

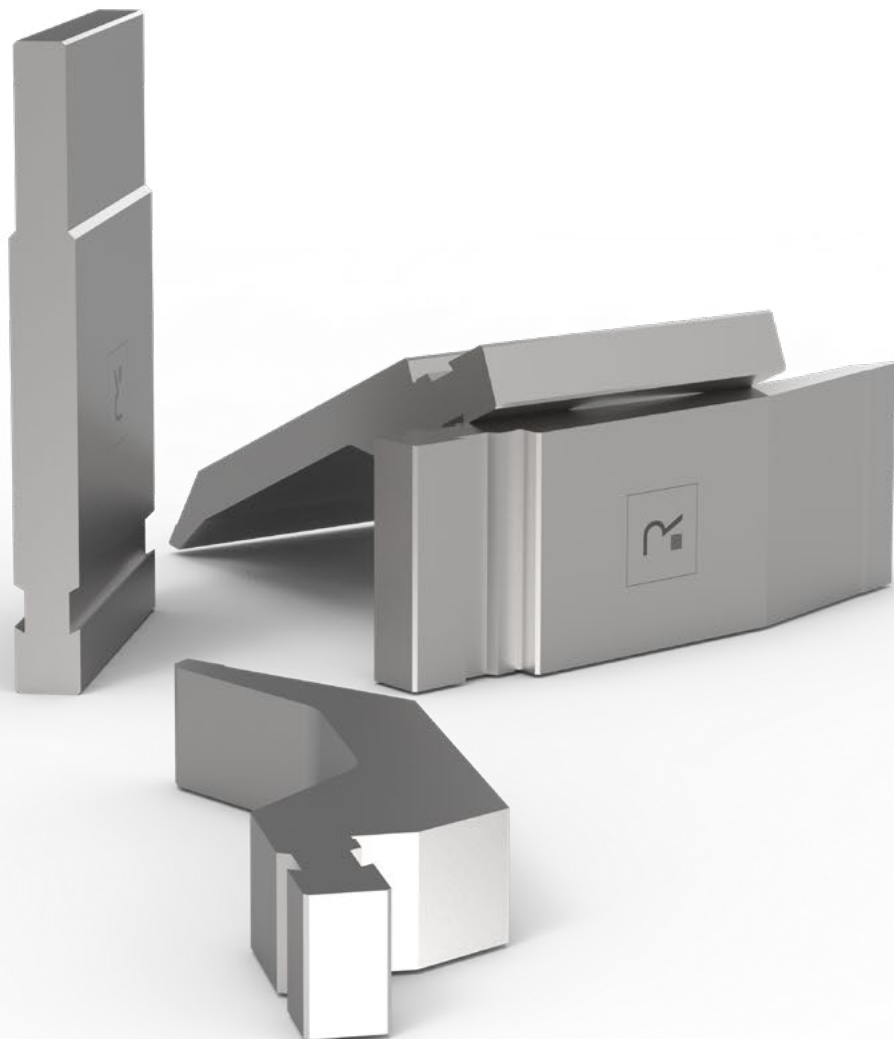
# ROLLERI

TOOLING LAB

LASER CONSUMABLES  
PUNCHING TOOLS - IRON WORKER  
SHEAR BLADES  
PANEL BENDING TOOLS

## BENDING

R8 TOOLS TYPE  
COLGAR





ISO 9001 - ISO 45001  
CERTIFIED  
COMPANY



Click on QR codes or scan them to watch videos. Follow our official Youtube channel [www.youtube.com/Rollerispa](http://www.youtube.com/Rollerispa) or watch videos in our website <https://www.rolleritools.com/media>



#### Download Rolleri **Bending App**

It contains not only a lot of interesting contents but also sheet metal development calculator and bending ruler. Furthermore this free app contains a useful tool to scan the QR codes in this catalogue.



Ask for our punching tooling, ironworker, laser consumables, panel bending tooling and shear blades catalogues at [www.rolleritools.com/download](http://www.rolleritools.com/download)



The **Bending handbook** target is to supply practice and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.



Create your account on [www.rolleritools.com](http://www.rolleritools.com)  
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.



Click on the QR code or scan it to find prices and availability. Create your account on [www.rolleritools.com](http://www.rolleritools.com)



Check standard available sectioning.  
You can also ask for customized tool sectioning.  
Contact [sales@rolleri.it](mailto:sales@rolleri.it) to ask for feasibility and for customized products.



#### Download Rolleri **Clamping App**

Rolleri App contains a lot of useful information about our fast clamping systems, details for their installation and all user manuals.



## BENDING TOOLS

### R1 TOOLS TYPE

Compatible with press brakes: Accurl, Accurpress, ACL, Adira, Amada, Atlantic, Baykal, BL, Boschert, Boutillon, Bystronic, Beyeler, Euro-B, Coastone, Colgar, Dener, Deratech, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gecko, Gilardi, Gizelis, Haco, Hindustan, HPM, Iturraspe, Jfy, JMT, LFK, Metfab, MVD, Oriance, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vicla, Vimercati, Warcom, Yawei,...

### R2-R3 TOOLS TYPE

Compatible with press brakes: Darley, LVD, Safan, Trumpf and press brakes with NSCL system, Bystronic Beyeler RFA, RF, R, S

### R4 TOOLS TYPE

Compatible with press brakes: LVD

### R5 TOOLS TYPE

Compatible with press brakes: American

### R6 TOOLS TYPE

Compatible with press brakes: Hämmerle-Bystronic

### R7 TOOLS TYPE

Compatible with press brakes: Colly

### R8 TOOLS TYPE

Compatible with press brakes: Colgar

### R9 TOOLS TYPE

Compatible with press brakes: Gasparini (axial)

### R10 TOOLS TYPE

Compatible with press brakes: Ajial Axial

### Rx TOOLS TYPE

Compatible with press brakes: EHT, Ursviken and Weinbrenner

### ROLLERI TECH, MODIFICATIONS AND SERVICES

Compatible with all types of press brakes

### CLAMPING SYSTEMS, INTERMEDIATES AND ADAPTERS

Compatible with all types of press brakes

### ROLLA-V AND SPECIAL DIES

Compatible with all types of press brakes

### MARK FREE BENDING AND ACCESSORIES

Compatible with all types of press brakes

## PANEL BENDING TOOLS

## SHEAR BLADES

## PUNCHING TOOLS

### R1 TOOLS TYPE

Compatible with punching machines Amada, Amada ABS, Wilson HP, Wilson HP WLS, Mate Ultra Tec

### R2 TOOLS TYPE

Compatible with Trumpf punching machines

### RS TOOLS TYPE

Compatible with Salvagnini punching machines

### SPECIAL TOOLS

Compatible with different types of punching machines

### ACCESSORIES

Compatible with different types of punching machines

### IRON WORKER

Iron cutting tools

## LASER CONSUMABLES

Find our wide range of laser consumables: one of the widest in the market.



# 6 R8 TOOLS

8 - PUNCHES: CONTENT EXPLANATION

9 - PUNCHES

10 - RADIUS TOOLS

11 - ADAPTERS

12 - DIES: CONTENT EXPLANATION

**A**

AD12 11

AW12 11

**C**

C13.08 10

C13.09 10

C16.10 10

C17.12 10

C20.15 10

C22.17 10

C24.20 10

C25.22 10

C29.25 10

C34.27 10

C34.30 10

C37.32 10

C42.37 10

C45.35 10

C45.40 10

C60.45 10

C70.50 10

**P**

PAC175.14 10

PAC195.26.R08 9

PAC195.60.R08 9

PAC195.85.R08 9

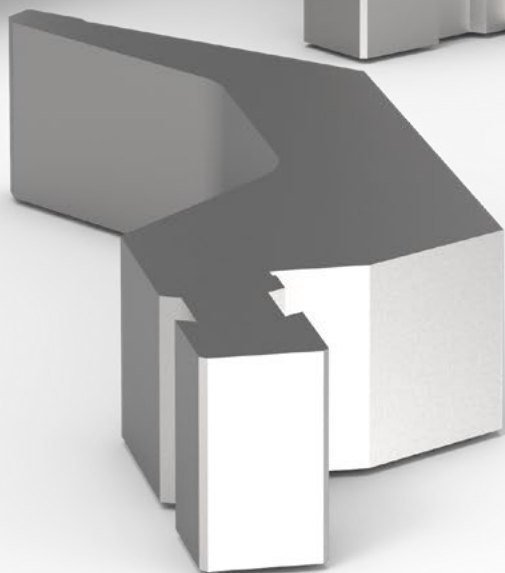
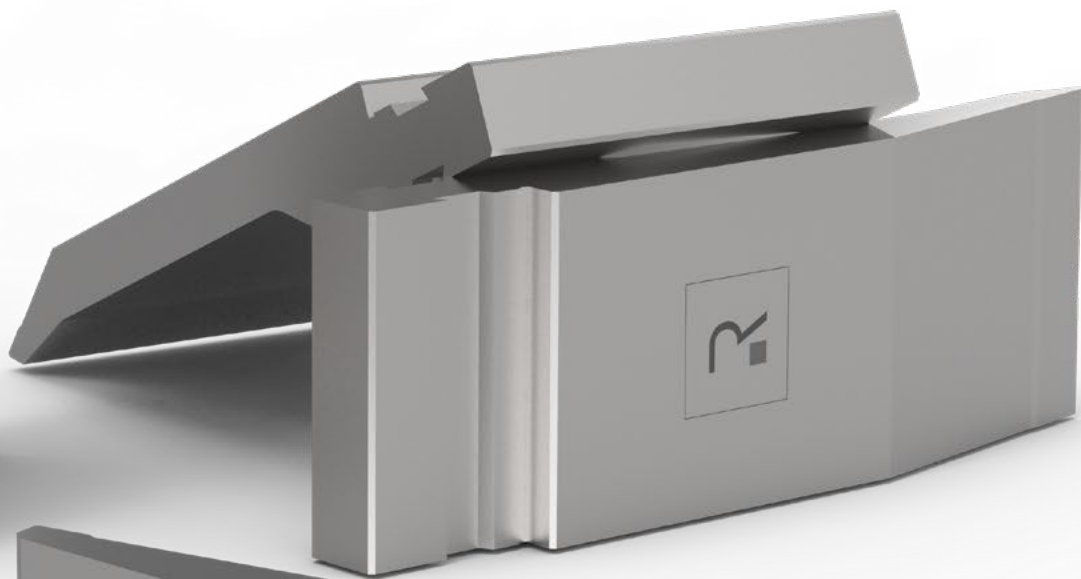
R8

TOOLS

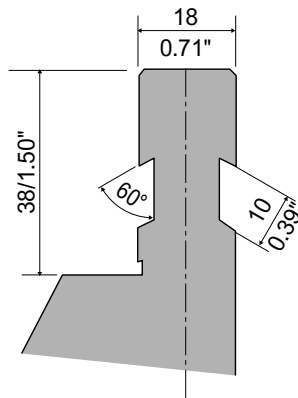
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Colgar

Our tool codes are listed according to the **tool angle**



### STANDARD TANG

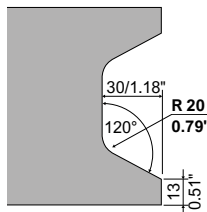


### STANDARD LENGTH

525 mm | 20.66"

### HORNS

the corresponding standard horn is shown for each code.  
Other horns are available on request according to the tool series -  
verify the feasibility writing to [sales@rolleri.it](mailto:sales@rolleri.it)



### SEGMENTATION

On request we can make customized sectioning. Contact [sales@rolleri.it](mailto:sales@rolleri.it) to know more about price and availability

◁ = horn left ▷ = horn right

F: 495 mm - 19.48"

mm: 170-100-50-45-40-35-30-25

in: 9.84-3.94-1.97-1.77-1.57-1.37-1.18-0.98



F: 500 mm - 19.68"

mm: <100-300-100>

in: <3.94-11.81-3.94>



Rolleri **BLACKFIRE** is a surface treatment against steel oxidation. After such treatment tools become black and laser marking golden.



Rolleri **FREEZINC** is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation



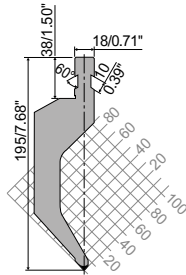
**PAC195.85.R08**



525 mm 20.67" 20.6 kg  
 495 mm 19.48" 19.4 kg F  
 500 mm 19.68" 19.6 kg F

42Cr: 900-1150 N/mm<sup>2</sup>  
 850 kN/m max.

85°  
 H=195 | R=0.8 mm  
 H=7.68 | R=0.031 in



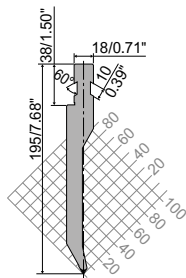
**PAC195.60.R08**



525 mm 20.67" 12.0 kg  
 495 mm 19.49" 11.3 kg F  
 500 mm 19.68" 11.4 kg F

42Cr: 900-1150 N/mm<sup>2</sup>  
 1000 kN/m max.

60°  
 H=195 | R=0.8 mm  
 H=7.68 | R=0.031 in



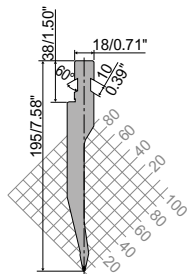
**PAC195.26.R08**



525 mm 20.67" 12.0 kg  
 495 mm 19.49" 11.3 kg F  
 500 mm 19.68" 11.4 kg F

42Cr: 900-1150 N/mm<sup>2</sup>  
 1000 kN/m max.

26°  
 H=195 | R=0.8 mm  
 H=7.68 | R=0.031 in



F: 495 mm - 19.48"  
 mm: 170-100-50-45-40-35-30-25  
 in: 9.84-3.94-1.97-1.77-1.57-1.37-1.18-0.98



F: 500 mm - 19.68"  
 mm: <100-300-100>  
 in: <3.94-11.81-3.94>

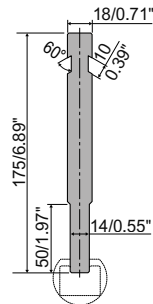


**PAC175.14**

830 mm 32.68" 12.0 kg  
 412 mm 16.22" 19.4 kg

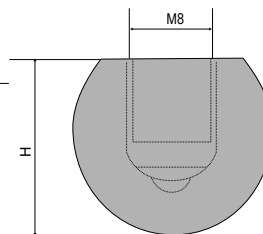
C45: 560-710 N/mm<sup>2</sup>  
 1000 kN/m max.

H=175 mm  
 H=6.89 in



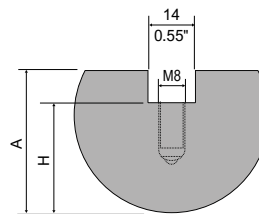
**RADIUS TOOLS Ø 16 - 20**

	R	R	H	H	A	A	835 mm	415 mm
	mm	in	mm	in	mm	in	32.87 in	16.34 in
C13.08	8	0.31	13	0.51	-	-	2.0 kg	1.0 kg
C13.09	9	0.35	16	0.63	-	-	2.0 kg	1.0 kg
C16.10	10	0.39	16	0.63	-	-	2.0 kg	1.0 kg



**RADIUS TOOLS Ø 25 - 100**

	R	R	H	H	A	A	835 mm	415 mm
	mm	in	mm	in	mm	in	32.87 in	16.34 in
C17.12	12.5	0.49	17	0.67	22	0.87	2.5 kg	1.2 kg
C20.15	15	0.59	20	0.79	27	1.06	3.7 kg	1.8 kg
C22.17	17.5	0.69	22	0.87	32	1.26	5.0 kg	2.4 kg
C24.20	20	0.79	24	0.94	34	1.33	7.0 kg	3.5 kg
C25.22	22.5	0.89	25	0.98	35	1.38	7.5 kg	3.8 kg
C29.25	25	0.98	29	1.14	39	1.53	10.0 kg	4.7 kg
C34.27	27.5	1.08	34	1.33	44	1.73	12.4 kg	6.2 kg
C34.30	30	1.18	34	1.33	44	1.73	13.5 kg	6.7 kg
C37.32	32.5	1.28	37	1.46	47	1.85	15.9 kg	7.9 kg
C45.35	35	1.38	45	1.77	55	2.16	20.3 kg	10.0 kg
C42.37	37.5	1.48	42	1.65	52	2.04	20.5 kg	10.3 kg
C45.40	40	1.57	45	1.77	55	2.16	23.0 kg	11.5 kg
C60.45	22.5	0.89	60	2.36	70	2.75	34.0 kg	17.0 kg
C70.50	50	1.97	70	2.75	80	3.15	43.5 kg	21.7 kg



F: 495 mm - 19.48"  
 mm: 170-100-50-45-40-35-30-25  
 in: 9.84-3.94-1.97-1.77-1.57-1.37-1.18-0.98



F: 500 mm - 19.68"  
 mm: <100-300-100>  
 in: <3.94-11.81-3.94>

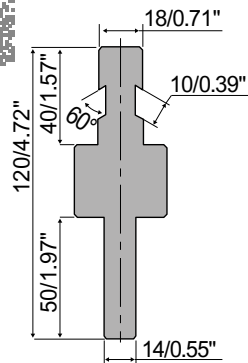


## AD12

150 mm 5.90" 3 kg

R8 Colgar → R1  
C45: 560-710 N/mm<sup>2</sup>  
1000 kN/m max.

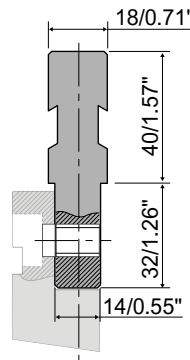
W=82 | H=120  
W= 3.23 | H=4.72



## AW12

835 mm 32.87" 7 kg  
415 mm 16.34" 3.5 kg  
805 mm 31.69" 6.7 kg F

R8 Colgar → R1  
C45: 560-710 N/mm<sup>2</sup>  
1000 kN/m max.



Upper adapters have very precise dimensions and limited height. They are studied to be mounted directly to press brake upper beam and when mounted, they can host punches with a different tang than the original one. Such solution is very interesting when you have to retrofit a press brake: in a press brake with a special tang you can mount all standard tools in the catalogue.

Thanks to this operation, time and costs are reduced.

Adapter precision needs to have max +/-0.01mm tolerance, so that bending axis is precise and guaranteed. In this way you can get precise profiles, as distance between backgauges and die V center is also precise.

As far as dimensions is concerned, we have limited height not to lose too much daylight. AW adapters enable standard R1 type tools to be mounted in a press brake with a different tang.

They consist in small adapters as big as press brake tang and as long as the punch they have to be mounted with. They can be supplied in segmented version as well. Some holes are drilled and countersunk in punch tang, whereas some threaded holes are made in AW adapter so that they can be screwed together and become a single body.

In press brake CNC the total height of punch and adapter has to be set either manually or imported automatically from our DXF drawing. This system offers the possibility to use a wide range of standard R1 type punches and avoid using special tooling.



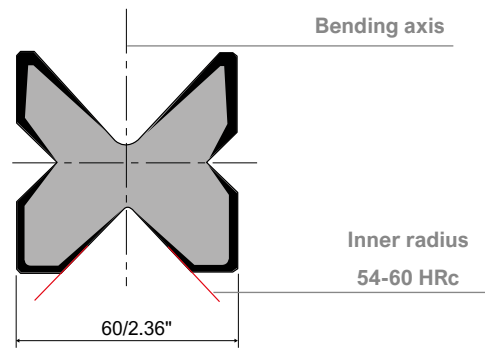
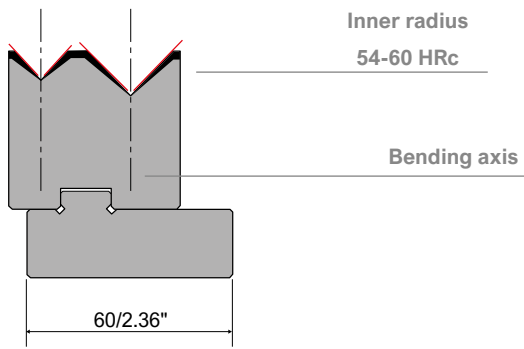
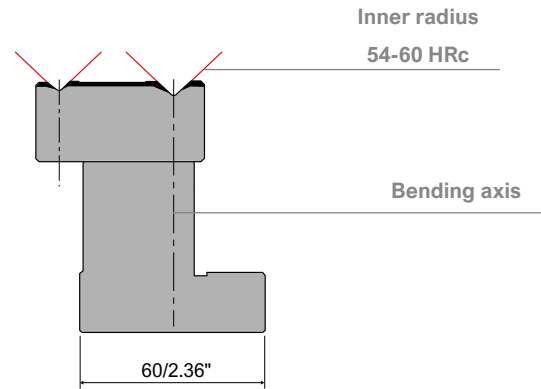
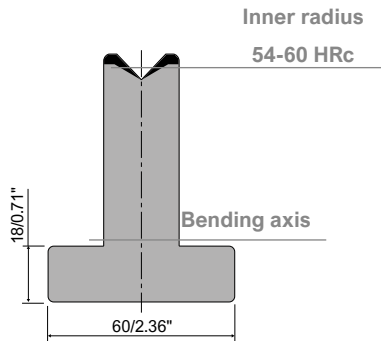
Download or request type R1 bending tools catalogue [www.rolleritools.com/download-66100.html](http://www.rolleritools.com/download-66100.html)



Create your account on [www.rolleritools.com](http://www.rolleritools.com)  
Visit the area [markfree bending](#) to find out a lot of solutions to avoid sheet metal marks.

### STANDARD TANG

All dies R1 have base 60 mm 2.36", 90 mm 3.54" or 120 mm 4.72".



### STANDARD LENGTH

	TOP Series	CLASSIC Series	A Series	AFH Series
525 mm   20.67"	●			
415 mm   16.34"		●	●	●
835 mm   32.87"		●	●	●
900 mm   35.43"		○	○	

○ Available only for some models



Rolleri **BLACKFIRE** is a surface treatment against steel oxidation. After such treatment tools become black and laser marking golden.

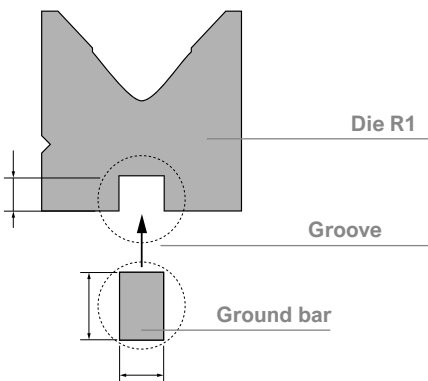


Rolleri **FREEZINC** is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation

## MODIFICATIONS WEDGE/BAR TAIL

To use R1 dies, a 10 mm 0.39" groove is milled where a ground bar is mounted.

Wedge/BarTail (W x H)		System
13 x 30 mm 0.51" x 1.18"	R2 R3	Bystronic-Beyeler, Safan, Trumpf,...
55 x 55 mm 2.16" x 2.16"	RX	EHT
12.7 x 29 mm 0.5" x 1.14"	R4	LVD
35 x 55 mm 1.37" x 2.16"	RX	Weinbrenner



## SEGMENTATION

Available also special fractioning on request - check the feasibility with [sales@rolleri.it](mailto:sales@rolleri.it)

FC: 495 mm - 19.48"  
mm: 25-30-35-40-45-50-100-170  
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-9.84



F: 805 mm - 31.69"  
mm: 200-50-40-20-15-10  
in: 7.87-1.96-1.57-0.78-0.59-0.39



FX: 795 mm - 31.29"  
mm: 100-250-20-25-30-35-40-45-50 -200  
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87



FC (serie A): 835 mm - 32.87"  
mm: 10-15-20-40-50-100-200-400  
in: 0.39-0.59-0.78-1.57-1.96" -7.87-15.75



F: 800 mm - 21.49"  
mm: 100-300-150-50-40-20-15-10-100  
in: 3.94-11.81-5.90-1.96-1.57-0.79-0.59-0.59-0.39-3.94



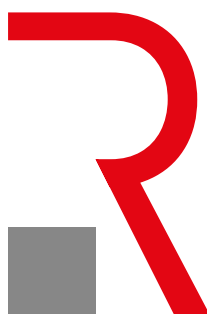
! Download or request type R1 bending tools catalogue to discover standard codes.



Ask for our punching tooling, ironworker, laser consumables, panel bending tooling and shear blades catalogues at [www.rolleritools.com/download](http://www.rolleritools.com/download)



**ROLLA-V** dies are different from conventional dies as they have inserts which rotate and accompany sheet metal during the bending process. This system has several advantages, including the reduction of sheetmetal resistance against friction and of minimum flange.



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