

ROLLERI

TOOLING LAB

LASER CONSUMABLES

PUNCHING TOOLS - IRON WORKER

SHEAR BLADES

PANEL BENDING TOOLS

BENDING

R7 TOOLS TYPE
COLLY





ISO 9001 - ISO 45001
CERTIFIED
COMPANY



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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



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.



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Check standard available sectioning.
You can also ask for customized tool sectioning.
Contact 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 R7 TOOLS

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R7

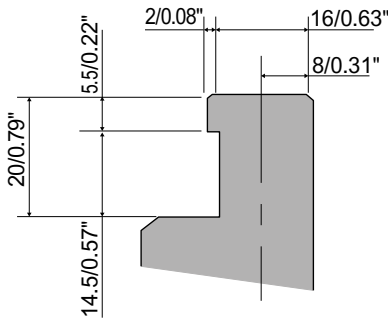
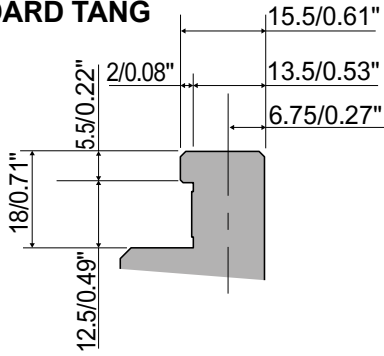
TOOLS

Colly

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



STANDARD TANG



STANDARD LENGTH

1020 mm | 40.16"

SEGMENTATION PUNCHES

On request we can make customized sectioning. Contact sales@rolleri.it to know more about price and availability.

◀ = horn left ▶ = horn right

F: 1250 mm - 49.21"

mm: <100-30-30-30-35-40-40-45-45-50-50-55-500-100-100>
in: <3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-3.94-3.94>

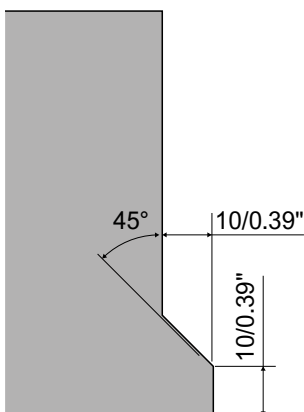


SEGMENTATION DIES

On request we can make customized sectioning. Contact sales@rolleri.it to know more about price and availability.

F: 1250 mm - 49.21"

mm: 100-30-30-30-35-40-40-45-45-50-50-55-500-200
in: 3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-7.87



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

CP72.90.08

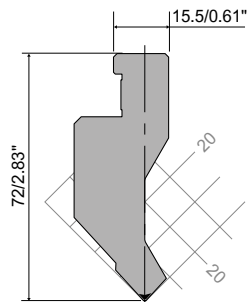
1020 mm 40.16" 10.2 kg
1250 mm 49.21" 12.5 kg F



C45: 560-710 N/mm²
700 kN/m max.

90°

W= 56 | H=72 | R=0.8 mm
W=2.20 | H=2.83 | R=0.031 in



CP120.88.08

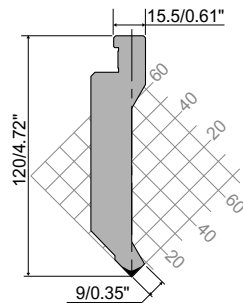
1020 mm 40.16" 18.5 kg
1250 mm 49.21" 22.6 kg F



C45: 560-710 N/mm²
700 kN/m max.

88°

W=104 | H=120 | R=0.8 mm
W=4.09 | H=4.72 | R=0.031 in



CP100.88.08-A

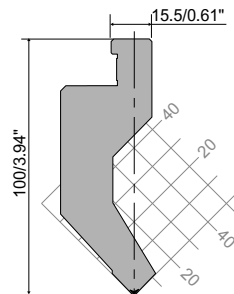
1020 mm 40.16" 10.2 kg
1250 mm 49.21" 12.5 kg F



42Cr: 900-1150 N/mm²
500 kN/m max.

88°

W=84 | H=100 | R=0.8 mm
W=3.31 | H=3.94 | R=0.031 in



CP200.85.07

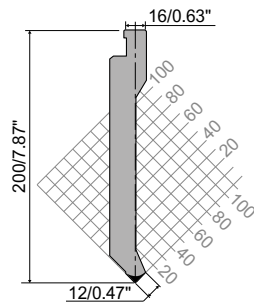
1020 mm 40.16" 18.5 kg
1250 mm 49.21" 22.6 kg F



42Cr: 900-1150 N/mm²
1000 kN/m max.

88°

W=184 | H=200 | R=0.7 mm
W=7.24 | H=7.87 | R=0.028 in



F: 1250 mm - 49.21"

mm: <100-30-30-30-35-40-40-45-45-50-50-55-500-100-100>
in: <3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-3.94-3.94>



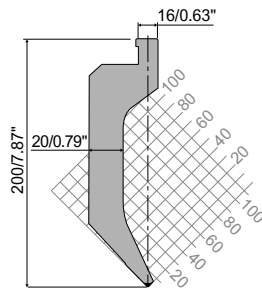
Create your account on www.rolleritools.com
Visit the area [markfree bending](#) to find out a lot of solutions to avoid sheet metal marks.

CP200.85.07-A

1020 mm 40.16" 49 kg
 1250 mm 49.21" 60 kg F

42Cr: 900-1150 N/mm²
 750 kN/m max.

85°
 W=184 | H=200 | R=0.7 mm
 W=7.24 | H=7.87 | R=0.028 in

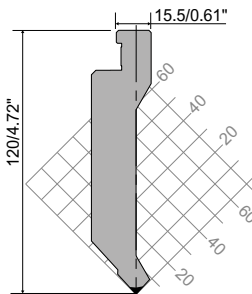


CP120.85.07

1020 mm 40.16" 17.9 kg
 1250 mm 49.21" 21.9 kg F

C45: 560-710 N/mm²
 700 kN/m max.

85°
 W=104 | H=120 | R=0.7 mm
 W=4.09 | H=4.72 | R=0.028 in

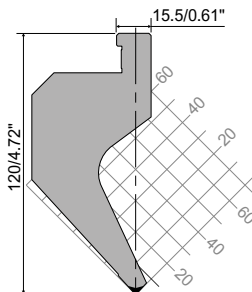


CP120.85.07-A

1020 mm 40.16" 25.5 kg
 1250 mm 49.21" 49 kg F

C45: 560-710 N/mm²
 450 kN/m max.

85°
 W=104 | H=120 | R=0.7 mm
 W=4.09 | H=4.72 | R=0.028 in

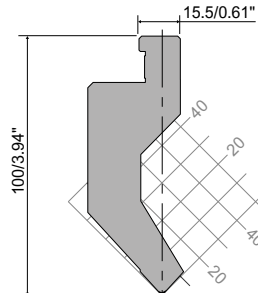


CP100.85.07-A

1020 mm 40.16" 17 kg
 1250 mm 49.21" 49 kg F

C45: 560-710 N/mm²
 500 kN/m max.

85°
 W=84 | H=100 | R=0.7 mm
 W=3.31 | H=3.94 | R=0.028 in



F: 1250 mm - 49.21"

mm: <100-30-30-30-35-40-40-45-45-50-50-55-500-100-100>
 in: <3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-3.94-3.94>



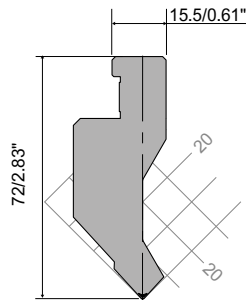
Create your account on www.rolleritools.com
 You can use our website to check availability, send enquiries, check our news, prices and order online.

CP72.85.07

1020 mm 40.16" 10 kg
1250 mm 49.21" 49 kg F

C45: 560-710 N/mm²
700 kN/m max.

85°
W= 56 | H=72 | R=0.7 mm
W=2.20 | H=2.83 | R=0.028 in

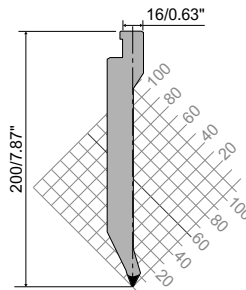


CP200.50.R1

1020 mm 40.16" 18.5 kg
1250 mm 49.21" 22.6 kg F

42Cr: 900-1150 N/mm²
1000 kN/m max.

50°
W=184 | H=200 | R=1.0 mm
W=7.24 | H=7.87 | R=0.039 in

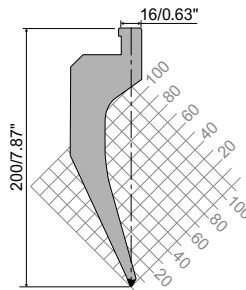


CP200.50.R1-A

1020 mm 40.16" 10.2 kg
1250 mm 49.21" 12.5 kg F

42Cr: 900-1150 N/mm²
550 kN/m max.

50°
W=184 | H=200 | R=1.0 mm
W=7.24 | H=7.87 | R=0.039 in

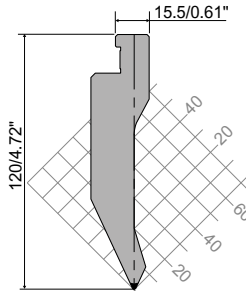


CP120.50.R1

1020 mm 40.16" 18.5 kg
1250 mm 49.21" 22.6 kg F

42Cr: 900-1150 N/mm²
1000 kN/m max.

50°
W=104 | H=120 | R=1.0 mm
W=4.09 | H=4.72 | R=0.039 in



F: 1250 mm - 49.21"

mm: <100-30-30-30-35-40-40-45-45-50-50-55-500-100-100>
in: <3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-3.94-3.94>



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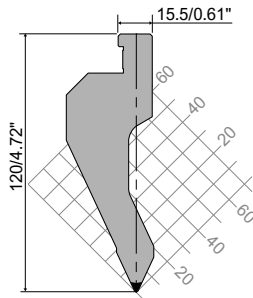
Visit the area of our [accessories](#) to find out a lot of solutions to organize and ease pressbraking operations.

CP120.50.R1-A

1020 mm 40.16" 49 kg
 1250 mm 49.21" 60 kg F

42Cr: 900-1150 N/mm²
 550 kN/m max.

50°
 W=104 | H=120 | R=1.0 mm
 W=4.09 | H=4.72 | R=0.039 in

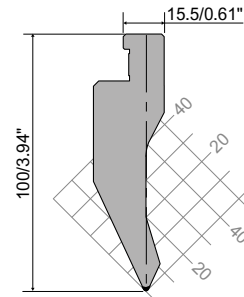


CP100.50.R1

1020 mm 40.16" 17.9 kg
 1250 mm 49.21" 21.9 kg F

42Cr: 900-1150 N/mm²
 1000 kN/m max.

50°
 W=84 | H=100 | R=1.0 mm
 W=3.31 | H=3.94 | R=0.039 in

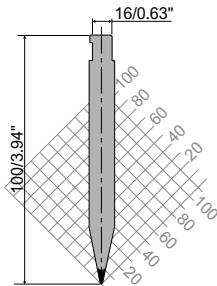


CP200.24.R1

1020 mm 40.16" 49 kg
 1250 mm 49.21" 38 kg F

C45: 560-710 N/mm²
 1300 kN/m max.

24°
 W=184 | H=200 | R=1.0 mm
 W=7.24 | H=7.87 | R=0.039 in



F: 1250 mm - 49.21"

mm: <100-30-30-30-35-40-40-45-45-50-50-55-500-100-100>
 in: <3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-3.94-3.94>



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.

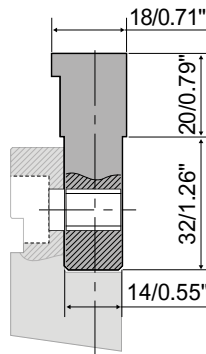
AWC16

835 mm	32.87"	5 kg
415 mm	16.34"	2.5 kg
805 mm	31.69"	4.8 kg

R7 Colly → R1

C45: 560-710 N/mm²

1000 kN/m max.



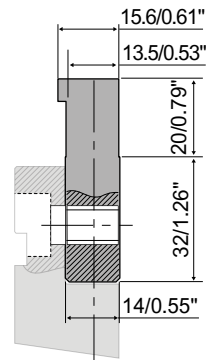
AWC13.5

835 mm	32.87"	4.8 kg
415 mm	16.34"	2.4 kg
805 mm	31.69"	4.6 kg

R7 → R1

C45: 560-710 N/mm²

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



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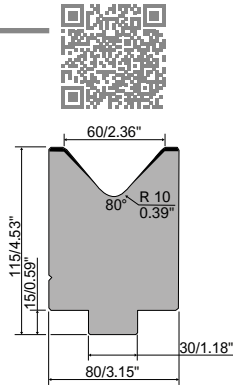
You can visit [mark free bending](#) section to discover many useful solutions on how to obtain sheet metal without signs of friction.

M115.80.60

1020 mm 40.16" 60 kg
 1250 mm 49.21" 73.6 kg F

C45: 560-710 N/mm²
 1200 kN/m max.

80°
 H=115 | V=60 | R=4 mm
 H=4.53 | V=2.36 | R=0.157 in

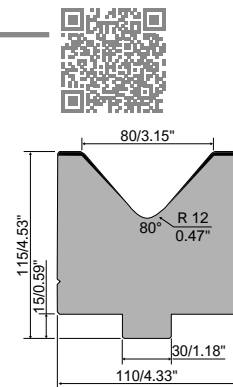


M115.80.80

1020 mm 40.16" 80 kg
 1250 mm 49.21" 98 kg F

C45: 560-710 N/mm²
 1000 kN/m max.

80°
 H=115 | V=80 | R=4 mm
 H=4.53 | V=3.15 | R=0.157 in

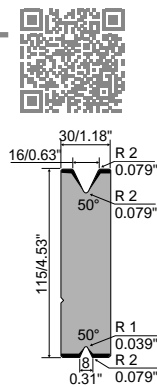


M115.50.16

1020 mm 40.16" 26.5 kg
 1250 mm 49.21" 32.4 kg F

C45: 560-710 N/mm²
 600 kN/m max.

50°
 H=115 mm
 H=4.53 in

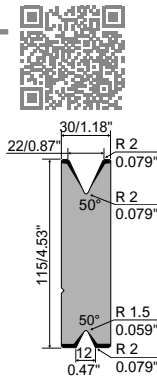


M115.50.22

1020 mm 40.16" 25.5 kg
 1250 mm 49.21" 31.2 kg F

C45: 560-710 N/mm²
 500 kN/m max.

50°
 H=115 mm
 H=4.53 in



F: 1250 mm - 49.21"

mm: 100-30-30-30-35-40-40-45-45-50-50-55-500-200
 in: 3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-7.87



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 You can visit [mark free bending](#) section to discover many useful solutions on how to obtain sheet metal without signs of friction.

M115.50.30

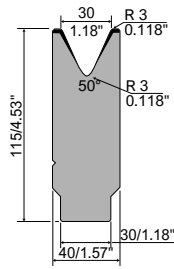
1020 mm 40.16" 34.5 kg
1250 mm 49.21" 43 kg F



C45: 560-710 N/mm²
400 kN/m max.

50°

H=115 | V=30 | R=3 mm
H=4.53 | V=1.18 | R=0.118 in



M115.50.40

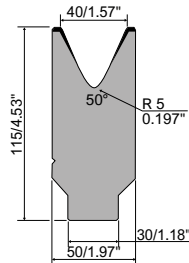
1020 mm 40.16" 36 kg
1250 mm 49.21" 44 kg F



C45: 560-710 N/mm²
400 kN/m max.

50°

H=115 | V=40 | R=3 mm
H=4.53 | V=1.57 | R=0.118 in



M115.50.50

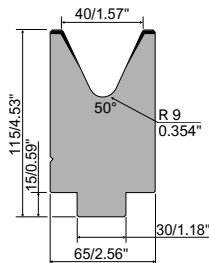
1020 mm 40.16" 45.5 kg
1250 mm 49.21" 55.7 kg F



C45: 560-710 N/mm²
600 kN/m max.

50°

H=115 | V=50 | R=4 mm
H=4.53 | V=1.97 | R=0.157 in



M115.24.16

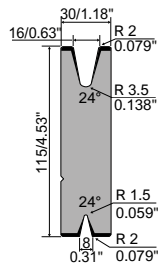
1020 mm 40.16" 24.9 kg
1250 mm 49.21" 31 kg F



C45: 560-710 N/mm²
8: 700 kN/m max - 16: 300 kN/m max.

24°

H=115 mm
H=4.53 in



F: 1250 mm - 49.21"

mm: 100-30-30-30-35-40-40-45-45-50-50-55-500-200
in: 3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-7.87



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You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.



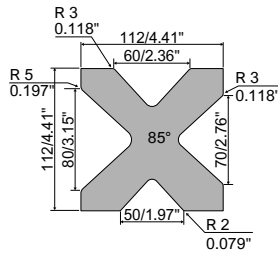
MC112.3050

1020 mm 40.16" 188 kg

C45: 560-710 N/mm²



85°		kN/m max.
R=2.0 V=50	R=0.079 V=1.97	800
R=3.0 V=60	R=0.118 V=2.36	850
R=3.0 V=70	R=0.118 V=2.76	900
R=5.0 V=80	R=0.197 V=3.15	800



MC80.2050 / MC80.3050

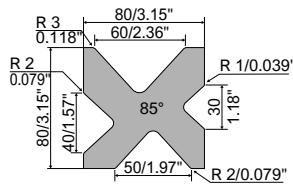
2050 mm 80.70" 66 kg

3050 mm 120.07" 98 kg F

C45: 560-710 N/mm²



85°		kN/m max.
R=1.0 V=40	R=0.039 V=1.57	750
R=2.0 V=30	R=0.079 V=1.18	750
R=2.0 V=50	R=0.079 V=1.97	750
R=3.0 V=60	R=0.118 V=2.36	750



F: 1250 mm - 49.21"

mm: 100-30-30-30-35-40-40-45-45-50-50-55-500-200

in: 3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-7.87



Click on the QR Code or scan it to watch the video and find out more about the MULTI-V dies.

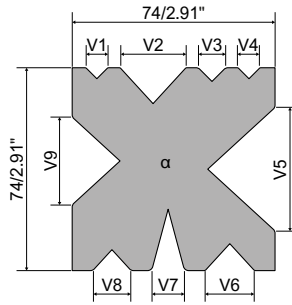
MC74.2050 / MC74.3050



2050 mm 80.70" 67 kg
 3050 mm 120.07" 101 kg F

C45: 560-710 N/mm²

			kN/m max.
90° R=0.8 V=8	R=0.031 V=0.31		500
85° R=0.8 V=24	R=0.031 V=0.94		600
90° R=2.0 V=10	R=0.079 V=0.39		600
90° R=0.8 V=8	R=0.031 V=0.31		500
85° R=2.0 V=45	R=0.079 V=1.77		550
85° R=1.0 V=18	R=0.039 V=0.71		500
30° R=2.0 V=12	R=0.079 V=0.47		550
85° R=2.0 V=14	R=0.079 V=0.55		550
85° R=2.0 V=32	R=0.079 V=1.26		550



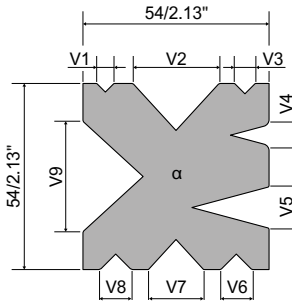
MC54.2050 / MC54.3050



2050 mm 80.70" 35.6 kg
 3050 mm 120.07" 53 kg F

C45: 560-710 N/mm²

			kN/m max.
90° R=0.5 V=6	R=0.02 V=0.24		500
85° R=1.0 V=25	R=0.39 V=0.98		600
90° R=0.5 V=6	R=0.02 V=0.24		600
30° R=2.0 V=6	R=0.079 V=0.24		500
30° R=0.5 V=12	R=0.02 V=0.47		550
90° R=1.0 V=9	R=0.039 V=0.35		500
85° R=0.5 V=16	R=0.02 V=0.63		550
90° R=1.5 V=9	R=0.059 V=0.35		550
85° R=1.0 V=32	R=0.039 V=1.26		550



F: 1250 mm - 49.21"

mm: 100-30-30-30-35-40-40-45-45-50-55-500-200
 in: 3.94-1.18-1.18-1.18-1.37-1.57-1.57-1.77-1.77-1.97-1.97-2.16-19.68-7.87



Click on the QR Code or scan it to watch the video and find out more about the MULTI-V dies.



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