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TOOLING LAB

LASER CONSUMABLES

PUNCHING TOOLS - IRON WORKER

SHEAR BLADES

PANEL BENDING TOOLS

BENDING

R5 - AMERICAN STYLE TOOLS

ROLLA-V

VARIO ADJUSTABLE DIE

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BENDING TOOLS

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

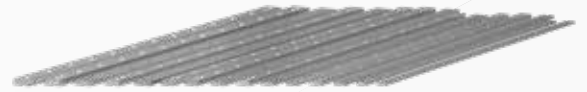
MARK FREE BENDING AND ACCESSORIES

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.

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R5 AMERICAN STYLE PUNCHES

Accurl, Accurpress, Cincinnati, Durma, Ermaksan, Pacific, RMT,
Wysong, ecc.

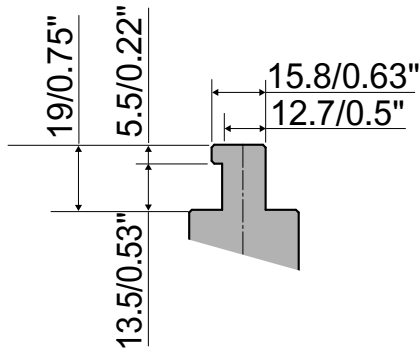




- All tools receive batch numbers and therefore have complete traceability
- Precision ground tolerance: +/-0.01mm (+/-0.0004")
- We use only certified best quality raw steel from known suppliers, ensuring material yield and tensile strenght

- ISO Certification
- PRECISION DEEP INDUCTION HARDENED TOOLS WITH 54-60R HRC HARDNESS

STANDARD TANG



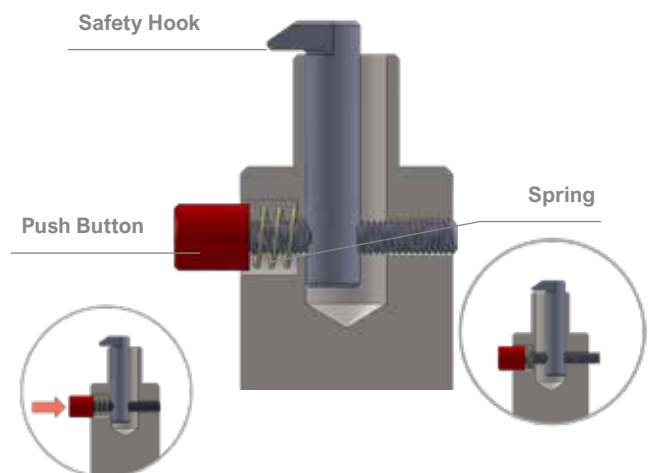
Precision ground tolerance: +/-0.01 mm (+/-0.0004")

STANDARD LENGTHS

	TOP Series	CLASSIC Series
20.67" 525 mm	•	
16.34" 415 mm		•
32.87" 835 mm		•

QUICK-LOCK SYSTEM

- Fast and vertical load/unload button system for upper tools;
- Quick-lock system eliminates the need of special clamps or dedicated holders;
- Upper beam opening should not exceed 0.53" (13.5 mm), otherwise the punch can be released during the opening phase.
- Maximum punch weight compatible with Quick-lock system: 12.5 Kg (25.5 Lbs).



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.



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 info@rolleriusa.com

	TOP Series	CLASSIC Series
	1	•
	2	•
	7	•

SEGMENTATION

Customized sectioning is also available on request. info@rolleriusa.com to know more about price and availability.

◁ = horn left ▷ = horn right

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



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



F: 31.69" - 805 mm
 in: <3.94-14.56-0.39-0.59-0.78-1.57-1.97-3.94-3.94>
 mm: <100-370-10-15-20-40-50-100-100>



FX: 31.29" - 795 mm
 in: <3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94>
 mm: <100-250-20-25-30-35-40-45-50-100-100>



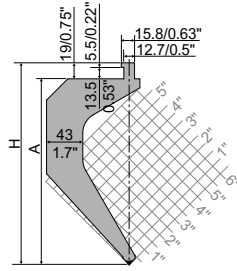
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ASP.250.85

16.34" 415 mm 33.1 kg
 31.29" 795 mm 63.3 kg FX

42Cr: 900-1150 N/mm²
 85 Ton/mt max - 29 US Ton/ft max
 Horn 1



Other Tip Radius available:

ASP.250.85.R59

85°

H=9.41 | A=8.66 | R=0.059 in
 H=239 | W=220 | R=1.5 mm

ASP.250.85.R125

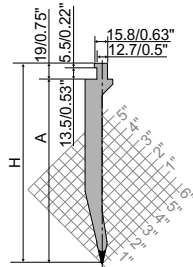
85°

H=9.36 | A=8.61 | R=0.125 in
 H=237.7 | W=218.7 | R=3.17 mm

ASP.250.26

20.67" 525 mm 17.7 kg
 19.49" 495 mm 16.7 kg FA
 19.68" 500 mm 16.8 kg FB

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 31 US Ton/ft max
 Horn 2



Other Tip Radius available:

ASP.250.26.R39

26°

H=9.41 | A=8.66 | R=0.039 in
 H=239 | W=220 | R=1.0 mm

ASP.250.26.R125

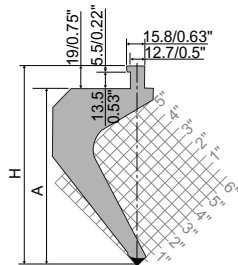
26°

H=9.05 | A=8.31 | R=0.125 in
 H=230 | W=211 | R=3.17 mm

ASP.175.85

20.67" 525 mm 20.9 kg
 19.49" 495 mm 19.7 kg FA
 19.68" 500 mm 19.9 kg FB

42Cr: 900-1150 N/mm²
 90 Ton/mt max - 30 US Ton/ft max
 Horn 2



Other Tip Radius available:

ASP.175.85.R31

85°

H=6.46 | A=5.71 | R=0.031 in
 H=164 | W=145 | R=0.8 mm

ASP.175.85.R07

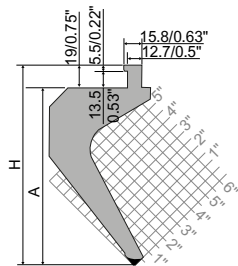
85°

H=6.43 | A=5.68 | R=0.007 in
 H=163.3 | W=144.3 | R=2 mm

ASP.175.75

20.67" 525 mm 21.5 kg
 19.49" 495 mm 20.3 kg FA
 19.68" 500 mm 20.5 kg FB

42Cr: 900-1150 N/mm²
 75 Ton/mt max - 25 US Ton/ft max
 Horn 2



Other Tip Radius available:

ASP.175.75.R31

75°

H=6.46 | A=5.71 | R=0.031 in
 H=164 | W=145 | R=0.8 mm

ASP.175.75.R07

75°

H=6.42 | A=5.68 | R=0.007 in
 H=163.2 | W=144.2 | R=2.0 mm

FX: 31.29" - 795 mm

in: <3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.97-3.94-3.94>

mm: <100-250-20-25-30-35 -40-45-50-100-100>



FA: 19.48" - 495 mm

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

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

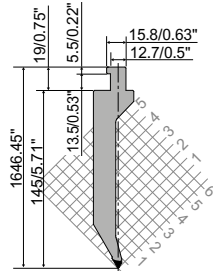


ASP.175.60.R31

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

42Cr: 900-1150 N/mm²
 80 Ton/mt max - 26 US Ton/ft max
 Horn 2

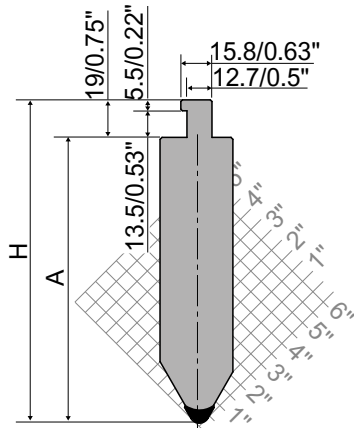
60°
 H=6.46 | A=5.71 | R=0.031 in
 H=164 | W=145 | R=0.8 mm



ASP.175.60

20.67" 525 mm 22.0 kg
 19.49" 495 mm 20.7 kg FA
 19.68" 500 mm 20.9 kg FB

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 87 US Ton/ft max
 Horn 2



Other Tip Radius available:

ASP.175.60.R20

60°
 H=6.45 | A=5.71 | R=0.2 in
 H=164 | W=145 | R=5 mm

ASP.175.60.R25

60°
 H=6.4 | A=5.65 | R=0.25 in
 H=162.2 | W=143.6 | R=6.35 mm

ASP.175.60.R375

60°
 H=6.18 | A=5.43 | R=0.37 in
 H=157 | W=138 | R=9.5 mm

ASP.175.60.R50

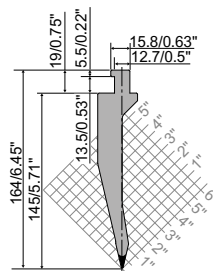
60°
 H=6.05 | A=5.3 | R=0.5 in
 H=153.7 | W=134.7 | R=12.7 mm

ASP.175.26.R31

20.67" 525 mm 11.0 kg
 19.49" 495 mm 10.4 kg FA
 19.68" 500 mm 10.5 kg FB

42Cr: 900-1150 N/mm²
 95 Ton/mt max - 32 US Ton/ft max
 Horn 2

26°
 H=6.46 | A=5.71 | R=0.031 in
 H=164 | W=145 | R=0.8 mm



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

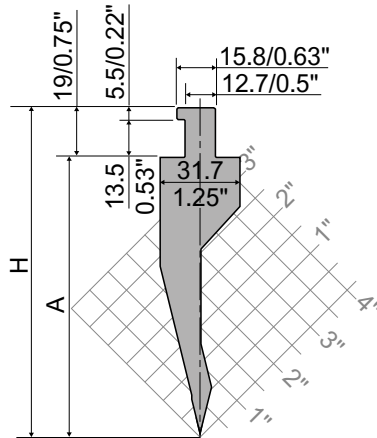


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ASP.19

33.00" 838 mm 13.8 kg
 16.34" 415 mm 6.8 kg
 31.69" 805 mm 13.3 kg F

42Cr: 900-1150 N/mm²
 86 Ton/mt max - 29 US Ton/ft max
 Horn 1



Other Tip Radius available:

ASP.19.31

28°

H=5.00 | A=4.25 | R=0.031 in
 H=127 | W=108 | R=0.8 mm

ASP.19.62

28°

H=4.9 | A=4.15 | R=0.062 in
 H=124.5 | W=105.5 | R=1.6 mm

ASP.19.125

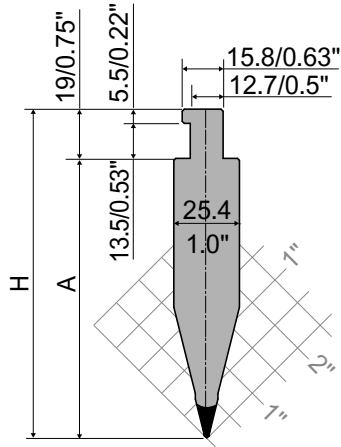
28°

H=4.67 | A=3.91 | R=0.125 in
 H=118.5 | W=99.5 | R=3.2 mm

ASP.23

33.00" 838 mm 12.5 kg
 16.34" 415 mm 5.4 kg
 31.69" 805 mm 10.5 kg F

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max
 Horn 1



Other Tip Radius available:

ASP.23.31

28°

H=5.00 | A=4.25 | R=0.031 in
 H=127 | W=108 | R=0.8 mm

ASP.23.62

28°

H=4.88 | A=4.25 | R=0.062 in
 H=124 | W=108 | R=1.6 mm

F: 31.69" - 805 mm

in: <3.94-14.56-0.39-0.59-1.78-1.57-1.97-3.94-3.94>

mm: <100-370-10-15-20-40-50-100-100>

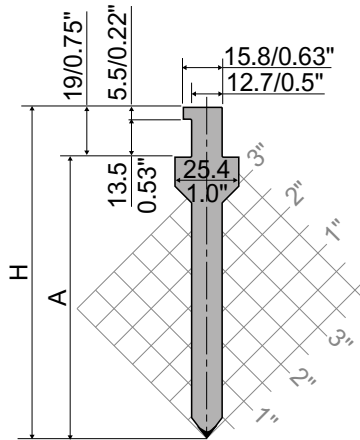


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ASP.14

33.00" 838 mm 13.4 kg
 16.34" 415 mm 6.6 kg
 31.69" 805 mm 12.9 kg F

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max
 Horn 2



Other Tip Radius available:

ASP.14.16

75°

H=5.00 | A=4.25 | R=0.016 in
 H=127 | W=108 | R=0.4 mm

ASP.14.31

75°

H=5.00 | A=4.25 | R=0.031 in
 H=127 | W=108 | R=0.8 mm

ASP.14.62

75°

H=4.98 | A=4.235 | R=0.062 in
 H=126.5 | W=107.5 | R=1.6 mm

ASP.14.125

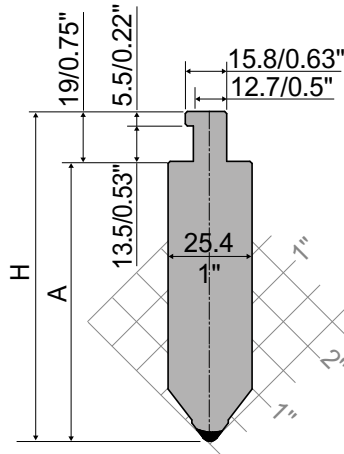
75°

H=4.96 | A=4.21 | R=0.125 in
 H=126 | W=107 | R=3.2 mm

ASP.22

33.00" 838 mm 21.9 kg
 16.34" 415 mm 6.6 kg
 31.69" 805 mm 12.9 kg F

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max
 Horn 1



Other Tip Radius available:

ASP.22.125

75°

H=4.95 | A=4.2 | R=0.12 in
 H=125.7 | W=106.7 | R=3.2 mm

ASP.22.250

75°

H=4.11 | A=4.85 | R=0.25 in
 H=123.3 | W=104.3 | R=6.35 mm

ASP.22.375

75°

H=4.72 | A=3.98 | R=0.37 in
 H=120 | W=101 | R=9.5 mm

ASP.22.500

75°

H=4.64 | A=3.89 | R=0.5 in
 H=118 | W=99 | R=12.7 mm

F: 31.69" - 805 mm

in: <3.94-14.56-0.39-0.59-1.78-1.57-1.97-3.94-3.94>

mm: <100-370-10-15-20-40-50-100-100>



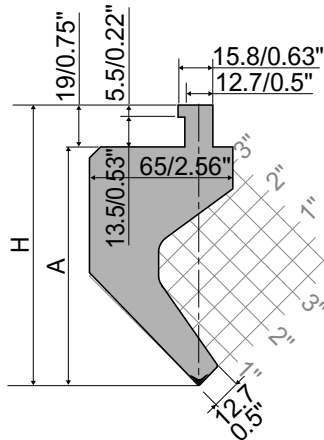
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It contains not only a lot of interesting contents but also sheet metal development calculator and bending ruler.

ASP.24

33.00"	838 mm	31.8 kg
16.34"	415 mm	15.8 kg
31.69"	805 mm	30.6 kg F

42Cr: 900-1150 N/mm²
 70 Ton/mt max - 23 US Ton/ft max
 Horn 2



Other Tip Radius available:

ASP.24.16

85°

H=5.00 | A=4.25 | R=0.016 in
 H=127 | W=108 | R=0.4 mm

ASP.24.31

85°

H=4.9 | A=4.15 | R=0.031 in
 H=124.5 | W=105.5 | R=0.8 mm

ASP.24.62

85°

H=5.00 | A=4.25 | R=0.062 in
 H=127 | W=108 | R=1.6 mm

ASP.24.125

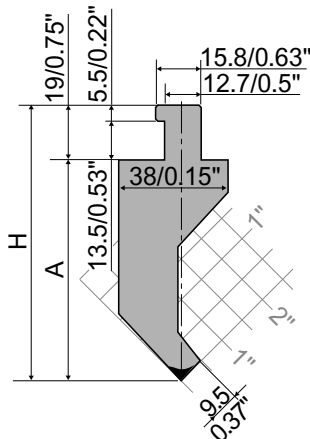
85°

H=5.00 | A=4.25 | R=0.125 in
 H=127 | W=108 | R=3.2 mm

ASP.9

33.00"	838 mm	12.8 kg
16.34"	415 mm	5.4 kg
31.69"	805 mm	10.5 kg F

42Cr: 900-1150 N/mm²
 66 Ton/mt max - 22 US Ton/ft max
 Horn 1



Other Tip Radius available:

ASP.9.16

85°

H=3.78 | A=3.03 | R=0.016 in
 H=96 | W=77 | R=0.4 mm

ASP.9.31

85°

H=3.78 | A=3.03 | R=0.031 in
 H=96 | W=77 | R=0.8 mm

ASP.9.63

85°

H=3.76 | A=3.01 | R=0.063 in
 H=95.5 | W=76.5 | R=1.6 mm

ASP.9.125

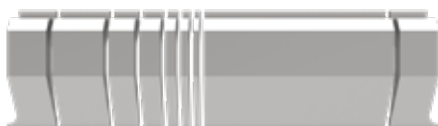
85°

H=3.73 | A=2.98 | R=0.125 in
 H=94.8 | W=75.8 | R=3.2 mm

F: 31.69" - 805 mm

in: <3.94-14.56-0.39-0.59-1.78-1.57-1.97-3.94-3.94>

mm: <100-370-10-15-20-40-50-100-100>



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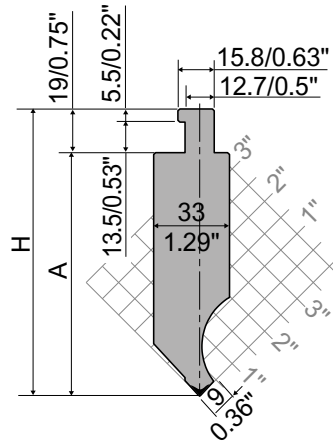


You will have access to our online store where you can get what you need. You will also get our sheet metal unfolding software for free and our bending rule.

ASP.135 / 0813-011-11

33.00" 838 mm 21.0 kg
 16.34" 415 mm 10.4 kg
 31.69" 805 mm 20.1 kg F

C45: 560-710 N/mm²
 90 Ton/mt max - 30 US Ton/ft max
 Horn 7



Other Tip Radius available:

ASP.135.16 / 0813-011-11
85°

H=4.92 | A=4.17 | R=0.016 in
 H=125 | W=106 | R=0.4 mm

ASP.135.31 / 0813-011-11
85°

H=4.92 | A=4.17 | R=0.031 in
 H=125 | W=106 | R=0.8 mm

ASP.135.62 / 0813-011-11
85°

H=4.9 | A=4.15 | R=0.062 in
 H=124.5 | W=105.5 | R=1.6 mm

ASP.135.125 / 0813-011-11
85°

H=4.87 | A=4.12 | R=0.125 in
 H=123.8 | W=104.8 | R=3.2 mm

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

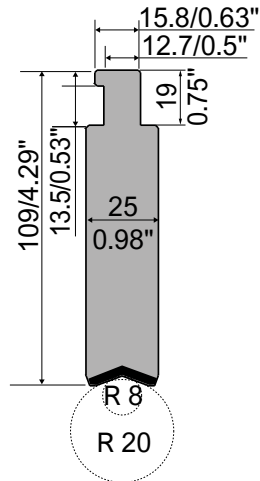
Rolleri **FREEZINC** is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation.

ASP.120-08

20.55" 522 mm 11.0 kg
 19.49" 495 mm 12.0 kg F

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

For Radius tools with R8-R20
 (TOP.C08-TOP.C20) see below

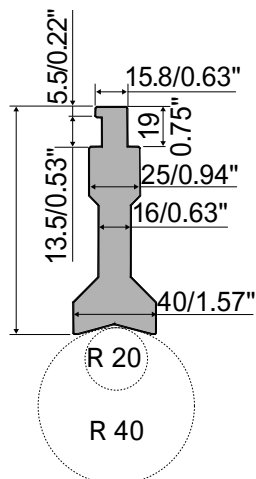


ASP.PC.120-20

20.55" 522 mm 10.5 kg
 19.49" 495 mm 10.0 kg F

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

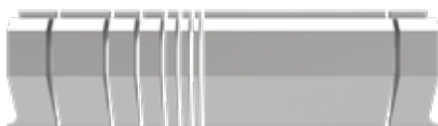
For Radius tools with R20-R40
 (TOP.C20-TOP.C40) see below



F: 31.69" - 805 mm

in: <3.94-14.56-0.39-0.59-1.78-1.57-1.97-3.94-3.94>

mm: <100-370-10-15-20-40-50-100-100>



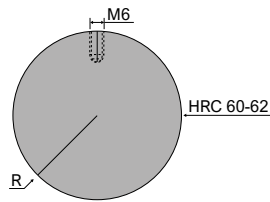
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ASP-Radius Tools: R8-40

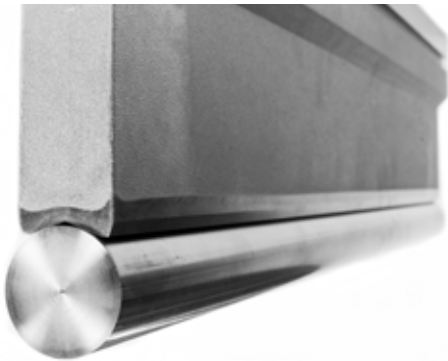
	R	525 mm	495 mm
		20.67"	19.49"
TOP.C08	0.31"	8.0 mm	0.8 kg 1.9 kg
TOP.C10	0.39"	10.0 mm	1.3 kg 2.7 kg
TOP.C12.5	0.49"	12.5 mm	2.0 kg 2.8 kg
TOP.C15	0.59"	15.0 mm	3.0 kg 3.8 kg
TOP.C17.5	0.69"	17.5 mm	4.0 kg 4.7 kg
TOP.C20	0.79"	20.0mm	5.2 kg 6.6 kg
TOP.C22.5	0.88"	22.5 mm	6.6 kg 6.6 kg
TOP.C25	0.98"	25.0 mm	8.1 kg 7.5 kg
TOP.C27.5	1.08"	27.5 mm	9.8 kg 9.2 kg
TOP.C30	1.18"	30.0 mm	11.7 kg 11.3 kg
TOP.C32.5	1.28"	32.5 mm	13.7 kg 12.9 kg
TOP.C35	1.14"	35.0 mm	16 kg 15.1 kg
TOP.C37.5	1.47"	37.5 mm	18.2 kg 17.2 kg
TOP.C40	1.57"	40.0 mm	20.7 kg 19.5 kg



C53: 60-62 HRC

100 Ton/mt max - 33 US Ton/ft max

All ASP radius are deep induction hardened to HRC60-62. This makes them last longer and be suitable to work on thick plate and abrasion resistant materials



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INT100-A

5.91" 150 mm 3.5 kg

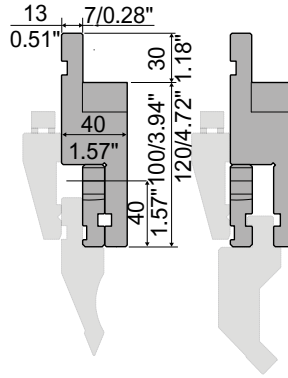
C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

Options:

Screw clamping system

Fast lever clamping system



INT120-A

5.91" 150 mm 5.2 kg

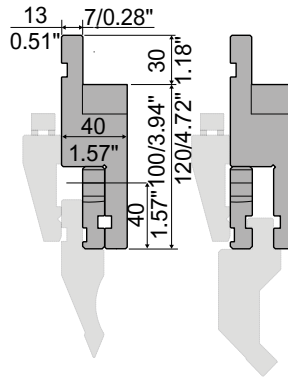
C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

Options:

Screw clamping system

Fast lever clamping system



INT100-A (American)

5.91" 150 mm 3.5 kg

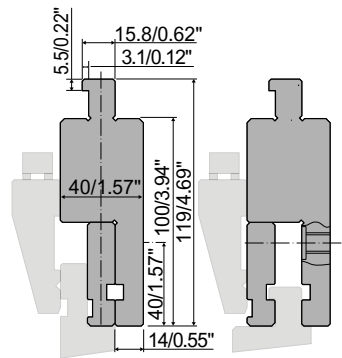
C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

Options:

Screw clamping system

Fast lever clamping system



INT120-40-A

5.91" 150 mm 6.0 kg

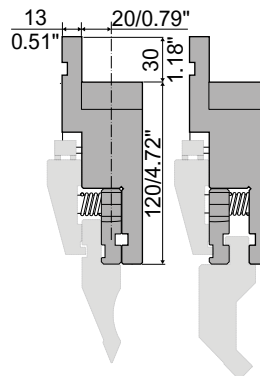
C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

Options:

Screw clamping system

Fast lever clamping system



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AD16

5.90" 150 mm 4 kg

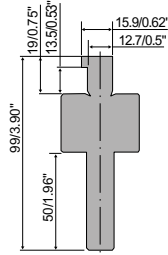
R5 → R1

C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

W=3.15 | H=3.90 in

W=80 | H=99 mm



Our Universal Clamps will allow any PB to use both european and american style upper tooling.

AD16 clamp allows european upper tools to be clamped into an american style upper ram.

AW adapters will mount onto European upper tools allowing them to be used on american style upper rams.

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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.

R5 AMERICAN STYLE DIES

Accurl, Accurpress, Cincinnati, Durma, Ermaksan, Pacific, RMT,
Wysong, ecc.

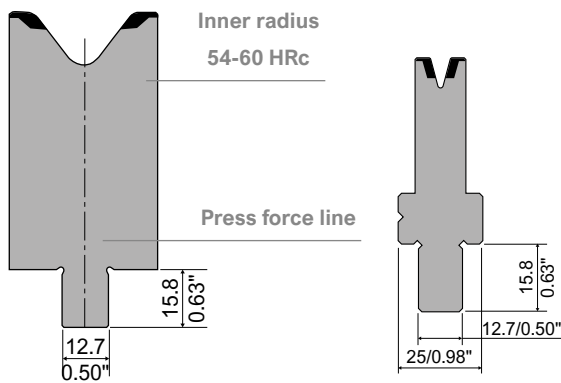


- Every single tool is traceable thanks to a unique serial number stamped after the first quality control
- All tools receive batch numbers and therefore have complete traceability
- Precision ground tolerance: $\pm 0.01\text{ mm}$ ($\pm 0.0004\text{"}\text{"}$)
- Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed
- ISO Certification
- All tools induction hardened to 54-60 HRc.

Dies Roller Type American are:

- Compatible with press brakes American;
- Also applicable on all other press brakes with adapters and die holders.

STANDARD TANG



Precision ground tolerance: $\pm 0.01\text{ mm}$ ($\pm 0.0004\text{"}\text{"}$)

STANDARD LENGTHS

16.34" | 415 mm

19.69" | 500 mm

32.99" | 838 mm

39.37" | 1000 mm

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

Customized sectioning is also available on request.

info@rolleriusa.com to know more about price and availability.

FC: 9.84" - 250 mm

In: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

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



FW: 21.65" - 550 mm

In:7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

mm:200-100-50-45-40-35-30-25-25



FX: 31.29" - 795mm

In:3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

mm:100-250-20-25-30-35-40-45-50-200



F: 31.69" - 805 mm

In: 7.87-1.97-1.57-0.78-0.59-0.39-14.56-3.94

mm: 200-50-40-20-15-10-370-100



F: 43.31" - 1100 mm

In:15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39

mm:400-200-100-100-75-60-50-40-30-20-15-10



R5 Dies



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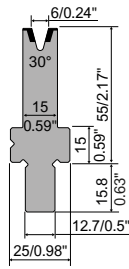
ASD55.06.30

39.37" 1000 mm 8.0 kg
 19.68" 500 mm 4.0 kg
 43.31" 1100 mm 9.0 kg F

42Cr: 900-1150 N/mm²
 35 Ton/mt max - 12 US Ton/ft max

30°

W=2.17 | R=0.024 | V=0.24 in
 W=55 | R=0.6 | V=6 mm



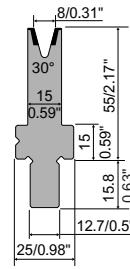
ASD55.08.30

39.37" 1000 mm 9.2 kg
 19.68" 500 mm 4.0 kg
 43.31" 1100 mm 10.1 kg F

42Cr: 900-1150 N/mm²
 20 Ton/mt max - 7 US Ton/ft max

30°

W=2.17 | R=0.031 | V=0.31 in
 W=55 | R=0.8 | V=8 mm



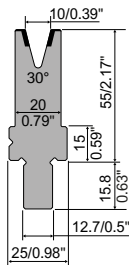
ASD55.10.30

39.37" 1000 mm 10.0 kg
 19.68" 500 mm 5.0 kg
 43.31" 1100 mm 11.0 kg F

42Cr: 900-1150 N/mm²
 35 Ton/mt max - 12 US Ton/ft max

30°

W=2.17 | R=0.039 | V=0.39 in
 W=55 | R=1.0 | V=10 mm



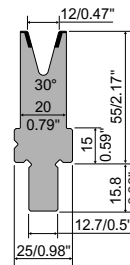
ASD55.12.30

39.37" 1000 mm 10.0 kg
 19.68" 500 mm 5.0 kg
 43.31" 1100 mm 11.0 kg F

42Cr: 900-1150 N/mm²
 30 Ton/mt max - 10 US Ton/ft max

30°

W=2.17 | R=0.059 | V=0.47 in
 W=55 | R=1.5 | V=12 mm



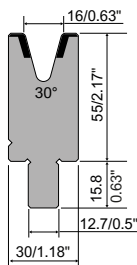
ASD55.16.30

39.37" 1000 mm 13.5 kg
 19.68" 500 mm 6.7 kg
 43.31" 1100 mm 14.9 kg F

42Cr: 900-1150 N/mm²
 45 Ton/mt max - 15 US Ton/ft max

30°

W=2.17 | R=0.079 | V=0.63 in
 W=55 | R=2.0 | V=16 mm



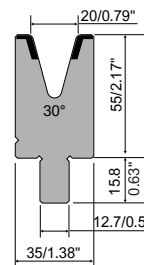
ASD55.20.30

39.37" 1000 mm 14.0 kg
 19.68" 500 mm 7.0 kg
 43.31" 1100 mm 13.5 kg F

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

30°

W=2.17 | R=0.098 | V=0.79 in
 W=55 | R=2.5 | V=20 mm



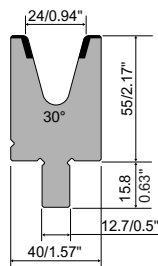
ASD55.24.30

39.37" 1000 mm 15.5 kg
 19.68" 500 mm 7.8 kg
 43.31" 1100 mm 17.0 kg F

42Cr: 900-1150 N/mm²
 55 Ton/mt max - 18 US Ton/ft max

30°

W=2.17 | R=0.118 | V=0.94 in
 W=55 | R=3.0 | V=24 mm



F: 43.30" - 1100 mm

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39
 mm: 400 - 200 - 100 - 100 - 75 - 60 - 50 - 40 - 30 - 20 - 15 - 10



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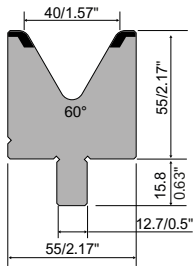
ASD55.40.60

39.37" 1000 mm 20.3 kg
 19.68" 500 mm 10.5 kg
 43.31" 1100 mm 22.3 kg F

42Cr: 900-1150 N/mm²
 130 Ton/mt max - 44 US Ton/ft max

60°

W=2.17 | R=0.197 | V=1.57 in
 W=55 | R=5.0 | V=40 mm



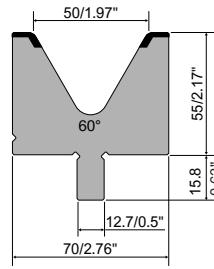
ASD55.50.60

39.37" 1000 mm 24.0 kg
 19.68" 500 mm 12.0 kg
 43.31" 1100 mm 21.0 kg F

42Cr: 900-1150 N/mm²
 130 Ton/mt max - 44 US Ton/ft max

60°

W=2.17 | R=0.197 | V=1.97 in
 W=55 | R=5.0 | V=50 mm



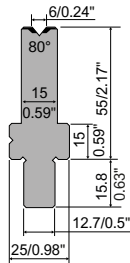
ASD55.06.80

39.37" 1000 mm 8.5 kg
 19.68" 500 mm 4.2 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

80°

W=2.17 | R=0.016 | V=0.24 in
 W=55 | R=0.4 | V=6 mm



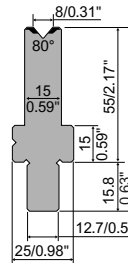
ASD55.08.80

39.37" 1000 mm 9.0 kg
 19.68" 500 mm 4.5 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

80°

W=2.17 | R=0.020 | V=0.31 in
 W=55 | R=0.5 | V=8 mm



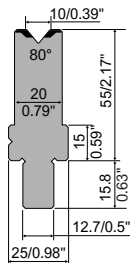
ASD55.10.80

39.37" 1000 mm 11.0 kg
 19.68" 500 mm 5.0 kg
 43.31" 1100 mm 12.0 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

80°

W=2.17 | R=0.039 | V=0.39 in
 W=55 | R=1.0 | V=10 mm



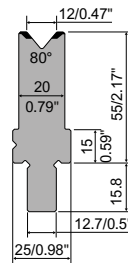
ASD55.12.80

39.37" 1000 mm 10.5 kg
 19.68" 500 mm 5.2 kg
 43.31" 1100 mm 10.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

80°

W=2.17 | R=0.059 | V=0.47 in
 W=55 | R=1.5 | V=12 mm



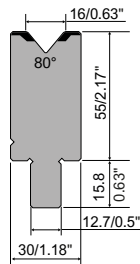
ASD55.16.80

39.37" 1000 mm 14.5 kg
 19.68" 500 mm 7.2 kg
 43.31" 1100 mm 14.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

80°

W=2.17 | R=0.079 | V=0.63 in
 W=55 | R=2.0 | V=16 mm



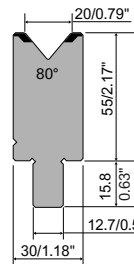
ASD55.20.80

39.37" 1000 mm 14.5 kg
 19.68" 500 mm 7.2 kg
 43.31" 1100 mm 14.0 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

80°

W=2.17 | R=0.079 | V=0.79 in
 W=55 | R=2.0 | V=20 mm



F: 43.30" - 1100 mm

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39
 mm: 400 - 200 - 100 - 100 - 75 - 60 - 50 - 40 - 30 - 20 - 15 - 10



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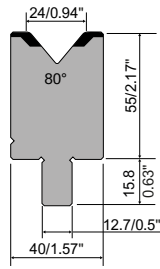
ASD55.24.80

39.37" 1000 mm 18.5 kg
 19.68" 500 mm 9.2 kg
 43.31" 1100 mm 18.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

80°

W=2.17 | R=0.118 | V=0.94 in
 W=55 | R=3.0 | V=24 mm



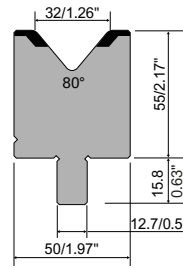
ASD55.32.80

39.37" 1000 mm 21.0 kg
 19.68" 500 mm 10.5 kg
 43.31" 1100 mm 20.5 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

80°

W=2.17 | R=0.157 | V=1.25 in
 W=55 | R=4.0 | V=32 mm



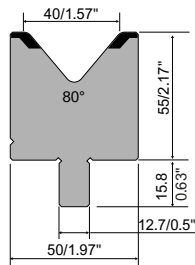
ASD55.40.80

39.37" 1000 mm 21.5 kg
 19.68" 500 mm 10.7 kg
 43.31" 1100 mm 25.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

80°

W=2.17 | R=0.157 | V=1.57 in
 W=55 | R=4.0 | V=40 mm



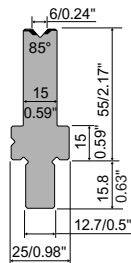
ASD55.06.85

39.37" 1000 mm 8.5 kg
 19.68" 500 mm 4.2 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

85°

W=2.17 | R=0.016 | V=0.24 in
 W=55 | R=0.4 | V=6 mm



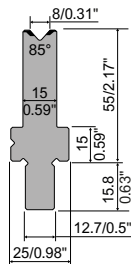
ASD55.08.85

39.37" 1000 mm 9.0 kg
 19.68" 500 mm 4.5 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

85°

W=2.17 | R=0.020 | V=0.31 in
 W=55 | R=0.5 | V=8 mm



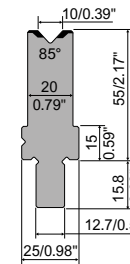
ASD55.10.85

39.37" 1000 mm 11.0 kg
 19.68" 500 mm 5.0 kg
 43.31" 1100 mm 12.0 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

85°

W=2.17 | R=0.039 | V=0.39 in
 W=55 | R=1.0 | V=10 mm



F: 43.30" - 1100 mm

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39
 mm: 400 - 200 - 100 - 100 - 75 - 60 - 50 - 40 - 30 - 20 - 15 - 10



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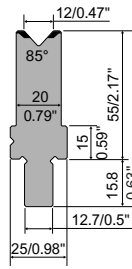
ASD55.12.85

39.37" 1000 mm 10.5 kg
 19.68" 500 mm 5.2 kg
 43.31" 1100 mm 10.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

85°

W=2.17 | R=0.059 | V=0.47 in
 W=55 | R=1.5 | V=12 mm



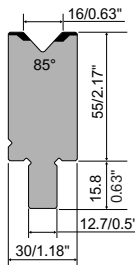
ASD55.16.85

39.37" 1000 mm 14.5 kg
 19.68" 500 mm 7.2 kg
 43.31" 1100 mm 14.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

85°

W=2.17 | R=0.079 | V=0.63 in
 W=55 | R=2.0 | V=16 mm



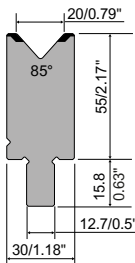
ASD55.20.85

39.37" 1000 mm 14.5 kg
 19.68" 500 mm 7.2 kg
 43.31" 1100 mm 14.0 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

85°

W=2.17 | R=0.079 | V=0.79 in
 W=55 | R=2.0 | V=20 mm



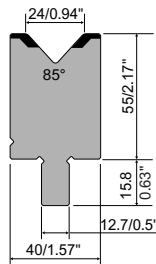
ASD55.24.85

39.37" 1000 mm 18.5 kg
 19.68" 500 mm 9.2 kg
 43.31" 1100 mm 18.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

85°

W=2.17 | R=0.118 | V=0.94 in
 W=55 | R=3.0 | V=24 mm



F: 43.30" - 1100 mm

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39
 mm: 400 - 200 - 100 - 100 - 75 - 60 - 50 - 40 - 30 - 20 - 15 - 10



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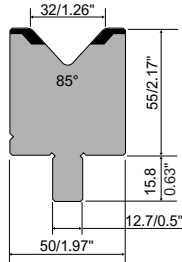
ASD55.32.85

39.37" 1000 mm 21.0 kg
 19.68" 500 mm 10.5 kg
 43.31" 1100 mm 20.5 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

85°

W=2.17 | R=0.157 | V=1.25 in
 W=55 | R=4.0 | V=32 mm



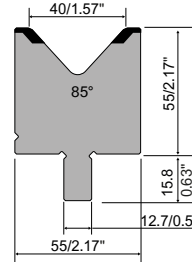
ASD55.40.85

39.37" 1000 mm 21.5 kg
 19.68" 500 mm 10.7 kg
 43.31" 1100 mm 25.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

85°

W=2.17 | R=0.157 | V=1.57 in
 W=55 | R=4.0 | V=40 mm



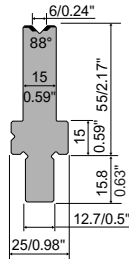
ASD55.06.88

39.37" 1000 mm 8.5 kg
 19.68" 500 mm 4.2 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

88°

W=55 | R=0.4 | V=6 mm
 W=2.17 | R=0.016 | V=0.24 in



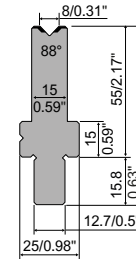
ASD55.08.88

39.37" 1000 mm 9.0 kg
 19.68" 500 mm 4.5 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

88°

W=55 | R=0.5 | V=8 mm
 W=2.17 | R=0.020 | V=0.31 in



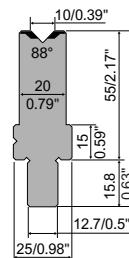
ASD55.10.88

39.37" 1000 mm 11.0 kg
 19.68" 500 mm 5.0 kg
 43.31" 1100 mm 12.0 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

88°

W=2.17 | R=0.039 | V=0.39 in
 W=55 | R=1.0 | V=10 mm



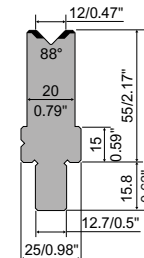
ASD55.12.88

39.37" 1000 mm 10.5 kg
 19.68" 500 mm 5.2 kg
 43.31" 1100 mm 10.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

88°

W=2.17 | R=0.059 | V=0.47 in
 W=55 | R=1.5 | V=12 mm



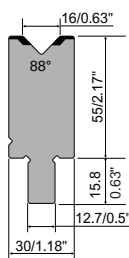
ASD55.16.88

39.37" 1000 mm 14.5 kg
 19.68" 500 mm 7.2 kg
 43.31" 1100 mm 14.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

88°

W=2.17 | R=0.079 | V=0.63 in
 W=55 | R=2.0 | V=16 mm



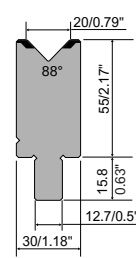
ASD55.20.88

39.37" 1000 mm 14.5 kg
 19.68" 500 mm 7.2 kg
 43.31" 1100 mm 14.0 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

88°

W=2.17 | R=0.079 | V=0.79 in
 W=55 | R=2.0 | V=20 mm



F: 43.30" - 1100 mm

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39
 mm: 400 - 200 - 100 - 100 - 75 - 60 - 50 - 40 - 30 - 20 - 15 - 10



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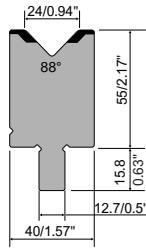
ASD55.24.88

39.37" 1000 mm 18.5 kg
 19.68" 500 mm 9.2 kg
 43.31" 1100 mm 18.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

88°

W=2.17 | R=0.118 | V=0.94 in
 W=55 | R=3.0 | V=24 mm



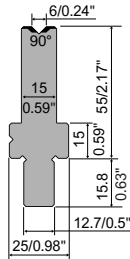
ASD55.06.90

39.37" 1000 mm 8.5 kg
 19.68" 500 mm 4.2 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

90°

W=2.17 | R=0.016 | V=0.24 in
 W=55 | R=0.4 | V=6 mm



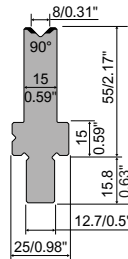
ASD55.08.90

39.37" 1000 mm 9.0 kg
 19.68" 500 mm 4.5 kg
 43.31" 1100 mm 8.5 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

90°

W=2.17 | R=0.020 | V=0.31 in
 W=55 | R=0.5 | V=8 mm



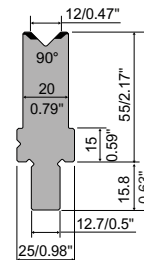
ASD55.12.90

39.37" 1000 mm 10.5 kg
 19.68" 500 mm 5.2 kg
 43.31" 1100 mm 10.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

90°

W=2.17 | R=0.059 | V=0.47 in
 W=55 | R=1.5 | V=12 mm



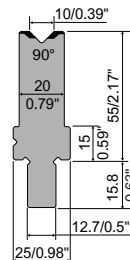
ASD55.10.90

39.37" 1000 mm 11.0 kg
 19.68" 500 mm 5.0 kg
 43.31" 1100 mm 12.0 kg F

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

90°

W=2.17 | R=0.039 | V=0.39 in
 W=55 | R=1.0 | V=10 mm



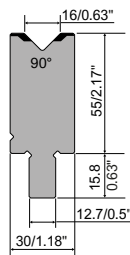
ASD55.16.90

39.37" 1000 mm 14.5 kg
 19.68" 500 mm 7.2 kg
 43.31" 1100 mm 14.0 kg F

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

90°

W=2.17 | R=0.079 | V=0.63 in
 W=55 | R=2.0 | V=16 mm



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.

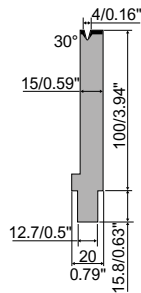
ASD100.04.30

19.68" 500 mm 7.0 kg
 9.84" 250 mm 3.5 kg FC
 21.65" 550 mm 7.7 kg FW

42Cr: 900-1150 N/mm²
 15 Ton/mt max - 5 US Ton/ft max

30°

W=3.94 | R=0.024 | V=0.16 in
 W=100 | R=0.6 | V=4 mm



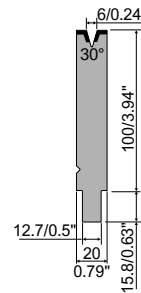
ASD100.06.30

19.68" 500 mm 8.8 kg
 9.84" 250 mm 4.4 kg FC
 21.65" 550 mm 9.6 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=3.94 | R=0.024 | V=0.24 in
 W=100 | R=0.6 | V=6 mm



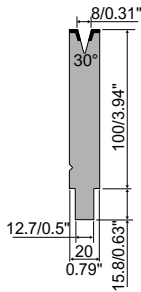
ASD100.08.30

19.68" 500 mm 12.2 kg
 9.84" 250 mm 6.1 kg FC
 21.65" 550 mm 13.4 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=3.94 | R=0.039 | V=0.31 in
 W=100 | R=1.0 | V=8 mm



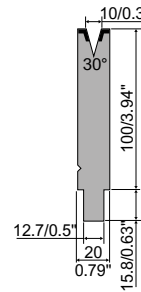
ASD100.10.30

19.68" 500 mm 8.5 kg
 9.84" 250 mm 4.3 kg FC
 21.65" 550 mm 9.4 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=3.94 | R=0.039 | V=0.39 in
 W=100 | R=1.0 | V=10 mm



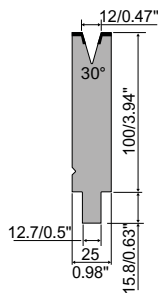
ASD100.12.30

19.68" 500 mm 10.3 kg
 9.84" 250 mm 5.1 kg FC
 21.65" 550 mm 11.3 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=3.94 | R=0.039 | V=0.47 in
 W=100 | R=1.0 | V=12 mm



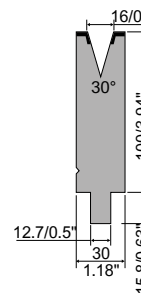
ASD100.16.30

19.68" 500 mm 11.8 kg
 9.84" 250 mm 6.0 kg FC
 21.65" 550 mm 13.0 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

30°

W=3.94 | R=0.063 | V=0.63 in
 W=100 | R=1.6 | V=16 mm



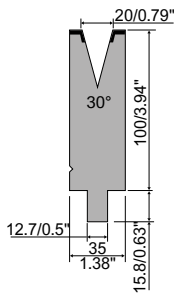
ASD100.20.30

19.68" 500 mm 13.2 kg
 9.84" 250 mm 6.5 kg FC
 21.65" 550 mm 15.0 kg FW

42Cr: 900-1150 N/mm²
 60 Ton/mt max - 20 US Ton/ft max

30°

W=3.94 | R=0.079 | V=0.79 in
 W=100 | R=2.0 | V=20 mm



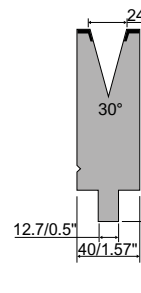
ASD100.24.30

19.68" 500 mm 14.8 kg
 9.84" 250 mm 7.4 kg FC
 21.65" 550 mm 16.2 kg FW

42Cr: 900-1150 N/mm²
 65 Ton/mt max - 22 US Ton/ft max

30°

W=3.94 | R=0.098 | V=0.94 in
 W=100 | R=2.5 | V=24 mm



F: 43.30" - 1100 mm

in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39
 mm: 400 - 200 - 100 - 100 - 75 - 60 - 50 - 40 - 30 - 20 - 15 - 10



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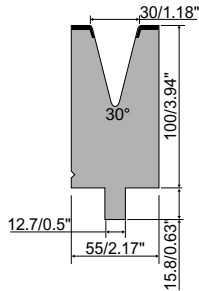
ASD100.30.30

19.68" 500 mm 19.0 kg
 9.84" 250 mm 9.5 kg FC
 21.65" 550 mm 21.0 kg FW

42Cr: 900-1150 N/mm²
 90 Ton/mt max - 30 US Ton/ft max

30°

W=3.94 | R=0.118 | V=1.18 in
 W=100 | R=3.0 | V=30 mm



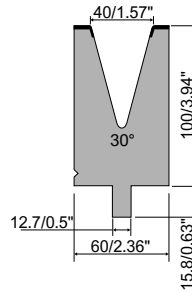
ASD100.40.30

19.68" 500 mm 18.3 kg
 9.84" 250 mm 9.3 kg FC
 21.65" 550 mm 20.1 kg FW

42Cr: 900-1150 N/mm²
 90 Ton/mt max - 30 US Ton/ft max

30°

W=3.94 | R=0.197 | V=1.57 in
 W=100 | R=5.0 | V=40 mm



F: 43.30" - 1100 mm
 in: 15.75-7.87-3.94-3.94-2.95-2.36-1.97-1.57-1.18-0.78-0.59-0.39
 mm: 400 - 200 - 100 - 100 - 75 - 60 - 50 - 40 - 30 - 20 - 15 - 10



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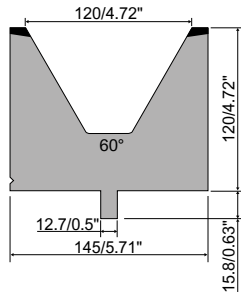
ASD120.120.60

19.68" 500 mm 44.5 kg
 9.84" 250 mm 22.8 kg FC
 21.65" 550 mm 49.0 kg FW

42Cr: 900-1150 N/mm²
 160 Ton/mt max - 54 US Ton/ft max

60°

W=4.72 | R=0.31 | V=4.72 in
 W=120 | R=8.0 | V=120 mm



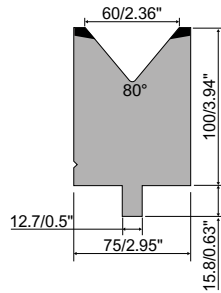
ASD100.60.80

19.68" 500 mm 25.8 kg
 9.84" 250 mm 13.0 kg FC
 21.65" 550 mm 28.4 kg FW

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

80°

W=3.94 | R=0.197 | V=2.36 in
 W=100 | R=5.0 | V=60 mm



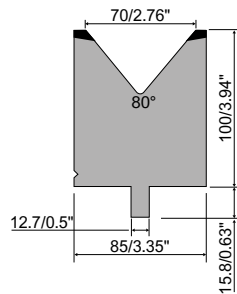
ASD100.70.80

19.68" 500 mm 28.2 kg
 9.84" 250 mm 14.1 kg FC
 21.65" 550 mm 31.0 kg FW

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

80°

W=3.94 | R=0.197 | V=2.76 in
 W=100 | R=5.0 | V=70 mm



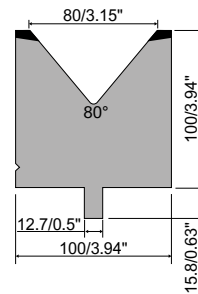
ASD100.80.80

19.68" 500 mm 32.3 kg
 9.84" 250 mm 16.1 kg FC
 21.65" 550 mm 35.5 kg FW

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

80°

W=3.94 | R=0.197 | V=3.15 in
 W=100 | R=5.0 | V=80 mm



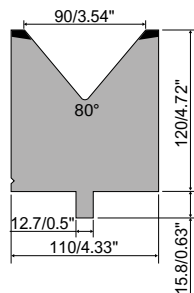
ASD120.90.80

19.68" 500 mm 42.1 kg
 9.84" 250 mm 21.0 kg FC
 21.65" 550 mm 46.3 kg FW

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

80°

W=4.72 | R=0.31 | V=3.54 in
 W=120 | R=8.0 | V=90 mm



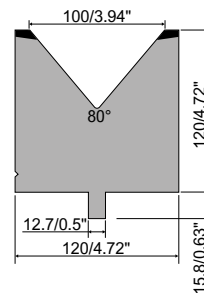
ASD120.100.80

19.68" 500 mm 44.7 kg
 9.84" 250 mm 22.4 kg FC
 21.65" 550 mm 49.2 kg FW

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

80°

W=4.72 | R=0.31 | V=3.94 in
 W=120 | R=8.0 | V=100 mm



FC: 9.84" - 250 mm

in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

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

FW: 21.65" - 550 mm

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

mm: 200-100-50-45-40-35-30-25-25





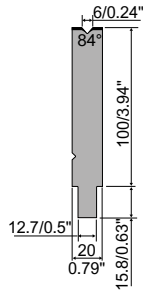
ASD100.06.84

19.68" 500 mm 8.8 kg
 9.84" 250 mm 4.4 kg FC
 21.65" 550 mm 8.8 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

84°

W=3.94 | R=0.024 | V=0.24 in
 W=100 | R=0.6 | V=6 mm



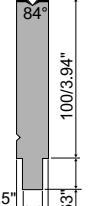
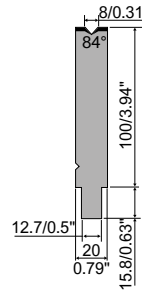
ASD100.08.84

19.68" 500 mm 8.8 kg
 9.84" 250 mm 4.4 kg FC
 21.65" 550 mm 9.7 kg FW

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

84°

W=3.94 | R=0.031 | V=0.31 in
 W=100 | R=0.8 | V=8 mm



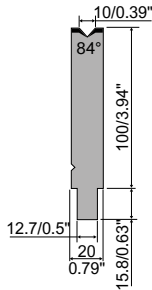
ASD100.10.84

19.68" 500 mm 8.8 kg
 9.84" 250 mm 4.4 kg FC
 21.65" 550 mm 9.6 kg FW

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

84°

W=3.94 | R=0.039 | V=0.39 in
 W=100 | R=1.0 | V=10 mm



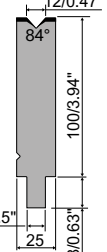
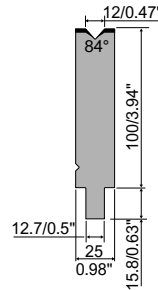
ASD100.12.84

19.68" 500 mm 10.7 kg
 9.84" 250 mm 5.3 kg FC
 21.65" 550 mm 11.7 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

84°

W=3.94 | R=0.039 | V=0.47 in
 W=100 | R=1.0 | V=12 mm



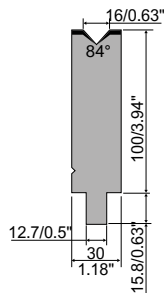
ASD100.16.84

19.68" 500 mm 12.5 kg
 9.84" 250 mm 6.3 kg FC
 21.65" 550 mm 13.8 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

84°

W=3.94 | R=0.063 | V=0.63 in
 W=100 | R=1.6 | V=16 mm



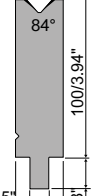
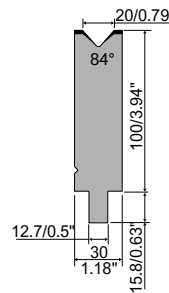
ASD100.20.84

19.68" 500 mm 12.2 kg
 9.84" 250 mm 6.1 kg FC
 21.65" 550 mm 13.4 kg FW

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

84°

W=3.94 | R=0.079 | V=0.79 in
 W=100 | R=2.0 | V=20 mm



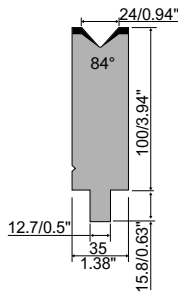
ASD100.24.84

19.68" 500 mm 14.0 kg
 9.84" 250 mm 7.0 kg FC
 21.65" 550 mm 15.4 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

84°

W=3.94 | R=0.098 | V=0.94 in
 W=100 | R=2.5 | V=24 mm



FC: 9.84" - 250 mm
 in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 50-45-40-40-35-30-25-25

FW: 21.65" - 550 mm
 in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 200-100-50-45-40-35-30-25-25



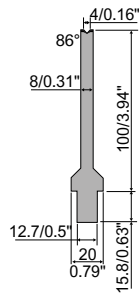
ASD100.04.86

19.68" 500 mm 4.8 kg
 9.84" 250 mm 2.4 kg FC
 21.65" 550 mm 5.2 kg FW

42Cr: 900-1150 N/mm²
 25 Ton/mt max - 8 US Ton/ft max

86°

W=3.94 | R=0.024 | V=0.16 in
 W=100 | R=0.6 | V=4 mm



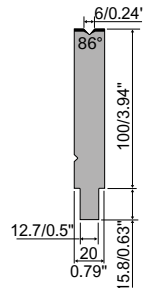
ASD100.06.86

19.68" 500 mm 8.9 kg
 9.84" 250 mm 4.4 kg FC
 21.65" 550 mm 8.9 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

86°

W=3.94 | R=0.024 | V=0.24 in
 W=100 | R=0.6 | V=6 mm



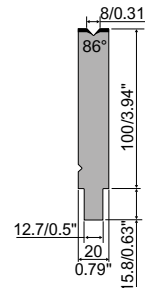
ASD100.08.86

19.68" 500 mm 8.9 kg
 9.84" 250 mm 4.4 kg FC
 21.65" 550 mm 8.9 kg FW

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

86°

W=3.94 | R=0.031 | V=0.31 in
 W=100 | R=0.8 | V=8 mm



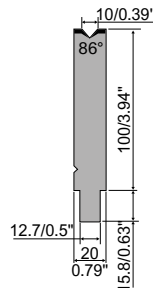
ASD100.10.86

19.68" 500 mm 8.9 kg
 9.84" 250 mm 4.4 kg FC
 21.65" 550 mm 8.9 kg FW

42Cr: 900-1150 N/mm²
 110 Ton/mt max - 37 US Ton/ft max

86°

W=3.94 | R=0.039 | V=0.39 in
 W=100 | R=1.0 | V=10 mm

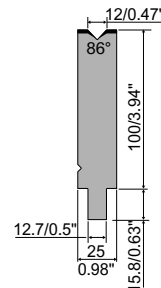


19.68" 500 mm 8.9 kg
 9.84" 250 mm 5.3 kg FC
 21.65" 550 mm 8.9 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

86°

W=3.94 | R=0.039 | V=0.47 in
 W=100 | R=1.0 | V=12 mm



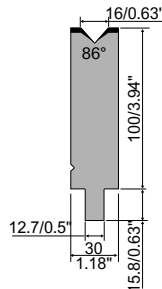
ASD100.16.86

19.68" 500 mm 8.9 kg
 9.84" 250 mm 6.3 kg FC
 21.65" 550 mm 8.9 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

86°

W=3.94 | R=0.063 | V=0.63 in
 W=100 | R=1.6 | V=16 mm



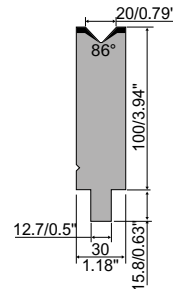
ASD100.20.86

19.68" 500 mm 12.2 kg
 9.84" 250 mm 6.1 kg FC
 21.65" 550 mm 13.5 kg FW

42Cr: 900-1150 N/mm²
 115 Ton/mt max - 39 US Ton/ft max

86°

W=3.94 | R=0.079 | V=0.79 in
 W=100 | R=2.0 | V=20 mm



FC: 9.84" - 250 mm

in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98

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

FW: 21.65" - 550 mm

in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98

mm: 200-100-50-45-40-35-30-25-25





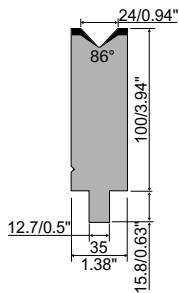
ASD100.24.86

19.68" 500 mm 14.0 kg
 9.84" 250 mm 7.0 kg FC
 21.65" 550 mm 15.5 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

86°

W=3.94 | R=0.098 | V=0.94 in
 W=100 | R=2.5 | V=24 mm



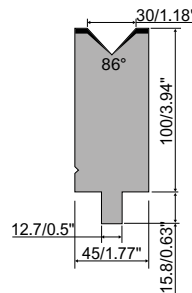
ASD100.30.86

19.68" 500 mm 17.6 kg
 9.84" 250 mm 8.8 kg FC
 21.65" 550 mm 19.4 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

86°

W=3.94 | R=0.118 | V=1.18 in
 W=100 | R=3.0 | V=30 mm



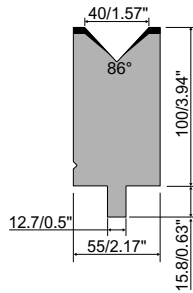
ASD100.40.86

19.68" 500 mm 6.5 kg
 9.84" 250 mm 14.0 kg FC
 21.65" 550 mm 22.8 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

86°

W=3.94 | R=0.118 | V=1.57 in
 W=100 | R=3.0 | V=40 mm



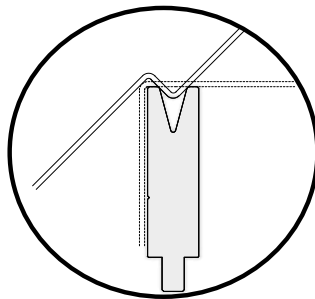
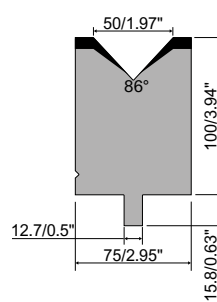
ASD100.50.86

19.68" 500 mm 6.5 kg
 9.84" 250 mm 14.0 kg FC
 21.65" 550 mm 22.8 kg FW

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

86°

W=3.94 | R=0.118 | V=1.97 in
 W=100 | R=3.0 | V=50 mm



FC: 9.84" - 250 mm
 in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 50-45-40-40-35-30-25-25

FW: 21.65" - 550 mm
 in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 200-100-50-45-40-35-30-25-25





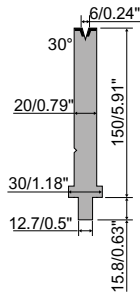
ASD150.06.30

19.68" 500 mm 13.0 kg
 9.84" 250 mm 6.5 kg FC
 21.65" 550 mm 14.3 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=5.91 | R=0.024 | V=0.24 in
 W=150 | R=0.6 | V=6 mm



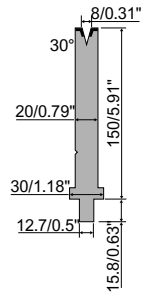
ASD150.08.30

19.68" 500 mm 13.0 kg
 9.84" 250 mm 6.5 kg FC
 21.65" 550 mm 14.3 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=5.91 | R=0.039 | V=0.31 in
 W=150 | R=1.0 | V=8 mm



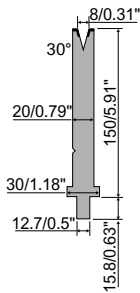
ASD150.10.30

19.68" 500 mm 12.8 kg
 9.84" 250 mm 6.4 kg FC
 21.65" 550 mm 13.9 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=5.91 | R=0.039 | V=0.39 in
 W=150 | R=1.0 | V=10 mm



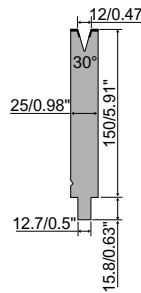
ASD150.12.30

19.68" 500 mm 15.2 kg
 9.84" 250 mm 7.6 kg FC
 21.65" 550 mm 16.7 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

30°

W=5.91 | R=0.039 | V=0.47 in
 W=150 | R=1.0 | V=12 mm



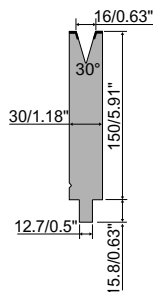
ASD150.16.30

19.68" 500 mm 17.7 kg
 9.84" 250 mm 8.9 kg FC
 21.65" 550 mm 19.6 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

30°

W=5.91 | R=0.063 | V=0.63 in
 W=150 | R=1.6 | V=16 mm



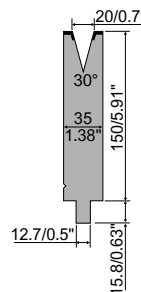
ASD150.20.30

19.68" 500 mm 20.1 kg
 9.84" 250 mm 10.0 kg FC
 21.65" 550 mm 22.0 kg FW

42Cr: 900-1150 N/mm²
 60 Ton/mt max - 20 US Ton/ft max

30°

W=5.91 | R=0.079 | V=0.079 in
 W=150 | R=2.0 | V=20 mm



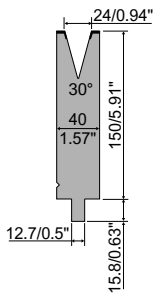
ASD150.24.30

19.68" 500 mm 22.3 kg
 9.84" 250 mm 11.2 kg FC
 21.65" 550 mm 24.5 kg FW

42Cr: 900-1150 N/mm²
 65 Ton/mt max - 22 US Ton/ft max

30°

W=5.91 | R=0.098 | V=0.94 in
 W=150 | R=2.5 | V=24 mm



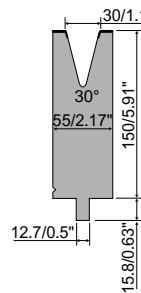
ASD150.30.30

19.68" 500 mm 30.0 kg
 9.84" 250 mm 15.0 kg FC
 21.65" 550 mm 33.0 kg FW

42Cr: 900-1150 N/mm²
 90 Ton/mt max - 30 US Ton/ft max

30°

W=5.91 | R=0.118 | V=1.1-8 in
 W=150 | R=3.0 | V=30 mm



FC: 9.84" - 250 mm
 in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 50-45-40-40-35-30-25-25

FW: 21.65" - 550 mm
 in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 200-100-50-45-40-35-30-25-25





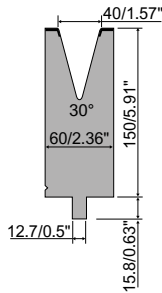
ASD150.40.30

19.68" 500 mm 30.1 kg
 9.84" 250 mm 15.1 kg FC
 21.65" 550 mm 33.1 kg FW

42Cr: 900-1150 N/mm²
 90 Ton/mt max - 30 US Ton/ft max

30°

W=150 | R=5.0 | V=40 mm
 W=5.91 | R=0.197 | V=1.57 in



Staged extra tall block dies

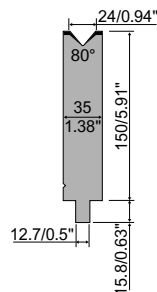
ASD150.24.80

19.68" 500 mm 20.9 kg
 9.84" 250 mm 10.4 kg FC
 21.65" 550 mm 22.9 kg FW

42Cr: 900-1150 N/mm²
 70 Ton/mt max - 24 US Ton/ft max

80°

W=5.91 | R=0.098 | V=0.94 in
 W=150 | R=2.5 | V=24 mm



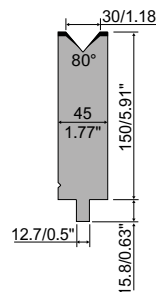
ASD150.30.80

19.68" 500 mm 26.3 kg
 9.84" 250 mm 13.1 kg FC
 21.65" 550 mm 28.9 kg FW

42Cr: 900-1150 N/mm²
 90 Ton/mt max - 30 US Ton/ft max

80°

W=5.91 | R=0.197 | V=1.18 in
 W=150 | R=5.0 | V=30 mm



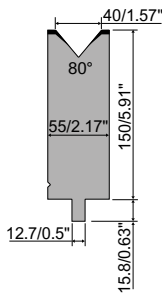
ASD150.40.80

19.68" 500 mm 31.3 kg
 9.84" 250 mm 15.6 kg FC
 21.65" 550 mm 34.4 kg FW

42Cr: 900-1150 N/mm²
 120 Ton/mt max - 40 US Ton/ft max

80°

W=5.91 | R=0.197 | V=1.57 in
 W=150 | R=5.0 | V=40 mm



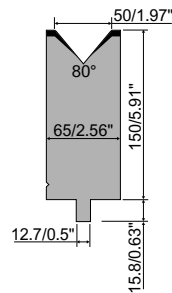
ASD150.50.80

19.68" 500 mm 36.0 kg
 9.84" 250 mm 18.0 kg FC
 21.65" 550 mm 39.6 kg FW

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

80°

W=5.91 | R=0.197 | V=1.97 in
 W=150 | R=5.0 | V=50 mm



FC: 9.84" - 250 mm
 in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 50-45-40-40-35-30-25-25

FW: 21.65" - 550 mm
 in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 200-100-50-45-40-35-30-25-25



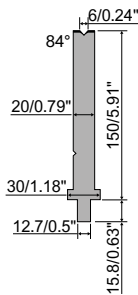
ASD150.06.84

19.68" 500 mm 13.1 kg
 9.84" 250 mm 6.6 kg FC
 21.65" 550 mm 14.3 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

84°

W=5.91 | R=0.024 | V=0.24 in
 W=150 | R=0.6 | V=6 mm



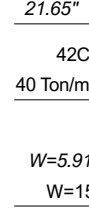
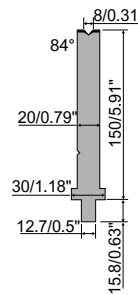
ASD150.08.84

19.68" 500 mm 13.1 kg
 9.84" 250 mm 6.6 kg FC
 21.65" 550 mm 14.3 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

84°

W=5.91 | R=0.031 | V=0.31 in
 W=150 | R=0.8 | V=8 mm



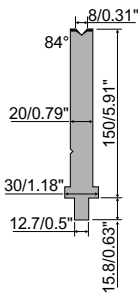
ASD150.10.84

19.68" 500 mm 13.0 kg
 9.84" 250 mm 6.5 kg FC
 21.65" 550 mm 14.3 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

84°

W=5.91 | R=0.039 | V=0.39 in
 W=150 | R=1.0 | V=10 mm



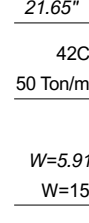
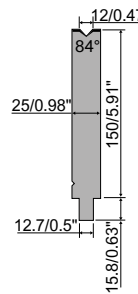
ASD150.12.84

19.68" 500 mm 15.5 kg
 9.84" 250 mm 7.8 kg FC
 21.65" 550 mm 17.0 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

84°

W=5.91 | R=0.039 | V=0.47 in
 W=150 | R=1.0 | V=12 mm



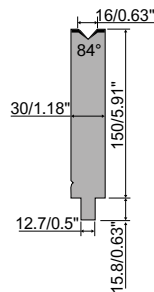
ASD150.16.84

19.68" 500 mm 18.4 kg
 9.84" 250 mm 9.2 kg FC
 21.65" 550 mm 20.2 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

84°

W=5.91 | R=0.063 | V=0.63 in
 W=150 | R=1.6 | V=16 mm



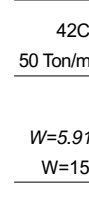
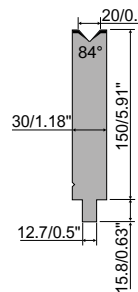
ASD150.20.84

19.68" 500 mm 18.3 kg
 9.84" 250 mm 9.1 kg FC
 21.65" 550 mm 20.0 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

84°

W=5.91 | R=0.079 | V=0.79 in
 W=150 | R=2.0 | V=20 mm



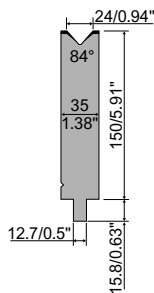
ASD150.24.84

19.68" 500 mm 20.9 kg
 9.84" 250 mm 10.4 kg FC
 21.65" 550 mm 22.9 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

84°

W=5.91 | R=0.098 | V=0.94 in
 W=150 | R=2.5 | V=24 mm



FC: 9.84" - 250 mm
 in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 50-45-40-40-35-30-25-25

FW: 21.65" - 550 mm
 in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 200-100-50-45-40-35-30-25-25





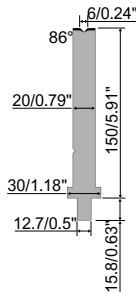
ASD150.06.86

19.68" 500 mm 6.5 kg
 9.84" 250 mm 14.0 kg FC
 21.65" 550 mm 22.8 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

84°

W=5.91 | R=0.024 | V=0.24 in
 W=150 | R=0.6 | V=6 mm



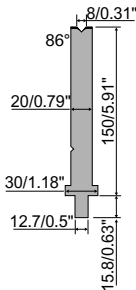
ASD150.08.86

19.68" 500 mm 6.5 kg
 9.84" 250 mm 14.0 kg FC
 21.65" 550 mm 22.8 kg FW

42Cr: 900-1150 N/mm²
 40 Ton/mt max - 13 US Ton/ft max

86°

W=5.91 | R=0.031 | V=0.31 in
 W=150 | R=0.8 | V=8 mm



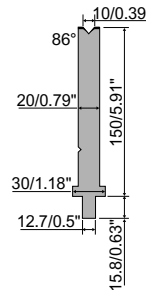
ASD150.10.86

19.68" 500 mm 13.0 kg
 9.84" 250 mm 6.5 kg FC
 21.65" 550 mm 14.3 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

86°

W=5.91 | R=0.039 | V=0.39 in
 W=150 | R=1.0 | V=10 mm



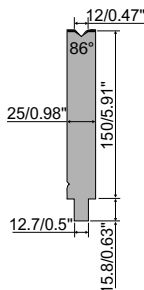
ASD150.12.86

19.68" 500 mm 15.5 kg
 9.84" 250 mm 7.8 kg FC
 21.65" 550 mm 17.0 kg FW

42Cr: 900-1150 N/mm²
 50 Ton/mt max - 17 US Ton/ft max

86°

W=5.91 | R=0.039 | V=0.47 in
 W=150 | R=1.0 | V=12 mm



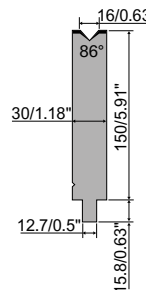
ASD150.16.86

19.68" 500 mm 18.4 kg
 9.84" 250 mm 9.2 kg FC
 21.65" 550 mm 20.0 kg FW

42Cr: 900-1150 N/mm²
 70 Ton/mt max - 24 US Ton/ft max

86°

W=5.91 | R=0.063 | V=0.63 in
 W=150 | R=1.6 | V=16 mm



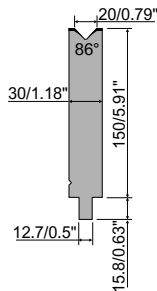
ASD150.20.86

19.68" 500 mm 18.3 kg
 9.84" 250 mm 9.1 kg FC
 21.65" 550 mm 20.0 kg FW

42Cr: 900-1150 N/mm²
 70 Ton/mt max - 24 US Ton/ft max

86°

W=5.91 | R=0.079 | V=0.79 in
 W=150 | R=2.0 | V=20 mm



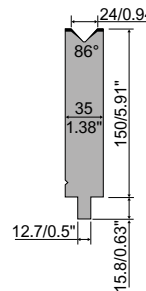
ASD150.24.86

19.68" 500 mm 20.9 kg
 9.84" 250 mm 10.5 kg FC
 21.65" 550 mm 23.0 kg FW

42Cr: 900-1150 N/mm²
 70 Ton/mt max - 24 US Ton/ft max

86°

W=5.91 | R=0.098 | V=0.94 in
 W=150 | R=2.5 | V=24 mm



FC: 9.84" - 250 mm
 in: 1.96-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 50-45-40-40-35-30-25-25

FW: 21.65" - 550 mm
 in: 7.87-3.94-1.97-1.77-1.57-1.37-1.18-0.98-0.98
 mm: 200-100-50-45-40-35-30-25-25

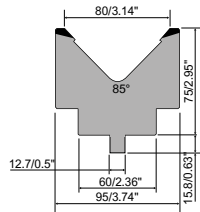


ASD80.85.80

32.87" 835 mm 33.5 kg
 16.34" 415 mm 16.6 kg
 31.29" 795 mm 31.9 kg FX
 31.69" 805 mm 32.2 kg F

C45: 560-710 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

85°
 W=3.14 | R=0.24 | V=3.14 in
 W=80 | R=6.0 | V=80 mm

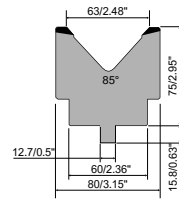


ASD75.85.63

32.87" 835 mm 29.2 kg
 16.34" 415 mm 14.5 kg
 31.29" 795 mm 27.8 kg FX
 31.69" 805 mm 28.0 kg F

C45: 560-710 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

85°
 W=2.96 | R=0.196 | V=2.48 in
 W=75 | R=5.0 | V=63 mm

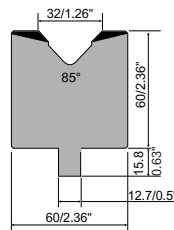


ASD60.32.85

32.87" 835 mm 21.6 kg
 16.34" 415 mm 10.7 kg
 31.29" 795 mm 20.6 kg FX
 31.69" 805 mm 20.8 kg F

C45: 560-710 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

85°
 W=2.36 | R=0.157 | V=1.269 in
 W=60 | R=4.0 | V=32 mm

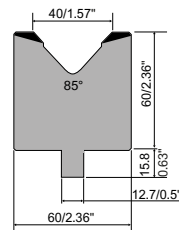


ASD60.40.85

32.87" 835 mm 20.0 kg
 16.34" 415 mm 10.5 kg
 31.29" 795 mm 19.0 kg FX
 31.69" 805 mm 18.3 kg F

C45: 560-710 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

85°
 W=2.36 | R=0.157 | V=1.57 in
 W=60 | R=4.0 | V=40 mm

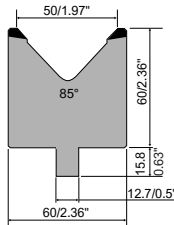


ASD60.50.85

32.87" 835 mm 19.0 kg
 16.34" 415 mm 9.5 kg
 31.29" 795 mm 18.1 kg FX
 31.69" 805 mm 18.3 kg F

C45: 560-710 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

85°
 W=2.36 | R=0.16 | V=1.97 in
 W=60 | R=4.0 | V=50 mm

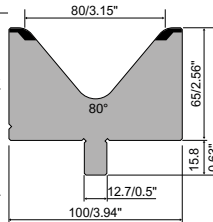


ASD65.80.80

39.37" 1000 mm 39.0 kg
 19.68" 500 mm 20.0 kg
 43.31" 1100 mm 43.0 kg F

42Cr: 900-1150 N/mm²
 170 Ton/mt max - 57 US Ton/ft max

80°
 W=2.56 | R=0.394 | V=3.15 in
 W=65 | R=10 | V=80 mm

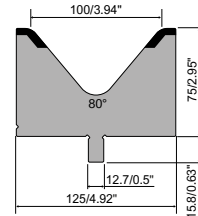


ASD85.100.80

39.37" 1000 mm 62.0 kg
 19.68" 500 mm 31.0 kg
 43.31" 1100 mm 69.0 kg F

42Cr: 900-1150 N/mm²
 230 Ton/mt max - 77 US Ton/ft max

80°
 W=3.35 | R=0.472 | V=3.94 in
 W=85 | R=12 | V=100 mm



FX: 31.29" - 795 mm

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

F: 31.69" - 805 mm

in: 3.94-14.56-0.39-0.59-0.78-1.57-1.57-1.96-7.87
 mm: 100-370-10-15-20-40-50-200

ASD95.80.100

32.87" 835 mm 46.2 kg
 16.34" 415 mm 22.9 kg
 31.29" 795 mm 44.0 kg FX
 31.69" 805 mm 44.5 kg F

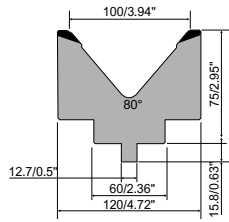
C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

80°

W=3.74 | R=0.314 | V=3.94 in

W=95 | R=8.0 | V=100 mm



ASD103.80.125

32.87" 835 mm 62.0 kg
 16.34" 415 mm 31.0 kg
 31.29" 795 mm 59.8 kg FX
 31.69" 805 mm 59.8 kg F

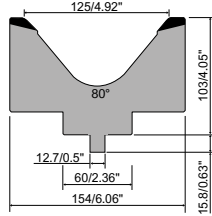
C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

80°

W=4.05 | R=0.59 | V=4.92 in

W=103 | R=15 | V=125 mm



ASD130.160.80

32.87" 835 mm 64.9 kg
 16.34" 415 mm 32.2 kg
 31.29" 795 mm 61.4 kg FX
 31.69" 805 mm 62.5 kg F

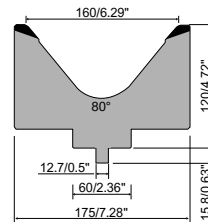
C45: 560-710 N/mm²

100 Ton/mt max - 33 US Ton/ft max

80°

W=5.12 | R=0.39 | V=6.29 in

W=130 | R=10 | V=160 mm



ASD65.60.60

39.37" 1000 mm 39.0 kg
 19.68" 500 mm 20.0 kg
 43.31" 1100 mm 43.0 kg F

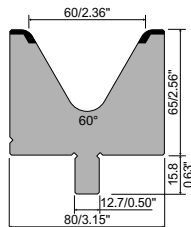
42Cr: 900-1150 N/mm²

170 Ton/mt max - 57 US Ton/ft max

60°

W=2.56 | R=0.276 | V=2.36 in

W=65 | R=7 | V=60 mm



FX: 31.29" - 795 mm

in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87

mm: 100-250-20-25-30-35-40-45-50-200

F: 31.69" - 805 mm

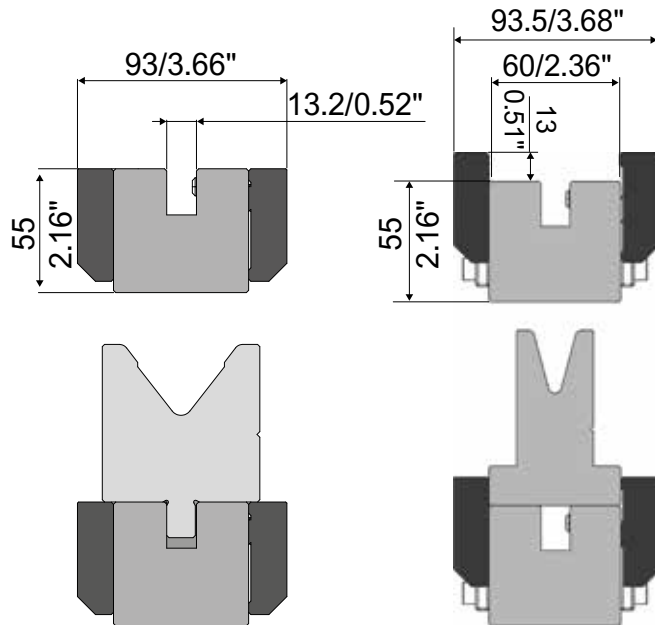
in: 3.94-14.56-0.39-0.59-0.78-1.57-1.57-1.96-7.87

mm: 100-370-10-15-20-40-50-200



CTS60.U

41.34" 1050 mm 29.0 kg
 20.55" 522 mm 14.5 kg



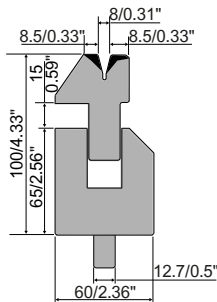
Rolleri **BLACKFIRE** is a surface treatment against steel oxidation. After such treatment tools become black and laser marking golden.

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.

ASH110.28.08

32.87" 835 mm 31.7 kg
 16.34" 415 mm 15.7 kg

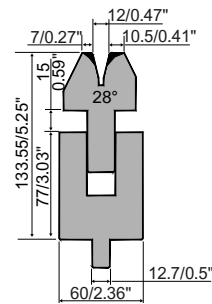
C45: 560-710 N/mm²
 80 Ton/mt max - 27 US Ton/ft max



ASH135.28.12

32.87" 835 mm 40.9 kg
 16.34" 415 mm 20.3 kg

C45: 560-710 N/mm²
 100 Ton/mt max - 33 US Ton/ft max



S mm	S in	A mm	A in	R.420 N/mm ² kN/m	R.700 N/mm ² kN/m
0.6	0.02	3.0	0.12	90	150
0.8	0.03	3.0	0.12	120	200
1.0	0.04	3.5	0.14	150	250
1.25	0.05	3.5	0.14	170	260
1.5	0.06	4.6	0.18	220	380
2.0	0.08	5.5	0.22	300	500
2.5	0.10	6.5	0.26	550	-
3.0	0.12	8.0	0.31	700	.



S mm	S in	A mm	A in	R.420 N/mm ² kN/m	R.700 N/mm ² kN/m
0.6	0.02	3.0	0.12	230	350
0.8	0.03	3.0	0.12	320	500
1.0	0.04	3.5	0.14	400	600
1.25	0.05	3.5	0.14	500	800
1.5	0.06	4.6	0.18	630	950
2.0	0.08	5.5	0.22	800	1300
2.5	0.10	6.5	0.26	900	-
3.0	0.12	8.0	0.31	1000	-



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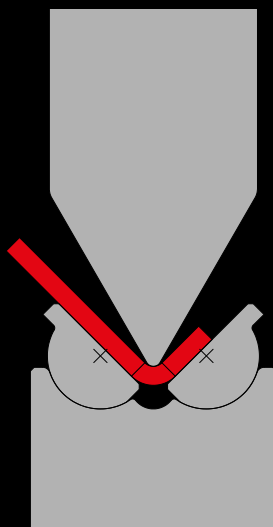


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ROLLA-V DIES

Rolla-V dies differ from traditional dies thanks to two rotors where sheet metal lay before being bent. During bending these rotors accompany sheet metal and reduce consistently its friction resistance and the minimum flange. This die type applies the principles of swivel bending and for this reason sheet metal reaction is different. In case there are holes near the bending line, they are not deformed or flared-out.



Sheet metal is always supported during bending

Minimum sheet metal movement onto inserts and therefore minimum marks

Internal bending radius equal to punch tip radius



Rolla-V dies have many advantages, but the main reasons for selecting a Rolla-V are:

Very short flanges

As material utilisation is always a common consideration for modern manufacturers, if it is possible to reduce flange sizes by even 5% this can have significant cost savings for the material bill.

On traditional fixed V dies the edge of the component needs to remain resting on the corner of the die V in order to obtain a good bend with no distortion or flaring.

Also, many components have what we call a “cut-out with a small flange along a longer and larger flange” – for these components, because it is supported during bending, it is possible to achieve very small flange sizes.

Bending close to holes and slots ,this includes forming tapered or feathered edges ,keeping flaring at the smallest end to a minimal

Some components have tapered or feathered edges which run-out to the bottom of the bend.

Using traditional fixed V dies it is usual for the final parts of the taper flange to flare-out because this part of the flange slips into the fixed V and is unsupported during the bend.

Because the Rolla-V inserts do support the taper flange almost to the bend line, the amount of flare is kept to an absolute minimum and is not usually noticeable.

Minimal marking

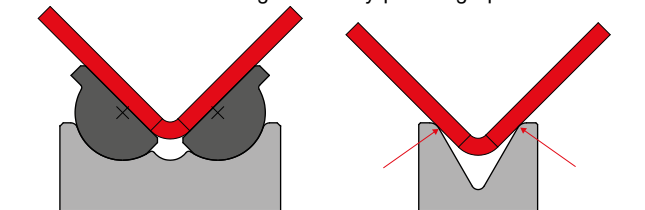
The material is completely supported during bending and therefore, there is no dragging over a vee edge and so the marking is significantly less than traditional bending using standard vees.

Also, because the material has not slid over any ‘edges’ on the die the tram-lining effect will be minimised. This is because the amount of lateral movement between the material and the Rolla-V inserts is very small and is spread over a wide area, so the ‘tram-line’ effect is almost eliminated.

Eliminate the need for second operations

Many aesthetic components must have a blemish-free surface finish either because the bare metal finish is visible on the final component or the metal has to be painted/powder coated after forming.

The use of time consuming secondary polishing operations can be



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dramatically reduced if bending with the Rolla-V.

The traditional ‘tramlines’ are not present and any scuffing of other marking is really minimised when comparing a Rolla-V bent component with one bent on traditional fixed V.

No secondary operations, product cost is reduced more importantly delivery time is reduced.

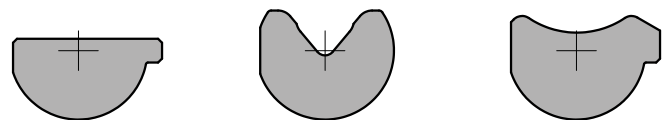
Each of the models has its own maximum outside radii and because the folding action of the tool gives extremely accurate radii's, it wraps itself around the tip on the top punch i.e. if your punch has 1mm nose radii, generally if the material being formed is comfortably working within the parameters of the tool there will be a 1m internal radii in the component.

ADJUSTABLE ROLLA-V

All advantages described for Rolla-V dies are extended to the adjustable models.

Obviously the adjustable is as it says and the ‘vee size’ is adjustable. Each of the HD models, 2, 2.5, 3 & 4 has its own parameters. Top formers can be supplied individually to form these radii, unfortunately there is not an adjustable top former.

There are 3 types of insert for all of these adjustable models, flat style for normal bending, concave style for producing complete radiused ‘U’ channels in one hit, and finally ‘Pacman’ style inserts to produce flat type channels. One standard bottom tool to do all these.



NON STANDARD ROLLA-V TOOLS

Whilst there is normally a standard Rolla-V to suit most applications, on occasion a project needs to achieve a profile that is outside of standard parameters. As we manufacture every part of the Rolla-V in our “State of the Art” facility we regularly manufacture non standard Rolla-V profiles to suit a specific application.

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.



The Rolla-V has a complete range of models and each one represents a 'vee' size, which is measured by the centre of the radius inserts. Whether forming 0,02" to 1,18" thick, an outside flange length of 0,10" in 0,039" thick material to 1,57" in 1,18" thick material, there is a Rolla-V die for the operation.

Rolla-V offers a wide die range with different dimensions and is able to bend different sheet metal thicknesses; in fact each model can usually bend 3 different thicknesses. Another important feature is their resistance, as it reaches 2500 kN/m.

All dies are anticorrosion coated and don't need any particular maintenance.

EQUIVALENT V SIZE

For each Rolla-V die model you can find the 'vee' size it corresponds to in a normal die. Such equivalent vee size is measured by the centre of its radius inserts.

MAX TOOL LOAD

This value represents the max. allowed bending force that each die can stand.

MATERIAL THICKNESS

The table shows the sheet metal thickness range that the die can bend. According to the sheet metal thickness you have to bend, find all possible dies you can use and check the following values to find the most suitable die model for your needs.

MIN. BENDING ANGLE

For each sheet metal thickness, the table indicates the narrowest angle you can reach by bending that thickness with the selected die model.

NEEDED PRESS FORCE

The table indicates the necessary press force to bend the selected mild steel thickness with the selected die.

The formula to calculate the necessary press force in kN/m is:

$$FN \text{ (kN/m)} = \frac{Rm \times (\text{thickness})^2 \times C}{C} \times \left(1 + \frac{4 \times \text{thickness}}{C}\right)$$

Aluminium: Rm=200-300 N/mm²

Steel: Rm=370-450 N/mm²

Stainless: Rm=650-700 N/mm²

Example: 2 mm aluminium with model 2

$$FN \text{ (kN/m)} = \frac{300 \times 2^2}{13.16} \times \left(1 + \frac{4 \times 2}{13.16}\right)$$

Needed press force = 146.62 kN/m

MIN. OUTSIDE FLANGE

For each sheet metal thickness, the table indicates the minimum outside edge you can bend by using the selected die model.

$$BEM \text{ (kN/m)} = \sqrt{B^2 / 2}$$

Example: calculation of the min. outside flange with model 1

$$BEM \text{ (kN/m)} = \sqrt{7.17^2 / 2}$$

Minimum edge = 5.07 mm

MAX. OUTSIDE RADIUS

For each sheet metal thickness, the table indicates the maximum outside radius you can produce by bending that thickness with the selected die model. If you deduct the sheet metal thickness value from the max. outside radius, you will obtain the max. inside radius and therefore the max. punch tip radius you can use. Bear in mind that during the bending process, the sheet metal is wrapped around the punch tip and tends to produce the internal bending radius equal to the punch tip radius used if its features enable this.

$$\text{Rule 1: } RE \text{ (mm)} = \sqrt{(C^2 / 2) - (s+Z)}$$

Rule 2: if OUTSIDE RADIUS > B/2.2, ER=B/2.2

despite sheet metal thickness, max. outside radius is the result of rule 2. You cannot get a bigger radius than that.

Example: 3 mm with model 2.5

Rule 1: 17.8 - 5 = 12.8

Rule 2: 26.34 / 2.2 = 11.97

MAX. OUTSIDE RADIUS = 11.97

PUNCH TIP RADIUS

To calculate the correct punch tip radius to use according to the outside radius, use the following formula:

Model 1 and 2

$$pR = (\text{outside radius} - \text{sheet metal thickness}) \times 0.9$$

Model 2.5, 3, 3.5 and 4

$$pR = (\text{outside radius} - \text{sheet metal thickness}) \times 0.8$$

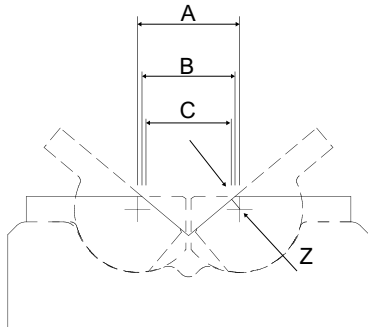


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Model	A		B		C		Z	
	in	mm	in	mm	in	mm	in	mm
XT1	0.22	5.7	0.2	5.04	0.18	4.57	0.03	0.8
XT2	0.39	10	0.36	9.21	0.34	8.66	0.04	0.95
Model 1	0.31	8	0.28	7.17	0.26	6.59	0.04	1
Model 2	0.59	15	0.55	13.92	0.52	13.16	0.05	1.3
Model 2.5	1.1	28	1.04	26.34	0.99	25.17	0.08	2
Model 3	1.5	38	1.32	33.44	1.19	30.22	0.22	5.5
Model 3.5	2.36	60	2.25	57.1	2.17	55.05	0.14	3.5
Model 4	3.35	85	3.15	80.03	3.01	76.51	0.24	6

	with V		Max. tool load (kN/m)	Material Thickness		Min. bending angle	Needed press force mild steel with max. 450 N/mm ² (kN/m)	Needed press force stainless steel with max. 700 N/mm ² (kN/m)	Min. outside flange		Max. outside radius	
	in	mm		in	mm				in	mm	in	mm
Model XT1 Max. recommended thickness = 0.05" 1.2 mm	0.22	5.7	500	0.02	0.5	60°	50	75	0.11	2.7	0.07	1.7
				0.04	1.0	60°	180	260	0.16	4.0	0.05	1.3
Model XT2 Max. recommended thickness = 0.09" 2.3 mm	0.39	10	500	0.05	1.2	60°	120	170	0.19	4.9	0.13	3.3
				0.79	2.0	60°	320	450	0.24	6.0	0.09	2.4
Model 1 Max. recommended thickness = 0.06" 1.5 mm	0.31	8	1000	0.03	0.7	40°	50	70	0.12	3	0.12	3
				0.04	1.1	35°	130	200	0.15	3.9	0.1	2.6
				0.06	1.5	35°	270	410	0.17	4.2	0.09	2.2
Model 2 Max. recommended thickness = 0.12" 3.2 mm	0.59	15	1500	0.08	2	59°	210	320	0.33	8.5	0.24	6
				0.12	3	47°	550	850	0.37	9.3	0.2	5
				0.13	3.2	47°	650	1000	0.37	9.3	0.19	4.8
Model 2.5 Max. recommended thickness = 0.25" 6.3 mm	1.1	28	2500	0.08	2	46°	100	150	0.73	18.6	0.52	13.2
				0.16	4	46°	470	730	0.73	18.6	0.47	12
				0.24	6	55°	1270	1960	0.73	18.6	0.39	9.8
Model 3 Max. recommended thickness = 0.25" 6.3 mm	1.5	38	2500	0.08	2	68°	70	110	0.89	22.5	0.55	13.9
				0.16	4	47°	340	500	0.89	22.5	0.47	11.9
				0.24	6	50°	900	1300	0.89	22.5	0.39	9.9
Model 3.5 Max. recommended thickness = 0.31" 8 mm	2.36	60	2500	0.24	6	75°	440	610	1.53	39	0.79	20
				0.31	8	75°	850	1190	1.53	39	0.79	20
				0.47	12	73°	1290	2150	2.23	56.6	1.43	36.4
Model 4 Max. recommended thickness = 0.63" 16 mm	3.35	85	3000	0.24	6	78°	260	440	2.23	56.6	1.43	36.4
				0.31	8	76°	500	840	2.23	56.6	1.43	36.4
				0.47	12	73°	1290	2150	2.23	56.6	1.43	36.4



Download Roller Bending App.

Further to many interesting contents, the free app contains the tool for sheet metal development calculation and bending ruler.

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.



COMPATIBILITY

serie \ tools	R1	R2	R3	R4	R5
RVP	●	-	-	-	-
RVS	○	-	-	-	-
RVT55-60	-	●	●	-	○
RVT100	-	●	●	-	○
RVT90	-	-	-	●	-
RVM	○	○	○	○	○
RVHD-RVPV	○	○	○	○	○
XT	●	○	○	-	-

○ available for some models only or on request with modifications

STANDARD LENGTH

serie \ length	RVP	RVS	RVT 55-60	RVT 100	RVT 90	RVM	RVHD RVPV	XT
1.97" 50 mm	-	-	-	-	-	-	-	●
3.94" 100 mm	-	-	-	-	-	-	-	●
7.87" 200 mm	-	-	-	-	-	-	-	●
9.84" 250 mm	-	-	-	-	-	-	●	-
19.68" 500 mm	●	●	●	●	●	●	●	●

ROTORS MATERIAL

material \ model	1	2	2.5	3	3.5	4	XT
LR 606 through hardened and triple tempered to give hardness of 54-56 HRC	●	●	-	-	-	-	●
D2 through hardened in a Vacuum to 61 HRC (Rockwell)	-	-	●	●	●	●	-

All measurements using HRc hardness are accurate to within 2 points.

SEGMENTATION

single segments are also available on request - contact info@rolleriusa.com to know more about price and availability

Model 1 and XT Serie: 17.32" | 440 mm
in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59
mm: 200-100-50-30-25-20-15



Model 2: 17.72" | 450 mm
in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79
mm: 200-100-40-35-30-25-20



Model 2.5: 18.50" | 470 mm
in: 7.87-3.94-1.97-1.77-1.57-1.38
mm: 200-100-50-45-40-35



Model 3: 17.91" | 455 mm
in: 7.87-3.94-2.36-1.97-1.77
mm: 200-100-60-50-45



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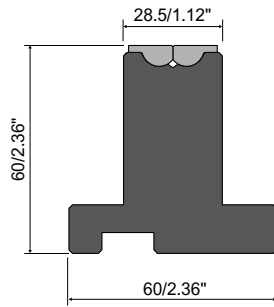
Create your account on www.rolleriusa.com. You can use Rolleriusa website to check the delivery time, request quotes and stay update with the news.

RVP60-1

16.68" 500 mm 6.9 kg
 17.32" 440 mm 6.1 kg F

Model 1

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

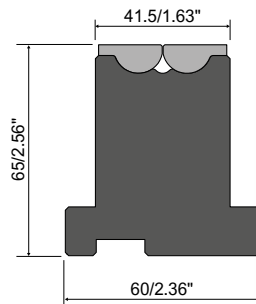


RVP65-2

16.68" 500 mm 7.9 kg
 17.72" 450 mm 7.4 kg F

Model 2

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

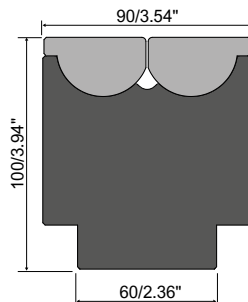


RVP100-3

16.68" 500 mm 28.8 kg
 17.91" 455 mm 26.2 kg F

Model 3

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 80 US Ton/ft max



Model 1: 17.32" - 440 mm
 in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59
 mm: 200-100-50-30-25-20-15



Model 2: 17.72" - 450 mm
 in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79
 mm: 200-100-40-35-30-25-20

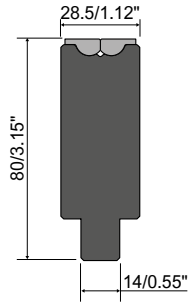


RVS80-1

19.68" 500 mm 6.3 kg
 17.32" 440 mm 5.8 kg F

Model 1

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

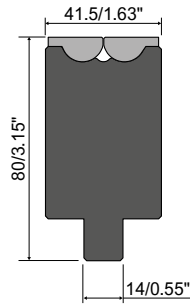


RVS80-2

19.68" 500 mm 8.3 kg
 17.72" 450 mm 7.8 kg F

Model 2

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max



Model 3: 17.91" - 455 mm
 in: 7.87-3.94-2.36-1.97-1.77
 mm: 200-100-60-50-45



Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

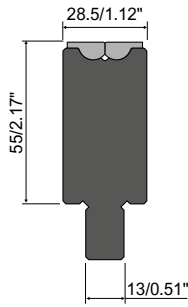


RVT55-1

19.68" 500 mm 5.5 kg
 17.32" 440 mm 5.0 kg F

Model 1

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

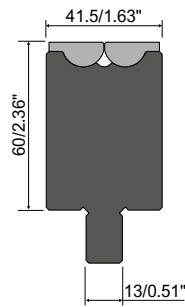


RVT60-2

19.68" 500 mm 7.9 kg
 17.72" 450 mm 7.4 kg F

Model 2

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max



Model 1: 17.32" - 440 mm
 in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59
 mm: 200-100-50-30-25-20-15



Model 2: 17.72" - 450 mm
 in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79
 mm: 200-100-40-35-30-25-20



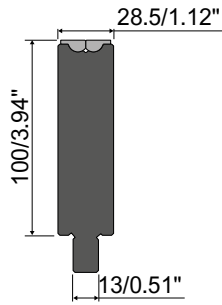


RVT100-1

19.68" 500 mm 9.4 kg
 17.32" 440 mm 8.6 kg F

Model 1

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

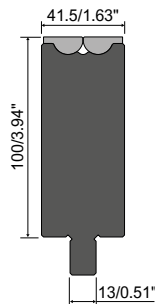


RVT100-2

19.68" 500 mm 12.4 kg
 17.72" 450 mm 11.7 kg F

Model 2

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max

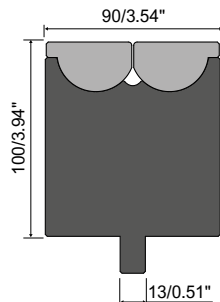


RVT100-3

19.68" 500 mm 30.9 kg
 17.91" 455 mm 28.5 kg F

Model 3

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 80 US Ton/ft max



Model 3: 17.91" - 455 mm
 in: 7.87-3.94-2.36-1.97-1.77
 mm: 200-100-60-50-45



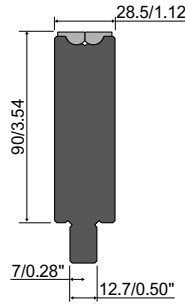
Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

RVT90-1

19.68" 500 mm 9.4 kg
 17.32" 440 mm 7.8 kg F

Model 1

42Cr: 900-1150 N/mm²
 100 Ton/mt max - 33 US Ton/ft max

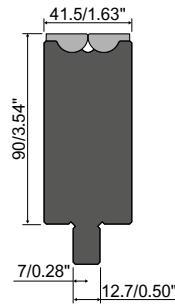


RVT90-2

19.68" 500 mm 11.3 kg
 17.72" 450 mm 10.6 kg F

Model 2

42Cr: 900-1150 N/mm²
 150 Ton/mt max - 50 US Ton/ft max



Model 1: 17.32" - 440 mm
 in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59
 mm: 200-100-50-30-25-20-15



Model 2: 17.72" - 450 mm
 in: 7.87-3.94-1.57-1.38-1.18-0.98-0.79
 mm: 200-100-40-35-30-25-20



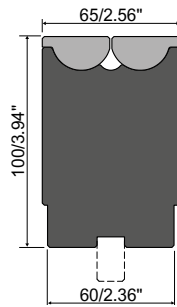
RVM2.5

Without tang

19.68" 500 mm 22.0 kg
 18.50" 470 mm 21.0 kg F

Model 2.5

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 80 US Ton/ft max



RVM2.5-13 / RVM2.5-12.7

With tang 0.51" 13 mm

19.68" 500 mm 23.5 kg
 18.50" 470 mm 22.4 kg F

With tang 0.5" 12.7

19.68" 500 mm 23.5 kg
 18.50" 470 mm 22.4 kg F

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 80 US Ton/ft max

RVM3.5

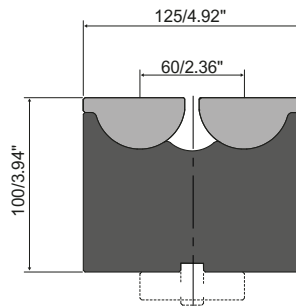
With base 2.36" 60

9.84" 250 mm 22.0 kg
 19.68" 500 mm 44.0 kg F

Model 3.5

42Cr: 900-1150 N/mm²
 200 Ton/mt max - 66 US Ton/ft max

NEW



RVM3.5-13 / RVM3.5-12.7

With tang 0.51" 13 mm

9.84" 250 mm 22.0 kg
 19.68" 500 mm 44.0 kg F

With tang 0.5" 12.7

9.84" 250 mm 22.0 kg
 19.68" 500 mm 44.0 kg F

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 80 US Ton/ft max

Model 2.5: 18.50" - 470 mm
 in: 7.87-3.94-1.97-1.77-1.57 -1.38
 mm: 200-100-50-45-40-35



Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

RVM70-3 / RVM70-3-60

Without tang

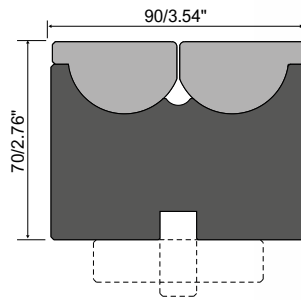
19.68" 500 mm 20.6 kg
 17.91" 455 mm 18.7 kg F

With tang 2.36" - 60 mm

19.68" 500 mm 23.5 kg
 17.91" 455 mm 23.0 kg F

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 80 US Ton/ft max

Model 3



RVM70-3-13 / RVM70-3-12.7

With tang 0.51" - 13 mm

19.68" 500 mm 22.1 kg
 17.91" 455 mm 20.1 kg F

With offset tang 0.5" - 12.7

19.68" 500 mm 22.1 kg
 17.91" 455 mm 20.1 kg F

42Cr: 900-1150 N/mm²
 250 Ton/mt max - 80 US Ton/ft max

RVM90-4 / RVM90-4-60

Without tang

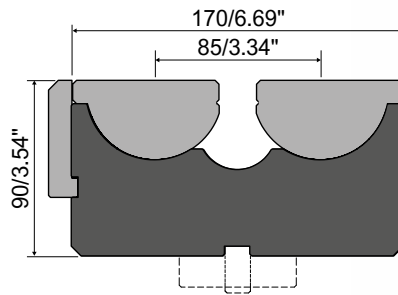
9.84" 250 mm 56.6 kg
 19.68" 500 mm 22.7 kg

With tang 2.36" - 60 mm

9.84" 250 mm 61.3 kg
 19.68" 500 mm 24.6 kg

42Cr: 900-1150 N/mm²
 300 Ton/mt max - 99 US Ton/ft max

Model 4



RVM90-4-13 / RVM90-4-12.7

With tang 0.51" - 13 mm

9.84" 250 mm 58.1 kg
 19.68" 500 mm 23.3 kg

With offset tang 0.5" - 12.7

9.84" 250 mm 58.1 kg
 19.68" 500 mm 23.3 kg

42Cr: 900-1150 N/mm²
 300 Ton/mt max - 99 US Ton/ft max

Model 3: 17.91" - 455 mm
 in: 7.87-3.94-2.36-1.97-1.77
 mm: 200-100-60-50-45



Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

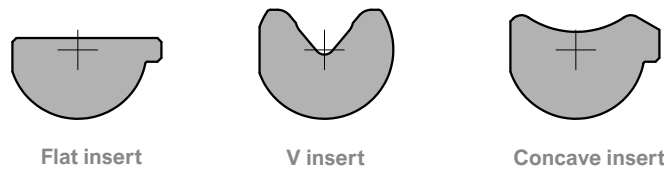
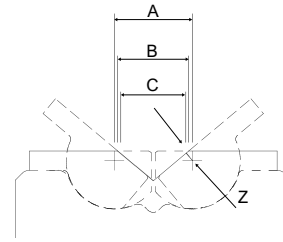


ADJUSTABLE ROLLA-V DIES

All advantages described for Rolla-V dies are extended to the adjustable models.

Obviously the adjustable is as it says and the 'vee size' is adjustable. Each of the HD models, 2, 2.5, 3 & 4 has its own parameters. Top formers can be supplied individually to form these radii, unfortunately there is not an adjustable top former.

There are 3 types of insert for all of these adjustable models, flat style for normal bending, concave style for producing complete radiused 'U' channels in one hit, and finally 'Pacman' style inserts to produce flat type channels. One standard bottom tool to do all these.

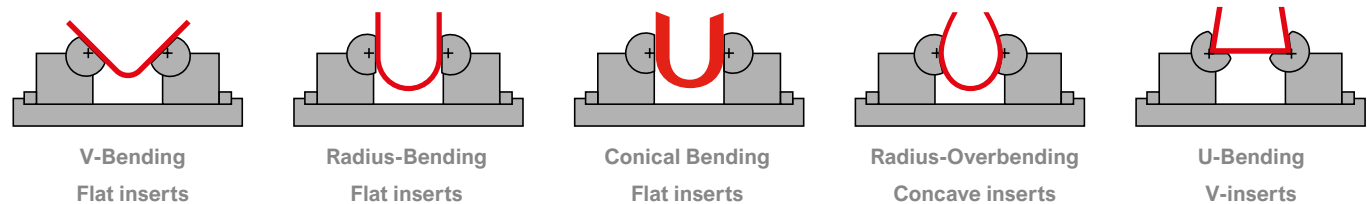


Model	A		B		C		Z	
	in	mm	in	mm	in	mm	in	mm
RVHD2	1.18	30	1.14	29	1.11	28.2	0.05	1.3
RVHD2.5	2.72	69	2.65	67.3	2.61	66.2	0.08	2.0
RVHD3	4.65	118	4.46	113.4	4.34	110.2	0.22	5.5
RVHD4	8.66	220	8.46	215	8.33	211.5	0.24	6.0

Model	A		B		C		Z	
	in	mm	in	mm	in	mm	in	mm
RVHD2	0.63	16	0.59	15	0.56	14.2	0.05	1.3
RVHD2.5	1.1	28	1.04	26.3	0.99	25.2	0.08	2.0
RVHD3	1.5	38	1.31	33.4	1.19	30.2	0.22	5.5
RVHD4	2.7	68.5	2.5	63.5	2.36	60	0.24	6.0

Model	Max. load kN/m	Min. equivalent Vee - Flat Insert		Max. equivalent Vee - Flat insert		Max. Material Thickness - Flat Insert		Min. Outside Radius - Concave Insert		Max. Outside Radius - Concave Insert		Max. Material Thickness - Concave Insert		V Insert equivalent vee		Minimum Channel Width - V Insert		Maximum Channel Width - V Insert		Min/Max External Corner Radius - V insert		MAX Material Thickness - V Insert	
		in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm	in	mm
RVHD2	2000	0.55	14	1.10	28	0.19	5	0.31	8	0.47	12	0.07	2	0.39	10	0.72	18.5	1.25	31.75	0.09-0.15	2.5-4	0.06	1.5
RVHD2.5	2500	0.98	25	2.56	65	0.39	10	0.59	15	1.06	27	0.15	4	0.71	18	1.38	35	2.83	72	0.15-0.35	4-9	0.07	2
RVHD3	3500	1.18	30	4.33	110	0.63	16	0.78	20	1.57	40	0.31	8	0.98	25	1.77	45	4.72	120	0.19-0.47	5-12	0.11	3
RVHD4	3500	2.36	60	8.27	210	1.02	26	1.57	40	2.56	65	0.47	12	1.57	40	2.85	72.5	8.66	220	0.19-0.78	5-20	0.19	5

The present table is a guideline only and specific tests are recommended. For further information contact info@rolleriusa.com and get the correct parameters.



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RVHD2

19.68" 500 mm 67.5 kg
9.84" 250 mm 27 kg

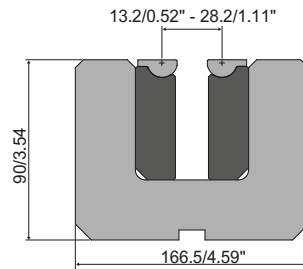
42Cr: 900-1150 N/mm²
200 Ton/mt max - 66 US Ton/ft max

V range

in: 0.52 - 1.11

mm: 13.2 - 28.2

NEW



RVHD2.5

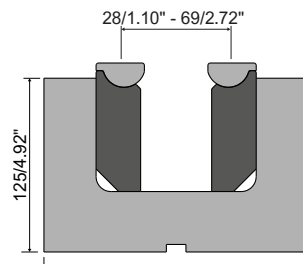
19.68" 500 mm 67.5 kg
9.84" 250 mm 27 kg

42Cr: 900-1150 N/mm²
250 Ton/mt max - 80 US Ton/ft max

V range

in: 0.52 - 1.11

mm: 13.2 - 28.2



RVHD3

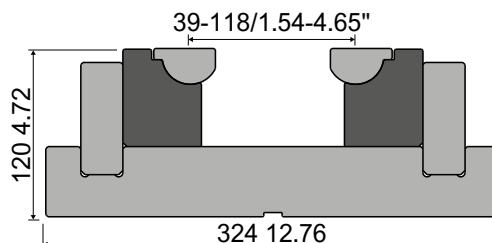
19.68" 500 mm 98 kg
9.84" 250 mm 38.1 kg

42Cr: 900-1150 N/mm²
350 Ton/mt max - 116 US Ton/ft max

V range

in: 0.52 - 1.11

mm: 13.2 - 28.2



RVX1 grease is a lithium-based lubricant with specific properties. Thanks to its additives it can bear high work load generated by compression; it protects components undergoing friction, therefore it is suitable to protect rotors seat and avoid abrasion.

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.

RVHD4

19.68" 500 mm 200 kg

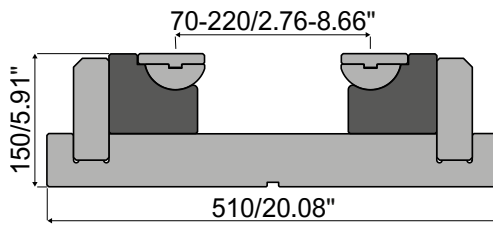
9.84" 250 mm 80 kg

42Cr: 900-1150 N/mm²
400 Ton/mt max - 132 US Ton/ft max

V range

in: 2.76 - 8.66

mm: 70 - 220



RVPV3

19.68" 500 mm 98.0 kg

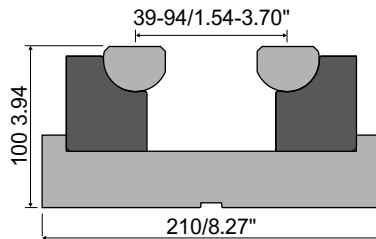
9.84" 250 mm 38.1 kg

42Cr: 900-1150 N/mm²
250 Ton/mt max - 80 US Ton/ft max

V range

in: 1.53 - 3.70

mm: 39 - 94



HANDLES INCLUDED

In order to move easily dies model RVPV3 and RVHD series, dies are equipped with two handles which can be screwed to threaded holes already drilled in the die. Such handles can be used for manual handling (when weight limit enables it) and for mechanical handling.

Thanks to this solution, die positioning and removal is easy and safe.



Download Roller Bending App.

Further to many interesting contents, the free app contains the tool for sheet metal development calculation and bending ruler.



Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

Rolla-V XT dies are suitable to:

- Make tight counterbends thanks to their thin stem
- Bend profiles with deformations near the bending line
- Bend shorter flanges than with conventional dies
- Bend feathered sides without flaring
- Bend profiles with holes or slots near the bending line without deformation.

Reference value for minimum flange: Mild steel

	RVXT-1				RVXT-2			
	<i>in</i>	mm	<i>in</i>	mm	<i>in</i>	mm	<i>in</i>	mm
Radius of the punch/top-tool	R0.019	R0.5	R0.039	R1.0	R0.019	R0.5	R0.039	R1.0
Material thickness 0.019" 0.5 mm	0.10	2.7	0.11	2.9				
Material thickness 0.031" 0.8 mm	0.12	3.2	0.12	3.1	1.19	4.9	0.18	4.7
Material thickness 0.039" 1.0 mm	0.14	3.5	0.14	3.6	0.22	5.5	0.21	5.4
Material thickness 0.059" 1.5 mm					0.24	6.0	0.24	6.1
Material thickness 0.078" 2.0 mm					0.23	5.8	0.26	6.6

Table of force: Tensile strength Rm = 450 N/mm², bending angle 90°

	RVXT-1				RVXT-2					
	<i>in</i>	mm	<i>in</i>	mm	<i>in</i>	mm	<i>in</i>	mm	<i>in</i>	mm
Raggio del punzone	R0.007	R0.2	R0.039	R1.0	R0.007	R0.2	R0.039	R1.0	R0.11	R3.0
Material thickness 0.01" 0.3 mm	1.57	40	1.96	50	1.57	40	1.96	50	1.96	50
Material thickness 0.019" 0.5 m	1.96	50	2.36	60	1.96	50	1.96	50	1.96	50
Material thickness 0.031" 0.8 mm	3.93	100	5.11	130	2.75	70	3.15	80	3.54	90
Material thickness 0.039" 1.0 mm	5.90	150	7.48	190	3.15	80	3.93	100	5.11	130
Material thickness 0.04" 1.2 mm	9.45	240	11.81	300	4.33	110	5.51	140	7.08	180
Material thickness 0.06" 1.6 mm					7.87	200	8.66	220	9.84	250
Material thickness 0.078" 2.0 mm					11.81	300	12.99	330		
Material thickness 0.09" 2.3 mm					15.74	400	16.53	420		

For mark free applications apply **RVX-TAPE** onto Rolla-V dies. This adhesive tape is made of a composite material able to resist compression and at the same time to avoid friction between sheet metal and die.

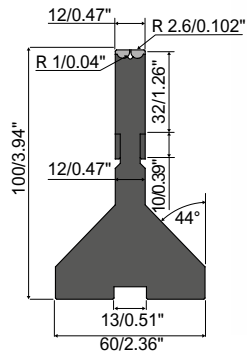
The **Bending handbook** target is to supply practice and useful information to reach quickly the required result. A lot of examples, easy formulas and information which explain the proper attitude towards the bending process.

RVXT-1

1.97"	50 mm	0.2 kg	
3.94"	100 mm	0.4 kg	
7.87"	200 mm	0.9 kg	
19.68"	500 mm	2.1 kg	
17.32"	440 mm	1.9 kg	F

42Cr: 900-1150 N/mm²
50 Ton/mt max - 17 US Ton/ft max

NEW

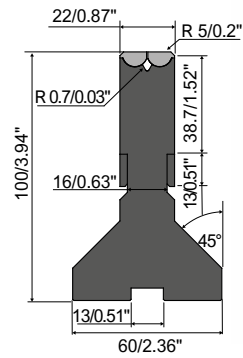


RVXT-2

1.97"	50 mm	1.0 kg	
3.94"	100 mm	2.0 kg	
7.87"	200 mm	4.0 kg	
19.68"	500 mm	10.0 kg	
17.32"	440 mm	8.8 kg	F

42Cr: 900-1150 N/mm²
50 Ton/mt max - 17 US Ton/ft max

NEW



Model 1: 17.32" - 440 mm
in: 7.87-3.94-1.97-1.18-0.98-0.79-0.59
mm: 200-100-50-30-25-20-15



Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

RVX1

GREASE

RVX1 grease is a lithium-based lubricant with specific properties. Thanks to its additives it can bear high work load generated by compression; it protects components undergoing friction, therefore it is suitable to protect rotors seat and avoid abrasion. A single pack contains 500g grease.

RVX-TAPE

PROTECTION

For mark free applications apply RVX-TAPE with width 12mm 0.47" or 20mm 0.79" onto Rolla-V dies. This adhesive tape is made of a composite material able to resist compression and at the same time to avoid friction between sheet metal and die.

RV-TO

MOUNTING TOOL

This tool has been designed to remove easily a spring from its dowel. Thanks to its shape, RV-TO can carry out this operation safely and replace worn parts very quickly.



Click the QRCode or scan it to watch a video and find out more about ROLLA-V dies.

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Compatibility	Springs	Inserts	Lower spines	U clip
RVP60-1	RVP60-1/SP	RVP60-1/IN	RVP60-1/DO	RVP60-1/U
RVP65-2	RVP65-2/SP	RVP65-2/IN	RVP65-2/DO	RVP65-2/U
RVP100-3	RVP100-3/SP	RVP100-3/IN	RVP100-3/DO	RVP100-3/U
RVS80-1	RVS80-1/SP	RVS80-1/IN	RVS80-1/DO	RVS80-1/U
RVS80-2	RVS80-2/SP	RVS80-2/IN	RVS80-2/DO	RVS80-2/U
RVT55-1	RVT55-1/SP	RVT55-1/IN	RVT55-1/DO	RVT55-1/U
RVT60-2	RVT60-2/SP	RVT60-2/IN	RVT60-2/DO	RVT60-2/U
RVT100-1	RVT100-1/SP	RVT100-1/IN	RVT100-1/DO	RVT100-1/U
RVT100-2	RVT100-2/SP	RVT100-2/IN	RVT100-2/DO	RVT100-2/U
RVT100-3	RVT100-3/SP	RVT100-3/IN	RVT100-3/DO	RVT100-3/U
RVT90-1	RVT90-1/SP	RVT90-1/IN	RVT90-1/DO	RVT90-1/U
RVT90-2	RVT90-2/SP	RVT90-2/IN	RVT90-2/DO	RVT90-2/U
RVM2.5	RVM2.5/SP	RVM2.5/IN	RVM2.5/DO	RVM2.5/U
RVM3.5	RVM3.5/SP	RVM3.5/IN	RVM3.5/DO	RVM3.5/U
RVM70-3	RVM70-3/SP	RVM70-3/IN	RVM70-3/DO	RVM70-3/U
RVM90-4	RVM90-4/SP	RVM90-4/IN	RVM90-4/DO	RVM90-4/U
RVHD2	RVHD2/SP	RVHD2/IN	RVHD2/DO	RVHD2/U
RVHD2.5	RVHD2.5/SP	RVHD2.5/IN	RVHD2.5/DO	RVHD2.5/U
RVHD3	RVHD3/SP	RVHD3/IN	RVHD3/DO	RVHD3/U
RVHD4	RVHD4/SP	RVHD4/IN	RVHD4/DO	RVHD4/U
RVPV3	RVPV3/SP	RVPV3/IN	RVPV3/DO	RVPV3/U
RVXT-1	RVXT-1/SP	RVXT-1/IN	RVXT-1/DO	RVXT-1/U
RVXT-2	RVXT-2/SP	RVXT-2/IN	RVXT-2/DO	RVXT-2/U

NEW

Download Rolleri **Bending App**.

Further to many interesting contents, the free app contains the tool for sheet metal development calculation and bending ruler.

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VARIO

ADJUSTABLE DIE

Rolleri Vario is a patent-pending adjustable die. Thanks to this solution you can mount one single tool onto a press brake table and change die V opening manually or with CNC.



Rolleri Vario is a patent-pending adjustable die. Thanks to this solution you can mount one single tool onto a press brake table and change die V opening manually or with CNC. The main features of Rolleri Vario are easy use, max Load - 85 tons/ft and 100 tons/ft on the Heavy-Duty version, 60° die angle to control better sheet metal springback and its modularization. Rolleri Vario is manufactured in modules of 40" length each, which can be connected to each other and work like a unique die. Minimum length is therefore 40" and maximum length depends on press brake length. Rolleri Vario already installed in the market are 4m, 6m, 7m, 8m and 12m long. A specific feature of Rolleri Vario consists in the possibility to disconnect single modules from each other and use them as single dies with different V openings at the same time. This is very useful for stage bending. Thanks to its modularization you can get different angles and different internal radii. The operating principle is very easy and handy: a pneumatic system releases the die from its toothed rack positioned on the bottom, so that the V opening needed can be set quickly. Once V opening is adjusted by rotating a round nonium, close compressed air (6bar) so that die sits in the toothed rack and it's ready to bend. To adjust the die from the smallest to the biggest V opening you need about 5 seconds in the manual version. The system is supplied

with an acoustic device which signals the correct position of every V opening. Vario is equipped with hardened R11 fixed elements. An effective compromise for bending a wide variety of materials and sheet thicknesses. Rolleri Vario reduces the necessary bending force by about 25-30%. The die is made of heavy duty steel and its base and toothed rack are induction hardened. The die is also supplied with a protective cloth to be quickly positioned in the V opening in order to protect the internal structure from dust and sheet metal residues. Rolleri offers dies ranging from 2" to 16". There are 4 models with max. opening V= 7.87" (200 mm), 10.23" (260 mm), 11.81" (300 mm) and 15.75" (400 mm) and V opening can be adjusted in steps of 0.75" (20 mm) or 0.98" (25 mm). Every die can be adjusted manually, with an independent motoreducer and PLC or with a motoreducer connected to press brake CNC. Rolleri Vario can also be supplied with an adapter positioned in the V opening, which can mount all standard dies in our catalogue. Rolleri Vario is the synthesis of technology, practicality, safety and time-saving: setup time is reduced by 85%, operators don't have to handle big and heavy tools and the investment is lower than the total amount of single dies.

VARIO 50 - 200
(V Openings)

in	mm
1.97	50
2.95	75
3.94	100
4.92	125
5.90	150
6.89	175
7.87	200

VARIO 40 - 260
(V Openings)

in	mm
1.57	40
2.36	60
3.15	80
3.94	100
4.72	120
5.51	140
6.23	160
7.09	180
7.87	200
8.66	220
9.45	240
10.23	260

VARIO 50 - 300
(V Openings)

in	mm
1.97	50
2.95	75
3.94	100
4.92	125
5.90	150
6.89	175
7.87	200
8.86	225
9.84	250
10.83	275
11.81	300

VARIO 50 - 400
(V Openings)

in	mm
1.97	50
2.95	75
3.94	100
4.92	125
5.90	150
6.89	175
7.87	200
8.86	225
9.84	250
10.83	275
11.81	300
12.80	325
13.78	350
14.76	375
15.75	400



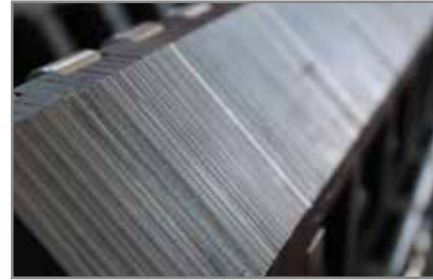
Scan the QRCode or click on it and watch the video to discover more about ROLLERI VARIO.



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Equipped with hardened R11 fixed elements



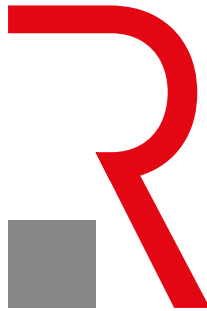
High resistance steel structure



Pneumatically operated positioning system

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