

ROLLERI

TOOLING LAB

LASER CONSUMABLES

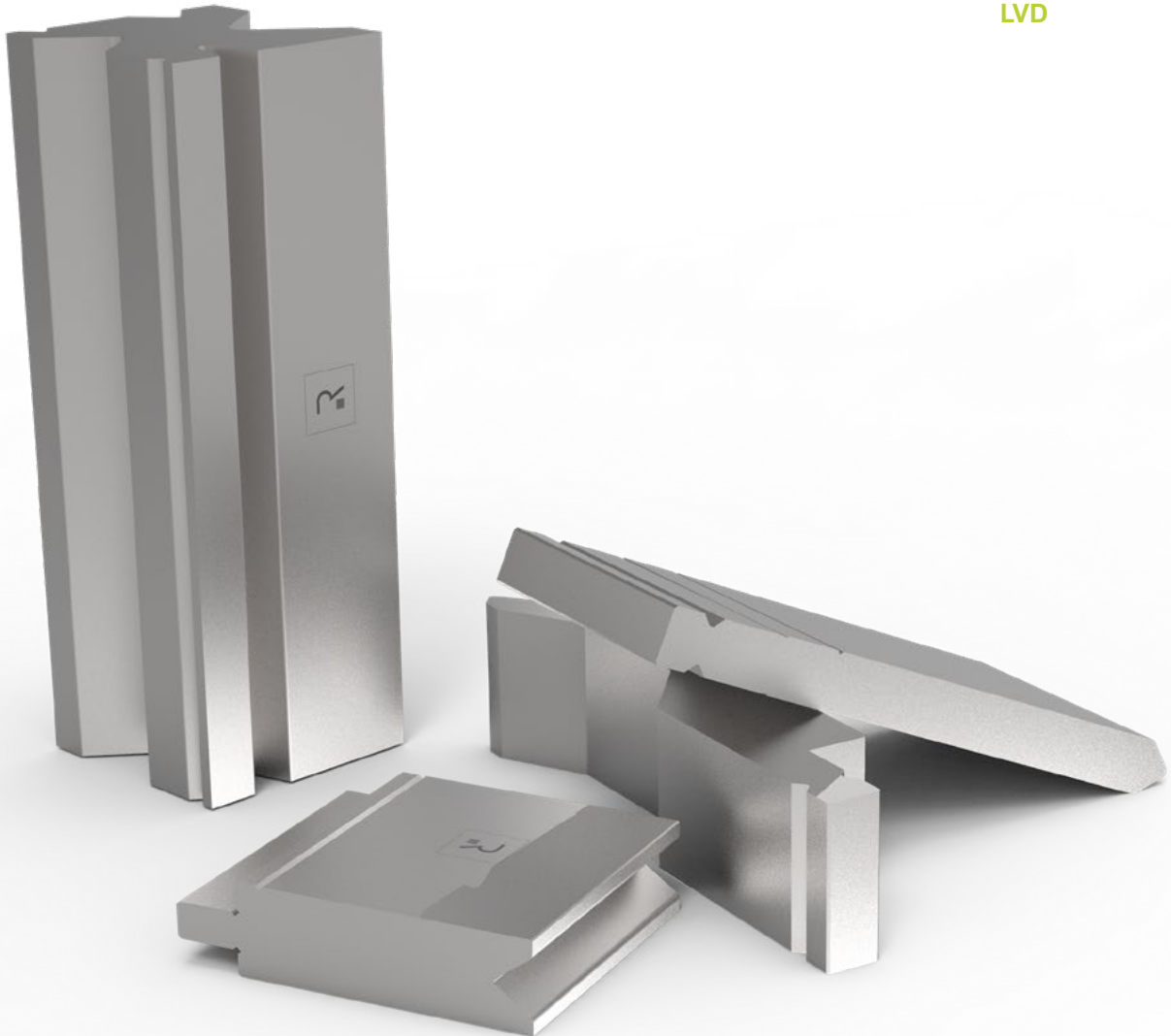
PUNCHING TOOLS - IRON WORKER

SHEAR BLADES

PANEL BENDING TOOLS

BENDING

R4 TOOLS TYPE
LVD





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 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



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
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



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 R4 PUNCHES

8 - PUNCHES: CONTENT EXPLANATION

10 - PUNCHES CLASSIC AND W SERIES

12 - PUNCHES W SERIES

14 - PUNCHES NEW W SERIES

18 - HEMMING TOOLS

20 R4 DIES

22 - DIES: CONTENT EXPLANATION

24 - DIES

31 - MULTI-V DIES

32 - HEMMING DIES

B	LM90.12.30 29	LPA.SP-190-20.12 19	LPW231.78.R2-B 12
BLM90.06.30 28	LM90.12.78 24	LPB180.26.R1 11	LPW231.78.R2-C 12
BLM90.06.78 24	LM90.16.30 29	LPB180.26.R1-A 11	LPW231.78.R3 13
BLM90.08.30 28	LM90.16.78 24	LPB180.78.R1-A 10	LPW231.D15-R1 16
BLM90.08.78 24	LM90.20.30 29	LPB180.78.R1-B 10	LPW231.D15-R2 16
BLM90.10.30 29	LM90.20.78 24	LPB180.78.R1-C 10	LPW231.E15-R1 16
BLM90.10.78 24	LM90.24.30 29	LPB180.78.R2 11	LPW231.E15-R2 16
BLM90.12.30 29	LM90.24.78 24	LPB.SP-190.20.8 19	LPW231.J15-R1 17
BLM90.12.78 24	LM90.30.78 25	LPB.SP-190.20.10 19	LPW231.J15-R2 17
BLM90.16.30 29	LM90.40.78 25	LPB.SP-190.20.12 19	LPW231.R15-R3 17
BLM90.20.30 29	LM90.50.78 25	LPC180.26.R1 11	LPW.SP-190.20.8 19
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BLM90.24.30 29	LM90.80.78 25	LPC180.78.R1-A 10	LPWSP-190.20.12 19
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BLM90.30.78 25	LM130 31	LPC180.78.R1-C 10	
BLM90.40.78 25	LM130.06.30 29	LPC180.78.R2 11	
BLM90.50.78 25	LM130.06.78 26	LPC.SP-190.20.8 19	
BLM90.60.78 25	LM130.08.30 30	LPC.SP-190.20.10 19	
BLM90.80.78 25	LM130.08.78 26	LPC.SP-190.20.12 19	
BLM90.100.78 25	LM130.10.30 30	LPD180.26.R1 11	
BLM130.06.30 29	LM130.10.78 26	LPD180.26.R1-A 11	
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BLM130.10.30 30	LM130.20.30 30	LPD180.78.R2 11	
BLM130.10.78 26	LM130.20.78 26	LPD.SP-190.20.8 19	
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BLM130.12.78 26	LM130.24.78 26	LPD.SP-190.20.12 19	
BLM130.16.30 30	LM130.30.60 27	LPSM-190.20.8-12 33	
BLM130.16.78 26	LM130.30.78 27	LPSM-190.20.8-12.7	
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BLM130.50.60 28	LM130.100.60 28	33	
BLM130.50.78 27	LM130.120.60 28	LPW196.26-R1 11	
BLM130.60.60 28	LM180 31	LPW196.26.R1-A 11	
BLM130.60.78 27	LP180.26-R1 11	LPW196.78.R1-A 10	
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BLM130.100.60 28	LP180.78.R1-B 10	LPW196.78.R2 11	
BLM130.120.60 28	LP180.78.R1-C 10	LPW196.D10-R1 14	
	LP180.78.R2 11	LPW196.D10-R2 14	
	LPA180.26.R1 11	LPW196.E10-R1 14	
L	LPA180.26.R1-A 11	LPW196.E10-R2 14	
LM70 31	LPA180.78.R1-A 10	LPW196.J10-R1 15	
LM90 31	LPA180.78.R1-B 10	LPW196.J10-R2 15	
LM90.06.30 28	LPA180.78.R1-C 10	LPW196.R10-R2 15	
LM90.06.78 24	LPA180.78.R2 11	LPW231.26.R2 13	
LM90.08.30 28	LPA.SP-190-20.8 19	LPW231.26.R2-A 13	
LM90.08.78 24	LPA.SP-190-20.10 19	LPW231.78.R2-A 12	
LM90.10.30 29			
LM90.10.78 24			

R4

PUNCHES

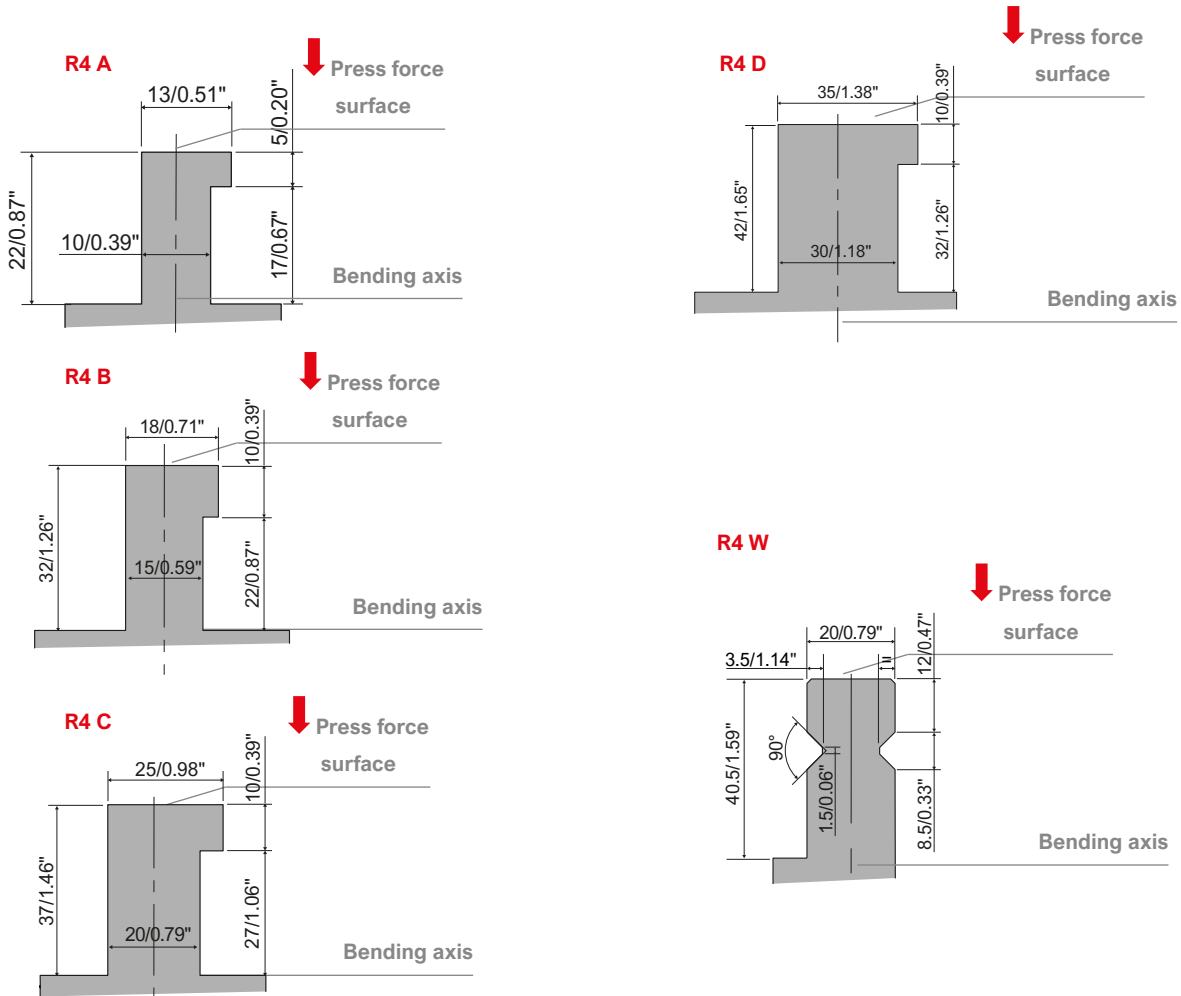
LVD

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





STANDARD TANG



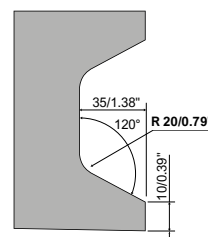
STANDARD LENGTH

	CLASSIC Series	W Series	NEW W Series
508 mm 20.00" (S 1 r 1)	•	•	
510 mm 20.08" (S 1 r 1)			•
525 mm 20.67" (OL 1 r 1)	○	○	○

○ Available only for hemming tools

HORN TYPES

Check the standard horn in each code. All the other horns are available on request based on the Series of the tool - check the feasibility with sales@rolleri.it



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.



SEGMENTATION

Available also special fractioning on request - check the feasibility with sales@rolleri.it

◀ = horn left ▶ = horn right

F: 550 mm - 21.65"

mm: <100-25-30-35-40-45-50-125-100>

in: <3.94-0.98-1.18-1.37-1.57-1.77-1.97-4.92-3.94>



FC: 500 mm - 19.68"

mm: 250-250

in: 9.84-9.84



F (NUOVA Series W): 550 mm - 21.65"

mm: <75-20-20-25-25-30-35-40-40-45-120-75>

in: <2.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95>



F: 495 mm - 19.49"

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

in: 0.98-1.18-1.38-1.57-1.77-1.97-3.94-6.69



FC: 500 mm - 19.68"

mm: 250-250

in: 9.84-9.84



CLAMPING SYSTEMS

QuickLock - standard

- Vertical tool change
- Easy handling
- Reduced setup time and costs
- Standard for tooling weight <12.5kg and segmented sets
- According to local regulation about weight limit to be lifted manually, QL can be applied with extra charge. For further information contact engineering@rolleritools.com



Safety pins - standard

- Horizontal tool change



ROL1 system

- Vertical tool change through spring-loaded ball bearing, which are mounted in the punch
- Increased longevity
- Easy handling
- To be used in hardened clamping systems onlt
- Applicable on tools < 12.5 kg



Ask for our punching tooling, ironworker, laser consumables, panel bending tooling and shear blades catalogues at www.rolleritools.com/download



Click on the QRCode or scan it to watch the video and find out more about the QuickLock.

LP180.78.R1-A

508 mm 20.00" 22 kg
 550 mm 21.65" 23.8 kg F
 2x250 mm 2x9.84" 21.7 kg FC

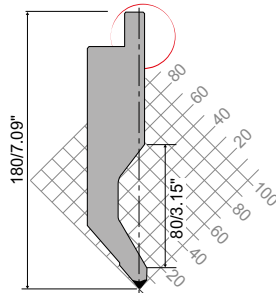
42Cr: 900-1150 N/mm²
 700 kN/m max.
 Horn 1

78°
 H=180 | R=1.0 mm
 H=7.09 | R=0.039 in

CLASSIC Series

- Tang A LPA180.78.R1-A
- Tang B LPB180.78.R1-A
- Tang C LPC180.78.R1-A
- Tang D LPD180.78.R1-A

78° >



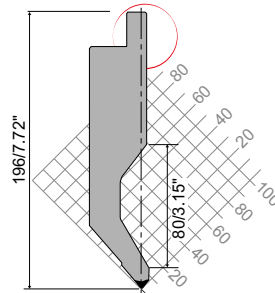
LPW196.78.R1-A

508 mm 20.00" 22 kg
 550 mm 21.65" 23.8 kg F
 2x250 mm 2x9.84" 21.7 kg FC

42Cr: 900-1150 N/mm²
 700 kN/m max.
 Horn 1

78°
 H=196 | R=1.0 mm
 H=7.72 | R=0.039 in

W Series



LP180.78.R1-B

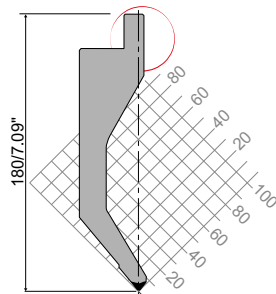
508 mm 20.00" 22 kg
 550 mm 21.65" 24 kg F
 2x250 mm 2x9.84" 21.7 kg FC

42Cr: 900-1150 N/mm²
 450 kN/m max.
 Horn 1

78°
 H=180 | R=1.0 mm
 H=7.09 | R=0.039 in

CLASSIC Series

- Tang A LPA180.78.R1-B
- Tang B LPB180.78.R1-B
- Tang C LPC180.78.R1-B
- Tang D LPD180.78.R1-B



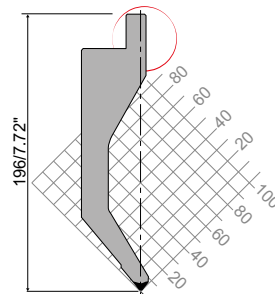
LPW196.78.R1-B

508 mm 20.00" 22 kg
 550 mm 21.65" 24 kg F
 2x250 mm 2x9.84" 21.7 kg FC

42Cr: 900-1150 N/mm²
 450 kN/m max.
 Horn 1

78°
 H=196 | R=1.0 mm
 H=7.72 | R=0.039 in

W Series



LP180.78.R1-C

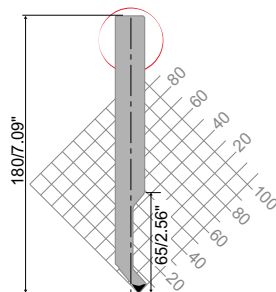
508 mm 20.00" 11 kg
 550 mm 21.65" 12 kg F
 2x250 mm 2x9.84" 10 kg FC

42Cr: 900-1150 N/mm²
 500 kN/m max.
 Horn 1

78°
 H=180 | R=1.0 mm
 H=7.09 | R=0.039 in

Series CLASSIC

- Tang A LPA180.78.R1-C
- Tang B LPB180.78.R1-C
- Tang C LPC180.78.R1-C
- Tang D LPD180.78.R1-C



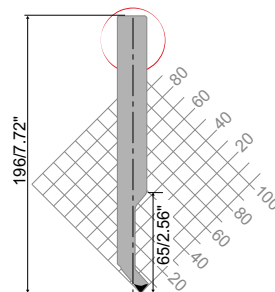
LPW196.78.R1-C

508 mm 20.00" 11 kg
 550 mm 21.65" 12 kg F
 2x250 mm 2x9.84" 10 kg FC

42Cr: 900-1150 N/mm²
 500 kN/m max.
 Horn 1

78°
 H=196 | W=159 | R=1.0 mm
 H=7.72 | W=6.26 | R=0.039 in

W Series



F: 550 mm - 21.65"

mm: <100-25-30-35-40-45-50-125-100>
 in: <3.94-0.98-1.18-1.37-1.57-1.77-1.97-4.92-3.94>



FC: 500 mm - 19.68"

mm: 250-250
 in: 9.84-9.84





LP180.78.R2



508 mm 20.00" 9 kg
 550 mm 21.65" 9.7 kg F
 2x250 mm 2x9.84" 8.9 kg FC

42Cr: 900-1150 N/mm²
 1000 kN/m max.

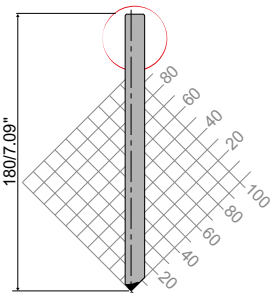
Horn 1

78°

H=180 | R=2.0 mm
 H=7.09 | R=0.079 in

CLASSIC Series

- Tang A LPA180.78.R2
- Tang B LPB180.78.R2
- Tang C LPC180.78.R2
- Tang D LPD180.78.R2



LPW196.78.R2



508 mm 20.00" 9 kg
 550 mm 21.65" 9.7 kg F
 2x250 mm 2x9.84" 8.9 kg FC

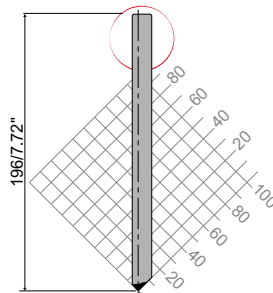
42Cr: 900-1150 N/mm²
 1000 kN/m max.

Horn 1

78°

H=196 | R=2.0 mm
 H=7.72 | R=0.079 in

W Series



LPW196.26-R1



508 mm 20.00" 9 kg
 550 mm 21.65" 10 kg F
 2x250 mm 2x9.84" 8.9 kg FC

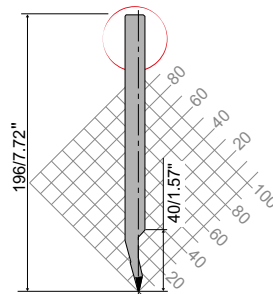
42Cr: 900-1150 N/mm²
 500 kN/m max.

Horn 1

26°

H=196 | R=1.0 mm
 H=7.72 | R=0.039 in

W Series



LP180.26-R1



26° >

508 mm 20.00" 9 kg
 550 mm 21.65" 10 kg F
 2x250 mm 2x9.84" 8.9 kg FC

42Cr: 900-1150 N/mm²
 500 kN/m max.

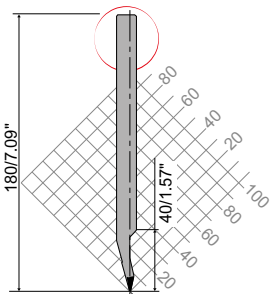
Horn 1

26°

H=180 | R=1.0 mm
 H=7.09 | R=0.039 in

CLASSIC Series

- Tang A LPA180.26.R1
- Tang B LPB180.26.R1
- Tang C LPC180.26.R1
- Tang D LPD180.26.R1



LP180.26.R1-A



508 mm 20.00" 12.5 kg
 550 mm 21.65" 13.5 kg F
 2x250 mm 2x9.84" 12.3 kg FC

42Cr: 900-1150 N/mm²
 400 kN/m max.

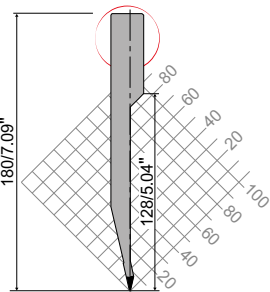
Horn 1

26°

H=180 | R=1.0 mm
 H=7.09 | R=0.039 in

CLASSIC Series

- Tang A LPA180.26.R1-A
- Tang B LPB180.26.R1-A
- Tang C LPC180.26.R1-A
- Tang D LPD180.26.R1-A



LPW196.26.R1-A



508 mm 20.00" 12.5 kg
 550 mm 21.65" 13.5 kg F
 2x250 mm 2x9.84" 12.3 kg FC

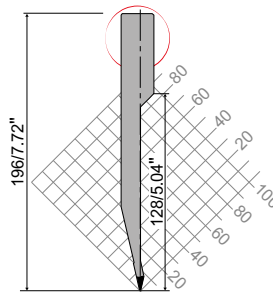
42Cr: 900-1150 N/mm²
 400 kN/m max.

Horn 1

26°

H=196 | R=1.0 mm
 H=7.72 | R=0.039 in

W Series



F: 550 mm - 21.65"

mm: <100-25-30-35-40-45-50-125-100>

in: <3.94-0.98-1.18-1.37-1.57-1.77-1.97-4.92-3.94>



FC: 500 mm - 19.68"

mm: 250-250

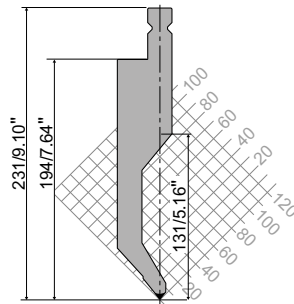
in: 9.84-9.84



LPW231.78.R2-A

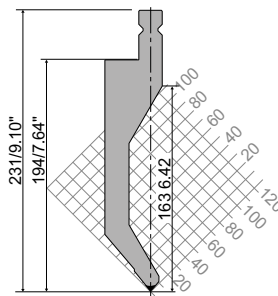
508 mm 20.00" 27.6 kg
 550 mm 21.65" 29.9 kg F
 2x250 mm 2x9.84" 27.2 kg FC

78° >



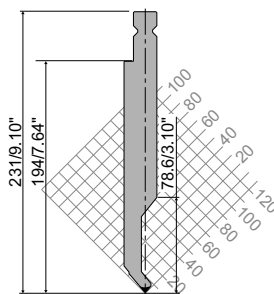
LPW231.78.R2-B

508 mm 20.00" 23.4 kg
 550 mm 21.65" 25.4 kg F
 2x250 mm 2x9.84" 23.1 kg FC



LPW231.78.R2-C

508 mm 20.00" 19.1 kg
 550 mm 21.65" 20.7 kg F
 2x250 mm 2x9.84" 18.8 kg FC



F: 550 mm - 21.65"

mm: <100-25-30-35-40-45-50-125-100>
 in: <3.94-0.98-1.18-1.37-1.57-1.77-1.97-4.92-3.94>



FC: 500 mm - 19.68"

mm: 250-250
 in: 9.84-9.84



LPW231.78.R3

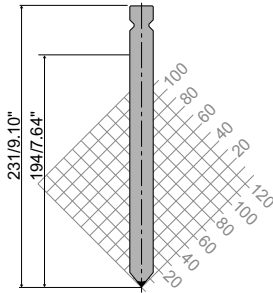
508 mm 20.00" 18.3 kg
 550 mm 21.65" 19.8 kg F
 2x250 mm 2x9.84" 18 kg FC

C45: 560-710 N/mm²
 1200 kN/m max.

Horn 1

78°

W=194 | H=231 | R=3.0 mm
 W=7.64 | H=9.10 | R=0.12 in



LPW231.26.R2-A

508 mm 20.00" 11 kg
 550 mm 21.65" 12 kg F
 2x250 mm 2x9.84" 10 kg FC

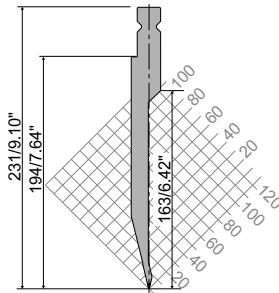
42Cr: 900-1150 N/mm²
 500 kN/m max.

Horn 1

26°

W=194 | H=231 | R=2.0 mm
 W=7.64 | H=9.10 | R=0.079 in

26° >



LPW231.26.R2

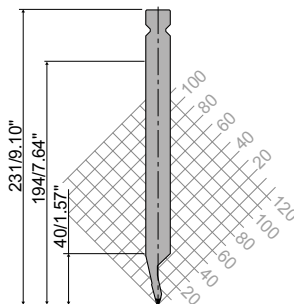
508 mm 20.00" 9 kg
 550 mm 21.65" 9.7 kg F
 2x250 mm 2x9.84" 8.9 kg FC

42Cr: 900-1150 N/mm²
 500 kN/m max.

Horn 1

26°

W=194 | H=231 | R=2.0 mm
 W=7.64 | H=9.10 | R=0.079 in



F: 550 mm - 21.65"

mm: <100-25-30-35-40-45-50-125-100>

in: <3.94-0.98-1.18-1.37-1.57-1.77-1.97-4.92-3.94>



FC: 500 mm - 19.68"

mm: 250-250

in: 9.84-9.84

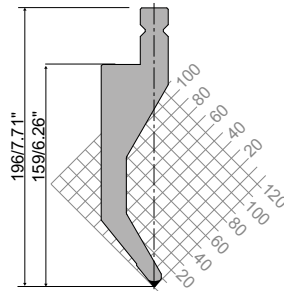




LPW196.D10-R1

510 mm	20.07"	16.3 kg
250 mm	9.84"	16 kg
550 mm	21.65"	17.6 kg F

78° >

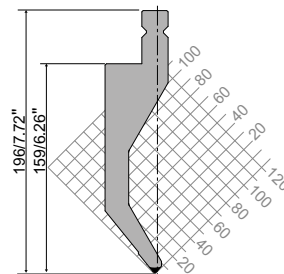


42Cr: 900-1150 N/mm²
400 kN/m max.
Horn 1

78°
W=159 | H=196 | R=1.0 mm
W=6.26 | H=7.71 | R=0.039 in

LPW196.D10-R2

510 mm	20.07"	12.5 kg
250 mm	9.84"	12.3 kg
550 mm	21.65"	13.5 kg F

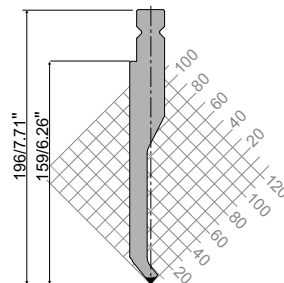


42Cr: 900-1150 N/mm²
750 kN/m max.
Horn 1

78°
W=159 | H=196 | R=1.0 mm
W=6.26 | H=7.71 | R=0.039 in

LPW196.E10-R1

510 mm	20.07"	12.9 kg
250 mm	9.84"	12.7 kg
550 mm	21.65"	14 kg F

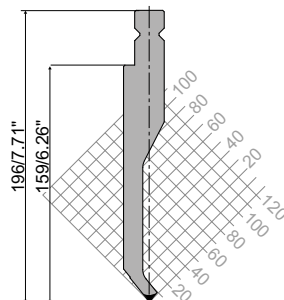


42Cr: 900-1150 N/mm²
400 kN/m max.
Horn 1

78°
W=159 | H=196 | R=1.0 mm
W=6.26 | H=7.71 | R=0.039 in

LPW196.E10-R2

510 mm	20.07"	13.7 kg
250 mm	9.84"	13.5 kg
550 mm	21.65"	14.9 kg F



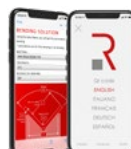
42Cr: 900-1150 N/mm²
680 kN/m max.
Horn 1

78°
W=159 | H=196 | R=2.0 mm
W=6.26 | H=7.71 | R=0.078 in

F: 550 mm - 21.65"

mm: <75-20-20-25-25-30-35-40-40-45-120-75>

in: <42.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95>



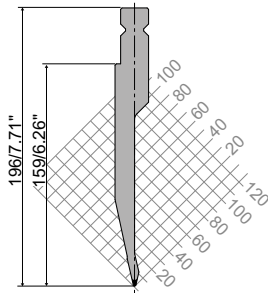
Download Roller Bending App

You will have access to our online store where you can get what you need. You will also get our sheet metal unfolding software for free and our bending rule.

LPW196.J10-R1

510 mm	20.07"	8.8 kg
250 mm	9.84"	8.6 kg
550 mm	21.65"	9.4 kg F

26° >

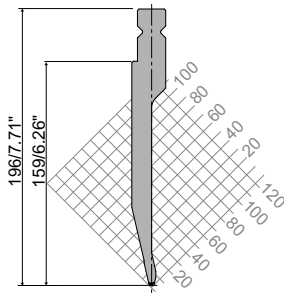


42Cr: 900-1150 N/mm²
400 kN/m max.
Horn 1

26°
W=159 | H=196 | R=1.0 mm
W=6.26 | H=7.71 | R=0.039 in

LPW196.J10-R2

510 mm	20.07"	11.4 kg
250 mm	9.84"	11.2 kg
550 mm	21.65"	12.3 kg F

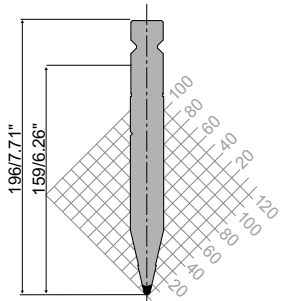


42Cr: 900-1150 N/mm²
600 kN/m max.
Horn 1

26°
W=159 | H=196 | R=2.0 mm
W=6.26 | H=7.71 | R=0.078 in

LPW196.R10-R2

510 mm	20.07"	9 kg
250 mm	9.84"	8.8 kg
550 mm	21.65"	9.8 kg F



42Cr: 900-1150 N/mm²
800 kN/m max.
Horn 1

26°
H=196 | R=2.0 mm
H=7.71 | R=0.078 in

F: 550 mm - 21.65"

mm: <75-20-20-25-25-30-35-40-40-45-120-75>
in: <2.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95>



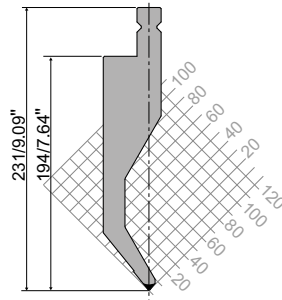
Create your account on www.rolleritools.com

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LPW231.D15-R1

510 mm	20.07"	20.1 kg
250 mm	9.84"	19.8 kg
550 mm	21.65"	21.7 kg F

78° >



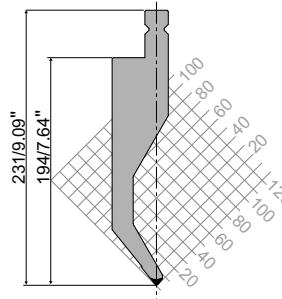
LPW231.D15-R2

510 mm	20.07"	21.9 kg
250 mm	9.84"	21.4 kg
550 mm	21.65"	23.7 kg F

42Cr: 900-1150 N/mm²
750 kN/m max.
Horn 1

78°

W=194 | H=231 | R=2.0 mm
W=7.64 | H=9.09 | R=0.078 in



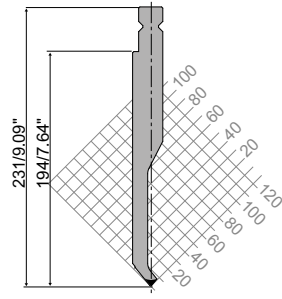
LPW231.E15-R1

510 mm	20.07"	16.5 kg
250 mm	9.84"	16.3 kg
550 mm	21.65"	17.9 kg F

42Cr: 900-1150 N/mm²
400 kN/m max.
Horn 1

78°

W=194 | H=231 | R=1.0 mm
W=7.64 | H=9.09 | R=0.039 in



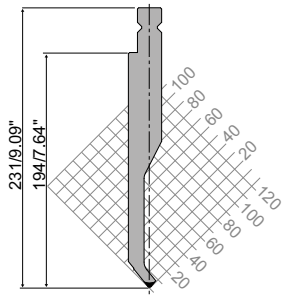
LPW231.E15-R2

510 mm	20.07"	17.6 kg
250 mm	9.84"	17.4 kg
550 mm	21.65"	19 kg F

42Cr: 900-1150 N/mm²
680 kN/m max.
Horn 1

78°

W=194 | H=231 | R=2.0 mm
W=7.64 | H=9.09 | R=0.078 in



F: 550 mm - 21.65"

mm: <75-20-20-25-25-30-35-40-40-45-120-75>

in: <42.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95>



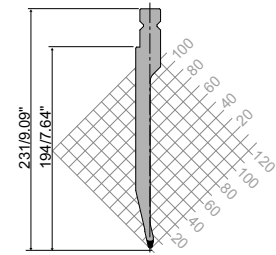
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LPW231.J15-R1

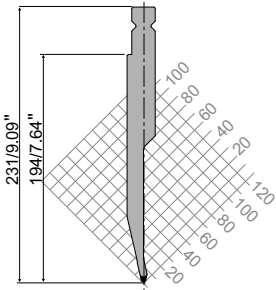
510 mm	20.07"	13.3 kg
250 mm	9.84"	13.1 kg
550 mm	21.65"	14.5 kg F

26° >



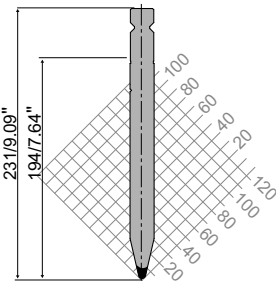
LPW231.J15-R2

510 mm	20.07"	12.1 kg
250 mm	9.84"	12 kg
550 mm	21.65"	13.2 kg F



LPW231.R15-R3

510 mm	20.07"	16.3 kg
250 mm	9.84"	16 kg
550 mm	21.65"	17.6 kg F



F: 550 mm - 21.65"

mm: <75-20-20-25-25-30-35-40-40-45-120-75>
 in: <2.95-0.79-0.79-0.98-0.98-1.18-1.38-1.57-1.57-1.77-4.72-2.95>



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Hemming tools are used to prebend and afterwards flatten a sheet metal edge by using the same tool set.

Thanks to this operation you can strengthen sheet metal edges and avoid burr on their external side. For this reason, this operation is especially used for safety reason, in order to avoid operators' accidental injuries which may occur to those who have to handle sheet metal parts.

The maximum sheet metal thickness usually recommended for this operation is 3mm mild steel and 2mm stainless steel. However, for thicker sheet metal special solutions can be proposed, which consider the necessary bending force involved to flatten.

There are 2 types of flattening: partial flattening and total flattening. Partial flattening is a kind of flattening which doesn't win against the sheet metal springback. For this reason, if you measure the flattened point, it won't be twice the sheet metal thickness but a bigger measure; for example, if you flatten 1.5mm partially, the flattened point will be about 4mm. This dimension depends on the bending force only. Hence, if you want to flatten 1.5mm mild steel and get 3mm high flattened point, you have to increase the tonnage.

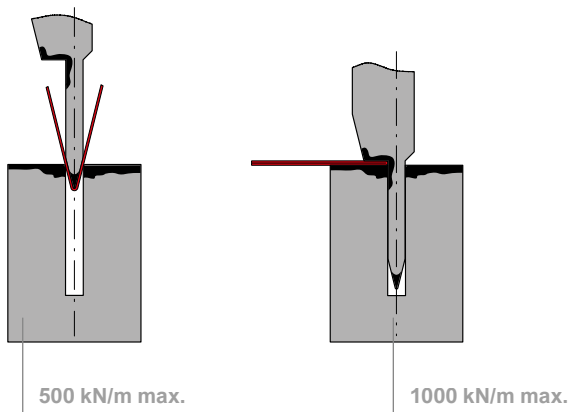
In the table below you can check the necessary tonnage according to sheet metal thickness and type.

The choice of hemming tools should be influenced by the sheet metal type to be flattened; 35° punch and dies are recommended to flatten aluminium and mild steel, which have small springback, whereas more resitant sheet metal types like stainless steel require at least 30°, or better 26°, punch and die.

Springback control is fundamental to win against sheet metal resistance during the flattening phase. In fact, if the angle obtained during the pre-bending phase is too wide, sheet metal will slip towards the operator during the flattening phase.

The choice of TOP Series hemming tools with dies with U shape opening has to take into consideration the fact that the U opening of the die has to match perfectly with the punch tip width. These tools are 525mm long and the sectioned set is also available.

MAX. CAPACITY



S	S	A	A	R.420 N/mm ²	R.700 N/mm ²
mm	in	mm	in	kN/m	kN/m
0.60	0.02	3.0	0.12	90	150
0.80	0.03	3.0	0.12	120	200
1.00	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260



S	S	A	A	R.420 N/mm ²	R.700 N/mm ²
mm	in	mm	in	kN/m	kN/m
0.60	0.02	1.2	0.05	230	350
0.80	0.03	1.6	0.06	320	500
1.00	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800



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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LP.SP-190.20.8

525 mm 20.67" 13.4 kg
 495 mm 19.49" 12.6 kg F
 2x250 mm 2x9.84" 12.8 kg FC

42Cr: 900-1150 N/mm²
 800 - 1000 kN/m max.

20°
 H=168 | R=0.6 mm
 H=6.61 | R=0.024 in

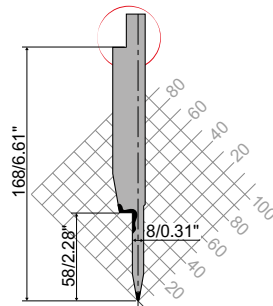
CLASSIC Series

- Tang A **LPA.SP-190-20.8**
- Tang B **LPB.SP-190.20.8**
- Tang C **LPC.SP-190.20.8**
- Tang D **LPD.SP-190.20.8**



To use with:

LPSM-190.20.8-12
LPSM-190.20.8-12.7



LPW.SP-190.20.8

525 mm 20.67" 13.4 kg
 495 mm 19.49" 12.6 kg F
 2x250 mm 2x9.84" 12.8 kg FC

42Cr: 900-1150 N/mm²
 800 - 1000 kN/m max.

20°
 H=168 | R=0.6 mm
 H=6.61 | R=0.024 in

W Series

LP.SP-190.20.10

525 mm 20.67" 13.1 kg
 495 mm 19.49" 12.3 kg F
 2x250 mm 2x9.84" 12.5 kg FC

42Cr: 900-1150 N/mm²
 800 - 1000 kN/m max.

20°
 H=168 | R=0.6 mm
 H=6.61 | R=0.024 in

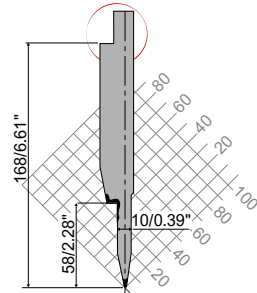
CLASSIC Series

- Tang A **LPA.SP-190-20.10**
- Tang B **LPB.SP-190.20.10**
- Tang C **LPC.SP-190.20.10**
- Tang D **LPD.SP-190.20.10**



To use with:

LPSM-190.20.10-12
LPSM-190.20.10-12.7



LPW.SP-190.20.10

525 mm 20.67" 13.1 kg
 495 mm 19.49" 12.3 kg F
 2x250 mm 2x9.84" 12.5 kg FC

42Cr: 900-1150 N/mm²
 800 - 1000 kN/m max.

20°
 H=168 | R=0.6 mm
 H=6.61 | R=0.024 in

W Series

LP.SP-190.20.12

525 mm 20.67" 13.6 kg
 495 mm 19.49" 12.8 kg F
 2x250 mm 2x9.84" 13 kg FC

42Cr: 900-1150 N/mm²
 800 - 1000 kN/m max.

20°
 H=168 | R=0.6 mm
 H=6.61 | R=0.024 in

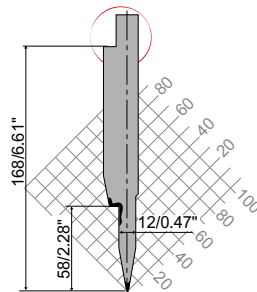
CLASSIC Series

- Tang A **LPA.SP-190-20.12**
- Tang B **LPB.SP-190.20.12**
- Tang C **LPC.SP-190.20.12**
- Tang D **LPD.SP-190.20.12**



To use with:

LPSM-190.20.12-12
LPSM-190.20.12-12.7



LPW.SP-190.20.12

525 mm 20.67" 13.6 kg
 495 mm 19.49" 12.8 kg F
 2x250 mm 2x9.84" 13 kg FC

42Cr: 900-1150 N/mm²
 800 - 1000 kN/m max.

20°
 H=168 | R=0.6 mm
 H=6.61 | R=0.024 in

W Series

F: 495 mm - 19.49"
 mm: 25-30-35-40-45-50-100-170
 in: 0.98-1.18-1.38-1.57 -1.77-1.97-3.94-6.69



FC: 500 mm - 19.68"
 mm: 250-250
 in: 9.84-9.84

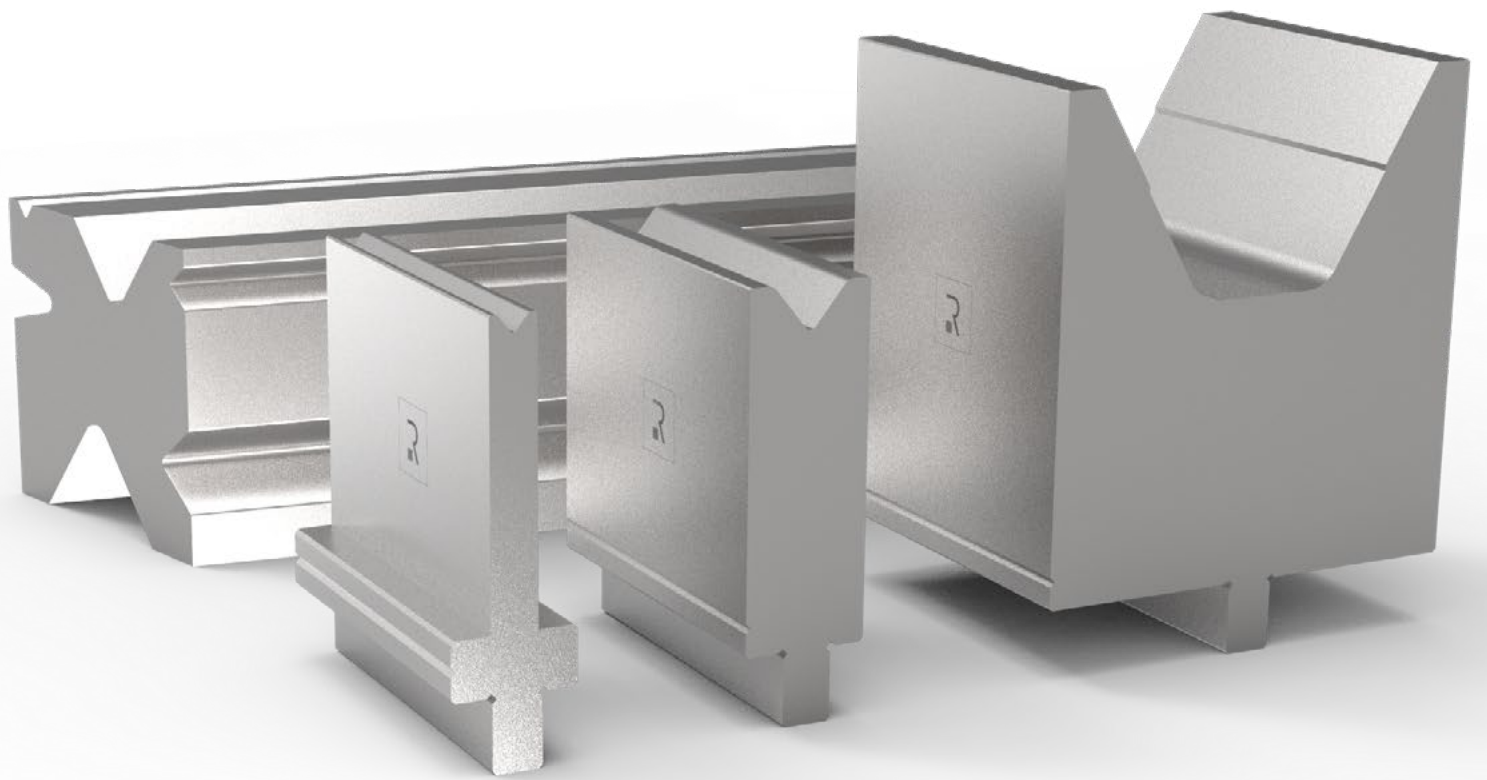


R4

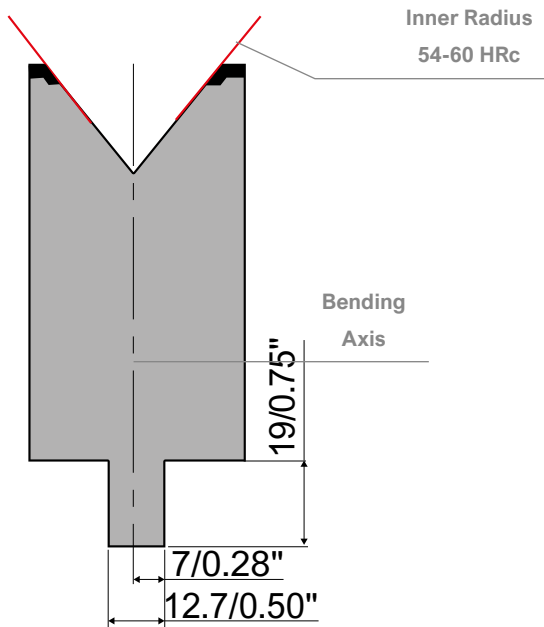
DIES

LVD

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



STANDARD TANG



! Le nuove BLM sono rettificate sui fianchi e compatibili con il sistema di misurazione angolo laser

STANDARD LENGTH

250 mm | 9.84" per nuova linea BLM

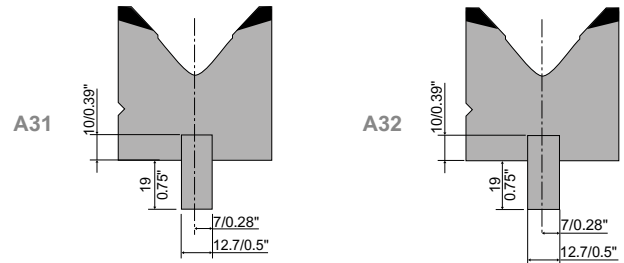
508 mm | 20.00"

510 mm | 20.08" per nuova linea BLM

525 mm | 20.67" Hemming dies

MODIFICATIONS FROM SAFETY GROOVES

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



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.

SEGMENTATION

Available also special fractioning on request - check the feasibility with sales@rolleri.it

F: 550 mm - 21.65"

mm: 25-30-35-40-45-50-100-100-125

in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94-4.92



FC: 500 mm - 19.68"

mm: 250-250

in: 9.84-9.84



FB: 550 mm - 21.65"

mm: 20-20-25-25-30-35-40-40-45-75-75-120

in: 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72



F: 495 mm - 19.48"

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

in: 6.69-3.94-1.97-1.77-1.57-1.37-1.18-0.98



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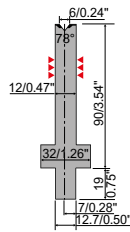


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LM90.06.78 / BLM90.06.78

508 mm	20.00"	8 kg
550 mm	21.65"	8.6 kg F
2x250 mm	43.31"	7.9 kg FC
510 mm	20.08"	8.0 kg
250 mm	9.84"	3.9 kg
550 mm	21.65"	8.7 kg FB

78° >



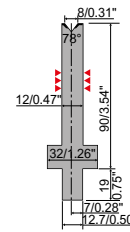
42Cr: 900-1150 N/mm²
400 kN/m max.

78°
W=90 | R=1.0 | V=6 mm
W=3.54 | R=0.03 | V=0.24 in



LM90.08.78 / BLM90.08.78

508 mm	20.00"	8 kg
550 mm	21.65"	8.6 kg F
2x250 mm	43.31"	7.9 kg FC
510 mm	20.08"	8.0 kg
250 mm	9.84"	3.9 kg
550 mm	21.65"	8.7 kg FB

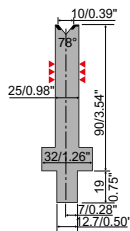


42Cr: 900-1150 N/mm²
400 kN/m max.

78°
W=90 | R=1.0 | V=8 mm
W=3.54 | R=0.03 | V=0.31 in

LM90.10.78 / BLM90.10.78

508 mm	20.00"	8 kg
550 mm	21.65"	8.6 kg F
2x250 mm	43.31"	7.9 kg FC
510 mm	20.08"	8.0 kg
250 mm	9.84"	3.9 kg
550 mm	21.65"	8.7 kg FB

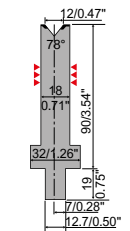


42Cr: 900-1150 N/mm²
500 kN/m max.

78°
W=90 | R=1.0 | V=10 mm
W=3.54 | R=0.03 | V=0.39 in

LM90.12.78 / BLM90.12.78

508 mm	20.00"	8 kg
550 mm	21.65"	8.6 kg F
2x250 mm	43.31"	7.9 kg FC
510 mm	20.08"	8.0 kg
250 mm	9.84"	3.9 kg
550 mm	21.65"	8.7 kg FB

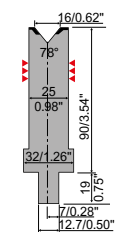


42Cr: 900-1150 N/mm²
600 kN/m max.

78°
W=90 | R=2.0 | V=12 mm
W=3.54 | R=0.07 | V=0.47 in

LM90.16.78 / BLM90.16.78

508 mm	20.00"	10 kg
550 mm	21.65"	10.8 kg F
2x250 mm	43.31"	9.9 kg FC
510 mm	20.08"	10.0 kg
250 mm	9.84"	4.9 kg
550 mm	21.65"	10.8 kg FB

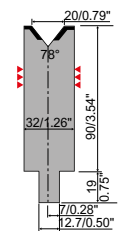


42Cr: 900-1150 N/mm²
800 kN/m max.

78°
W=90 | R=2.5 | V=16 mm
W=3.54 | R=0.09 | V=0.63 in

LM90.20.78 / BLM90.20.78

508 mm	20.00"	11.9 kg
550 mm	21.65"	12.8 kg F
2x250 mm	43.31"	11.8 kg FC
510 mm	20.08"	11.9 kg
250 mm	9.84"	5.9 kg
550 mm	21.65"	12.9 kg FB

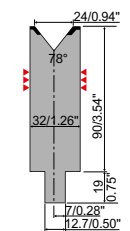


42Cr: 900-1150 N/mm²
1000 kN/m max.

78°
W=90 | R=3.0 | V=20 mm
W=3.54 | R=0.11 | V=0.79 in

LM90.24.78 / BLM90.24.78

508 mm	20.00"	10 kg
550 mm	21.65"	10.8 kg F
2x250 mm	43.31"	9.9 kg FC
510 mm	20.08"	10.0 kg
250 mm	9.84"	4.9 kg
550 mm	21.65"	10.8 kg FB



42Cr: 900-1150 N/mm²
1100 kN/m max.

78°
W=90 | R=3.0 | V=24 mm
W=3.54 | R=0.11 | V=0.94 in

F: 550 mm - 21.65"

mm: 25-30-35-40-45-50-100-100-125
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94-4.92

FC: 500 mm - 19.68"

mm: 250-250
in: 9.84-9.84



LM90.30.78 / BLM90.30.78

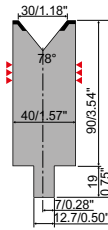


508 mm 20.00" 12 kg
 550 mm 21.65" 13 kg F
 2x250 mm 43.31" 11.8 kg FC
 510 mm 20.08" 12.0 kg
 250 mm 9.84" 5.9 kg
 550 mm 21.65" 13.0 kg FB

42Cr: 900-1150 N/mm²
 1100 kN/m max.

78°

W=90 | R=3.0 | V=30 mm
 W=3.54 | R=0.11 | V=1.18 in



LM90.40.78 / BLM90.40.78

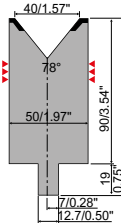


508 mm 20.00" 13 kg
 550 mm 21.65" 14 kg F
 2x250 mm 43.31" 12.8 kg FC
 510 mm 20.08" 13.1 kg
 250 mm 9.84" 6.4 kg
 550 mm 21.65" 14.1 kg FB

42Cr: 900-1150 N/mm²
 1300 kN/m max.

78°

W=90 | R=4.0 | V=40 mm
 W=3.54 | R=0.15 | V=1.57 in



LM90.50.78 / BLM90.50.78

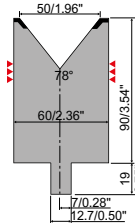
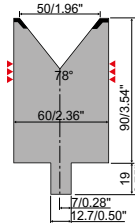


508 mm 20.00" 19.5 kg
 550 mm 21.65" 21 kg F
 2x250 mm 43.31" 19.2 kg FC
 510 mm 20.08" 19.6 kg
 250 mm 9.84" 9.6 kg
 550 mm 21.65" 21.1 kg FB

42Cr: 900-1150 N/mm²
 1500 kN/m max.

78°

W=90 | R=4.0 | V=50 mm
 W=3.54 | R=0.15 | V=1.97 in



LM90.60.78 / BLM90.60.78

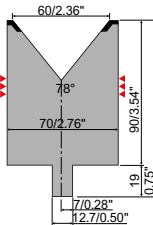


508 mm 20.00" 23 kg
 550 mm 21.65" 24.9 kg F
 2x250 mm 43.31" 22.7 kg FC
 510 mm 20.08" 23.1 kg
 250 mm 9.84" 11.3 kg
 550 mm 21.65" 24.9 kg FB

42Cr: 900-1150 N/mm²
 1500 kN/m max.

78°

W=90 | R=5.0 | V=60 mm
 W=3.54 | R=0.19 | V=2.36 in



LM90.80.78 / BLM90.80.78

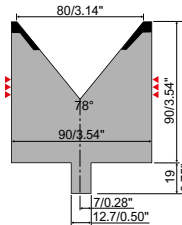
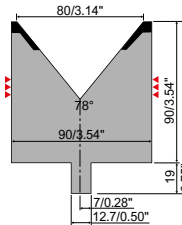


508 mm 20.00" 25.5 kg
 550 mm 21.65" 27.6 kg F
 2x250 mm 43.31" 25.1 kg FC
 510 mm 20.08" 25.6 kg
 250 mm 9.84" 12.5 kg
 550 mm 21.65" 27.6 kg FB

42Cr: 900-1150 N/mm²
 1500 kN/m max.

78°

W=90 | R=5.0 | V=80 mm
 W=3.54 | R=0.19 | V=3.15 in



LM90.100.78 / BLM90.100.78

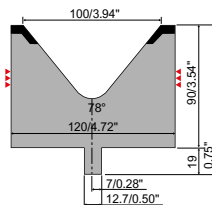


508 mm 20.00" 31 kg
 550 mm 21.65" 33.5 kg F
 2x250 mm 43.31" 30.6 kg FC
 510 mm 20.08" 31.1 kg
 250 mm 9.84" 15.3 kg
 550 mm 21.65" 33.6 kg FB

42Cr: 900-1150 N/mm²
 1200 kN/m max.

78°

W=90 | R=8.0 | V=100 mm
 W=3.54 | R=0.31 | V=3.94 in



FB: 550 mm - 21.65"

mm: 20-20-25-25-30-35-40-40-45-75-75-120

in: 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72



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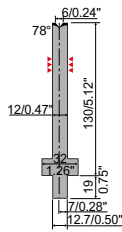
LM130.06.78 / BLM130.06.78



508 mm	20.00"	8.3 kg
550 mm	21.65"	9 kg F
2x250 mm	43.31"	8.2 kg FC
510 mm	20.08"	8.3 kg
250 mm	9.84"	4.1 kg
550 mm	21.65"	9.0 kg FB

42Cr: 900-1150 N/mm²
400 kN/m max.

78°
W=130 | R=1.0 | V=6 mm
W=5.12 | R=0.31 | V=0.23 in



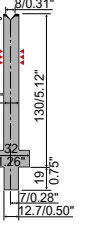
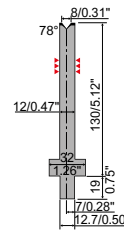
LM130.08.78 / BLM130.08.78



508 mm	20.00"	8.4 kg
550 mm	21.65"	9.1 kg F
2x250 mm	43.31"	8.3 kg FC
510 mm	20.08"	8.4 kg
250 mm	9.84"	4.1 kg
550 mm	21.65"	9.1 kg FB

42Cr: 900-1150 N/mm²
400 kN/m max.

78°
W=130 | R=1.0 | V=8 mm
W=5.12 | R=0.03 | V=0.31 in



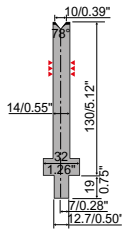
LM130.10.78 / BLM130.10.78



508 mm	20.00"	10.1 kg
550 mm	21.65"	11 kg F
2x250 mm	43.31"	10 kg FC
510 mm	20.08"	10.1 kg
250 mm	9.84"	5.0 kg
550 mm	21.65"	10.9 kg FB

42Cr: 900-1150 N/mm²
500 kN/m max.

78°
W=130 | R=1.0 | V=10 mm
W=5.12 | R=0.03 | V=0.39 in



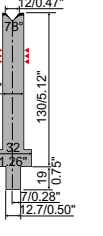
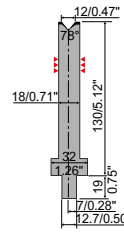
LM130.12.78 / BLM130.12.78



508 mm	20.00"	11.1 kg
550 mm	21.65"	12 kg F
2x250 mm	43.31"	10.9 kg FC
510 mm	20.08"	11.1 kg
250 mm	9.84"	5.5 kg
550 mm	21.65"	12.0 kg FB

42Cr: 900-1150 N/mm²
600 kN/m max.

78°
W=130 | R=2.0 | V=12 mm
W=5.12 | R=0.07 | V=0.47 in



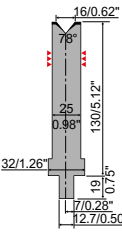
LM130.16.78 / BLM130.16.78



508 mm	20.00"	14.3 kg
550 mm	21.65"	15.5 kg F
2x250 mm	43.31"	14.1 kg FC
510 mm	20.08"	14.4 kg
250 mm	9.84"	7.0 kg
550 mm	21.65"	15.5 kg FB

42Cr: 900-1150 N/mm²
800 kN/m max.

78°
W=130 | R=2.5 | V=16 mm
W=5.12 | R=0.09 | V=0.63 in



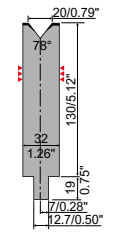
LM130.20.78 / BLM130.20.78



508 mm	20.00"	17.5 kg
550 mm	21.65"	19 kg F
2x250 mm	43.31"	17.2 kg FC
510 mm	20.08"	17.6 kg
250 mm	9.84"	8.6 kg
550 mm	21.65"	18.9 kg FB

42Cr: 900-1150 N/mm²
1000 kN/m max.

78°
W=130 | R=3.0 | V=20 mm
W=5.12 | R=0.11 | V=0.79 in



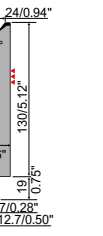
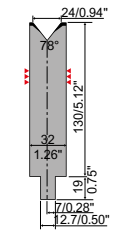
LM130.24.78 / BLM130.24.78



508 mm	20.00"	17 kg
550 mm	21.65"	18.5 kg F
2x250 mm	43.31"	16.8 kg FC
510 mm	20.08"	17.1 kg
250 mm	9.84"	8.4 kg
550 mm	21.65"	18.4 kg FB

42Cr: 900-1150 N/mm²
1000 kN/m max.

78°
W=130 | R=3.0 | V=24 mm
W=5.12 | R=0.11 | V=0.94 in



F: 550 mm - 21.65"

mm: 25-30-35-40-45-50-100-100-125

in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94-4.92

FC: 500 mm - 19.68"

mm: 250-250

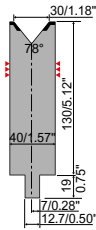
in: 9.84-9.84



LM130.30.78 / BLM130.30.78



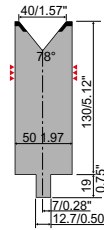
508 mm 20.00" 20.7 kg
 550 mm 21.65" 22.4 kg F
 2x250 mm 43.31" 20.4 kg FC
 510 mm 20.08" 20.8 kg
 250 mm 9.84" 10.2 kg
 550 mm 21.65" 22.4 kg FB



LM130.40.78 / BLM130.40.78



508 mm 20.00" 26.6 kg
 550 mm 21.65" 28.9 kg F
 2x250 mm 43.31" 26.2 kg FC
 510 mm 20.08" 26.7 kg
 250 mm 9.84" 13.1 kg
 550 mm 21.65" 28.8 kg FB



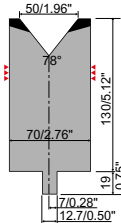
42Cr: 900-1150 N/mm²
 1300 kN/m max.

78°
 W=130 | R=4.0 | V=40 mm
 W=5.12 | R=0.15 | V=1.57 in

LM130.50.78 / BLM130.50.78



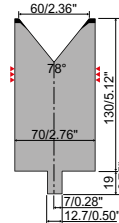
508 mm 20.00" 34.2 kg
 550 mm 21.65" 37 kg F
 2x250 mm 43.31" 33.6 kg FC
 510 mm 20.08" 34.3 kg
 250 mm 9.84" 16.8 kg
 550 mm 21.65" 37.0 kg FB



LM130.60.78 / BLM130.60.78



508 mm 20.00" 34.2 kg
 550 mm 21.65" 37 kg F
 2x250 mm 43.31" 33.6 kg FC
 510 mm 20.08" 34.3 kg
 250 mm 9.84" 16.8 kg
 550 mm 21.65" 37.0 kg FB



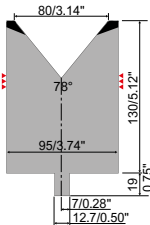
42Cr: 900-1150 N/mm²
 1500 kN/m max.

78°
 W=130 | R=5.0 | V=60 mm
 W=5.12 | R=0.19 | V=2.36 in

LM130.80.78 / BLM130.80.78



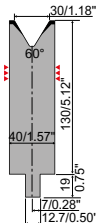
508 mm 20.00" 42.3 kg
 550 mm 21.65" 45.8 kg F
 2x250 mm 43.31" 41.6 kg FC
 510 mm 20.08" 42.5 kg
 250 mm 9.84" 20.8 kg
 550 mm 21.65" 45.8 kg FB



LM130.30.60 / BLM130.30.60



508 mm 20.00" 20.4 kg
 550 mm 21.65" 22.1 kg F
 2x250 mm 43.31" 20.1 kg FC
 510 mm 20.08" 20.5 kg
 250 mm 9.84" 10.0 kg
 550 mm 21.65" 22.1 kg FB



42Cr: 900-1150 N/mm²
 500 kN/m max.

60°
 W=130 | R=3.0 | V=30 mm
 W=5.12 | R=0.11 | V=1.18 in

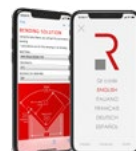
FB: 550 mm - 21.65"

mm: 20-20-25-25-30-35-40-40-45-75-75-120

in: 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72



Download Roller 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.

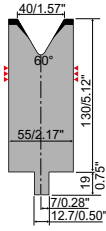
LM130.40.60 / BLM130.40.60



508 mm	20.00"	26.8 kg
550 mm	21.65"	29.1 kg F
2x250 mm	43.31"	26.4 kg FC
510 mm	20.08"	26.9 kg
250 mm	9.84"	13.2 kg
550 mm	21.65"	29.0 kg FB

42Cr: 900-1150 N/mm²
660 kN/m max.

60°
W=130 | R=5.0 | V=40 mm
W=5.12 | R=0.19 | V=1.57 in



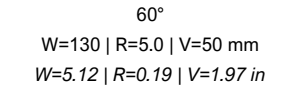
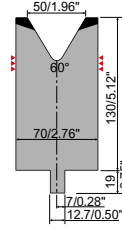
LM130.50.60 / BLM130.50.60



508 mm	20.00"	33 kg
550 mm	21.65"	35.7 kg F
2x250 mm	43.31"	32.5 kg FC
510 mm	20.08"	33.1 kg
250 mm	9.84"	16.2 kg
550 mm	21.65"	35.7 kg FB

42Cr: 900-1150 N/mm²
1050 kN/m max.

60°
W=130 | R=5.0 | V=50 mm
W=5.12 | R=0.19 | V=1.97 in



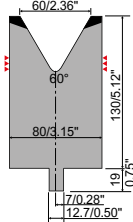
LM130.60.60 / BLM130.60.60



508 mm	20.00"	36.5 kg
550 mm	21.65"	39.6 kg F
2x250 mm	43.31"	36 kg FC
510 mm	20.08"	36.6 kg
250 mm	9.84"	18.0 kg
550 mm	21.65"	39.5 kg FB

42Cr: 900-1150 N/mm²
1200 kN/m max.

60°
W=130 | R=7.0 | V=60 mm
W=5.12 | R=0.27 | V=2.36 in



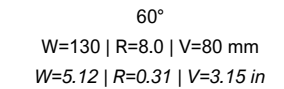
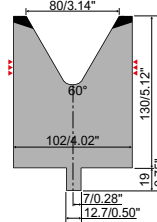
LM130.80.60 / BLM130.80.60



508 mm	20.00"	43 kg
550 mm	21.65"	46.6 kg F
2x250 mm	43.31"	42.4 kg FC
510 mm	20.08"	43.2 kg
250 mm	9.84"	21.2 kg
550 mm	21.65"	46.6 kg FB

42Cr: 900-1150 N/mm²
1750 kN/m max.

60°
W=130 | R=8.0 | V=80 mm
W=5.12 | R=0.31 | V=3.15 in



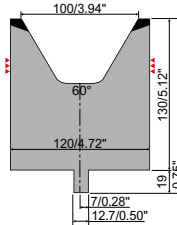
LM130.100.60 / BLM130.100.60



508 mm	20.00"	47.6 kg
550 mm	21.65"	51.5 kg F
2x250 mm	43.31"	46.8 kg FC
510 mm	20.08"	47.7 kg
250 mm	9.84"	23.4 kg
550 mm	21.65"	51.4 kg FB

42Cr: 900-1150 N/mm²
1600 kN/m max.

60°
W=130 | R=8.0 | V=100 mm
W=5.12 | R=0.31 | V=3.94 in



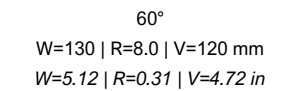
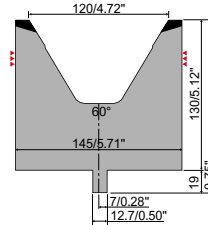
LM130.120.60 / BLM130.120.60



508 mm	20.00"	51 kg
550 mm	21.65"	55.2 kg F
2x250 mm	43.31"	50.2 kg FC
510 mm	20.08"	51.2 kg
250 mm	9.84"	25.1 kg
550 mm	21.65"	55.2 kg FB

42Cr: 900-1150 N/mm²
1300 kN/m max.

60°
W=130 | R=8.0 | V=120 mm
W=5.12 | R=0.31 | V=4.72 in



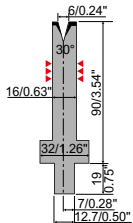
LM90.06.30 / BLM90.06.30



508 mm	20.00"	8 kg
550 mm	21.65"	8.6 kg F
2x250 mm	43.31"	7.9 kg FC
510 mm	20.08"	8.0 kg
250 mm	9.84"	3.9 kg
550 mm	21.65"	8.7 kg FB

42Cr: 900-1150 N/mm²
200 kN/m max.

30°
W=90 | R=8.0 | V=6 mm
W=3.54 | R=0.31 | V=0.24 in



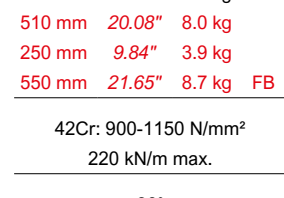
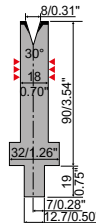
LM90.08.30 / BLM90.08.30



508 mm	20.00"	8 kg
550 mm	21.65"	8.6 kg F
2x250 mm	43.31"	7.9 kg FC
510 mm	20.08"	8.0 kg
250 mm	9.84"	3.9 kg
550 mm	21.65"	8.7 kg FB

42Cr: 900-1150 N/mm²
220 kN/m max.

30°
W=90 | R=1.0 | V=8 mm
W=3.54 | R=0.03 | V=0.31 in



F: 550 mm - 21.65"

mm: 25-30-35-40-45-50-100-100-125
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94-4.92

FC: 500 mm - 19.68"

mm: 250-250
in: 9.84-9.84



LM90.10.30 / BLM90.10.30

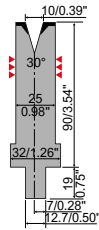


508 mm	20.00"	8 kg
550 mm	21.65"	8.6 kg F
2x250 mm	43.31"	7.9 kg FC
510 mm	20.08"	8.0 kg
250 mm	9.84"	3.9 kg
550 mm	21.65"	8.7 kg FB

42Cr: 900-1150 N/mm²
300 kN/m max.

30°

W=90 | R=1.2 | V=10 mm
W=3.54 | R=0.04 | V=0.39 in



LM90.12.30 / BLM90.12.30

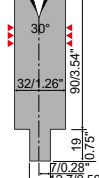
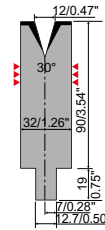


508 mm	20.00"	11.9 kg
550 mm	21.65"	12.6 kg F
2x250 mm	43.31"	11.8 kg FC
510 mm	20.08"	11.9 kg
250 mm	9.84"	5.9 kg
550 mm	21.65"	12.9 kg FB

42Cr: 900-1150 N/mm²
380 kN/m max.

30°

W=90 | R=1.2 | V=12 mm
W=3.54 | R=0.04 | V=0.47 in



LM90.16.30 / BLM90.16.30

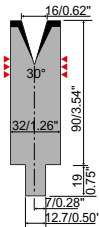


508 mm	20.00"	11.5 kg
550 mm	21.65"	12.4 kg F
2x250 mm	43.31"	11.4 kg FC
510 mm	20.08"	11.5 kg
250 mm	9.84"	5.7 kg
550 mm	21.65"	12.5 kg FB

42Cr: 900-1150 N/mm²
380 kN/m max.

30°

W=90 | R=3.0 | V=16 mm
W=3.54 | R=0.11 | V=0.63 in



LM90.20.30 / BLM90.20.30

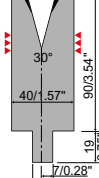
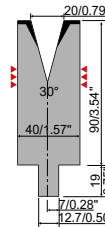


508 mm	20.00"	13.8 kg
550 mm	21.65"	15 kg F
2x250 mm	43.31"	13.6 kg FC
510 mm	20.08"	13.9 kg
250 mm	9.84"	6.8 kg
550 mm	21.65"	14.9 kg FB

42Cr: 900-1150 N/mm²
380 kN/m max.

30°

W=90 | R=3.0 | V=20 mm
W=3.54 | R=0.11 | V=0.79 in



LM90.24.30 / BLM90.24.30

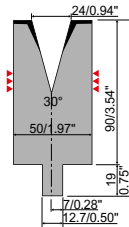


508 mm	20.00"	13 kg
550 mm	21.65"	14 kg F
2x250 mm	43.31"	12.8 kg FC
510 mm	20.08"	13.1 kg
250 mm	9.84"	6.4 kg
550 mm	21.65"	14.1 kg FB

42Cr: 900-1150 N/mm²
550 kN/m max.

30°

W=90 | R=3.0 | V=24 mm
W=3.54 | R=0.11 | V=0.94 in



LM130.06.30 / BLM130.06.30

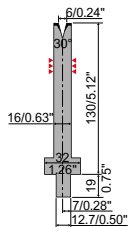


508 mm	20.00"	10 kg
550 mm	21.65"	10.8 kg F
2x250 mm	43.31"	9.8 kg FC
510 mm	20.08"	10.0 kg
250 mm	9.84"	4.9 kg
550 mm	21.65"	10.8 kg FB

42Cr: 900-1150 N/mm²
200 kN/m max.

30°

W=130 | R=0.8 | V=6 mm
W=5.12 | R=0.03 | V=0.24 in



FB: 550 mm - 21.65"

mm: 20-20-25-25-30-35-40-40-45-75-75-120

in: 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72



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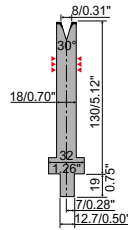
LM130.08.30 / BLM130.08.30



508 mm	20.00"	10.9 kg
550 mm	21.65"	11.8 kg F
2x250 mm	43.31"	10.7 kg FC
510 mm	20.08"	10.9 kg
250 mm	9.84"	5.4 kg
550 mm	21.65"	11.8 kg FB

42Cr: 900-1150 N/mm²
220 kN/m max.

30°
W=130 | R=1.0 | V=8 mm
W=5.12 | R=0.03 | V=0.31 in



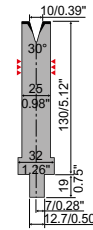
LM130.10.30 / BLM130.10.30



508 mm	20.00"	14 kg
550 mm	21.65"	15.1 kg F
2x250 mm	43.31"	13.8 kg FC
510 mm	20.08"	14.1 kg
250 mm	9.84"	6.9 kg
550 mm	21.65"	15.2 kg FB

42Cr: 900-1150 N/mm²
300 kN/m max.

30°
W=130 | R=1.2 | V=10 mm
W=5.12 | R=0.04 | V=0.39 in



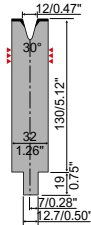
LM130.12.30 / BLM130.12.30



508 mm	20.00"	17.1 kg
550 mm	21.65"	18.5 kg F
2x250 mm	43.31"	16.9 kg FC
510 mm	20.08"	17.2 kg
250 mm	9.84"	8.4 kg
550 mm	21.65"	18.5 kg FB

42Cr: 900-1150 N/mm²
380 kN/m max.

30°
W=130 | R=2.0 | V=12 mm
W=5.12 | R=0.07 | V=0.47 in



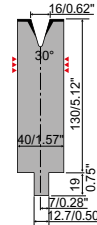
LM130.16.30 / BLM130.16.30



508 mm	20.00"	20.8 kg
550 mm	21.65"	22.6 kg F
2x250 mm	43.31"	20.5 kg FC
510 mm	20.08"	20.9 kg
250 mm	9.84"	10.2 kg
550 mm	21.65"	22.5 kg FB

42Cr: 900-1150 N/mm²
380 kN/m max.

30°
W=130 | R=3.0 | V=16 mm
W=5.12 | R=0.11 | V=0.63 in



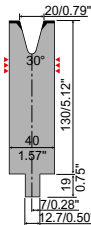
LM130.20.30 / BLM130.20.30



508 mm	20.00"	20.3 kg
550 mm	21.65"	22 kg F
2x250 mm	43.31"	20 kg FC
510 mm	20.08"	20.4 kg
250 mm	9.84"	10.0 kg
550 mm	21.65"	22.0 kg FB

42Cr: 900-1150 N/mm²
380 kN/m max.

30°
W=130 | R=3.0 | V=20 mm
W=5.12 | R=0.11 | V=0.79 in



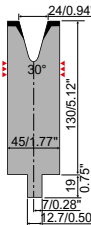
LM130.24.30 / BLM130.24.30



508 mm	20.00"	24.4 kg
550 mm	21.65"	26.4 kg F
2x250 mm	43.31"	24 kg FC
510 mm	20.08"	24.5 kg
250 mm	9.84"	12.0 kg
550 mm	21.65"	26.4 kg FB

42Cr: 900-1150 N/mm²
550 kN/m max.

30°
W=130 | R=3.0 | V=24 mm
W=5.12 | R=0.11 | V=0.94 in



F: 550 mm - 21.65"

mm: 25-30-35-40-45-50-100-100-125
in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94-4.92

FC: 500 mm - 19.68"

mm: 250-250
in: 9.84-9.84





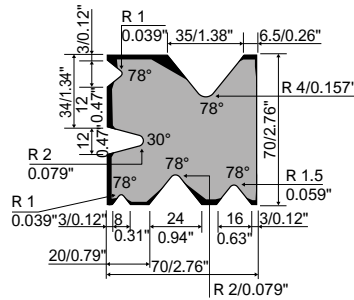
LM70



508 mm 20.00" 16.8 kg
550 mm 21.65" 18.2 kg F

42Cr: 900-1150 N/mm²

V	mm	12	8	12	16	24	35
	in	0.47	0.31	0.47	0.62	0.94	1.37
°		30°	78°	78°	78°	78°	78°
kN/m max.		1300	950	600	950	1200	1300



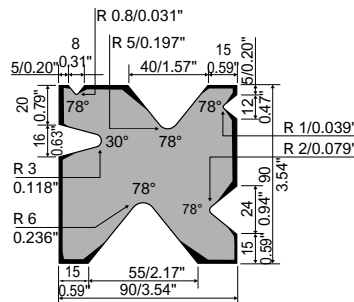
LM90



508 mm 20.00" 25.4 kg
550 mm 21.65" 27.5 kg F

42Cr: 900-1150 N/mm²

V	mm	16	8	12	24	40	55
	in	0.62	0.31	0.47	0.94	1.57	2.16
°		30°	78°	78°	78°	78°	78°
kN/m max.		1000	550	550	650	1400	1000



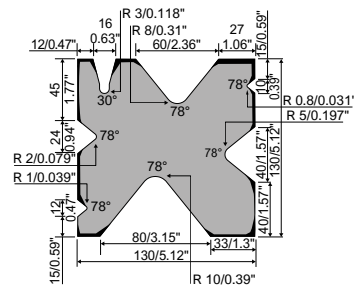
LM130



508 mm 20.00" 51.8 kg
550 mm 21.65" 56.1 kg F

42Cr: 900-1150 N/mm²

V	mm	16	10	12	24	40	60	80
	in	0.62	0.39	0.47	0.94	1.57	2.36	3.14
°		30°	78°	78°	78°	78°	78°	78°
kN/m max.		650	650	480	1500	1500	1500	1250



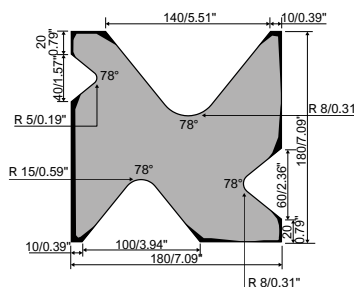
LM180



508 mm 20.00" 25.4 kg
550 mm 21.65" 27.5 kg F

42Cr: 900-1150 N/mm²

V	mm	140	60	100	40
	in	5.51	2.36	3.94	1.57
°		78°	78°	78°	78°
kN/m max.		550	650	700	320



FB: 550 mm - 21.65"

mm: 20-20-25-25-30-35-40-40-45-75-75-120

in: 0.79-0.79-0.98-0.98-1.18-1.37-1.57-1.57-1.77-2.95-2.95-4.72

F: 550 mm - 21.65"

mm: 25-30-35-40-45-50-100-100-125

in: 0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94-4.92



Hemming tools are used to prebend and afterwards flatten a sheet metal edge by using the same tool set.

Thanks to this operation you can strengthen sheet metal edges and avoid burr on their external side. For this reason, this operation is especially used for safety reason, in order to avoid operators' accidental injuries which may occur to those who have to handle sheet metal parts.

The maximum sheet metal thickness usually recommended for this operation is 3mm mild steel and 2mm stainless steel. However, for thicker sheet metal special solutions can be proposed, which consider the necessary bending force involved to flatten.

There are 2 types of flattening: partial flattening and total flattening. Partial flattening is a kind of flattening which doesn't win against the sheet metal springback. For this reason, if you measure the flattened point, it won't be twice the sheet metal thickness but a bigger measure; for example, if you flatten 1.5mm partially, the flattened point will be about 4mm. This dimension depends on the bending force only. Hence, if you want to flatten 1.5mm mild steel and get 3mm high flattened point, you have to increase the tonnage.

In the table below you can check the necessary tonnage according to sheet metal thickness and type.

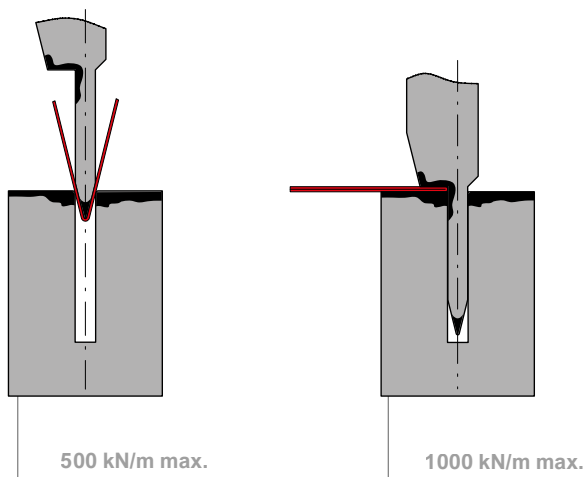
The choice of hemming tools should be influenced by the sheet metal

type to be flattened; 35° punch and dies are recommended to flatten aluminium and mild steel, which have small springback, whereas more resistant sheet metal types like stainless steel require at least 30°, or better 26°, punch and die.

Springback control is fundamental to win against sheet metal resistance during the flattening phase. In fact, if the angle obtained during the pre-bending phase is too wide, sheet metal will slip towards the operator during the flattening phase.

The choice of hemming tools with dies with U shape opening has to take into consideration the fact that the U opening of the die has to match perfectly with the punch tip width. These tools are 525mm long and the sectioned set is also available.

MAX. CAPACITY



S	S	A	A	R.420 N/mm ²	R.700 N/mm ²
mm	in	mm	in	kN/m	kN/m
0.60	0.02	3.0	0.12	90	150
0.80	0.03	3.0	0.12	120	200
1.00	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260

S	S	A	A	R.420 N/mm ²	R.700 N/mm ²
mm	in	mm	in	kN/m	kN/m
0.60	0.02	1.2	0.05	230	350
0.80	0.03	1.6	0.06	320	500
1.00	0.04	1.0	0.04	400	600
1.25	0.05	2.5	0.10	500	800



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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.

LP.SM-190.20.8-12.7

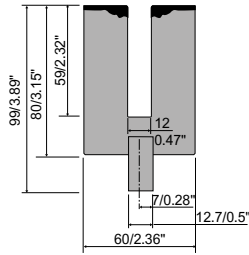
525 mm 20.67" 18.7 kg
 495 mm 19.49" 17.7 kg F
 2x250 mm 2x9.84" 17.7 kg FC

42Cr: 900-1150 N/mm²
 500 - 1000 kN/m max.

B=12.7 | 0.5
 H=99 | R=1.0 | V=12 mm
 H=3.90 | R=0.039 | V=0.47 in



To use with:
LPW.SP-190.20.8



LP.SM-190.20.8-12

525 mm 20.67" 18.7 kg
 495 mm 19.49" 17.7 kg F
 2x250 mm 2x9.84" 17.7 kg FC

42Cr: 900-1150 N/mm²
 500 - 1000 kN/m max.

B=12 | 0.47
 H=99 | R=1.0 | V=12 mm
 H=3.90 | R=0.039 | V=0.47 in

LP.SM-190.20.10-12.7

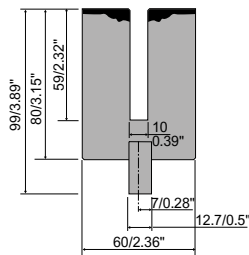
525 mm 20.67" 18.3 kg
 495 mm 19.49" 17.2 kg F
 2x250 mm 2x9.84" 17.4 kg FC

42Cr: 900-1150 N/mm²
 500 - 1000 kN/m max.

B=12.7 | 0.5
 H=99 | R=1.0 | V=10 mm
 H=3.90 | R=0.039 | V=0.39 in



To use with:
LPW.SP-190.20.10



LP.SM-190.20.10-12

525 mm 20.67" 18.3 kg
 495 mm 19.49" 17.2 kg F
 2x250 mm 2x9.84" 17.4 kg FC

42Cr: 900-1150 N/mm²
 500 - 1000 kN/m max.

B=12 | 0.47
 H=99 | R=1.0 | V=10 mm
 H=3.90 | R=0.039 | V=0.39 in

LP.SM-190.20.12-12.7

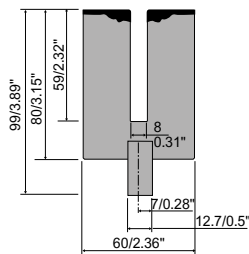
525 mm 20.67" 13.6 kg
 495 mm 19.49" 12.8 kg F
 2x250 mm 2x9.84" 13 kg FC

42Cr: 900-1150 N/mm²
 500 - 1000 kN/m max.

B=12.7 | 0.5
 H=99 | R=1.0 | V=8 mm
 H=3.90 | R=0.039 | V=0.31 in



To use with:
LPW.SP-190.20.12



LP.SM-190.20.12-12

525 mm 20.67" 13.6 kg
 495 mm 19.49" 12.8 kg F
 2x250 mm 2x9.84" 13 kg FC

42Cr: 900-1150 N/mm²
 500 - 1000 kN/m max.

B=12 | 0.47
 H=99 | R=1.0 | V=8 mm
 H=3.90 | R=0.039 | V=0.31 in

F: 495 mm - 19.48"
 mm: 170-100-50-45-40-35-30-25
 in: 6.69-3.94-1.97-1.77-1.57 -1.37-1.18-0.98

FC: 500 mm - 19.68"
 mm: 250-250
 in: 9.84-9.84





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