Price	Tool #039015 – 100 t/m
80°	V125	0390151	835 mm	£1,435	
		0390152	415 mm	£862	Was #Z0125

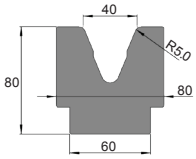
Angle	V-Size	Code	Length	Price	Tool #014011 – 100 t/m
80°	V160	0140111	835 mm	£1,691	
		0140112	415 mm	£1,134	Was #Z0160

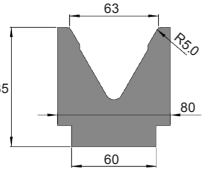
Heavy Duty 1V - Acute

Angle	V-Size	Code	Length	Price	Tool #340 – 80 t/m
30°	V18	340001	835 mm	£317	
		340002	415 mm	£184	

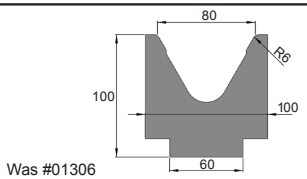
Angle	V-Size	Code	Length	Price	Tool #341 – 60 t/m
30°	V25	341001	835 mm	£342	
		341002	415 mm	£208	

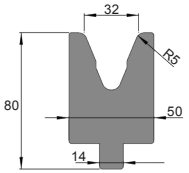
Angle	V-Size	Code	Length	Price	Tool #342 – 40 t/m
45°	V32	342001	835 mm	£342	
		342002	415 mm	£208	

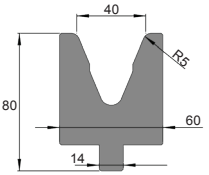
Angle	V-Size	Code	Length	Price	Tool #343150 – 70 t/m
45°	V40	3431501	835 mm	£510	
		3431502	415 mm	£286	Was #343

Angle	V-Size	Code	Length	Price	Tool #038650 – 100 t/m
60°	V63	0386501	835 mm	£1,179	
		0386502	415 mm	£659	Was #03806

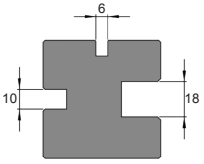
Heavy Duty 1V - Acute

Angle	V-Size	Code	Length	Price	Tool #013660 – 100 t/m
60°	V80	0136601	835 mm	£1,479	
		0136602	415 mm	£817	Was #01306

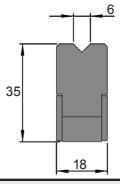
Angle	V-Size	Code	Length	Price	Tool #0871 – 100 t/m
45°	V32	0871501	835 mm	£817	
		0871502	415 mm	£484	

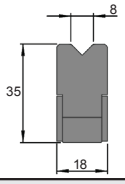
Angle	V-Size	Code	Length	Price	Tool #0881 – 100 t/m
45°	V40	0881501	835 mm	£914	
		0881502	415 mm	£593	

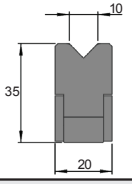
Other Dies

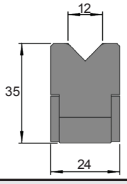
	V-Size	Code	Length	Price	Tool #0129 – 100 t/m
	V6, V10, V18	0129001	835 mm	£251	
		0129002	415 mm	£152	Was #12

Polycarbonate Dies

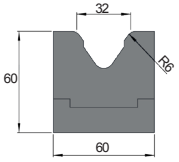
Angle	V-Size	Code	Length	Price	Tool #332 – 32 t/m
88°	V6	332881	835 mm	£195	
		332882	415 mm	£121	

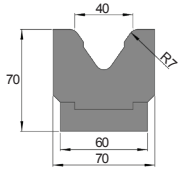
Angle	V-Size	Code	Length	Price	Tool #333 – 32 t/m
88°	V8	333001	835 mm	£195	
		333002	415 mm	£121	

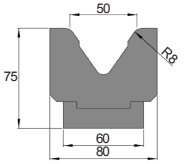
Angle	V-Size	Code	Length	Price	Tool #334 – 32 t/m
88°	V10	334001	835 mm	£195	
		334002	415 mm	£121	

Angle	V-Size	Code	Length	Price	Tool #335 – 32 t/m
88°	V12	335001	835 mm	£195	
		335002	415 mm	£121	

Polycarbonate Dies - Radius Bend

Angle	V-Size	Code	Length	Price	Tool #351 – 50 t/m
70°	V32	351001	835 mm	£473	
		351002	415 mm	£274	

Angle	V-Size	Code	Length	Price	Tool #361 – 50 t/m
70°	V40	361001	835 mm	£509	
		361002	415 mm	£293	

Angle	V-Size	Code	Length	Price	Tool #371 – 50 t/m
70°	V50	371001	835 mm	£562	
		371002	415 mm	£317	

Specification

	V=32			V=40			V=50		
thk / Radius	Mild Steel	Stainless	Aluminium	Mild Steel	Stainless	Aluminium	Mild Steel	Stainless	Aluminium
	0.4~2.3	0.4~1.5	0.4~3.0	0.6~2.3	0.6~1.5	0.6~3.0	0.8~2.3	0.8~1.5	0.8~3.0
6.0	✔	✔	✔						
8.0	✔	✔	✔	✔	✔	✔			
10.0	✔	✔	✔	✔	✔	✔	✔	✔	✔
12.5	✔	✔	✔	✔	✔	✔	✔	✔	✔
15.0		✔		✔	✔	✔	✔	✔	✔
17.5				✔	✔	✔	✔	✔	✔
20.0					✔		✔	✔	✔
22.5							✔	✔	✔
25.0								✔	

Note: All dimensions in mm

Polyurethane Die Technical Guidelines

1. Select Die Pad required

Radius (mm) / thk(mm)	10	15	17.5	20	25	30
0.4	Die 50 x 50				Die 80 x 30	
0.6						
0.8						
1.0						
1.2						
1.6						
2.3					Die 110 x 45	
2.6						
3.2						

Larger die includes the application range of smaller die

2. Tonnage guidelines

Tonnage to bend 90º in Mild Steel (400N/mm^2) using Die Holder # 60(4) with Die Pad 80x30 # 61(4)

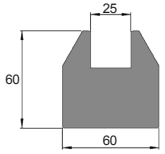
Radius (mm) / thk(mm)	10	15	17.5	20	25
0.4	13	16	18	21	26
0.6	15	18	21	24	29
0.8	17	21	23	27	33
1.0	19	23	27	30	36
1.2	22	25	29	34	39
1.6	26	30	34	40	46
2.3	34	39	43	50	58
2.6	37	43	47	55	63
3.2	48	54	60		

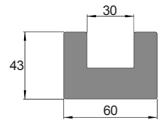
Tonnage required using Urethane Dies is 4-6 x more than standard steel dies. Please ensure that you are within the tonnage limits of both the tooling and machine when bending large radii or long lengths

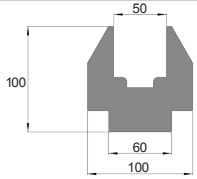
3. Other considerations

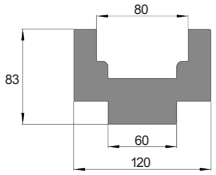
- No marking
- Excellent radius shape
- One die for many radius applications
- High tonnage required
- Die pad is a consumable item
- Short flanges can be difficult

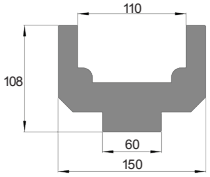
Polyurethane Holders

Width	Code	Length	Price	Tool #60 (1)
25 mm	060011	835 mm	£315	
	060012	415 mm	£193	

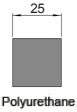
Width	Code	Length	Price	Tool #60 (2)
30 mm	060021	835 mm	£315	
	060022	415 mm	£193	

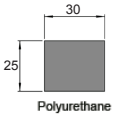
Width	Code	Length	Price	Tool #60 (3)
50 mm	060031	835 mm	£879	
	060032	415 mm	£526	

Width	Code	Length	Price	Tool #60 (4)
80 mm	060041	835 mm	£879	
	060042	415 mm	£526	

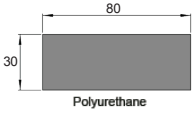
Width	Code	Length	Price	Tool #60 (5)
110 mm	060051	835 mm	£1,343	
	060052	415 mm	£795	

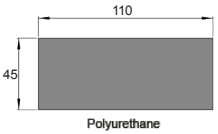
Polyurethane Die Pads

Pad Size	Code	Length	Price	Tool #61 (1)
25 x 25	061121	835 mm	£55	
	061122	415 mm	£25	

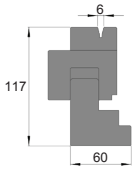
Pad Size	Code	Length	Price	Tool #61 (2)
25 x 30	061221	835 mm	£58	
	061222	415 mm	£30	

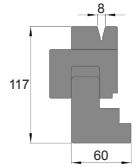
Pad Size	Code	Length	Price	Tool #61 (3)
50 x 50	061321	835 mm	£202	
	061322	415 mm	£108	

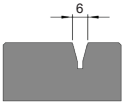
Pad Size	Code	Length	Price	Tool #61 (4)
30 x 80	061421	835 mm	£192	
	061422	415 mm	£108	

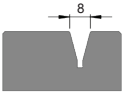
Pad Size	Code	Length	Price	Tool #61 (5)
45 x 110	061521	835 mm	£391	
	061522	415 mm	£206	

Hemming

Angle	V-Size	Code	Length	Price	Tool #106310 – 65 t/m
30°	V6	1063101	835 mm	£1,063	 Was #10469
		1063102	415 mm	£642	

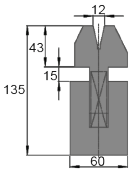
Angle	V-Size	Code	Length	Price	Tool #108310 – 65 t/m
30°	V8	1083101	835 mm	£1,063	 Was #10409
		1083102	415 mm	£642	

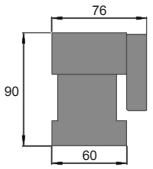
Angle	V-Size	Code	Length	Price	Tool #006310
30°	V6	0063101	835 mm	£342	 Was #80149
		0063102	415 mm	£207	

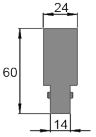
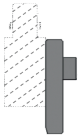
Angle	V-Size	Code	Length	Price	Tool #008310
30°	V8	0083101	835 mm	£342	 Was #80139
		0083102	415 mm	£207	

Note: For replacement bolts and springs see page 74

Hemming & Flattening

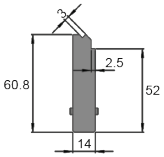
Angle	V-Size	Code	Length	Price	Tool #112220 – 100 t/m
26°	V12	1122201	835 mm	£928	 Was #Z330
		1122202	415 mm	£548	

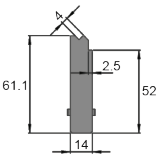
		Code	Length	Price	Tool #105
		105061	835 mm	£795	
		105062	415 mm	£526	

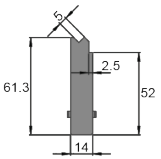
		Code	Length	Price	Tool #1600 STAGED – 100 t/m
Flattening		1600001	835 mm	£432	 Was #OSF600
		1600002	415 mm	£244	
		1600003	Sec	£652	
Tool Stop		1600011	835 mm	£207	 Tool Stops
		1600012	415 mm	£118	
		1600013	Sec	£302	

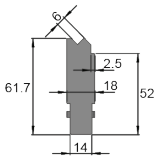
Note: Tool stop prevents thrust force and sideways movement of the tool. Use with Punch Holder #0282 or #0582 - see page 59. Tool is reversible and can be mounted on a punch or die holder

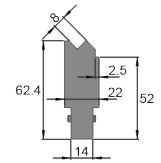
Joggle Tools

Joggle	Code	Length	Price	Tool #Z3 STAGED – 100 t/m
3.0	1630061	835 mm	£609	
	1630062	415 mm	£342	
	1630063	Sec	£828	

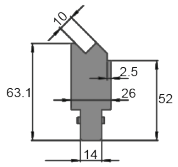
Joggle	Code	Length	Price	Tool #Z4 STAGED – 100 t/m
4.0	1640081	835 mm	£609	
	1640082	415 mm	£342	
	1640083	Sec	£828	

Joggle	Code	Length	Price	Tool #Z5 STAGED – 100 t/m
5.0	1650101	835 mm	£609	
	1650102	415 mm	£342	
	1650103	Sec	£828	

Joggle	Code	Length	Price	Tool #Z6 STAGED – 100 t/m
6.0	1660101	835 mm	£643	
	1660102	415 mm	£360	
	1660103	Sec	£861	

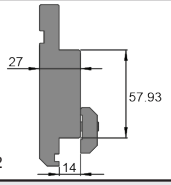
Joggle	Code	Length	Price	Tool #Z8 STAGED – 100 t/m
8.0	1680101	835 mm	£643	
	1680102	415 mm	£360	
	1680103	Sec	£861	

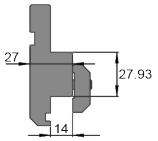
Joggle Tools

Joggle	Code	Length	Price	Tool #Z10 STAGED – 100 t/m
10.0	1610101	835 mm	£643	
	1610102	415 mm	£360	
	1610103	Sec	£861	

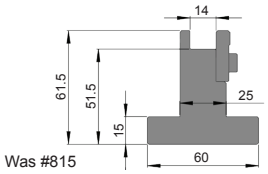
Note: Use with #815 Die Holder & #582 (H=120) or #282 (H=90) Punch Holder below. Staged Joggle tools are reversible and can be mounted on a punch or die holder. Two of each code are required to make a punch and die set.

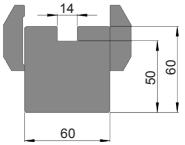
Punch Holder

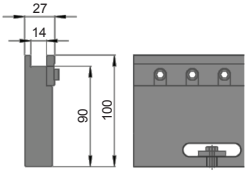
Height	Code	Length	Price	Tool #0582 – 100 t/m
120 mm	0582002	415 mm	£633	 Was #OSPH582

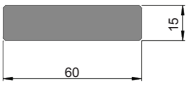
Height	Code	Length	Price	Tool #0282 - 100 t/m
90 mm	0282002	415 mm	£538	 Was #OSPH282

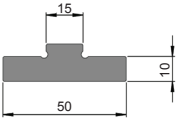
Holders, Blocks & Rails

Height	Code	Length	Price	Tool #0815 – 100 t/m
51.5 mm (use with 1V Dies)	0815001	840 mm	£593	 Was #815
	0815002	420 mm	£315	

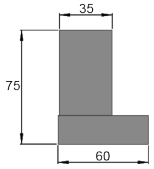
Height	Code	Length	Price	Tool #5330 – 100 t/m
50 mm (use with 1V Dies or Heavy Duty)	5330001	1050 mm	£885	 Was #533
	5330002	450 mm	£450	

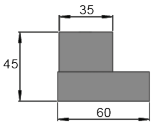
Height	Code	Length	Price	Tool #5340 – 100 t/m
90 mm (use with 1V Dies)	5340001	1050 mm	£685	
	5340002	450 mm	£423	

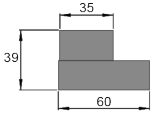
Height	Code	Length	Price	Support for Tool #5340
90 mm (use with #5340 above)	5340011	1050 mm	£132	
	5340012	450 mm	£82	

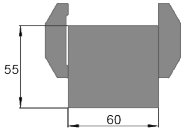
Height	Code	Length	Price	Tool #3000 Rail
10 mm (use with 2V Reversible Dies)	3000001	835 mm	£199	 Was #300
	3000002	415 mm	£163	

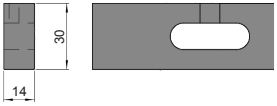
Holders, Blocks & Rails

Height	Code	Length	Price	Tool #75H (2910)
75 mm (use with 2V Dies)	2910001	835 mm	£214	
	2910002	415 mm	£108	

Height	Code	Length	Price	Tool #45H (2930)
45 mm (use with 2V Dies)	2930001	835 mm	£172	
	2930002	415 mm	£93	

Height	Code	Length	Price	Tool #39H (2900)
39 mm (use with 2V Dies)	2900001	835 mm	£155	
	2900002	415 mm	£80	

Height	Code	Length	Price	Tool #055
55 mm	0550001	835 mm	£389	 Was #55
	0550002	415 mm	£217	

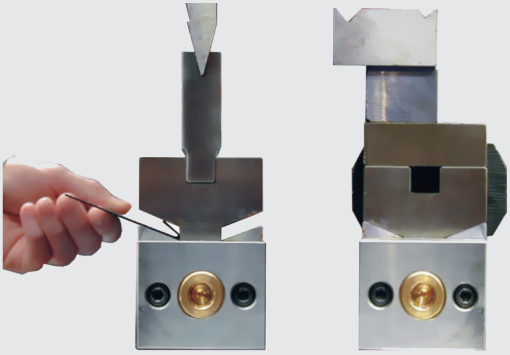
Height	Code	Length	Price	Adaptor for Polycarbonate Dies – 100 t/m
Adaptor (use with #5340 or #0815 holders)	3300011	834 mm	£287	
	3300012	414 mm	£159	

Pneumatic Hemming Die

A Permanent Fixture on Your Press Brake

- Remains in closed position until activated to perform the hemming operation
- 20° inclination to avoid workpiece fouling the lower beam
- Can be set permanently on the lower beam to allow traditional tooling to be used
- Hardened and ground solid length hemming tool, eliminates tool joint marking whilst flattening





1V die directly mounted
or use any die holder

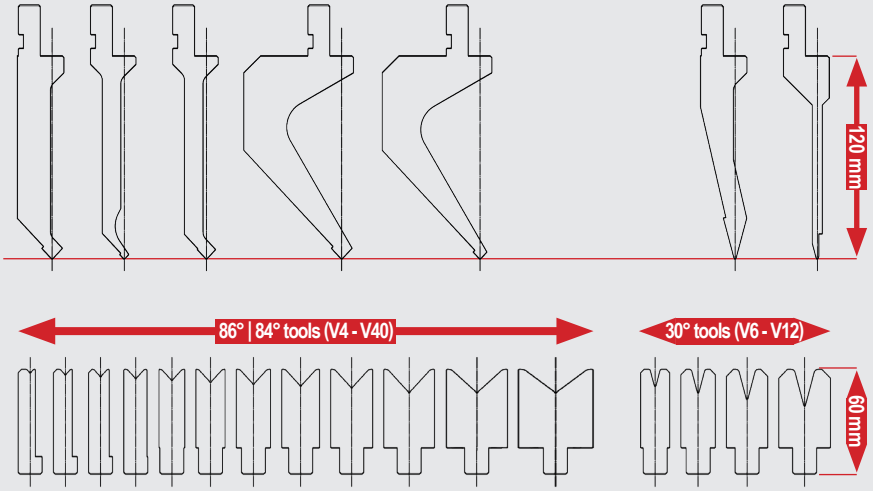
Specification

Maximum Material Thickness	Mild Steel: 2.0 mm Stainless Steel: 1.5 mm
Allowable Tonnage	100 t/m
Solenoid Valve Power	24V DC
Air Pressure	2 Bar
Air Flow	400 litres/min

Length
1250 mm
2050 mm
2550 mm
3050 mm
4050 mm

Price: POA
Images shown without PPE

AFH-ATC AMADA Fixed Height



Complete ID Marking





AFH-ATC Tooling Lengths



200 Division
4 x 200 mm = 800 mm

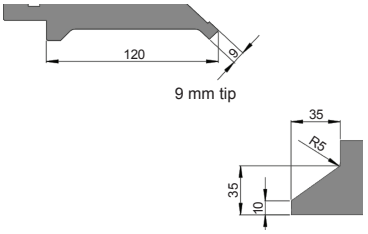


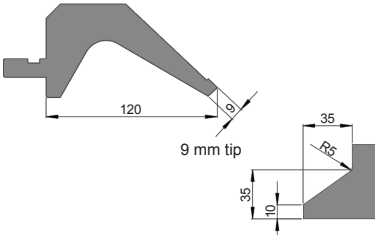
Short Division (All punches and V4 to V25 dies)
2 x 15, 2 x 20, 2 x 25, 2 x 40, 2 x 50, 2 x 100 = 500 mm
V32, V40 dies
2 x 20, 2 x 25, 2 x 30, 2 x 40, 2 x 50, 2 x 100 = 530 mm

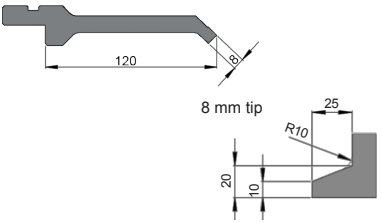


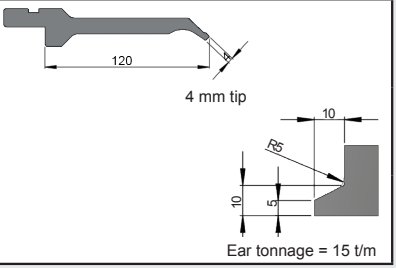
Ears
125 Left ear, 125 Right ear = 250 mm

AFH-ATC Punches H=120

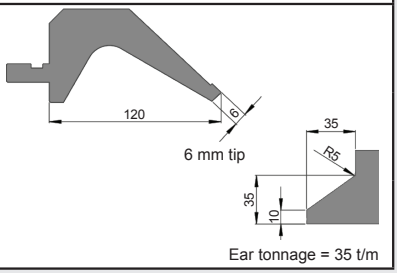
Angle	Radii	Code	Length	Price	Tool #804 AFH-ATC - 100 t/m
86°	R0.6	8048065	200 mm Div.	£678	
		8048066	Short Div.	£906	
		8048067	Ears	£354	
	R3.0	8048305	200 mm Div.	£743	
		8048306	Short Div.	£992	
		8048307	Ears	£375	

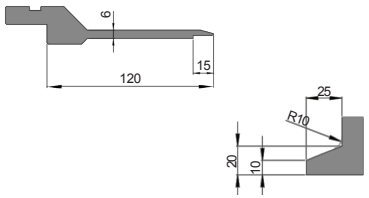
Angle	Radii	Code	Length	Price	Tool #847 AFH-ATC - 50 t/m
86°	R0.6	8478065	200 mm Div.	£1,247	
		8478066	Short Div.	£1,665	
		8478067	Ears	£556	
	R3.0	8478305	200 mm Div.	£1,394	
		8478306	Short Div.	£1,862	
		8478307	Ears	£604	

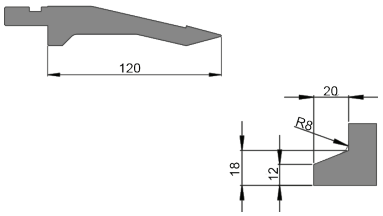
Angle	Radii	Code	Length	Price	Tool #820 AFH-ATC - 50 t/m
86°	R0.6	8208065	200 mm Div.	£837	
		8208066	Short Div.	£1,241	
		8208067	Ears	£404	

Angle	Radii	Code	Length	Price	Tool #817 AFH-ATC - 30 t/m
86°	R0.6	8178065	200 mm Div.	£890	
		8178066	Short Div.	£1,316	
		8178067	Ears	£421	

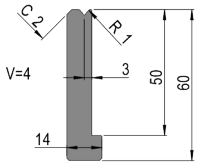
AFH-ATC Punches H=120

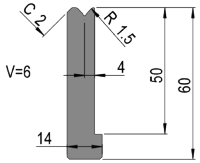
Angle	Radii	Code	Length	Price	Tool #846 AFH-ATC - 45 t/m
86°	R0.6	8468065	200 mm Div.	£1,267	
		8468066	Short Div.	£1,715	
		8468067	Ears	£563	

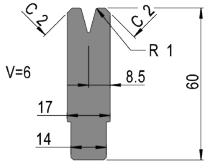
Angle	Radii	Code	Length	Price	Tool #814 AFH-ATC - 45 t/m
30°	R0.6	8143065	200 mm Div.	£878	
		8143066	Short Div.	£1,240	
		8143067	Ears	£416	

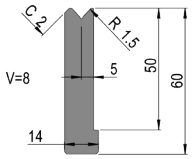
Angle	Radii	Code	Length	Price	Tool #831 AFH-ATC - 100 t/m
30°	R0.6	8313065	200 mm Div.	£797	
		8313066	Short Div.	£1,081	
		8313067	Ears	£389	
	R3.0	8313305	200 mm Div.	£906	
		8313306	Short Div.	£1,233	
		8313307	Ears	£427	

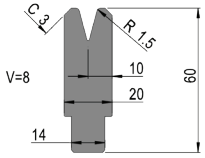
AFH-ATC 1V Dies

Angle	V-Size	Code	Length	Price	Tool #0848 AFH-ATC - 75 t/m
86°	V4	0848105	200 mm Div.	£675	
		0848106	Short Div.	£878	

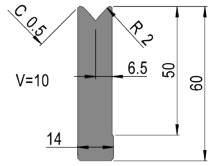
Angle	V-Size	Code	Length	Price	Tool #0708 AFH-ATC - 80 t/m
86°	V6	0708155	200 mm Div.	£559	
		0708156	Short Div.	£673	

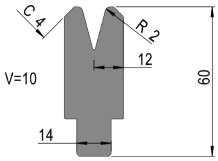
Angle	V-Size	Code	Length	Price	Tool #0703 AFH-ATC - 50 t/m
30°	V6	0703105	200 mm Div.	£738	
		0703106	Short Div.	£849	

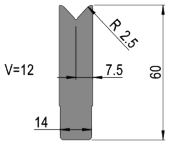
Angle	V-Size	Code	Length	Price	Tool #0718 AFH-ATC - 90 t/m
86°	V8	0718155	200 mm Div.	£559	
		0718156	Short Div.	£673	

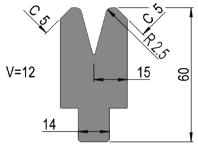
Angle	V-Size	Code	Length	Price	Tool #0713 AFH-ATC - 60 t/m
30°	V8	0713155	200 mm Div.	£761	
		0713156	Short Div.	£874	

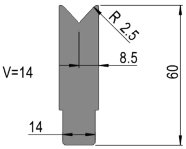
AFH-ATC 1V Dies

Angle	V-Size	Code	Length	Price	Tool #0728 AFH-ATC - 100 t/m
86°	V10	0728205	200 mm Div.	£559	
		0728206	Short Div.	£673	

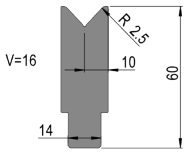
Angle	V-Size	Code	Length	Price	Tool #0723 AFH-ATC - 70 t/m
30°	V10	0723205	200 mm Div.	£774	
		0723206	Short Div.	£925	

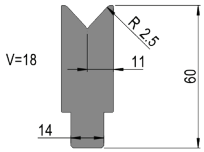
Angle	V-Size	Code	Length	Price	Tool #0748 AFH-ATC - 100 t/m
86°	V12	0748255	200 mm Div.	£559	
		0748256	Short Div.	£673	

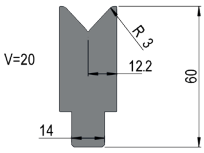
Angle	V-Size	Code	Length	Price	Tool #0743 AFH-ATC - 80 t/m
30°	V12	0743255	200 mm Div.	£774	
		0743256	Short Div.	£925	

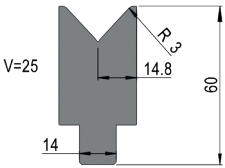
Angle	V-Size	Code	Length	Price	Tool #0768 AFH-ATC - 100 t/m
86°	V14	0768255	200 mm Div.	£720	
		0768256	Short Div.	£849	

AFH-ATC 1V Dies

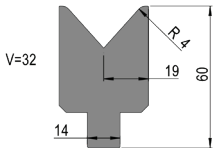
Angle	V-Size	Code	Length	Price	Tool #0778 AFH-ATC - 100 t/m
86°	V16	0778255	200 mm Div.	£720	
		0778256	Short Div.	£849	

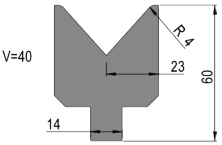
Angle	V-Size	Code	Length	Price	Tool #0788 AFH-ATC - 100 t/m
86°	V18	0788255	200 mm Div.	£720	
		0788256	Short Div.	£849	

Angle	V-Size	Code	Length	Price	Tool #0798 AFH-ATC - 100 t/m
86°	V20	0798305	200 mm Div.	£738	
		0798306	Short Div.	£881	

Angle	V-Size	Code	Length	Price	Tool #0828 AFH-ATC - 100 t/m
86°	V25	0828305	200 mm Div.	£763	
		0828306	Short Div.	£899	

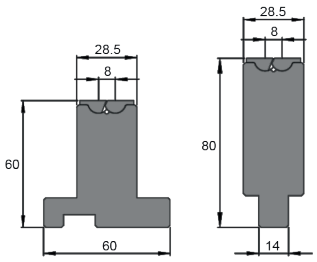
AFH-ATC 1V Dies

Angle	V-Size	Code	Length	Price	Tool #0874 AFH-ATC - 100 t/m
84°	V32	0874405	200 mm Div.	£1,154	
		0874406	Short Div.	£1,368	

Angle	V-Size	Code	Length	Price	Tool #0884 AFH-ATC - 100 t/m
84°	V40	0884405	200 mm Div.	£1,266	
		0884406	Short Div.	£1,510	

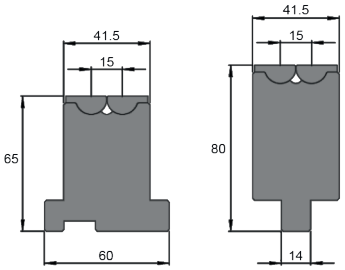
Rolla V

Model 1



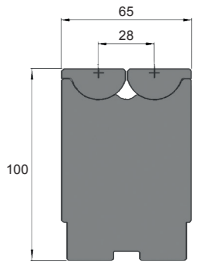
RVP60-1 RVS80-1

Model 2



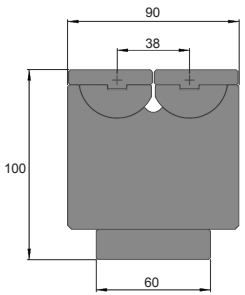
RVP65-2 RVS80-2

Model 2.5



RVM-2.5

Model 3

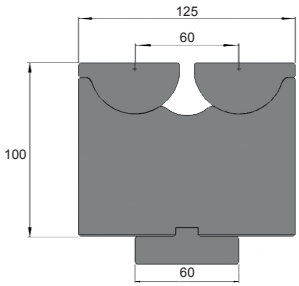


RVP100-3

Price: POA

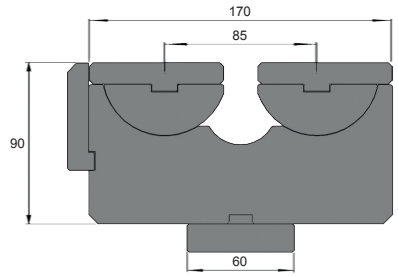
Rolla V

Model 3.5



RVM-3.5

Model 4



RVM90-4

Lengths

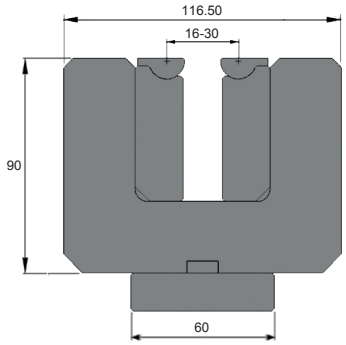
Model	Length	Sec Length
Model 1	500 mm	1x15, 1x20, 1x25, 1x30, 1x50, 1x100, 1x200 = 440 mm
Model 2	500 mm	1x20, 1x25, 1x30, 1x35, 1x40, 1x100, 1x200 = 450 mm
Model 2.5	500 mm	1x35, 1x40, 1x45, 1x50, 1x100, 1x200 = 470 mm
Model 3	500 mm	1x45, 1x50, 1x60, 1x100, 1x200 = 455 mm

Model	Length	Length
Model 3.5	250 mm	500 mm
Model 4	250 mm	500 mm

Price: POA

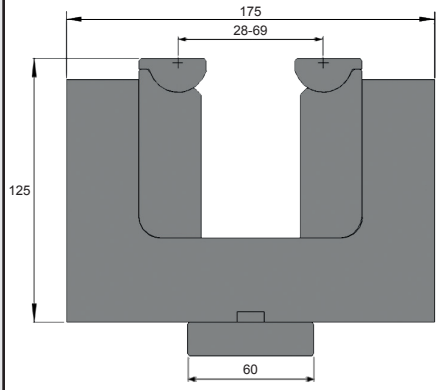
Adjustable Rolla V

Model 2 Adjustable



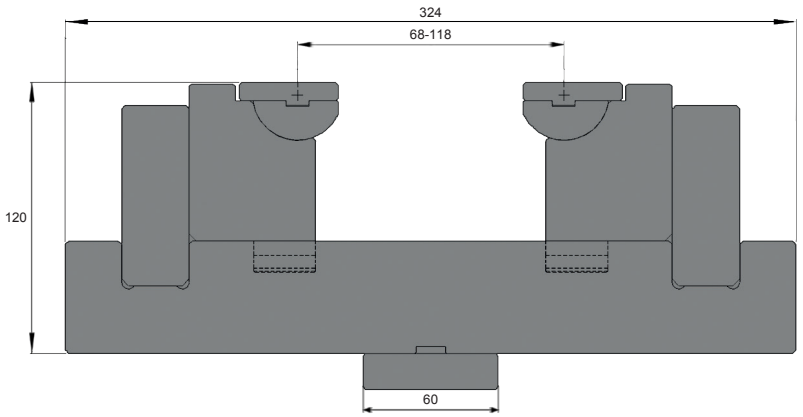
RVHD2 Adjustable Model 2

Model 2.5 Adjustable



RVHD2.5 Adjustable Model 2.5

Model 3 Adjustable

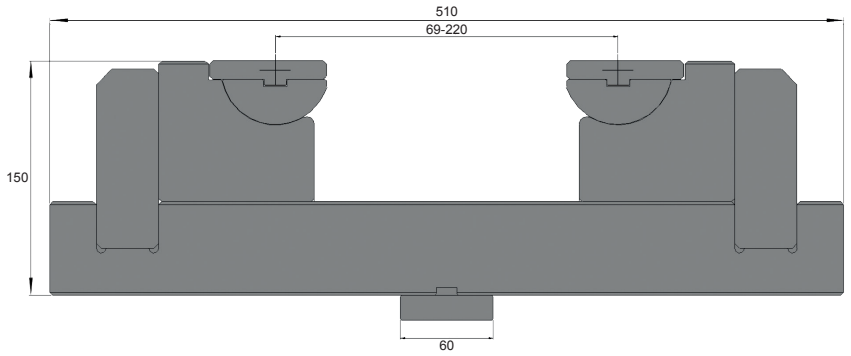


RVHD3 Adjustable Model 3

Price: POA

Adjustable Rolla V

Model 4 Adjustable



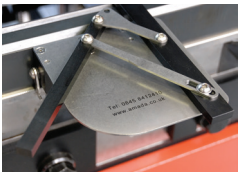
RVHD4 Adjustable Model 4

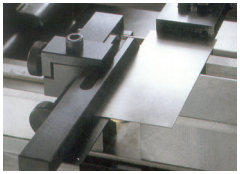
Lengths

Model	Length	Length
Model 2 Adjustable	250 mm	500 mm
Model 2.5 Adjustable	250 mm	500 mm
Model 3 Adjustable	250 mm	500 mm
Model 4 Adjustable	250 mm	500 mm

Price: POA

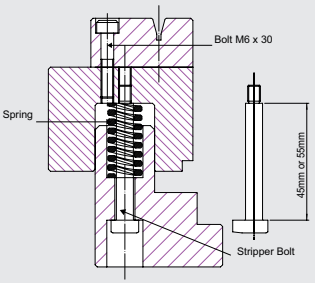
Accessories

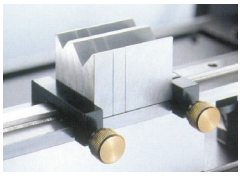
Code	Price	Magnetic Squaring Arm (LH)	Magnetic Squaring Arm (RH)
93000L (Left Hand)	£285		
93000R (Right Hand)	£285		

Code	Price	Side Gauge
930000 (Side Gauge)	£329	

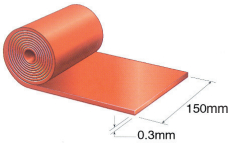
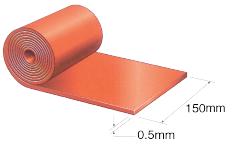
Code	Price	2V & 1V Die Accessories
800100	£0.82	Set bolt for 2V Die M8 x 25
800200	£1.75	Spring for 1V & 2V Die
800300	£1.75	Washer for 2V Die
800400	£0.82	Set bolt for 1V Die M8 x 30
800500	£3.77	Washer for 1V Die

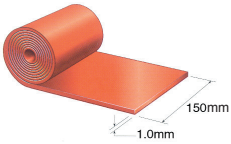
Code	Price	Hemming Die Accessories
800600	£3.26	Stripper bolt STO 8 x 45
800690	£3.26	Stripper bolt STO 8 x 55
800800	£1.75	Spring
800900	£0.82	Fixing bolt M6 x 30

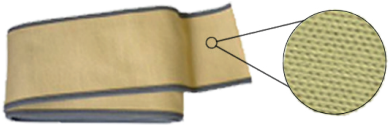


Code	Price	2V Die Stopper
936000	£74	

Marking Prevention

Code	Price	Tool #42620	Tool #42619
426201 (0.3 mm thick)	£19 Per metre	 For use up to 1 mm Mild Steel	 For use from 1 mm - 2 mm Mild Steel
426191 (0.5 mm thick)	£25 Per metre		

Code	Price	Tool #42618	Marking Protection Strip
426181 (1.0 mm thick)	£37 Per metre	 For use over 2 mm Mild Steel	
909910 (0.3 mm thick)	£197 (10 m)		

Code	Price	KIZU-NON Material
999905 (5 m)	POA	 For use up to 6 mm thick stainless steel
999910 (10 m)	POA	

Tooling Cabinet

Tooling Cabinet:

Keep your tooling organised and free from workplace atmospheric dust.

Width	1040 mm
Height	1240 mm
Depth	1000 mm

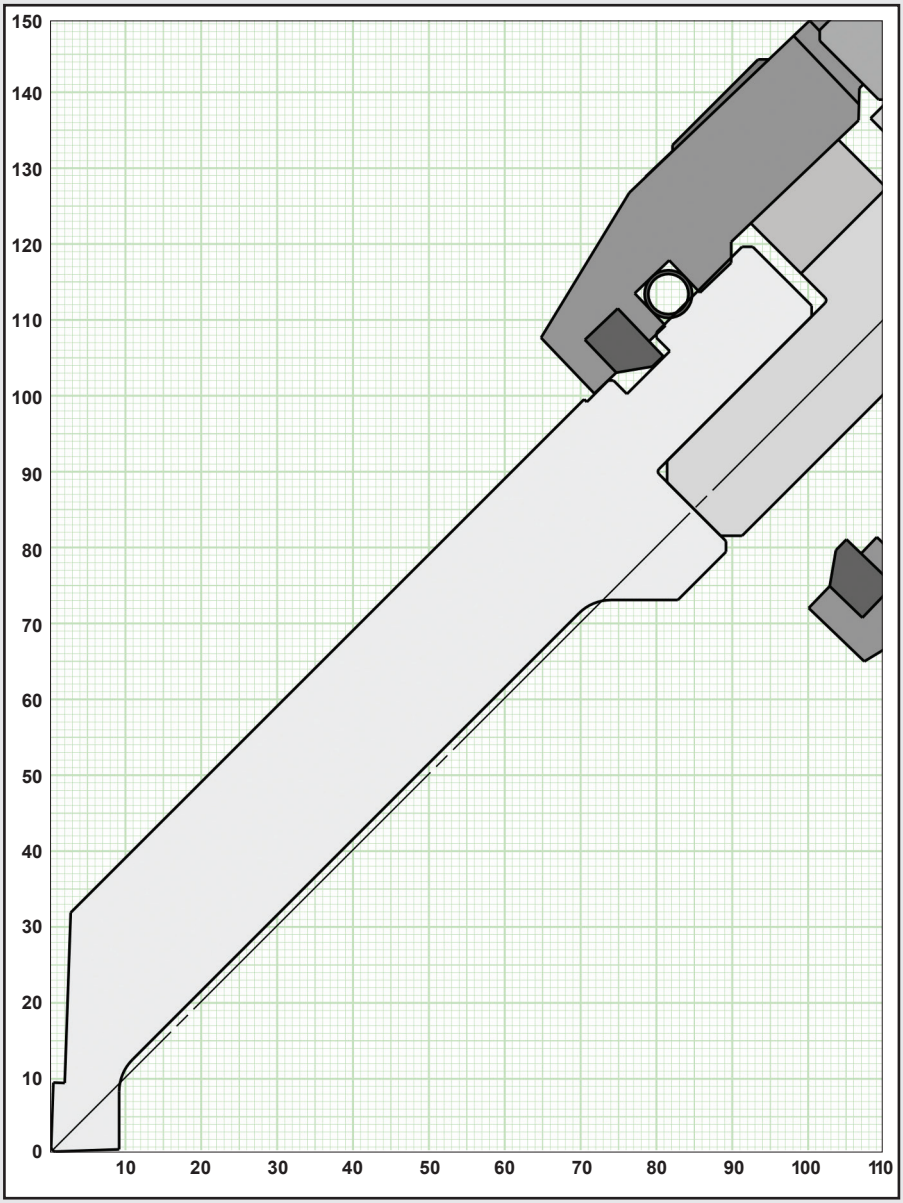
Safe working load = 650 kg

Code: 990000
Price: £3,160

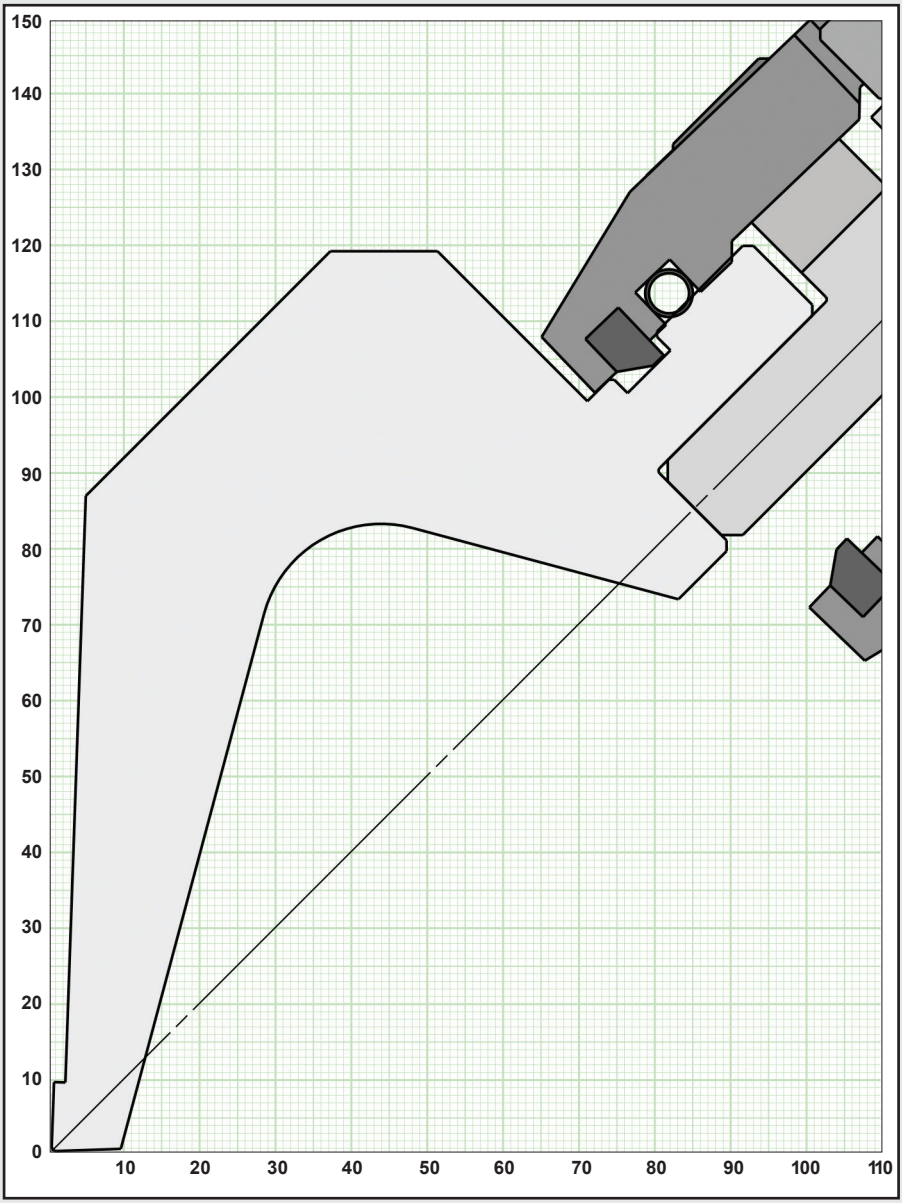



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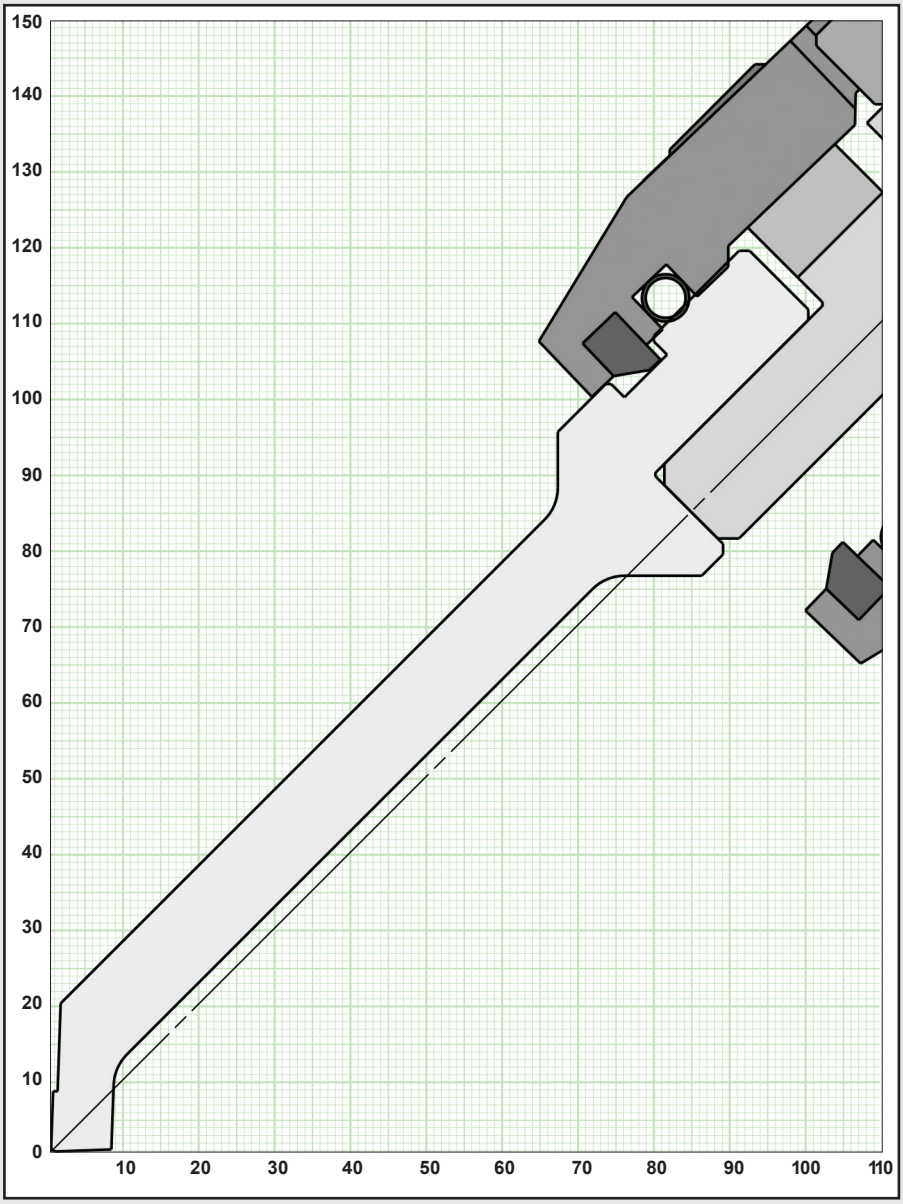
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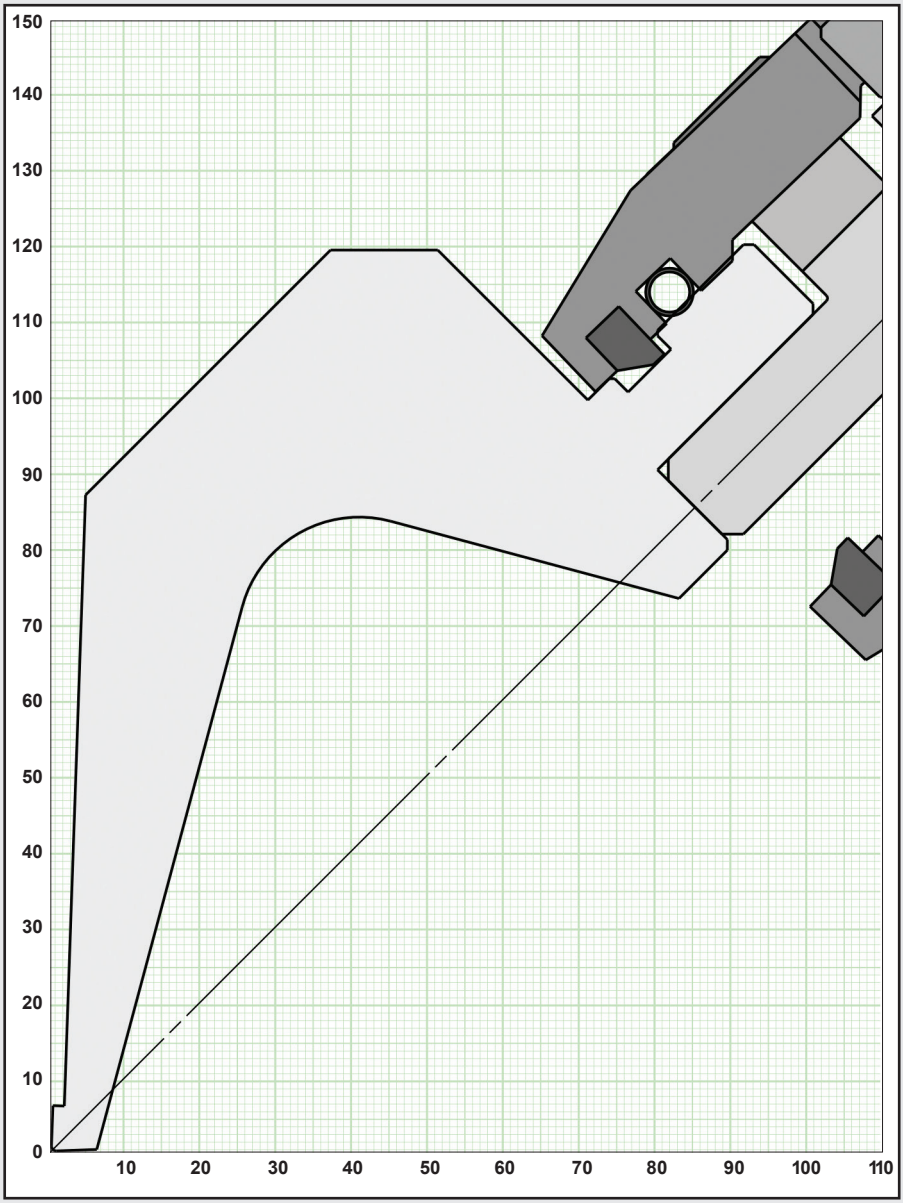
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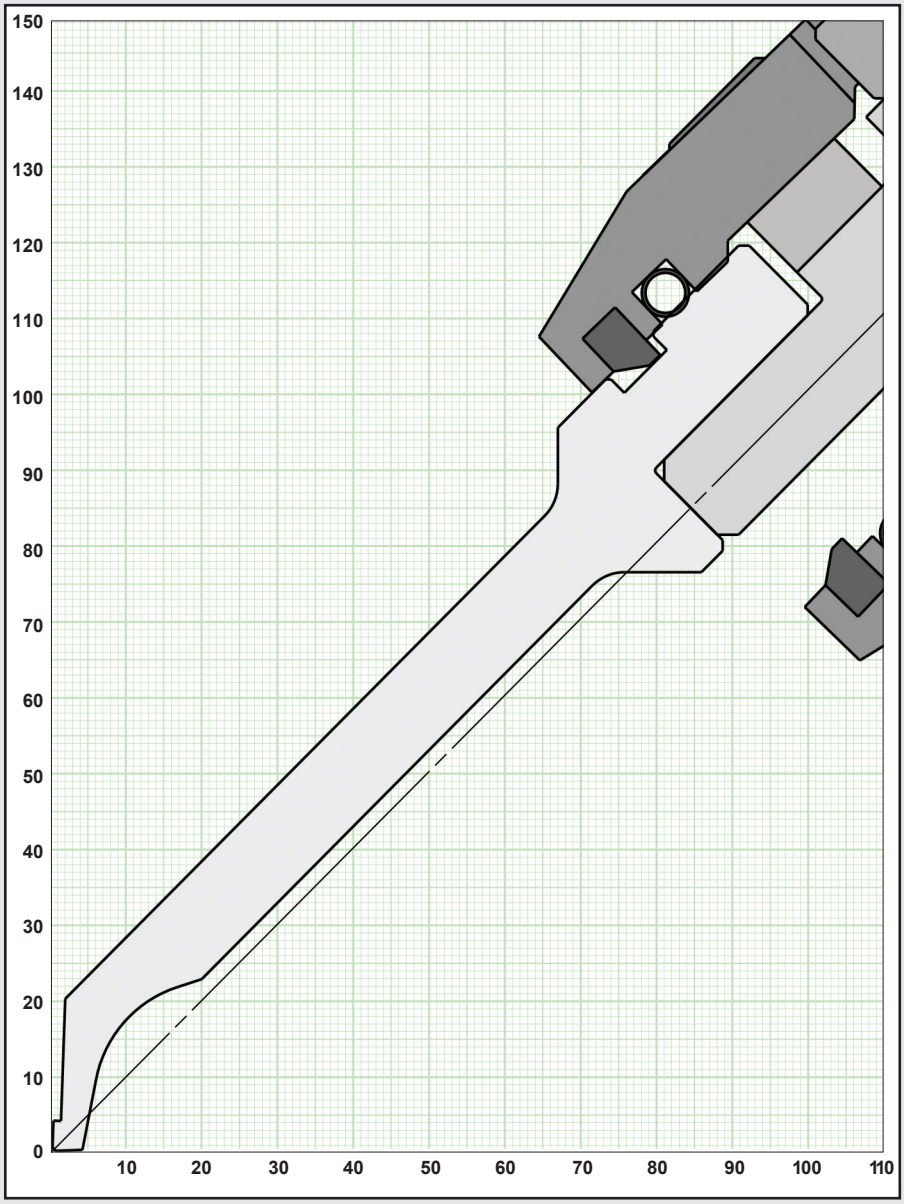
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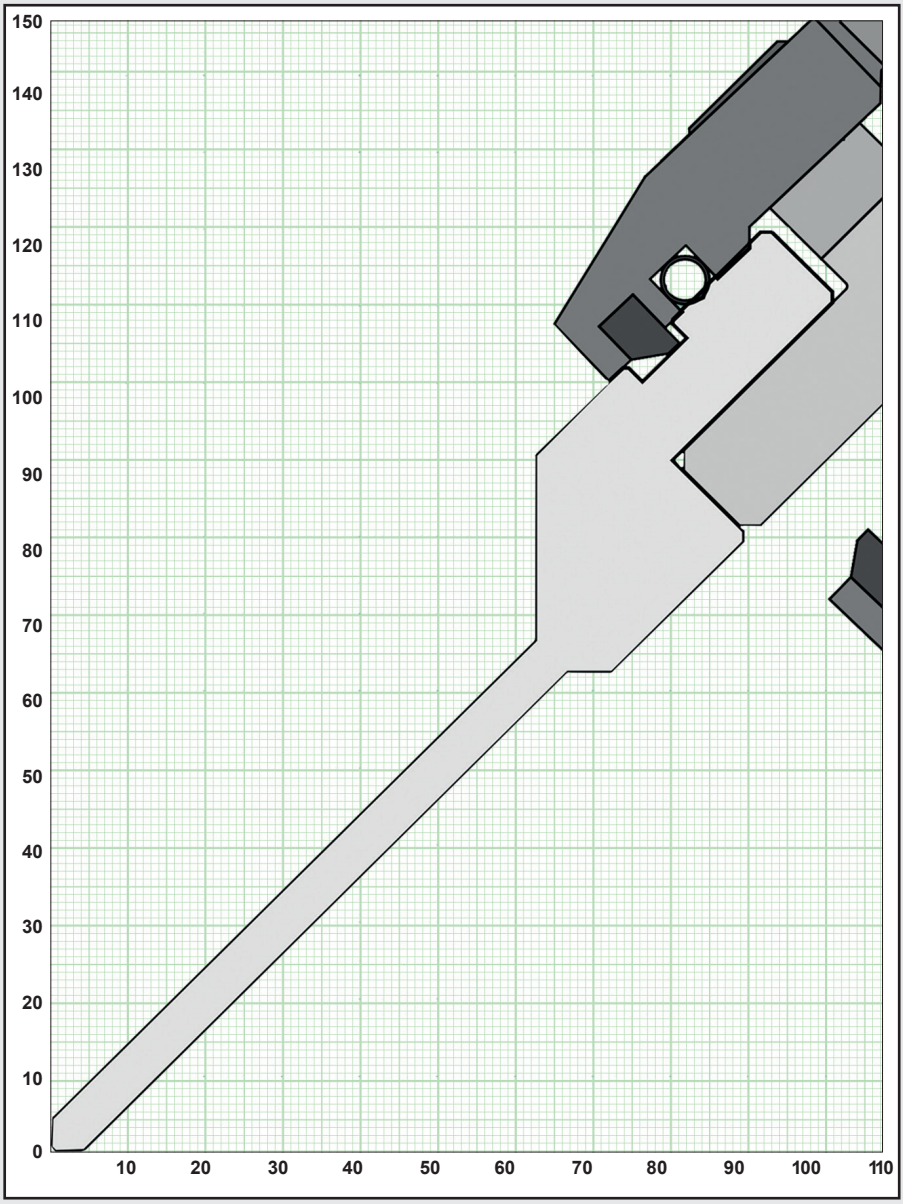
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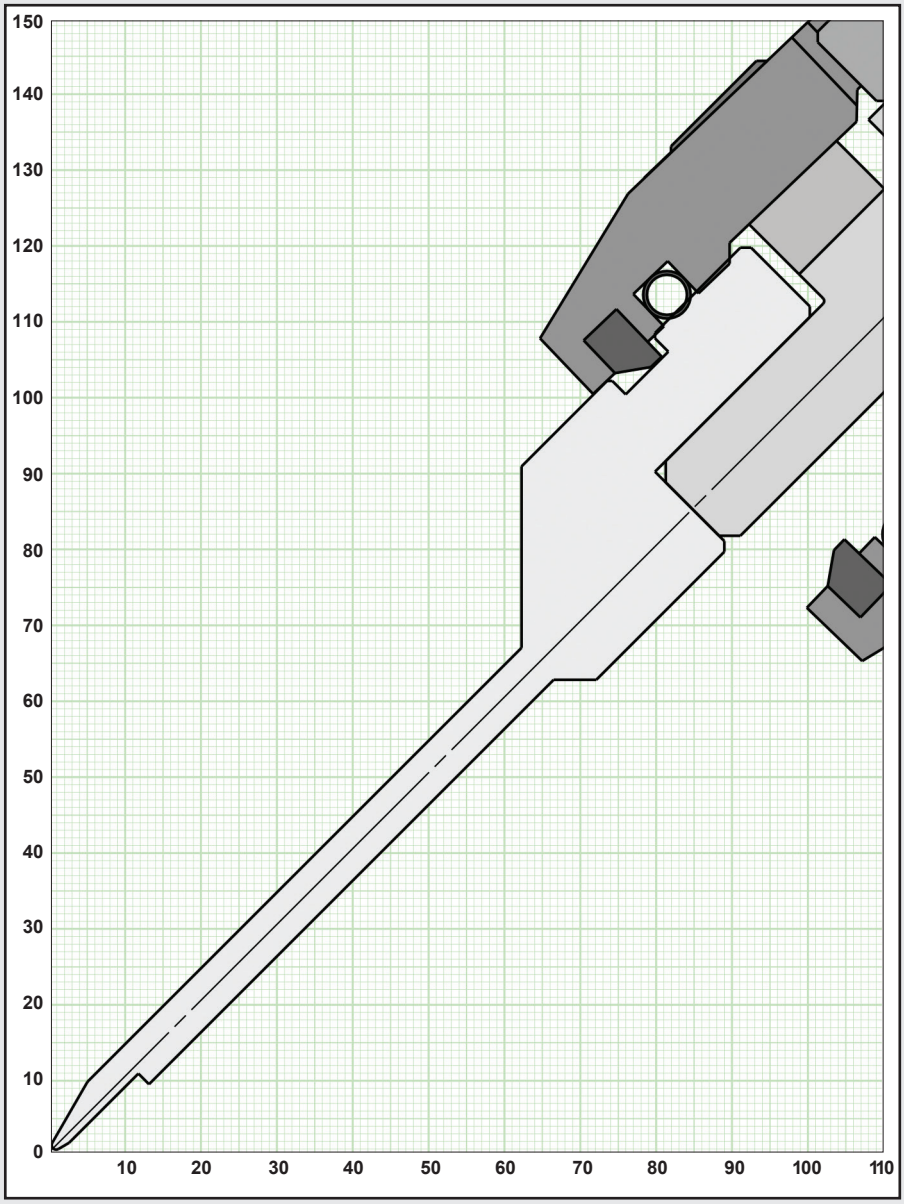
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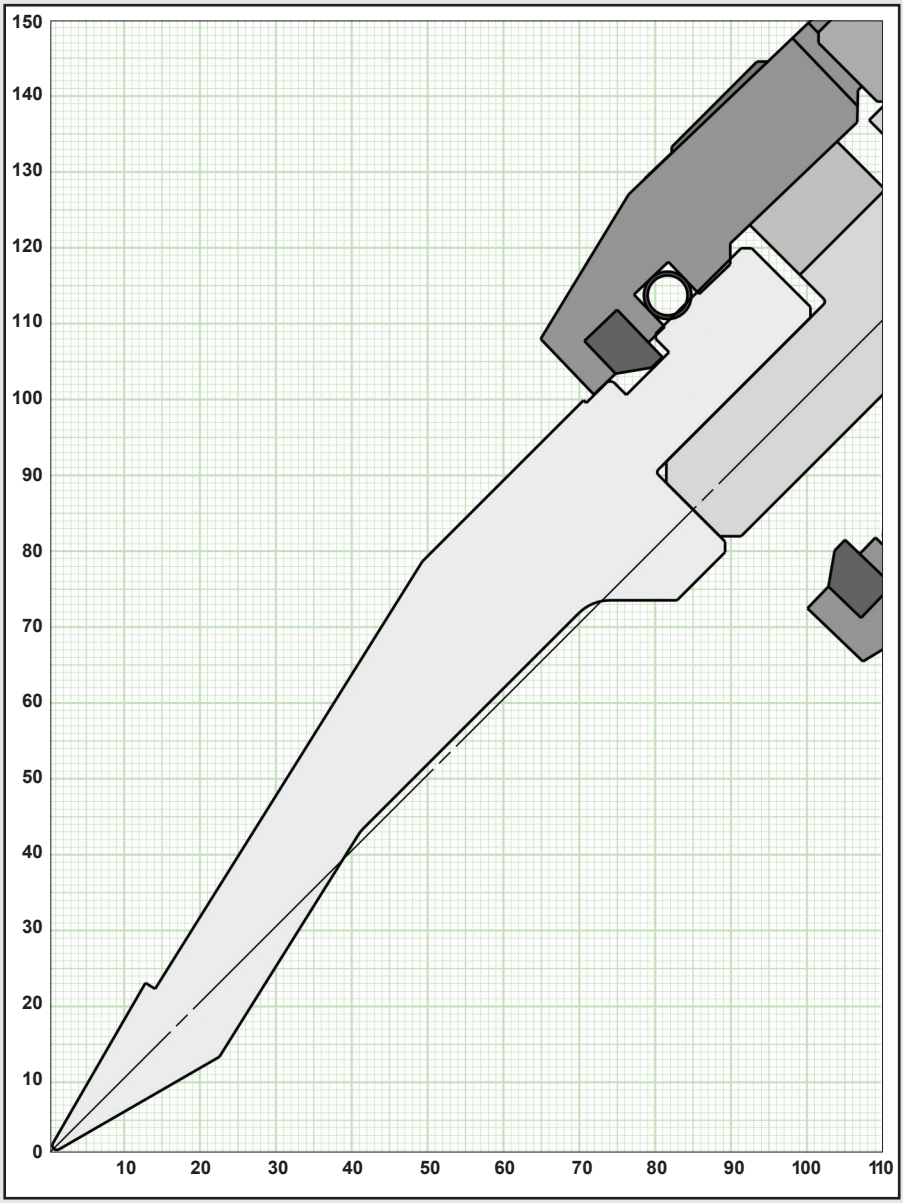
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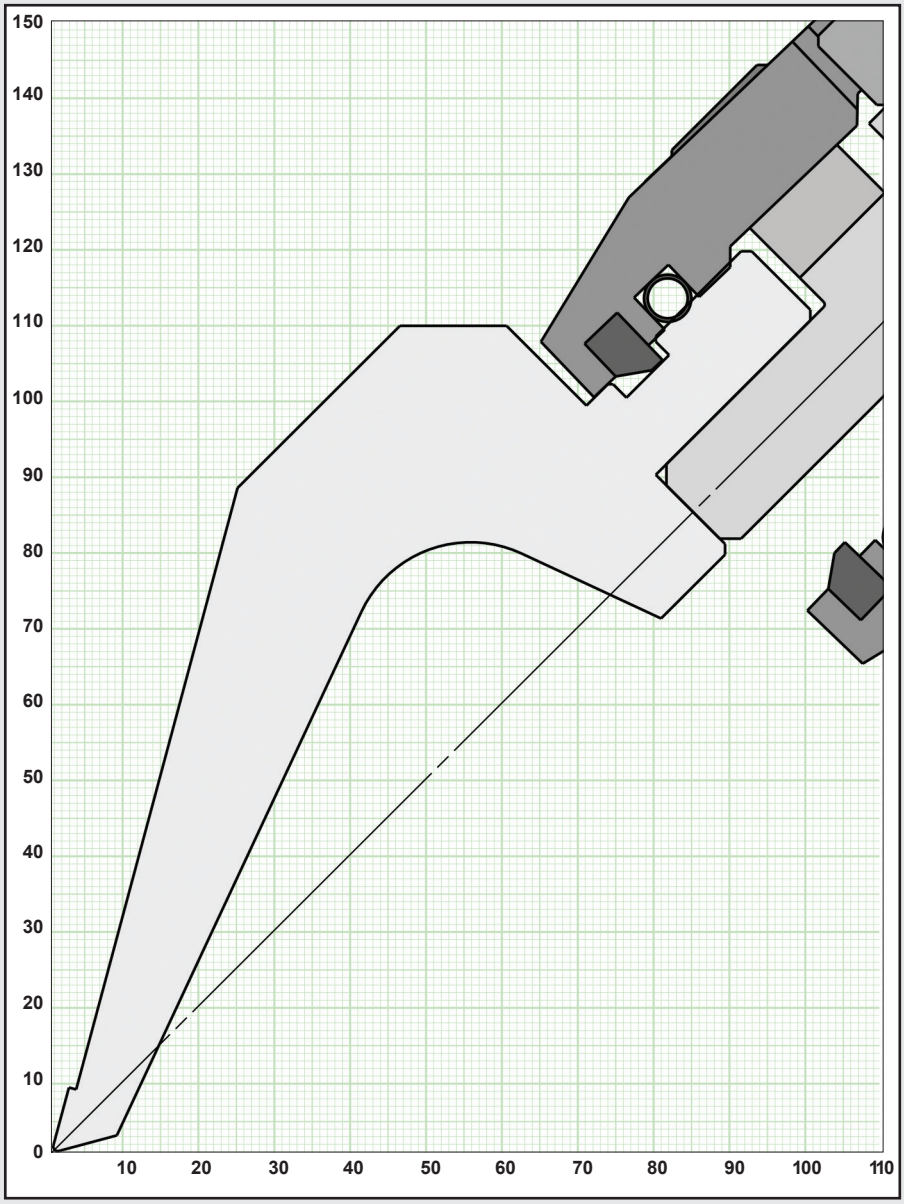
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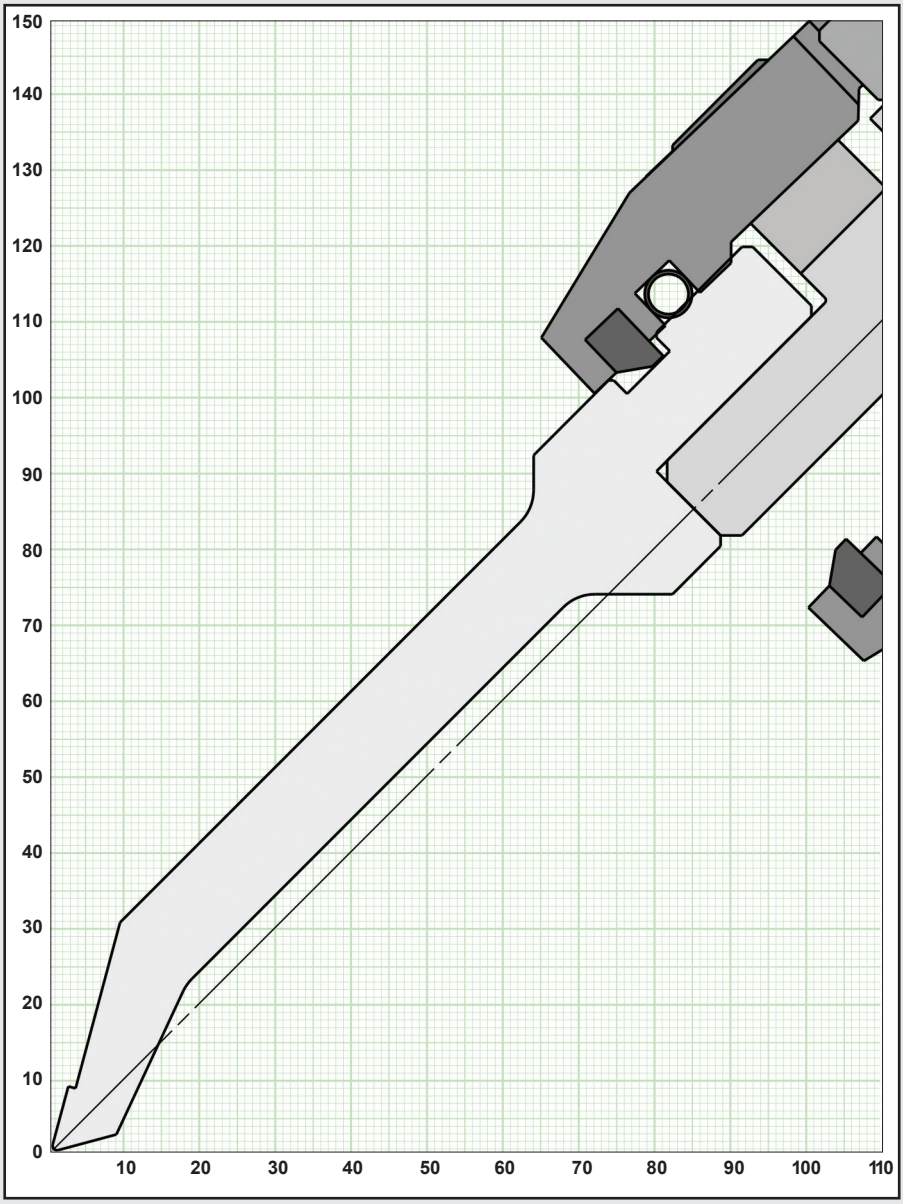
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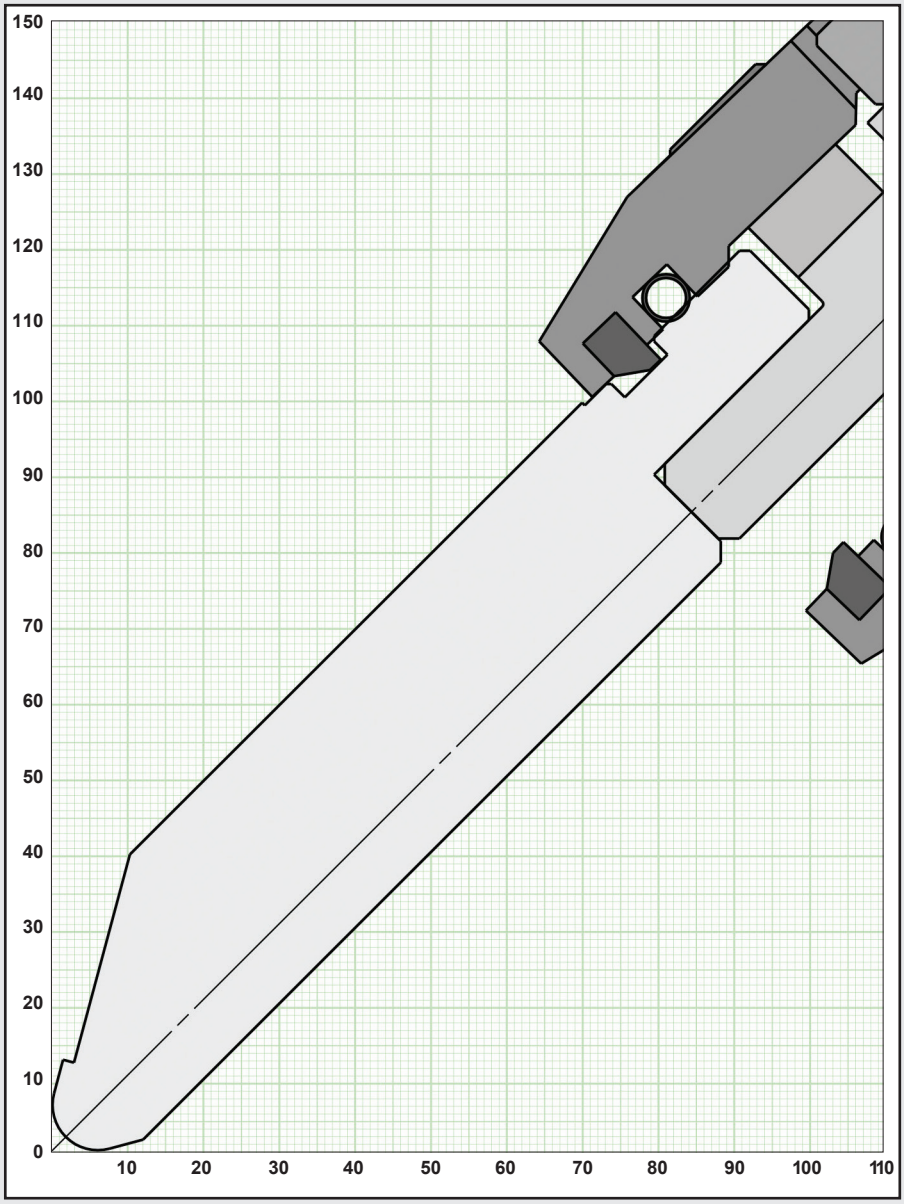
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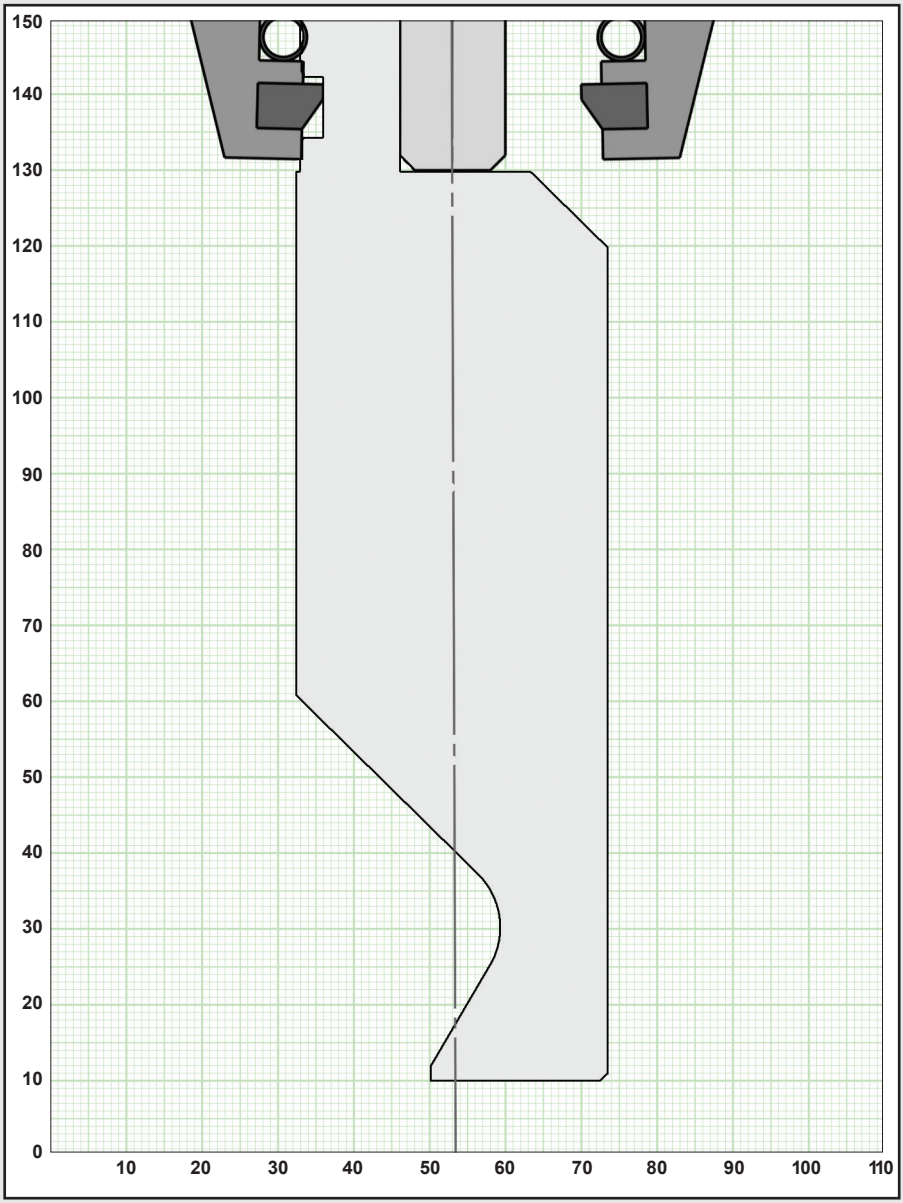
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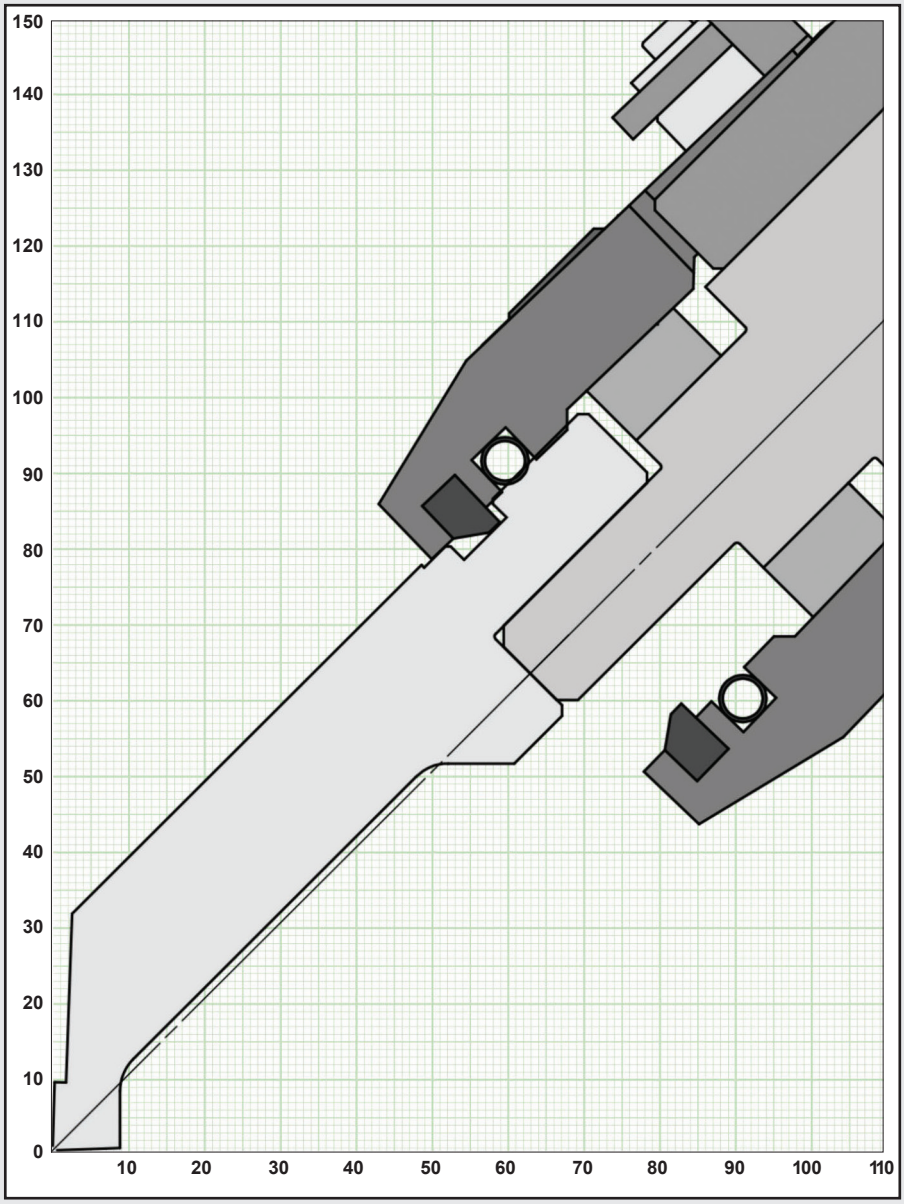
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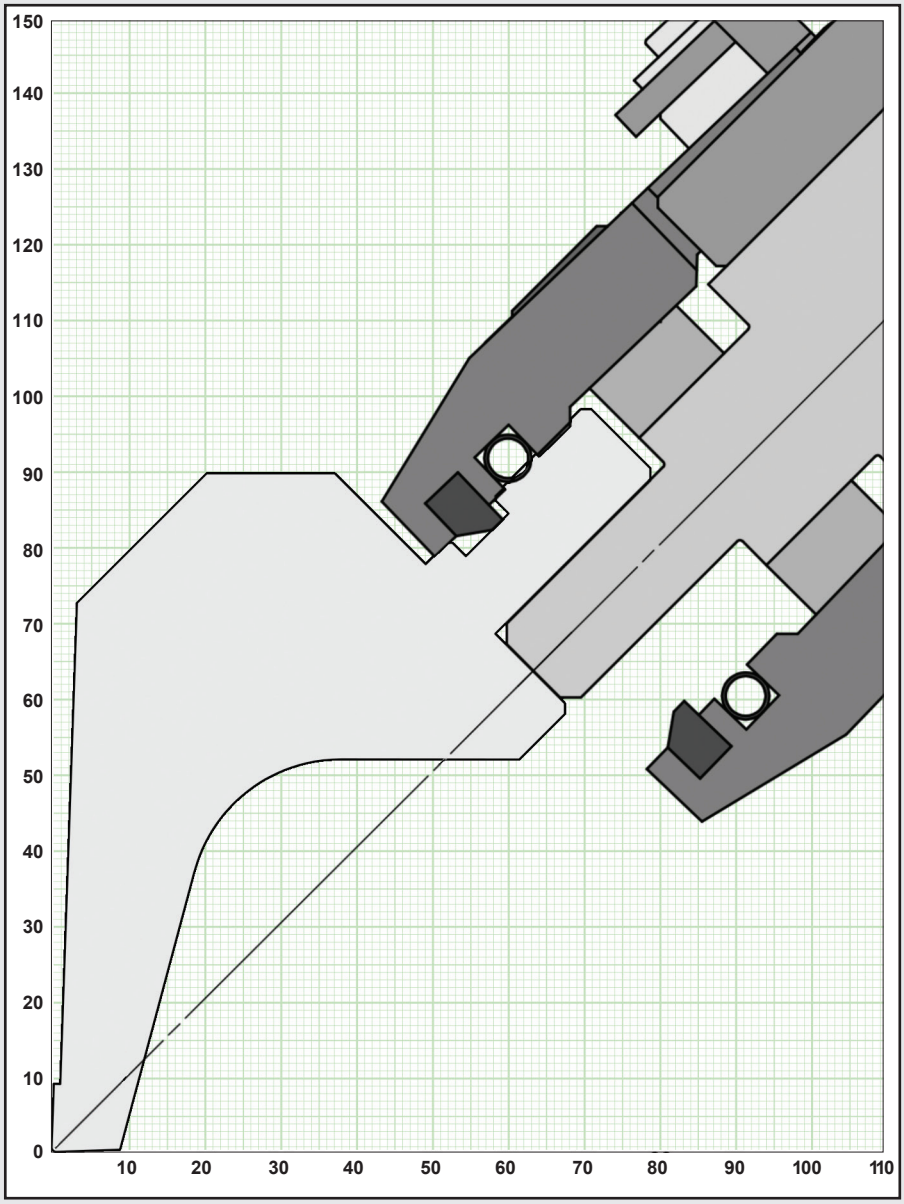
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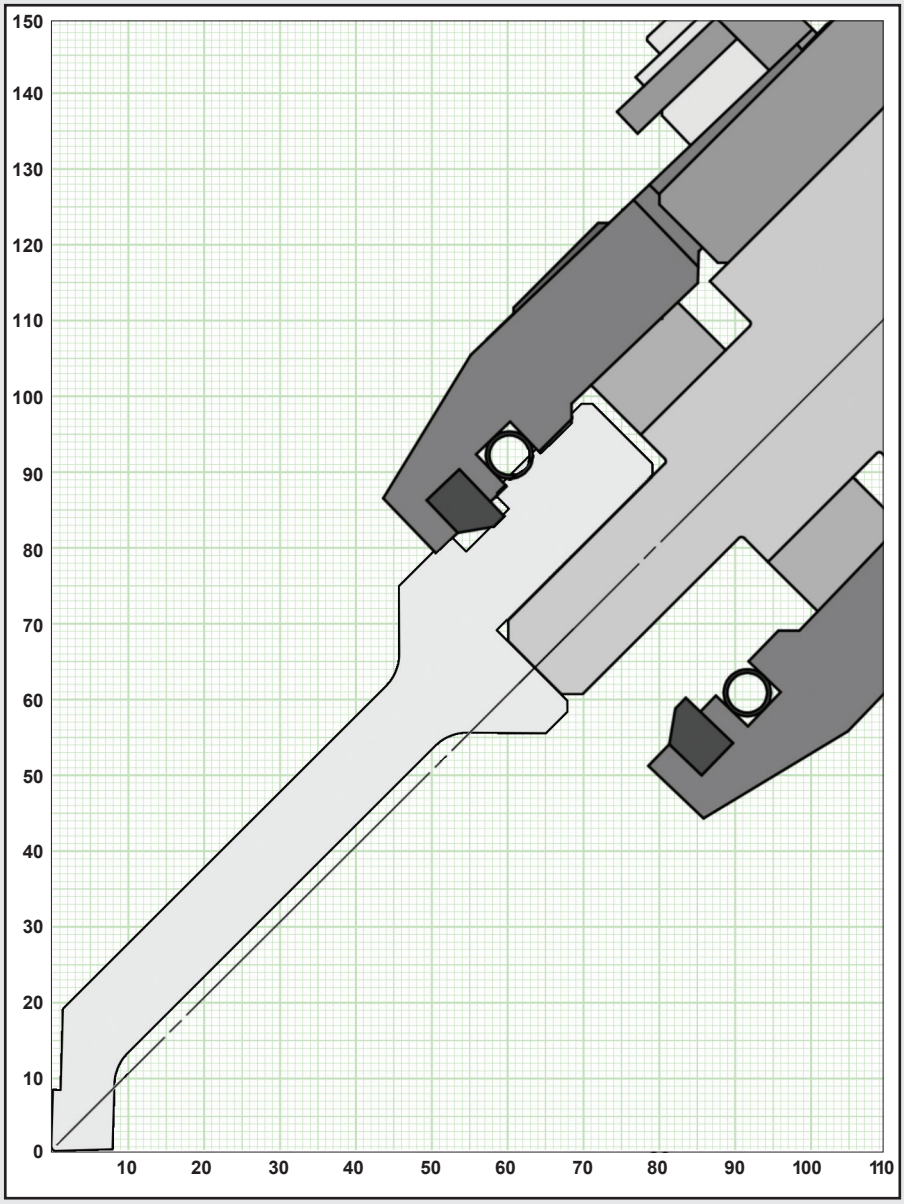
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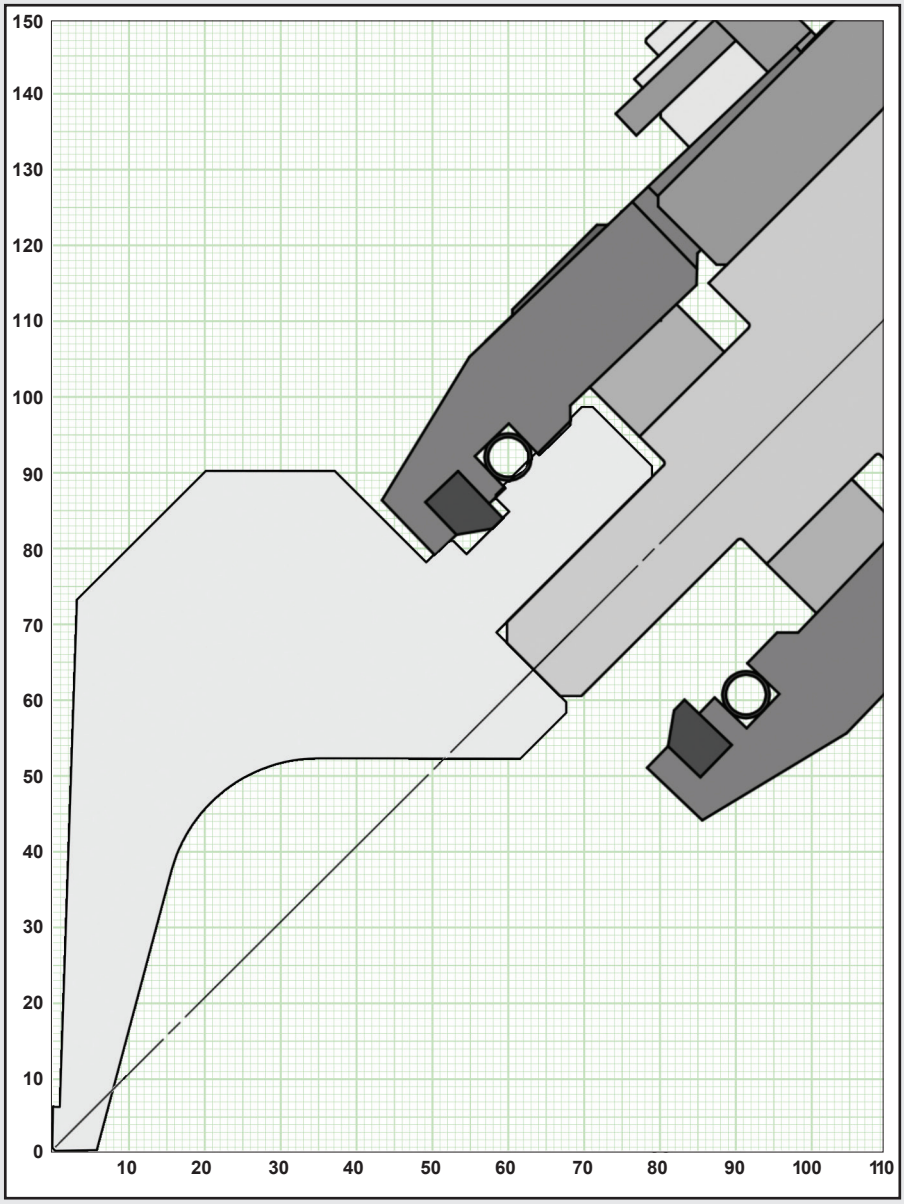
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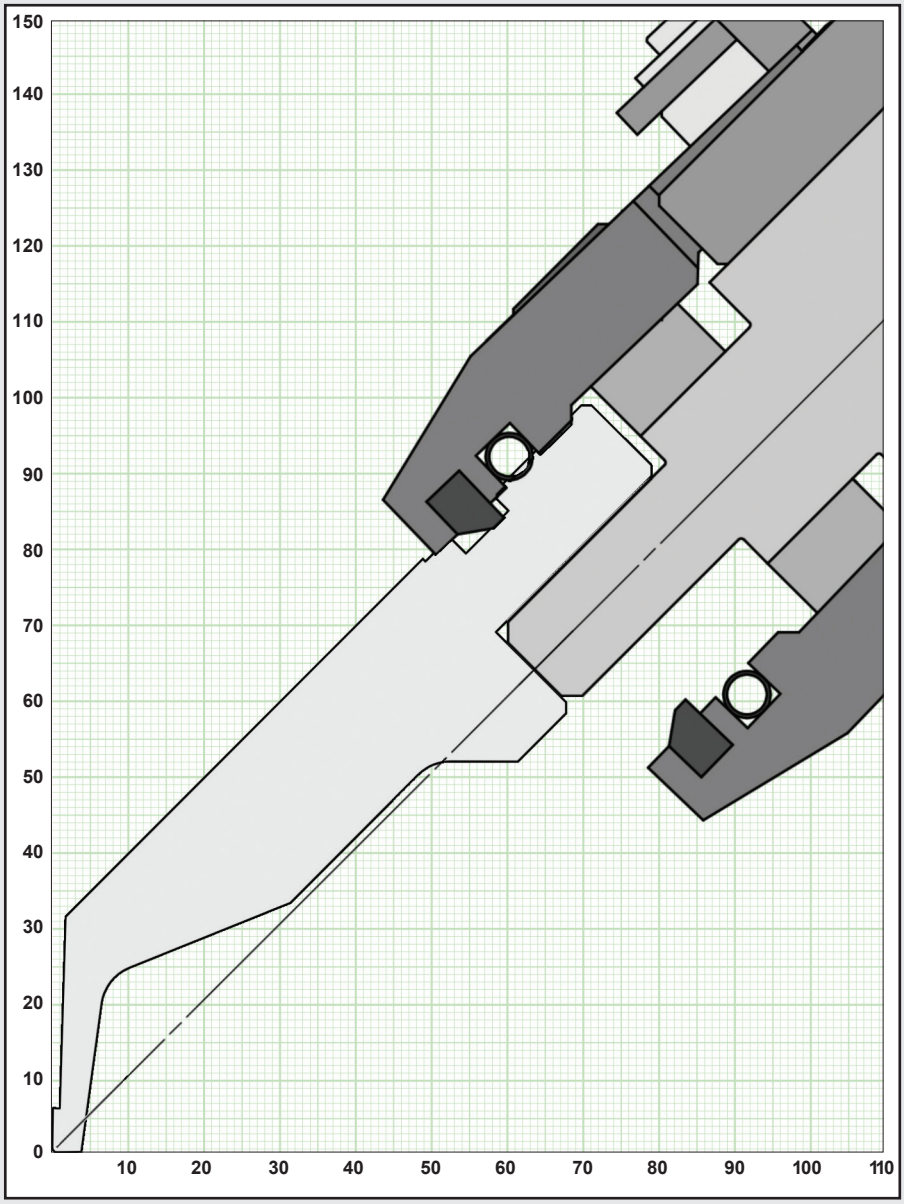
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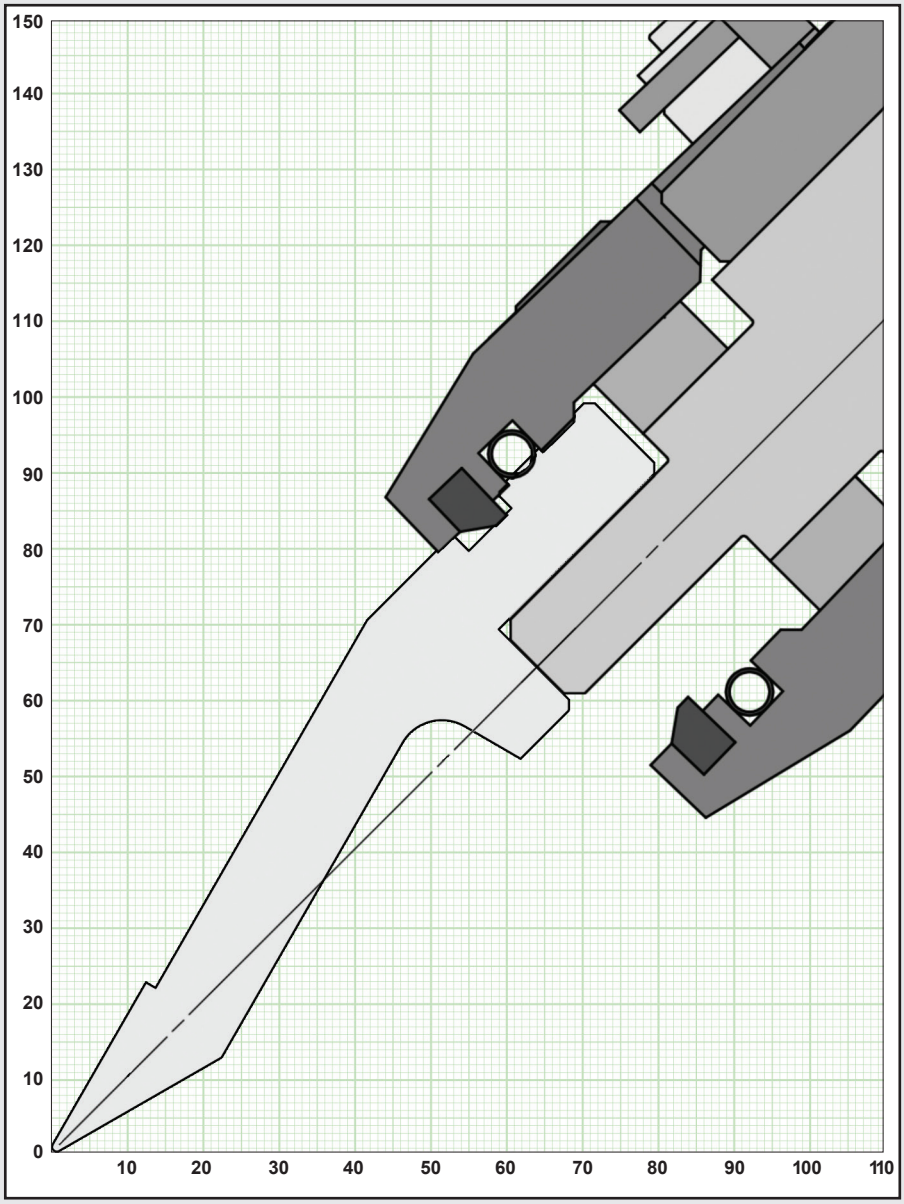
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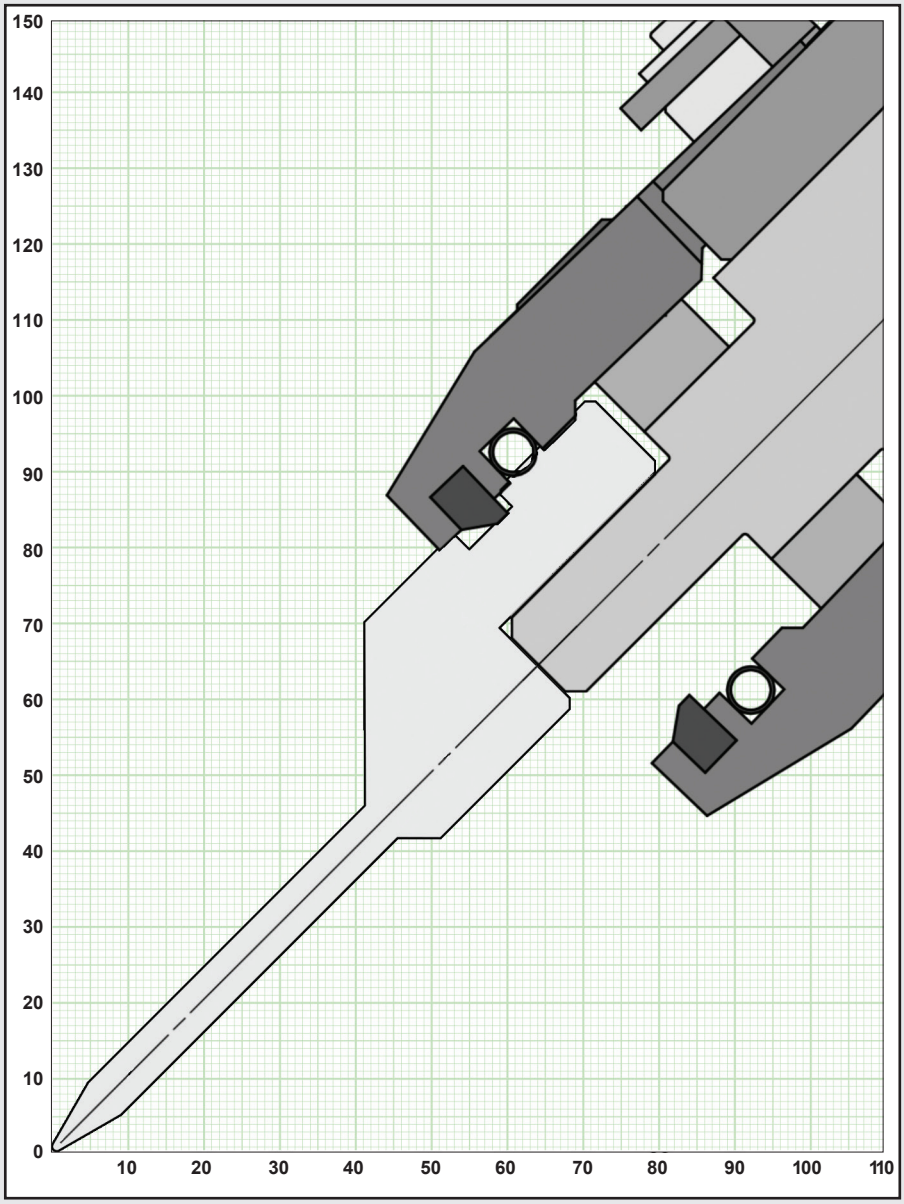
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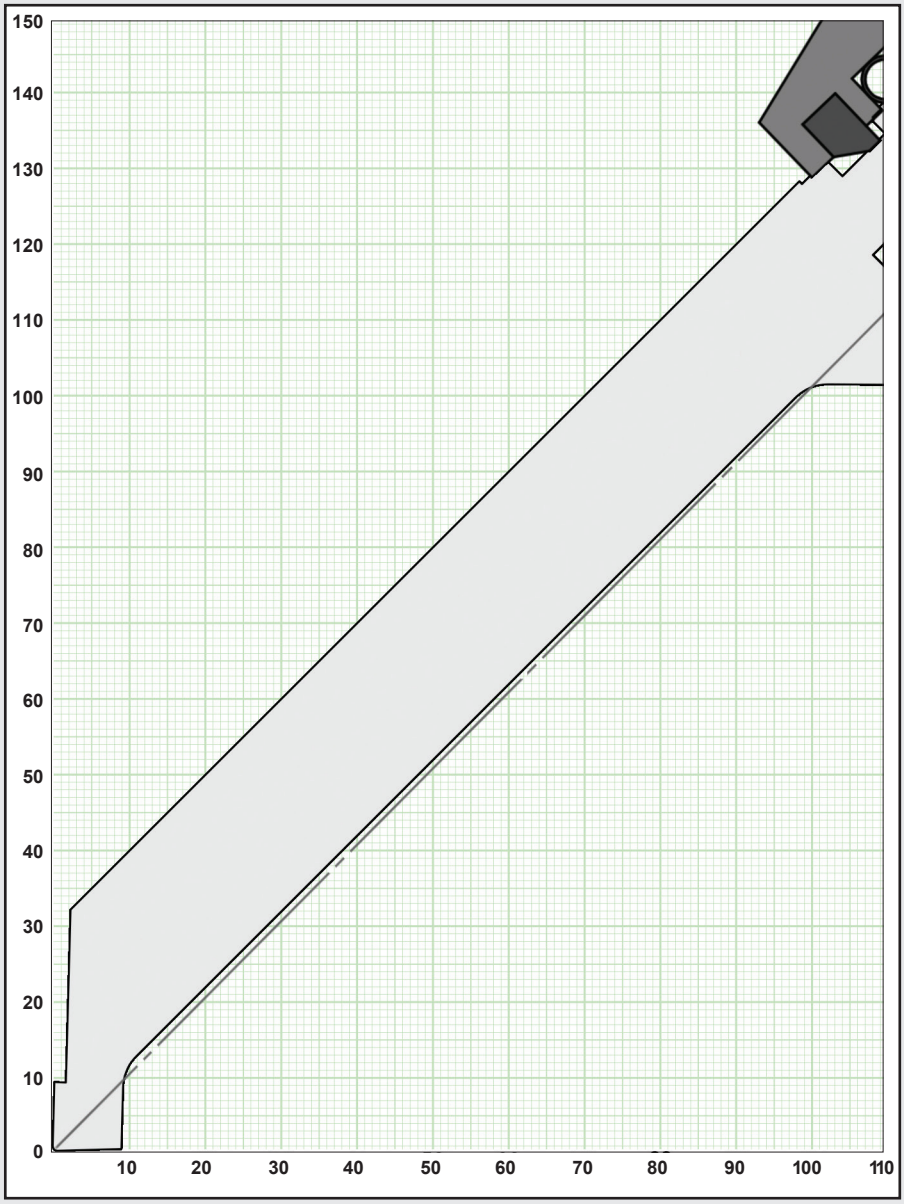
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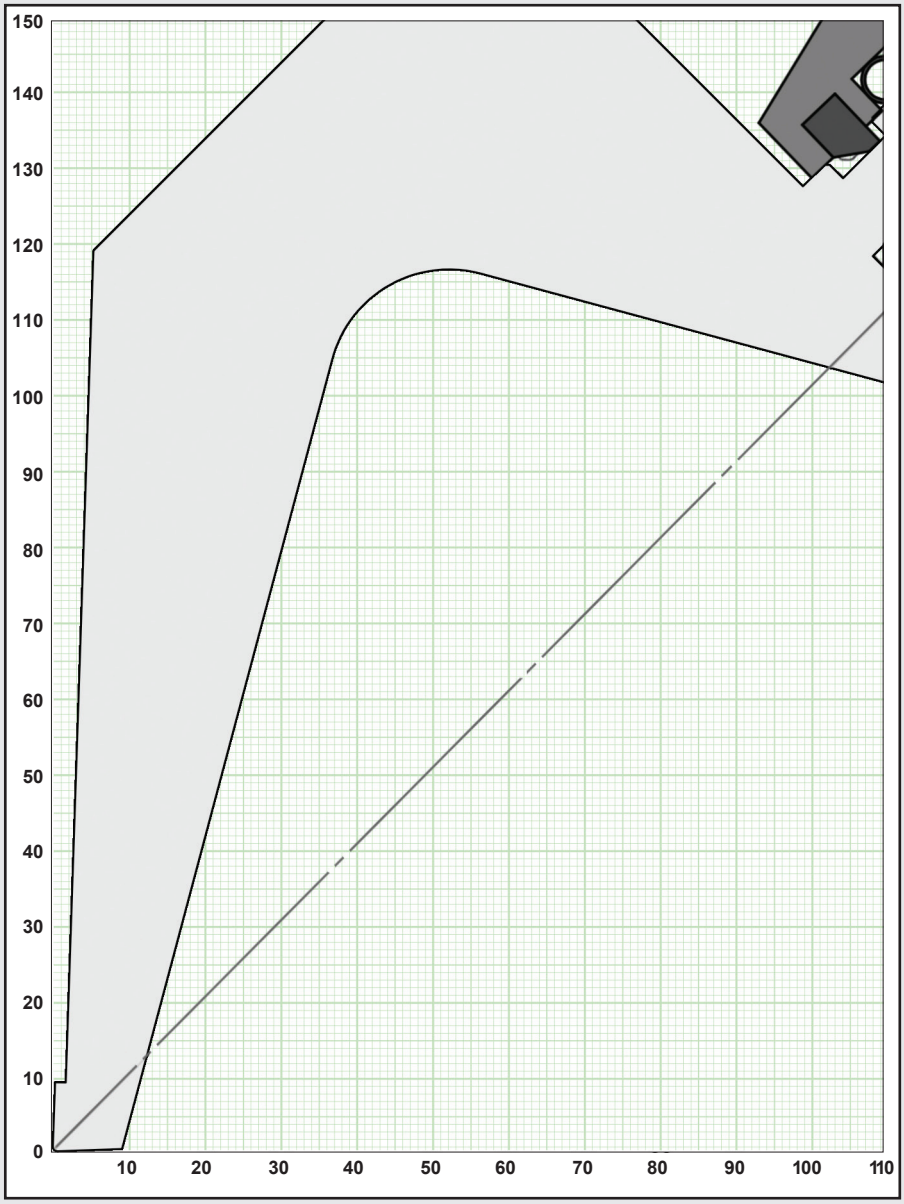
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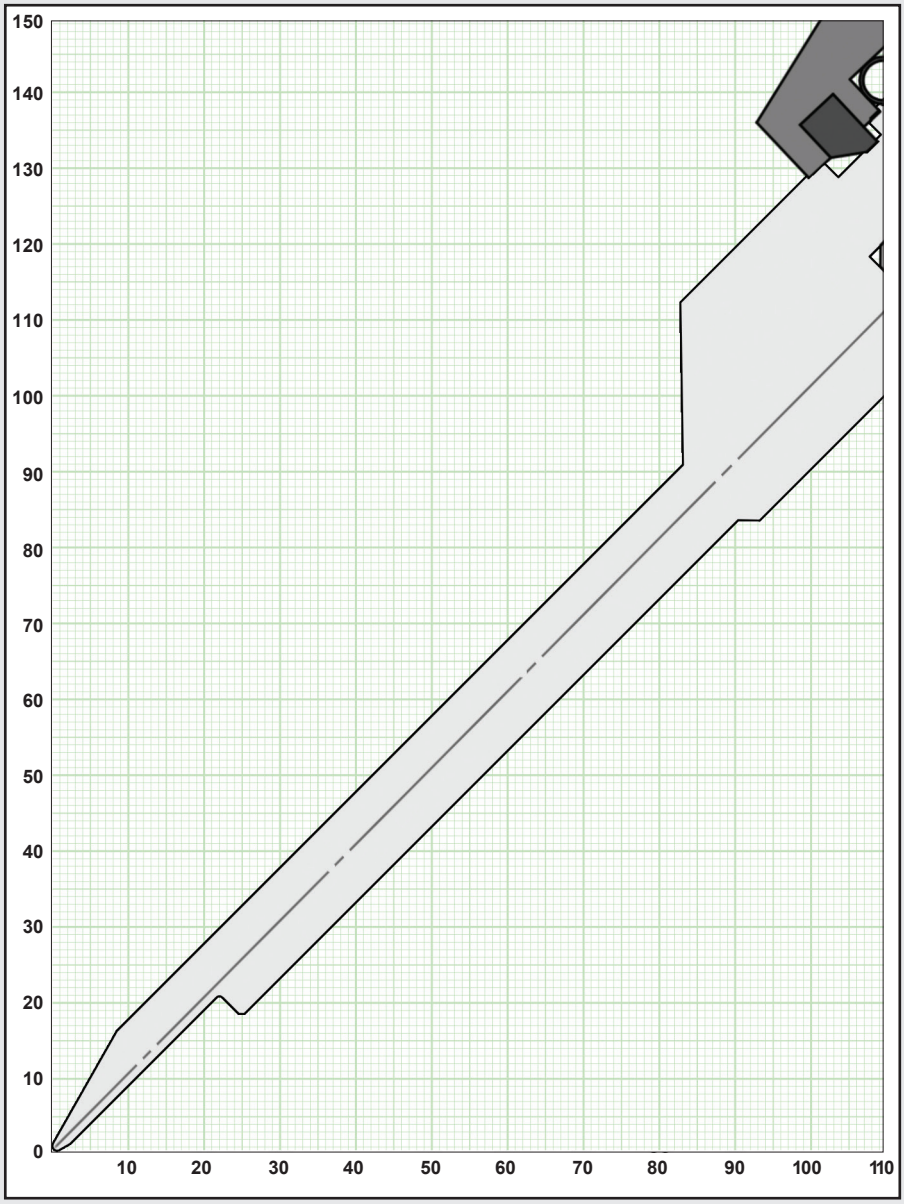
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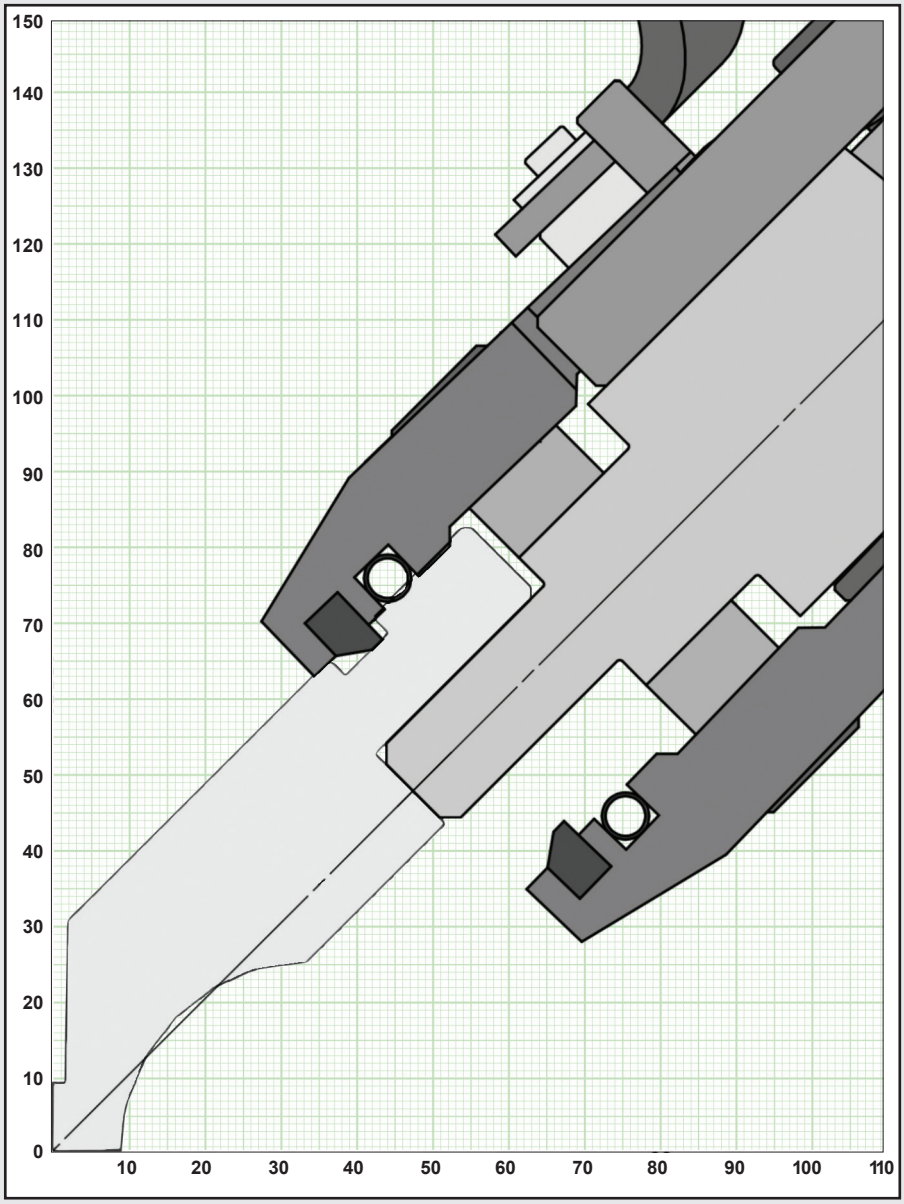
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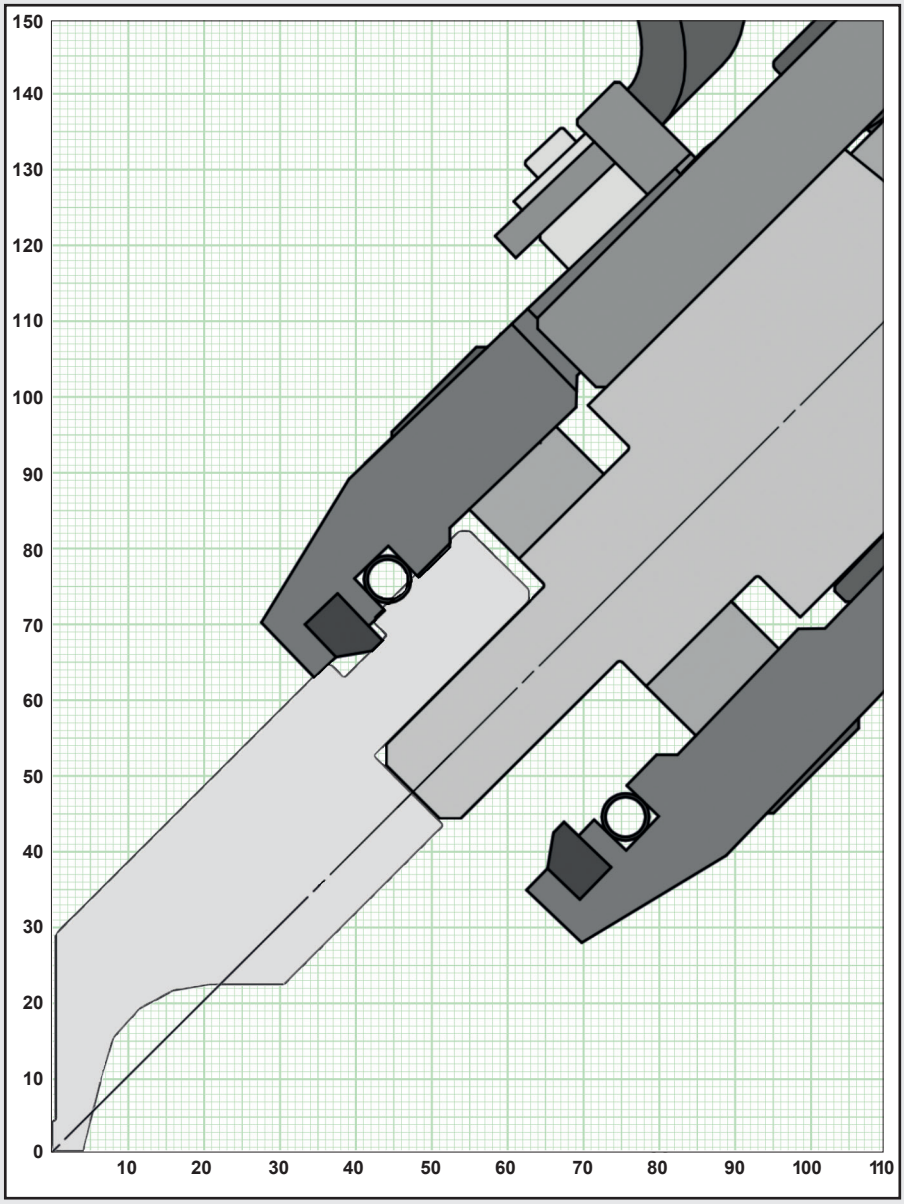
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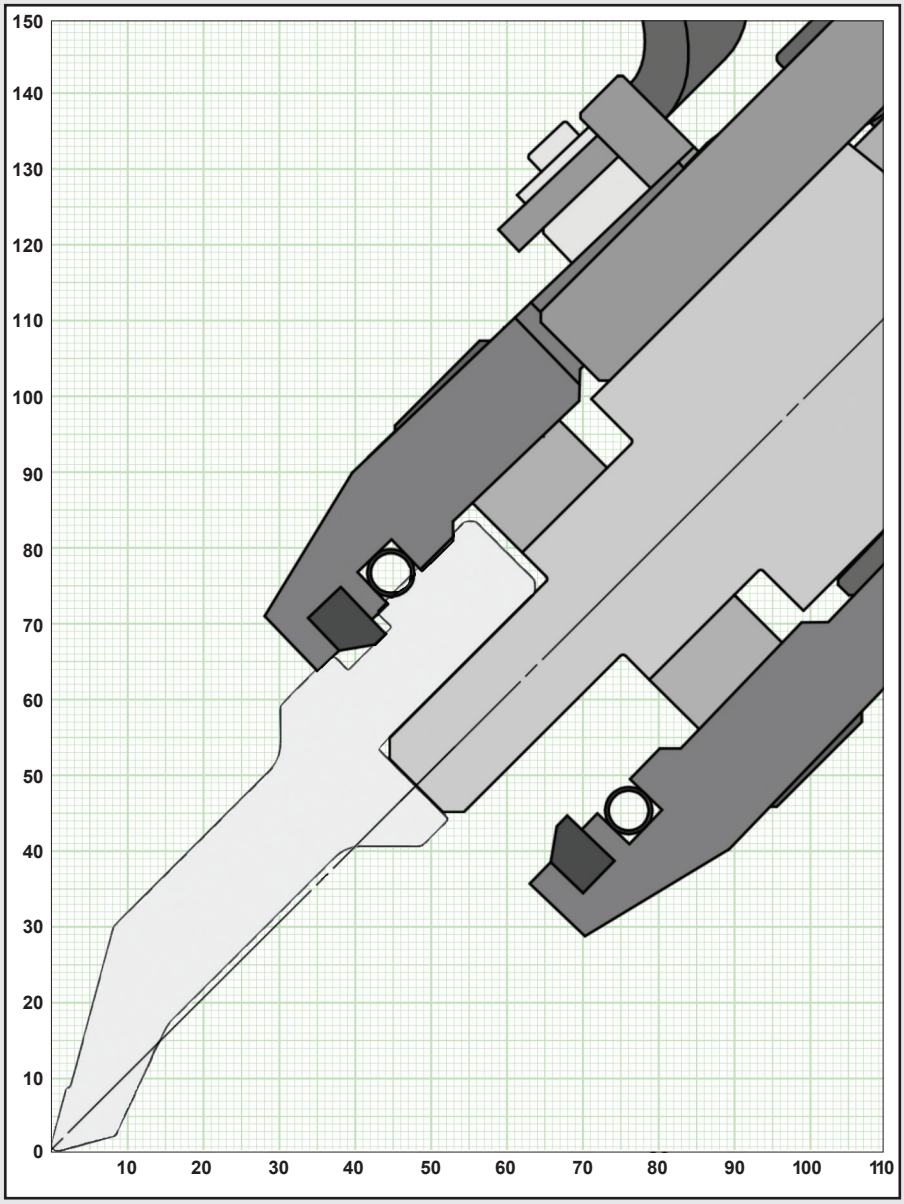
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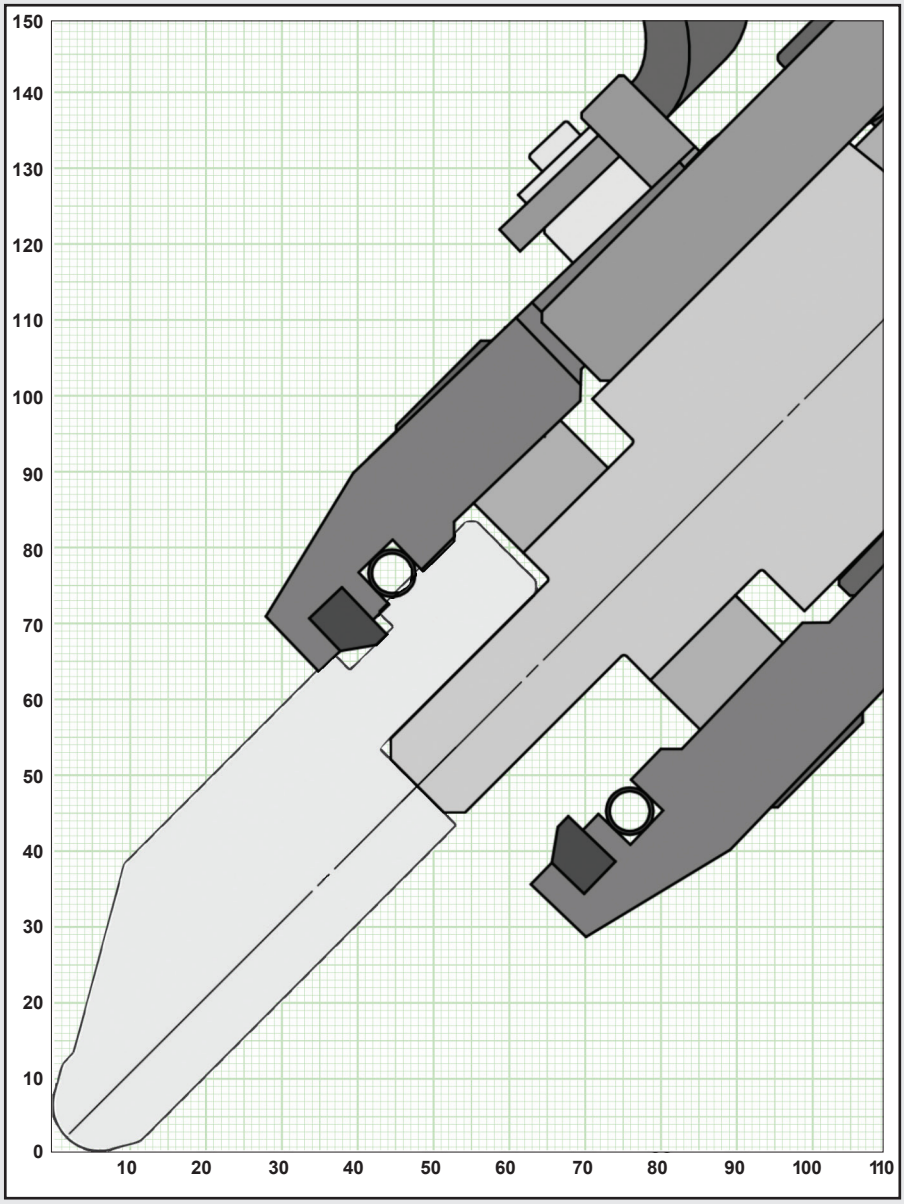
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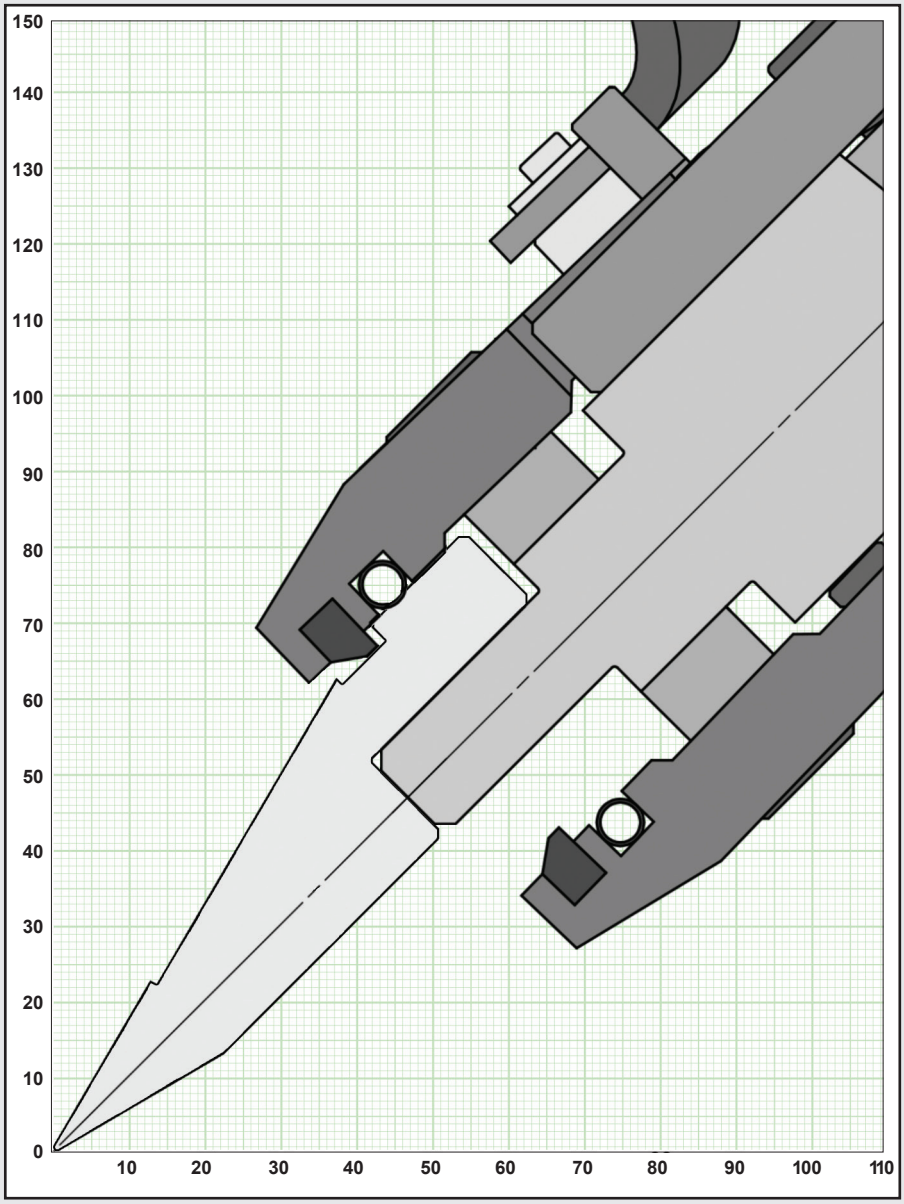
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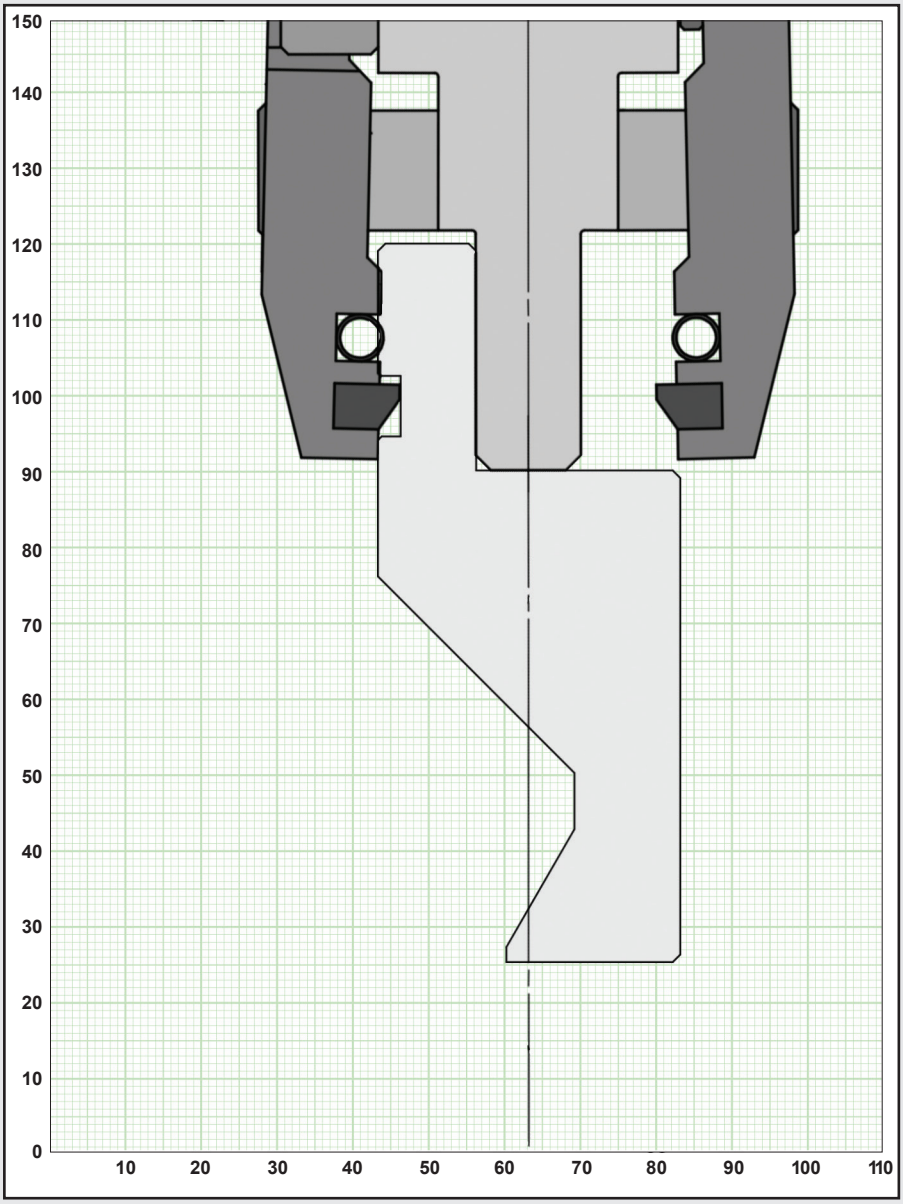
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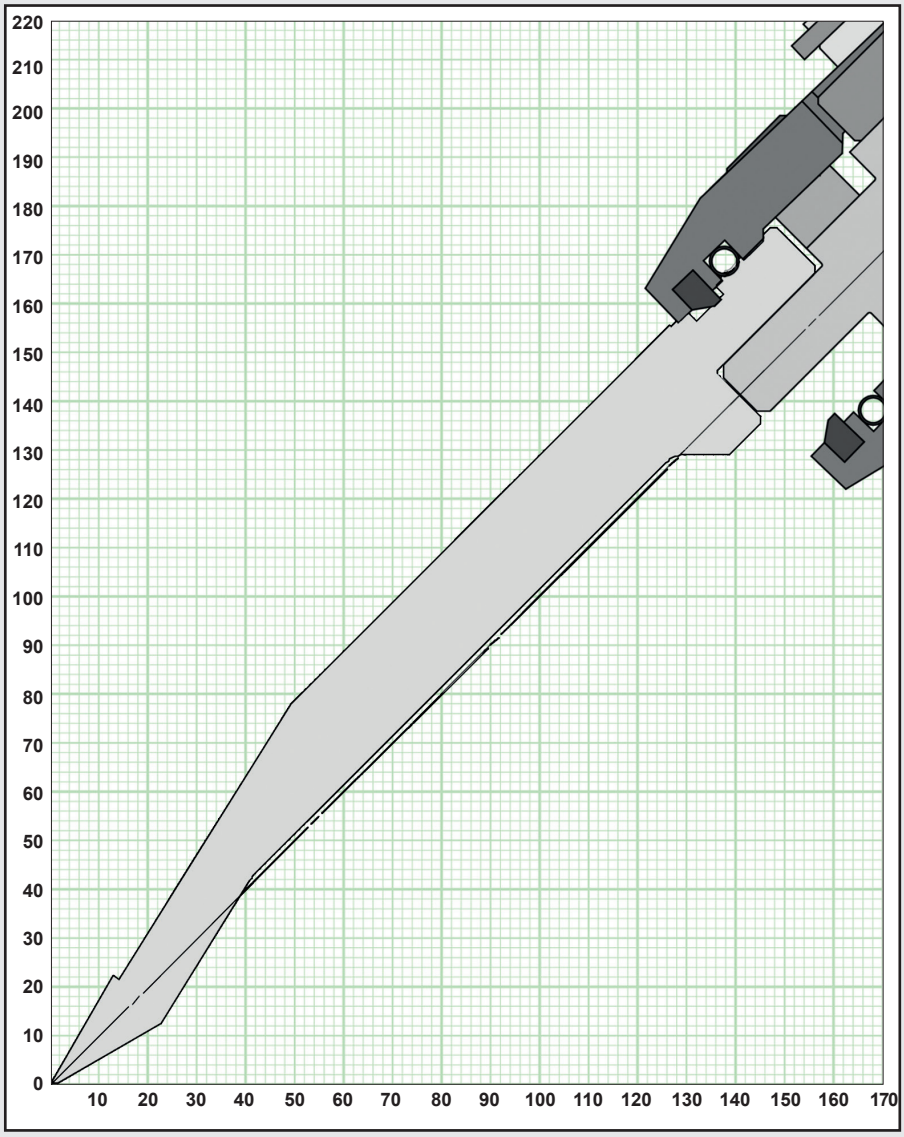
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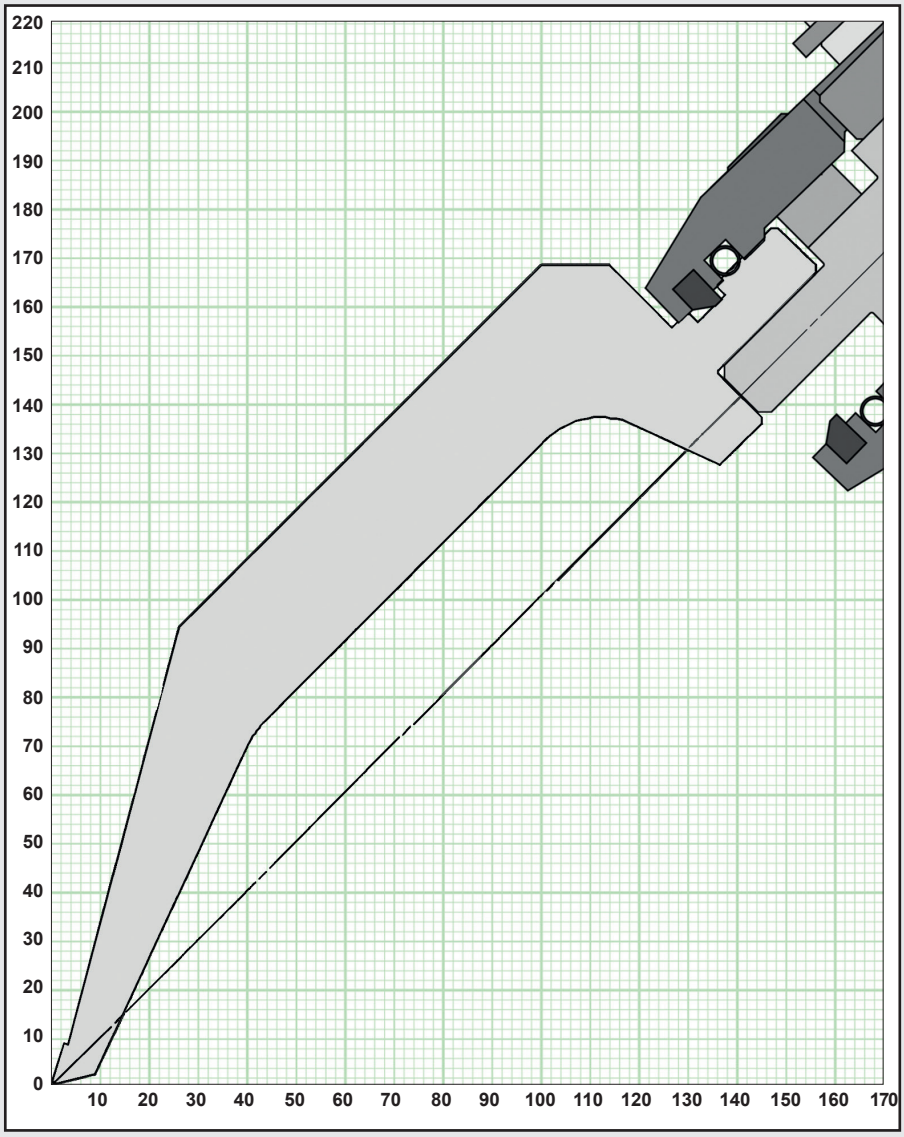

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Semi-Standard Punch
H=200 Type #831



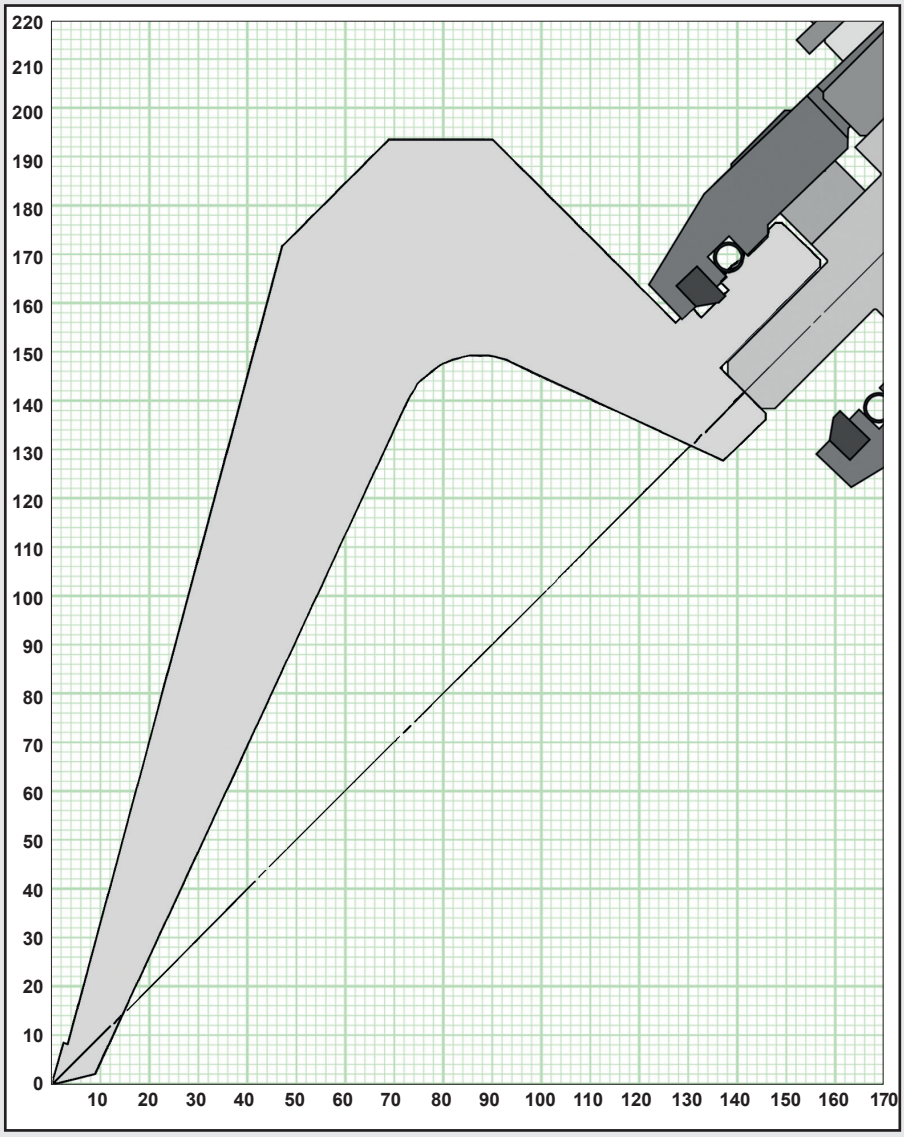
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Semi-Standard Punch
H=200 Type #841 W55



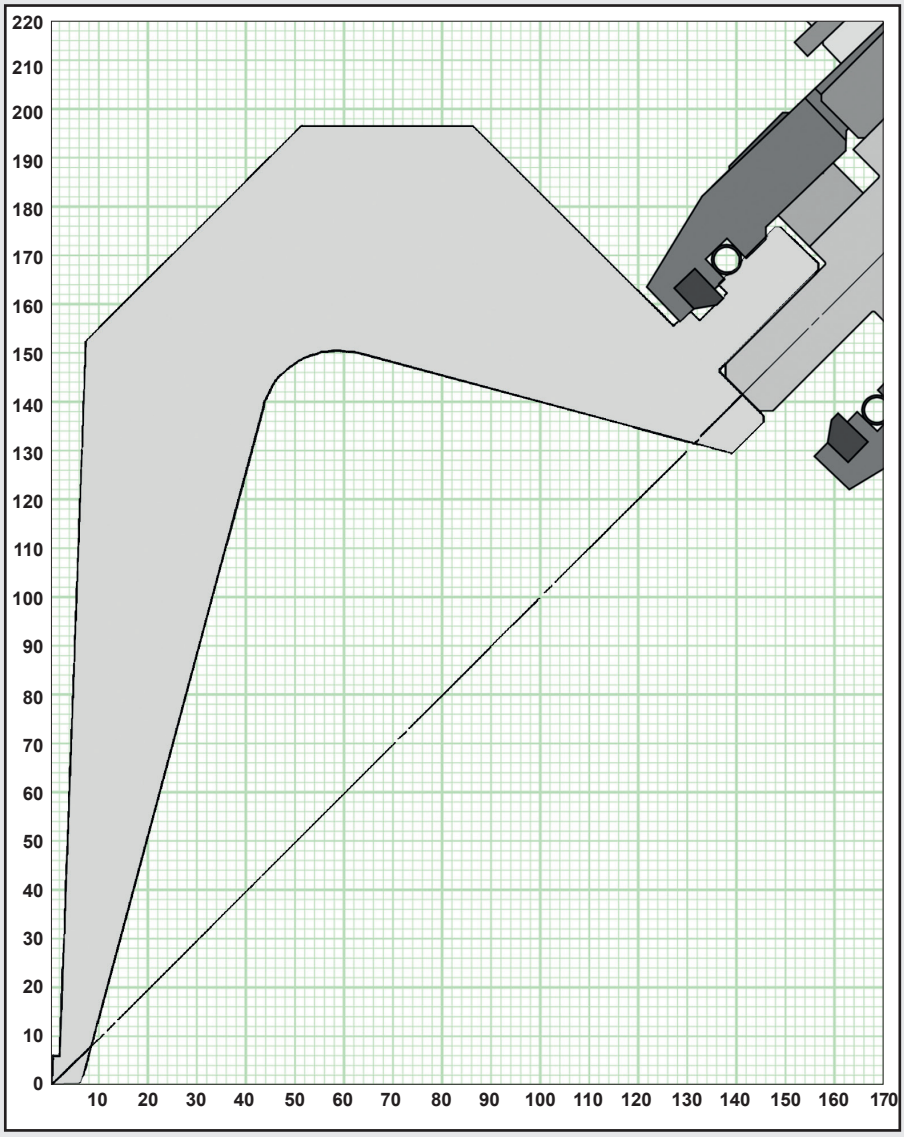
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Semi-Standard Punch H=200 Type #841 W95



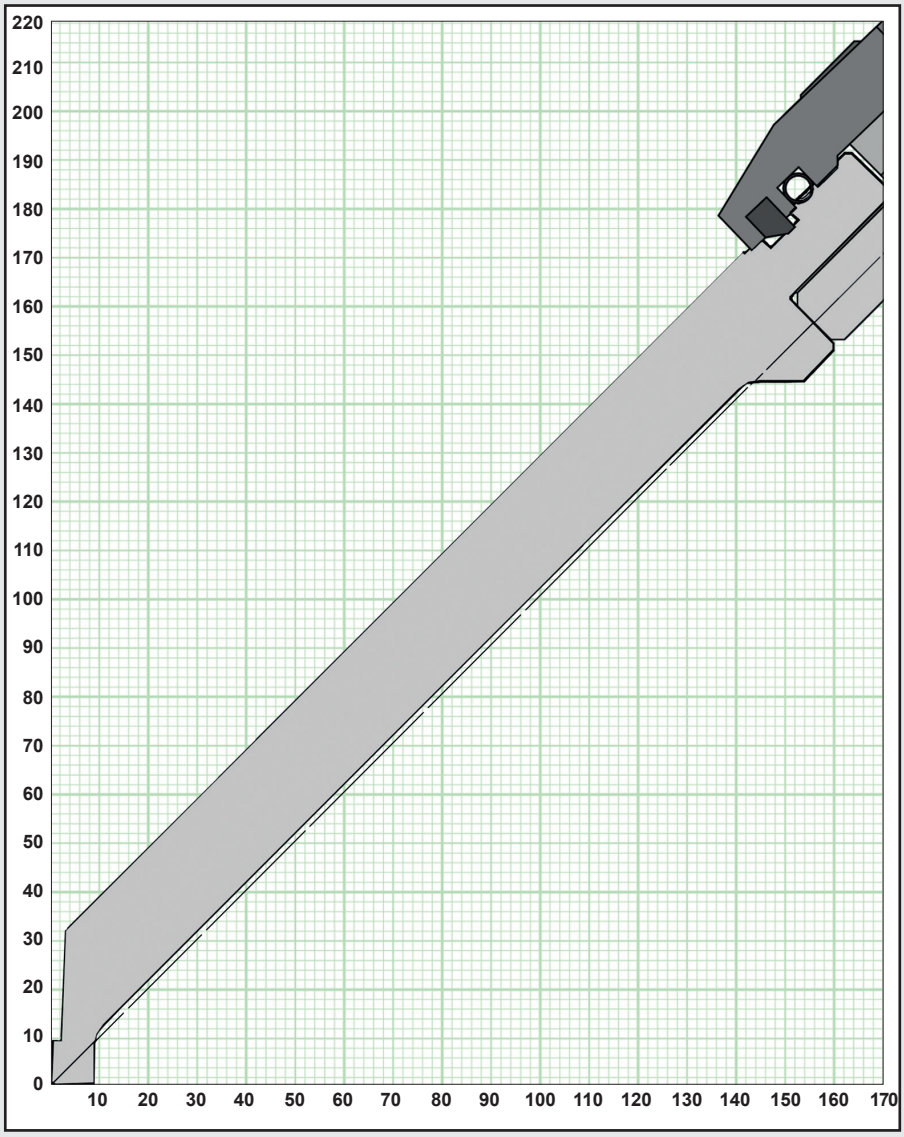
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Semi-Standard Punch
H=200 Type #846 W110



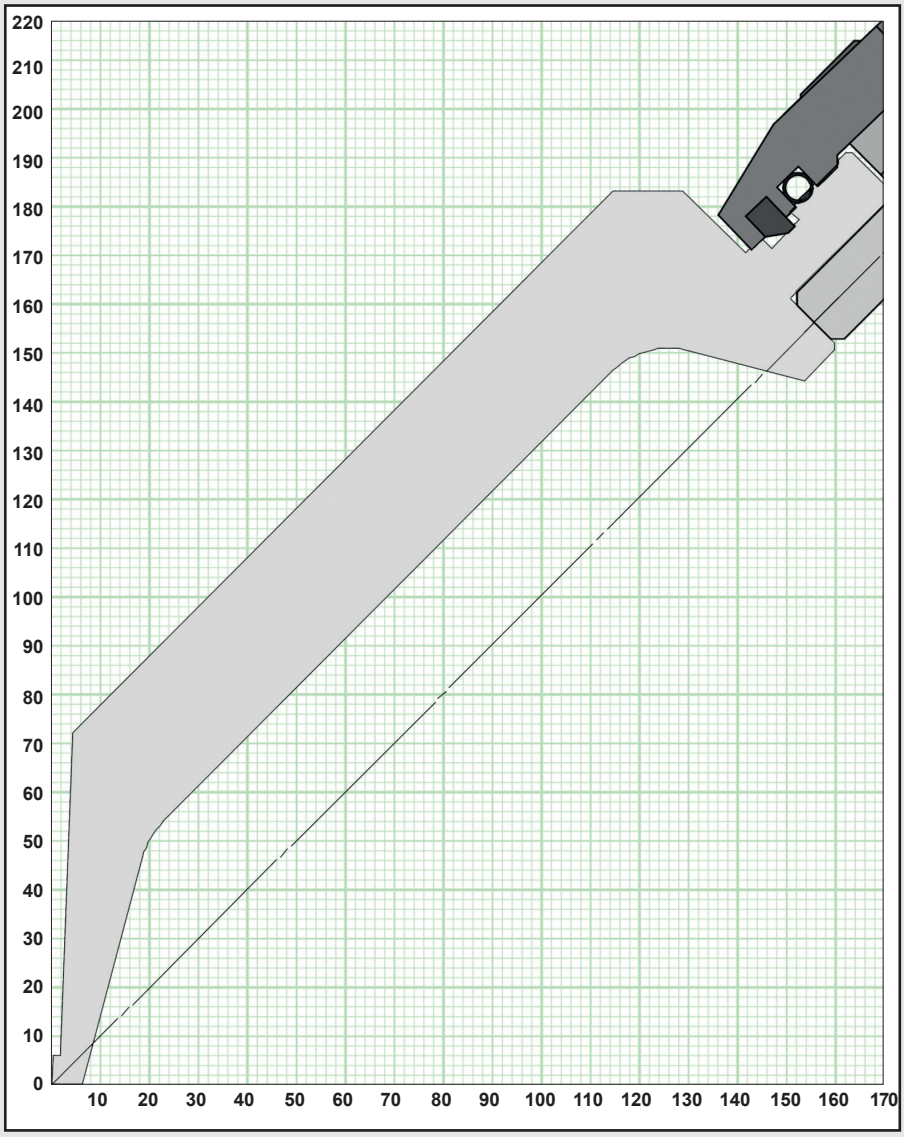
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Semi-Standard Punch
H=220 Type #804



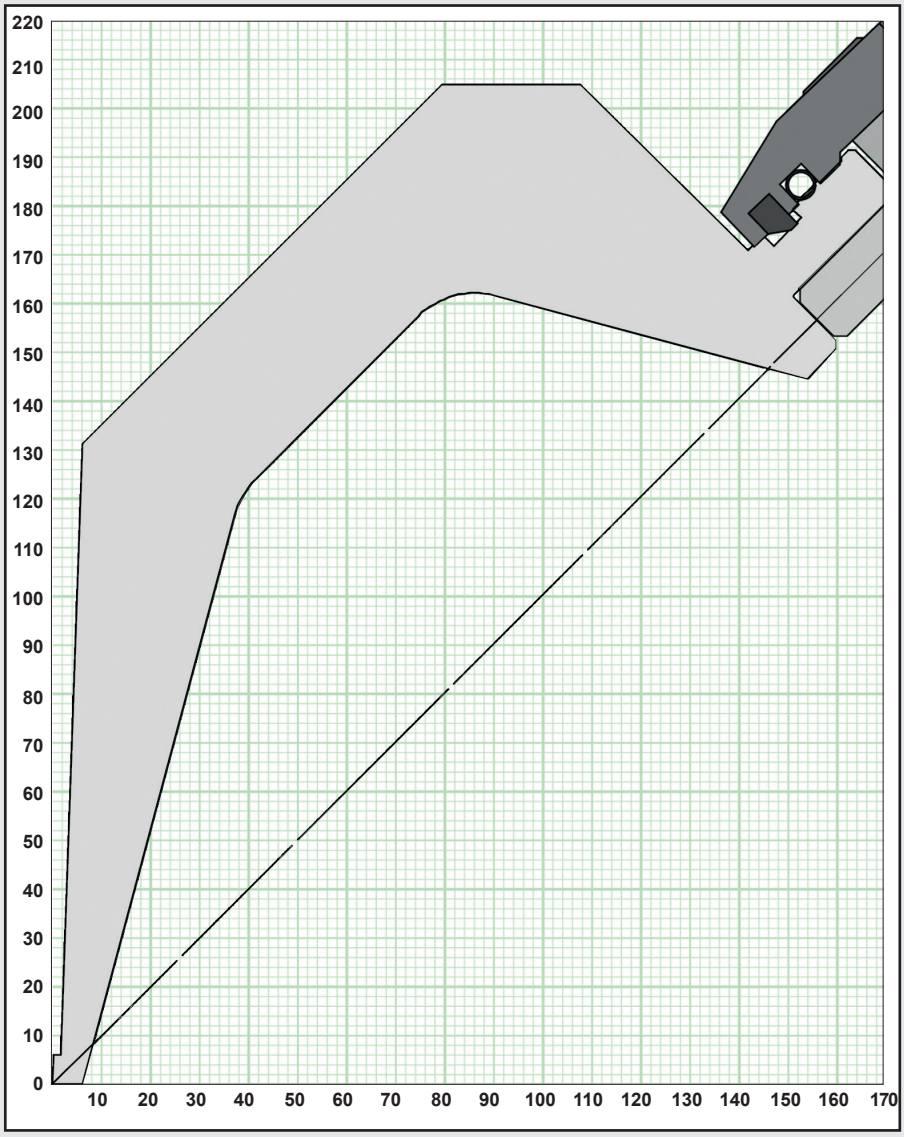
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Semi-Standard Punch
H=220 Type #846 W55



Graphic not full size

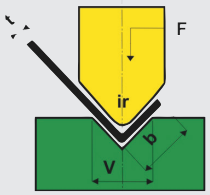
Semi-Standard Punch H=220 Type #846 W95



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Air Bending Tonnage Chart: Mild Steel

How to Read the Pressure Chart



If the material thickness and inner radius are known, the following information can be obtained from the chart below:

1. Tonnage required to bend material of 1 metre length
2. V-width to be used
3. Minimum flange length

t mm	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V
	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b
	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir
0.5	4	3																				F
0.6	6	4	4	4																		
0.8		7	7	5	4																	
1		11	10	8	7	6																
1.2			14	12	10	8	7	6														
1.4				15	13	11	10	9	8													
1.6					17	15	13	11	10	9												
2						22	19	17	15	13	11											
2.3							25	23	19	17	15	12										
2.6								28	25	22	18	14										
3									34	30	24	19	15									
3.2										34	27	22	17	14								
3.5											33	26	20	16	13							
4											43	34	27	21	17							
4.5												44	34	27	21							
5												52	42	33	26	21						
6													60	48	38	30	24					
7															52	41	33	26				
9																67	54	43				
10																85	67	53	42			
12																	96	78	60	55		
16																		136	107	86		
19																			150	125	100	
22																				160	130	
25																				210	170	
30																					240	

t Material thickness (tensile strength: 45 - 50 kg/mm²)
F Tonnage per 1 metre
ir Inside radius
b Minimum flange length
V V-width

Material Thickness and V-Width

The distance across the die opening is known as the V-width. The appropriate V-width should be selected in accordance with the thickness of material being bent. The table below shows the optimum relationship between the material thickness and V-width, although in practice this relationship is often determined by specific requirements, including flange lengths (b), the components inner bend radius (ir) and the tonnage capacity of the machine and tooling.

Relationship of Material Thickness (t) and V-Width

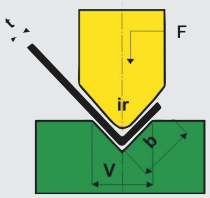
Material Thickness (t) mm	0.5 - 2.5	3.0 - 8.0	9.0 - 10.0	12.0 or more
V-Width	6 x t	8 x t	10 x t	12 x t

Air Bending Tonnage Chart: Stainless Steel

How to Read the Pressure Chart

If the material thickness and inner radius are known, the following information can be obtained from the chart below:

1. Tonnage required to bend material of 1 metre length
2. V-width to be used
3. Minimum flange length



t mm	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	V
	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b
	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir
0.5	6	5																				F
0.6	9	6	6	6																		
0.7	12	8	8	6	6																	
0.8		11	11	8	7																	
0.9		13	12	10	8	7																
1		17	15	12	11	8																
1.2			21	18	15	12	11	9														
1.5						20	17	15	13	12												
2						33	29	26	23	20	17											
2.5								39	35	30	25	19										
3									51	45	36	29	23									
4											65	51	41	32	26							
5												78	63	50	39	32						
6													90	72	57	45	36					
8															102	81	65	51				
10																128	101	80	63			
12																	144	117	90	83		
15																		180	141	114		
20																			250	208	167	
25																				315	255	
30																					360	

t Material thickness (tensile strength: 52 - 60 kg/mm²)
F Tonnage per 1 metre
ir Inside radius
b Minimum flange length
V V-width

Material Thickness and V-Width

The distance across the die opening is known as the V-width. The appropriate V-width should be selected in accordance with the thickness of material being bent. The table below shows the optimum relationship between the material thickness and V-width, although in practice this relationship is often determined by specific requirements, including flange lengths (b), the components inner bend radius (ir) and the tonnage capacity of the machine and tooling.

Relationship of Material Thickness (t) and V-Width

Material Thickness (t) mm	0.5 - 2.5	3.0 - 8.0	9.0 - 10.0	12.0 or more
V-Width	6 x t	8 x t	10 x t	12 x t