

PUNCHING SOLUTIONS



*Special
Edition*
INT

Dear customer,

Before reading our catalogue, we would like to explain you the reason why we have decided to enter in the punching tooling market.

During our long experience with our customers, we have realized that in the punching tooling field you need a more and more customized service based on efficiency and effectiveness.

Without a careful technical analysis, you cannot identify the best technological solution which is value for money for your needs.

Critical factors depend on the complexity of the part to produce, material type and working conditions of machine and tooling.

In order to support you understanding better the most suitable tool line for your application, we have developed the following guideline

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
Hit rate application	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
Machine type	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
Material type - Toughness	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	HARD (Tensile Strength >45 kg/mm ²)
Material thickness	Thin (< 1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
Punching operation	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
Amount of Hits for the Job	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

According to our new guideline, we recommend you take into consideration:

- The punching machine type and related punching speed (mechanical, hydraulic, servo-electric or high-speed hydraulic punch press);
- Product type (own product or subcontracting);
- If tooling has to make single piercing or nibbling;
- Sheet metal type and thickness to be punched;
- Tool setup;
- Proper punching machine maintenance;
- Proper tooling maintenance.

The above-mentioned parameters are only some factors which may influence tooling performance.

If you would like to investigate these aspects in depth, enrol at Rolleri Sheet Metal Academy by writing to sheetmetalacademy@rolleri.it and take part to one of our training classes.

Thanks to Rolleri Sheet Metal Academy you have the possibility to learn all tricks of the punching field: the importance of maintaining properly punching machine and tooling, the correct application of punching rules in order to improve the operational life of your tooling and the best solutions to the most common as well as the most complicated punching problems. Furthermore, you will get very useful information to improve your production process.

Rolleri Team

Compatibile with OEM:

- Amada
- Amada ABS
- Wilson HP
- Wilson HP WLS
- Mate Ultra Tec

R1

A-STATION

R1
A

B-STATION

R1
B

C-STATION

R1
C

D-STATION

R1
D

E-STATION

R1
E

MULTITOOLS

R1
m

ACCESSORIES

R1

STANDARD TOOLS

R2

MULTITOOLS

R2
m

SLITTING TOOLS

R2
s

ACCESSORIES

R2

SPECIAL TOOLS

Spe

VARIOUS INFORMATION

i

ABOUT US



ROLLERI TYPE R1 - A-STATION

TOT. H = 209.5 MM | TOOL Ø MAX. = 12.70 MM - 1/2"

▼ COMPATIBILITY

Amada
Amada ABS
Wilson HP
Wilson HP WLS
Mate Ultra Tec

METRIC STYLE	6
METRIC STYLE LUBRICATED	7
WT STYLE	8
WT STYLE LUBRICATED	9
MT STYLE	10
EXTREME LINE INSTRUCTION MANUAL	11



PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	HARD (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (< 1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

GUIDE ASSEMBLY

A-STATION	POWERline	SUPREMEline	EXTREMEline
METRIC STYLE AND METRIC STYLE LUBRICATED	Not Adjustable	Punch Length Adjustment	Easy Punch Length Adjustment
WT STYLE AND WT STYLE LUBRICATED	Punch Length Adjustment	Easy Punch Length Adjustment	-
MT STYLE	Punch Length Adjustment	Easy Punch Length Adjustment	-



A-STATION - METRIC STYLE

R1

TOT. H = 209.5 MM | TOOL Ø MAX. = 12.70 MM - 1/2"

SPRING PACK ASSEMBLY



1AKXA



POWERline

SUPREMEline

EXTREMEline



PUNCH



1APRA

1APSA*



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AA4HPS	2.0 mm	5 pcs
--------	--------	-------



GUIDES



1AGRA

1AGHA*



POWERline

SUPREMEline

EXTREMEline



STRIPPER



1ASRA

1ASHA*



SUPREMEline

ANTISLUG DIES



1ADRR

1ADSR*



POWERline

SUPREMEline

EXTREMEline



DIE SHIM PACKAGES

AA2H5S	0.5 mm	10 pcs
AA2HAS	1.0 mm	10 pcs
AA2HBS	1.5 mm	10 pcs
AA2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		

6

* Standard shapes:



Delivery within 48h

Please ask for delivery time

A-STATION - METRIC STYLE LUBRICATED

TOT. H = 209.5 MM | TOOL Ø MAX. = 12.70 MM - 1/2"



SPRING PACK ASSEMBLY



1AKXB



POWERline

SUPREMEline

EXTREMEline



PUNCH



1APRB

1APSB



POWERline

SUPREMEline

EXTREMEline



PUNCH SHIM PACKAGES

AA4HPS	2.0 mm	5 pcs
--------	--------	-------

GUIDES



1AGR B

1AGH B



POWERline

SUPREMEline

EXTREMEline



STRIPPERS



1ASRB

1ASHB



SUPREMEline



ANTISLUG DIES



1ADRR

1ADSR



POWERline

SUPREMEline

EXTREMEline



ANTISLUG CYCLONE DIES



1ADRC

1ADSC



EXTREMEline



Patented system fully compatible with Amada EM's Vacuum die system.

DIE SHIM PACKAGES

AA2H5S	0.5 mm	10 pcs
AA2HAS	1.0 mm	10 pcs
AA2HBS	1.5 mm	10 pcs
AA2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		



A-STATION - WT STYLE

RI

TOT. H = 209.5 MM | TOOL Ø MAX. = 12.70 MM - 1/2"

SPRING PACK ASSEMBLY

- *
- 1AKXL
- POWERline**
- SUPREMEline**



PUNCH

- *
- 1APRH 1APSH
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH SHIM PACKAGES

AA4HPS	2.0 mm	5 pcs
--------	--------	-------



GUIDES

- *
- 1AGRL 1AGHL
- POWERline**
- SUPREMEline**



STRIPPER

- *
- 1ASRH 1ASHH
- SUPREMEline**

ANTISLUG DIES

- *
- 1ADRR 1ADSR
- POWERline**
- SUPREMEline**
- EXTREMEline**



DIE SHIM PACKAGES

AA2H5S	0.5 mm	10 pcs
AA2HAS	1.0 mm	10 pcs
AA2HBS	1.5 mm	10 pcs
AA2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		





R1

A-STATION - WT STYLE LUBRICATED

TOT. H = 209.5 MM | TOOL Ø MAX. = 12.70 MM - 1/2"

SPRING PACK ASSEMBLY

- ✓ 1AKXL
POWERline
SUPREMEline

PUNCH

- ✓ 1APRL 1APSL
POWERline
SUPREMEline
EXTREMEline

PUNCH SHIM PACKAGES

AA4HPS	2.0 mm	5 pcs
--------	--------	-------



GUIDES

- ✓ 1AGRL 1AGHL
POWERline
SUPREMEline



STRIPPER

- ✓ 1ASRL 1ASHL
SUPREMEline

To be used on Amada ABS system.



ANTISLUG DIES

- ✓ 1ADRR 1ADSR
POWERline
SUPREMEline
EXTREMEline



ANTISLUG CYCLONE DIES

- ✓ 1ADRC 1ADSC
EXTREMEline

Patented system fully compatible with Amada EM's Vacuum die system.

DIE SHIM PACKAGES

AA2H5S	0.5 mm	10 pcs
AA2HAS	1.0 mm	10 pcs
AA2HBS	1.5 mm	10 pcs
AA2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		



A-STATION - MT STYLE

RI

TOT. H = 209.5 MM | TOOL Ø MAX. = 12.70 MM - 1/2"

SPRING PACK ASSEMBLY

- *
- 1AKXM
- POWERline**
- SUPREMEline**



GUIDES

- *
- 1AGRM 1AGHM
- POWERline**
- SUPREMEline**



ANTISLUG DIES

- *
- 1ADRR 1ADSR
- POWERline**
- SUPREMEline**
- EXTREMEline**



DIE SHIM PACKAGES

AA2H5S	0.5 mm	10 pcs
AA2HAS	1.0 mm	10 pcs
AA2HBS	1.5 mm	10 pcs
AA2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		

PUNCH

- *
- 1APRM 1APSM
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH SHIM PACKAGES

AA4HPS	2.0 mm	5 pcs
--------	--------	-------



STRIPPER

- *
- 1ASRM 1ASSM
- SUPREMEline**

STRIPPER, MT-STYLE LUBRICATED

- *
- 1ASRN 1ASSN
- SUPREMEline**

To be used on Amada ABS system



ANTISLUG CYCLONE DIES

- *
- 1ADRC 1ADSC
- EXTREMEline**

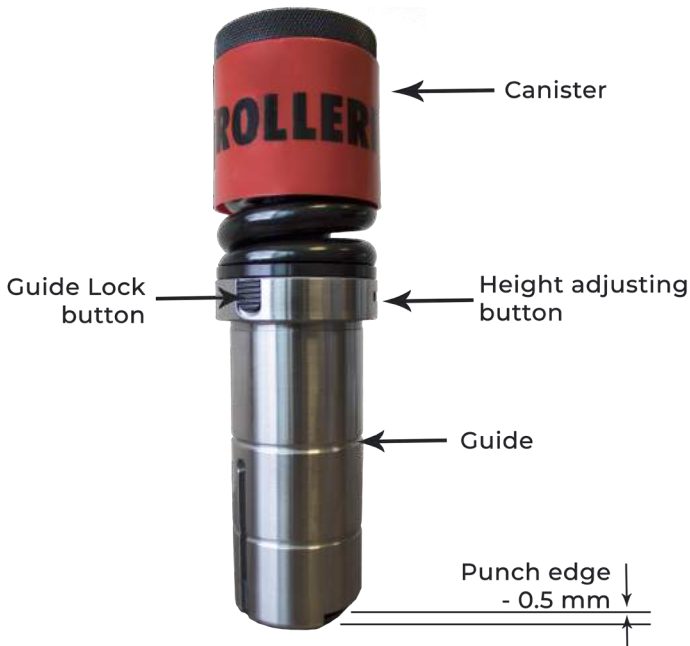
Patented system fully compatible with Amada EM's Vacuum die system.





TOT. H = 209.5 MM | TOOL Ø MAX. = 12.70 MM - 1/2"

SPECIFICATION



GUIDE LOCK BUTTON

You can put out and set in guide when you slide this button to side direction. Use this button when you put out and set in guide.



HEIGHT ADJUSTING BUTTON

You can release canister turning lock when you slide this button to arrow direction like photo.



HOW TO DISASSEMBLE

1. Slide guide lock button to side direction of the guide (Picture 1). During you push this button, guide lock has been releasing.
2. Pull out guide by pushing the guide lock button (Picture 2).
3. Turn the punch body out from the canister (Picture 3).



HOW TO ASSEMBLE

1. Turn the punch body insert into canister till punch screw comes to head part's. (Picture 4)
2. Insert punch body into guide, punch key and guide key should match each other. (Picture 5)

Picture 4



Picture 5



3. By pushing the guide lock button (picture 6), insert guide till guide flange touch the canister (picture 7). When release the guide lock button, guide is locked automatically.
4. Confirm if guide and canister are locked (picture 8).

Picture 6



Picture 7



Picture 8



HOW TO ADJUST PUNCH HEIGHT

1. Slide punch height adjusting button to punch edge direction (picture 9). Turn the canister during pushing the button.

Picture 9



Picture 10



2. Set the punch edge to same surface position as guide stripping surface (picture 10). Release height adjusting button, and lock guide and canister.

3. Punch height adjusting by 3 clicks:

1. During sliding height adjusting button to guide edge direction (picture 11),
2. Release height adjusting button as soon as starting to turn canister to right direction.
3. One click is approximately 0.2 mm in case of turning canister till automatic locked position.
4. In case you repeat this work 3 times (3 clicks), punch height will be adjusted in standard punch dimension.

Picture 11



ROLLERI TYPE R1 - B-STATION

TOT. H = 209.5 MM | TOOL Ø MAX. = 31.75 MM - 1.1/4"

▼ COMPATIBILITY

Amada
Amada ABS
Wilson HP
Wilson HP WLS
Mate Ultra Tec

METRIC STYLE	14
METRIC STYLE LUBRICATED	15
WT STYLE	16
WT STYLE LUBRICATED	17
MT STYLE	18
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PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	Hard (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (< 1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

GUIDE ASSEMBLY

B-STATION	POWERline	SUPREMEline	EXTREMEline
METRIC STYLE AND METRIC STYLE LUBRICATED	Not Adjustable	Punch Length Adjustment	Easy Punch Length Adjustment
WT STYLE AND WT STYLE LUBRICATED	Punch Length Adjustment	Easy Punch Length Adjustment	-
MT STYLE	Punch Length Adjustment	Easy Punch Length Adjustment	-



B-STATION - METRIC STYLE

R1

TOT. H = 209.5 MM | TOOL Ø MAX. = 31.75 MM - 1.1/4"

SPRING PACK ASSEMBLY



1BKXA



POWERline

SUPREMEline

EXTREMEline



PUNCH



1BPRA

1BPSA*



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AB4HPS	2.0 mm	5 pcs
--------	--------	-------



GUIDES



1BGRA

1BGHA



POWERline

SUPREMEline

EXTREMEline



STRIPPER



1BSRA

1BSHA*



SUPREMEline



ANTISLUG DIES



1BDRR

1BDSR



POWERline

SUPREMEline

EXTREMEline



DIE SHIM PACKAGES

AB2H5S	0.5 mm	10 pcs
AB2HAS	1.0 mm	10 pcs
AB2HBS	1.5 mm	10 pcs
AB2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		



B-STATION - METRIC STYLE LUBRICATED



TOT. H = 209.5 MM | TOOL Ø MAX. = 31.75 MM - 1.1/4"

RI
B

SPRING PACK ASSEMBLY



1BKXB



POWERline

SUPREMEline

EXTREMEline



PUNCH



1BPRB

1BPSB



POWERline

SUPREMEline

EXTREMEline



PUNCH SHIM PACKAGES

AB4HPS	2.0 mm	5 pcs
--------	--------	-------

GUIDES



1BGRB

1BGHB



POWERline

SUPREMEline

EXTREMEline



STRIPPER



1BSRB

1BSHB



SUPREMEline



ANTISLUG DIES



1BDRR

1BDSR



POWERline

SUPREMEline

EXTREMEline



ANTISLUG CYCLONE DIES



1BDRC

1BDSC



EXTREMEline

Patented system fully compatible with Amada EM's Vacuum die system.

DIE SHIM PACKAGES

AB2HSS	0.5 mm	10 pcs
AB2HAS	1.0 mm	10 pcs
AB2HBS	1.5 mm	10 pcs
AB2HMS	Set	15 pcs
		0.5 mm + 1.0 mm + 1.5 mm



B-STATION - WT STYLE

RI

TOT. H = 209.5 MM - TOOL Ø MAX. = 31.75 MM - 1.1/4"

SPRING PACK ASSEMBLY

*
 1BKXL 1BKXL
POWERline
SUPREMEline



PUNCH

*
 1BPRH 1BPSH
POWERline
SUPREMEline
EXTREMEline

PUNCH SHIM PACKAGES

AB4HPS	2.0 mm	5 pcs
--------	--------	-------



GUIDES

*
 1BGRL 1BGHL
POWERline
SUPREMEline



STRIPPER

*
 1BSRH 1BSHH
SUPREMEline



ANTISLUG DIES

*
 1BDRR 1BDSR
POWERline
SUPREMEline
EXTREMEline



DIE SHIM PACKAGES

AB2H5S	0.5 mm	10 pcs
AB2HAS	1.0 mm	10 pcs
AB2HBS	1.5 mm	10 pcs
AB2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		



B-STATION - WT STYLE LUBRICATED



TOT. H = 209.5 MM | TOOL Ø MAX. = 31.75 MM - 1.1/4"

RI
B

SPRING PACK ASSEMBLY

- ✓ 1BKXL
POWERline
SUPREMEline

PUNCH

- ✓ 1BPRL 1BPSL
POWERline
SUPREMEline
EXTREMEline

PUNCH SHIM PACKAGES

AB4HPS	2.0 mm	5 pcs
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GUIDES

- ✓ *POWERline*
SUPREMEline



STRIPPER

- ✓ 1BSRL 1BSHL
SUPREMEline

To be used on Amada ABS system.



ANTISLUG DIES

- ✓ 1BDRR 1BDSR
POWERline
SUPREMEline
EXTREMEline



ANTISLUG CYCLONE DIES

- ✓ 1BDRC 1BDSC
EXTREMEline

Patented system fully compatible with Amada EM's Vacuum die system.

DIE SHIM PACKAGES

AB2HSS	0.5 mm	10 pcs
AB2HAS	1.0 mm	10 pcs
AB2HBS	1.5 mm	10 pcs
AB2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		



B-STATION - MT-STYLE

RI

TOT. H = 209.5 MM | TOOL Ø MAX. = 31.75 MM - 1.1/4"

SPRING PACK ASSEMBLY

- *
- 1BKXM
- POWERline**
- SUPREMEline**



GUIDES

- *
- 1BGRM 1BGHM
- POWERline**
- SUPREMEline**



ANTISLUG DIES

- *
- 1BDRR 1BDSR
- POWERline**
- SUPREMEline**
- EXTREMEline**



DIE SHIM PACKAGES

AB2H5S	0.5 mm	10 pcs
AB2HAS	1.0 mm	10 pcs
AB2HBS	1.5 mm	10 pcs
AB2HMS	Set	15 pcs
0.5 mm + 1.0 mm + 1.5 mm		

PUNCH

- *
- 1BPRM 1BPSM
- POWERline**
- SUPREMEline**
- EXTREMEline**



PUNCH SHIM PACKAGES

AB4HPS	2.0 mm	5 pcs
--------	--------	-------

STRIPPER

- *
- 1BSRM 1BSSM
- SUPREMEline**

STRIPPER MT-STYLE LUBRICATED

- *
- 1BSRN 1BSSN
- SUPREMEline**

To be used on Amada ABS system.



ANTISLUG CYCLONE DIES

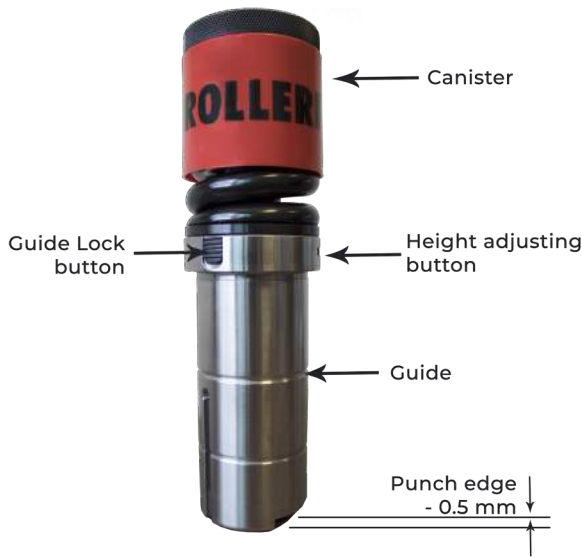
- *
- 1BDRC 1BDSC
- EXTREMEline**

Patented system fully compatible with Amada EM's Vacuum die system.





SPECIFICATION



GUIDE LOCK BUTTON

You can put out and set in guide when you slide this button to side direction. Use this button when you put out and set in guide.



HEIGHT ADJUSTING BUTTON

You can release canister turning lock when you slide this button to arrow direction like photo.



HOW TO DISASSEMBLE

1. Slide guide lock button to side direction of the guide (Picture 1). During you push this button, guide lock has been releasing.
2. Pull out guide by pushing the guide lock button (Picture 2).
3. Turn the punch body out from the canister (Picture 3).



HOW TO ASSEMBLE

1. Turn the punch body insert into canister till punch screw comes to head part's. (Picture 4)
2. Insert punch body into guide, punch key and guide key should mach each other. (Picture 5)

Picture 4



Picture 5



3. By pushing the guide lock button (picture 6), insert guide till guide flange touch the canister (picture 7). When release the guide lock button, guide is locked automatically.
4. Confirm if guide and canister are locked (picture 8).

Picture 6



Picture 7



Picture 8



HOW TO ADJUST PUNCH HEIGHT

1. Slide punch height adjusting buton to punch edge direction (picture 9). Turn the canister during pushing the button.

Picture 9



Picture 10



2. Set the punch edge to same surface position as guide stripping surface (picture 10). Release height adjusting button, and lock guide and canister.

3. Punch height adjusting by 3 clicks:

1. During sliding height adjusting button to guide edge direction (picture 11),
2. Release height adjusting button as soon as starting to turn canister to right direction.
3. One click is approximately 0.2 mm in case of turning canister till automatic locked position.
4. In case you repeat this work 3 times (3 clicks), punch height will be adjusted in standard punch dimension.

Picture 11



ROLLERI TYPE R1 - C-STATION

TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

▼ COMPATIBILITY

Amada
Amada ABS
Wilson HP
Wilson HP WLS
Mate Ultra Tec

METRIC STYLE	22
METRIC STYLE NESTING	23
METRIC STYLE LUBRICATED	24
METRIC STYLE LUBRICATED NESTING	25
WT STYLE	26
MT STYLE	27
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PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	HARD (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (< 1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

GUIDE ASSEMBLY

C-STATION	POWERline	SUPREMEline	EXTREMEline
METRIC STYLE AND METRIC STYLE LUBRICATED	Not Adjustable	Punch Length Adjustment	Punch length adjustment and quick stripper exchange system
WT STYLE LUBRICATED	Punch Length Adjustment	Easy Length Adjustment System	Punch length adjustment and quick stripper exchange system
MT STYLE	Punch Length Adjustment	Easy Length Adjustment System	Punch length adjustment and quick stripper exchange system



C-STATION - METRIC STYLE

R1

TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

GUIDE ASSEMBLY



1CAXA



POWERline

SUPREMEline

EXTREMEline

PUNCH



1CPRA

1CPSA



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AC3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 28.

STRIPPER



1CSRA

1CSSA



SUPREMEline

ANTISLUG DIES



1CDRR

1CDSR



POWERline

SUPREMEline

EXTREMEline

DIE SHIM PACKAGES

AC2H5S	0.5 mm	5 pcs
AC2HAS	1.0 mm	5 pcs
AC2HBS	1.5 mm	5 pcs



C-STATION - METRIC STYLE NESTING



TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

GUIDE ASSEMBLY

- ✓ *
1CYYA
ONE SIDE
POWERline

Also Available as TWO SIDES

PUNCH

- *
1CPRA 1CPSA
POWERline
- SUPREMEline**
- EXTREMEline**

PUNCH SHIM PACKAGES

AC3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 28.

STRIPPER

- ✓ *
1CMSA 1CVSA
ONE SIDE TWO SIDES
SUPREMEline

Compatible only with Rolleri Nesting Guide Assembly



ANTISLUG DIES

- ✓ *
1CNSR 1CWSR
ONE SIDE TWO SIDES
SUPREMEline
- EXTREMEline**



DIE SHIM PACKAGES

AC2H5S	0.5 mm	5 pcs
AC2HAS	1.0 mm	5 pcs
AC2HBS	1.5 mm	5 pcs

RI
C



C-STATION - METRIC STYLE LUBRICATED

R1

TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

GUIDE ASSEMBLY

- *
1CAXB
POWERline
- *
SUPREMEline
- *
EXTREMEline

PUNCH

- *
1CPRB 1CPSB
POWERline
- *
SUPREMEline
- *
EXTREMEline

PUNCH SHIM PACKAGES

AC3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 28.

STRIPPER

- *
1CSRБ 1CSSB
SUPREMEline



STRIPPER ALPHA

- *
1CSRР 1CSSP
SUPREMEline

Compatible with Amada Alpha Guide Assembly



ANTISLUG DIE

- *
1CDRR 1CDSR
POWERline
- *
SUPREMEline
- *
EXTREMEline



STRIPPER OEM

- *
1CSRO 1CSSO
SUPREMEline

Compatible with Amada ABS bolt-on stripper Guide Assembly



DIE SHIM PACKAGES

AC2H5S	0.5 mm	5 pcs
AC2HAS	1.0 mm	5 pcs
AC2HBS	1.5 mm	5 pcs



C-STATION - METRIC STYLE LUBRICATED NESTING



TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

GUIDE ASSEMBLY



1CYYB
ONE SIDE

POWERline

Also available as TWO SIDES

PUNCH



1CPRB 1CPSB

POWERline

SUPREMEline

EXTREMEline



PUNCH SHIM PACKAGES

AC3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 28.

STRIPPER



1CMSB 1CVSB
ONE SIDE TWO SIDES

SUPREMEline

Compatible only with Rolleri Nesting Guide Assembly

ANTISLUG DIE



1CNSR 1CWSR
ONE SIDE TWO SIDES

SUPREMEline

EXTREMEline



DIE SHIM PACKAGES

AC2H5S	0.5 mm	5 pcs
AC2HAS	1.0 mm	5 pcs
AC2HBS	1.5 mm	5 pcs

RI
C



C-STATION - WT STYLE

RI

TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

GUIDE ASSEMBLY



1CAXU



POWERline

SUPREMEline

EXTREMEline

PUNCH



1CPRU

1CPSU*



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AC3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



STRIPPER



1CSRU

1CSSU*



SUPREMEline

Compatible only with WT Style stripper Guide Assembly

ANTISLUG DIES



1CDRR

1CDSR



POWERline

SUPREMEline

EXTREMEline



DIE SHIM PACKAGES

AC2H5S	0.5 mm	5 pcs
AC2HAS	1.0 mm	5 pcs
AC2HBS	1.5 mm	5 pcs



C-STATION - MT STYLE



TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

GUIDE ASSEMBLY



1CAXM



POWERline

SUPREMEline

EXTREMEline

PUNCH



1CPRM

1CPSM



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AC3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



STRIPPER



1CSR

1CSSM



POWERline

Compatible only with Mate Ultra Style Stripper Guide Assembly

ANTISLUG DIES



1CDRR

1CDSR



POWERline

SUPREMEline

EXTREMEline

DIE SHIM PACKAGES

AC2H5S	0.5 mm	5 pcs
AC2HAS	1.0 mm	5 pcs
AC2HBS	1.5 mm	5 pcs

STRIPPER



1CSRA

1CSSA



SUPREMEline

RI
C




C-STATION

R1

TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

INSERT HOLDER
METRIC STYLE

✓ *

1CAYA


SUPREMEline



M-12 fixing bolt



PUNCH INSERT
METRIC STYLE

*

1CISA

✓ **POWERline**

SUPREMEline

EXTREMEline

INSERT HOLDER
METRIC STYLE LUBRICATED

✓ *

1CAYB


SUPREMEline



M-14 fixing bolt



PUNCH INSERT
METRIC STYLE LUBRICATED

*

1CISB

✓ **POWERline**

SUPREMEline

EXTREMEline

Amada Alpha Style insert available

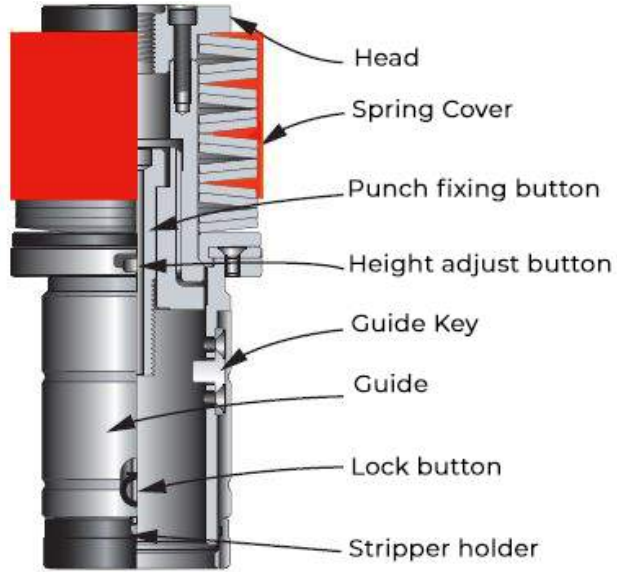




TOT. H = 210 MM | TOOL Ø MAX. = 50.80 MM - 2"

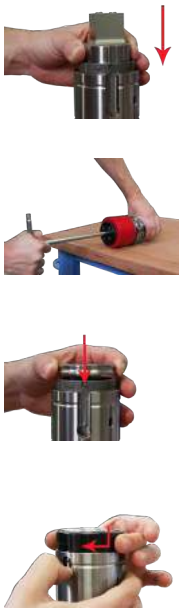
SPECIFICATION - TOPLINE GUIDE SET

1. Please use lubricated punch for this guide set. Punch fixing bolt has small hole for oil through.
2. Please use lubricated stripper plate for this guide set.
3. For ensuring accuracy, with the exception of the stripper holder, please do not disassemble. Please send to ROLLERI when maintain or repair guide set.



RI
C

HOW TO ASSEMBLE OR DISASSEMBLE PUNCH



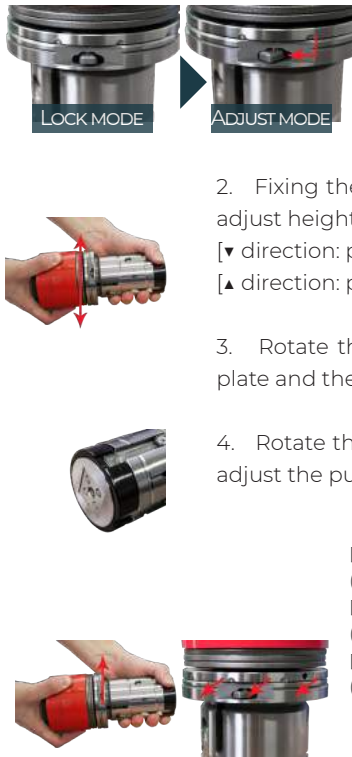
1. Insert the punch into the guide.
2. Insert hexagonal I wrench from head side and tighten the punch fixing bolt.
3. Set the stripper holder, and make sure the stripper holder locked perfectly. Please see reverse side for details.

*The procedure of disassemble is the reverse of this procedure.

NOTE

Please make sure that stripper holder is perfectly locked before use.

HOW TO ADJUST PUNCH HEIGHT



1. Set the height adjust button to "adjust mode".

2. Fixing the guide and rotate the head to adjust height.
[▼ direction: punch height extends]
[▲ direction: punch height shrinks]
3. Rotate the head and align the stripper plate and the cutting edge of the punch.
4. Rotate the head in the "▲" direction and adjust the punch height to certain length.

[E-Station: adjust 5 step of "adjust mark". (half round)]
[D-Station: adjust 10 step of "adjust mark". (one round)]
[C-Station: adjust 5 step of "adjust mark". (half round)]

5. Set the height adjust button to "Lock mode".
6. Rotate the head and the guide lightly and make sure that it is locked properly.

ROLLERI TYPE R1 - D-STATION

TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"

▼ COMPATIBILITY

Amada
Amada ABS
Wilson HP
Wilson HP WLS
Mate Ultra Tec

METRIC STYLE	32
METRIC STYLE NESTING	33
METRIC STYLE LUBRICATED	34
METRIC STYLE LUBRICATED NESTING	35
WT STYLE	36
MT STYLE	37
INSERT HOLDERS AND PUNCHES INSERTS	38
EXTREME LINE GUIDE SET TOOL MANUAL	39



PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	HARD (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (< 1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

GUIDE ASSEMBLY

D-STATION	POWERline	SUPREMEline	EXTREMEline
METRIC STYLE AND METRIC STYLE LUBRICATED	Not Adjustable	Punch Length Adjustment	Punch length adjustment and quick stripper exchange system
WT STYLE LUBRICATED	Punch Length Adjustment	Easy Length Adjustment System	Punch length adjustment and quick stripper exchange system
MT STYLE	Punch Length Adjustment	Easy Length Adjustment System	Punch length adjustment and quick stripper exchange system



D-STATION - METRIC STYLE

R1

TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"

GUIDE ASSEMBLY



1DAXA



POWERline

SUPREMEline

EXTREMEline

PUNCH



1DPRA

1DPSA



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AD3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 38.

STRIPPER



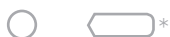
1DSRA

1DSSA



SUPREMEline

ANTISLUG DIES



1DDRR

1DDSR



POWERline

SUPREMEline

EXTREMEline

DIE SHIM PACKAGES

AD2H5S	0.5 mm	5 pcs
AD2HAS	1.0 mm	5 pcs
AD2HBS	1.5 mm	5 pcs



D-STATION - METRIC STYLE NESTING

TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"



GUIDE ASSEMBLY



1DYXA
ONE SIDE

POWERline

Also available as TWO SIDES

PUNCH



1DPRA 1DPSA

POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AD3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 38.

STRIPPER



1DMSA 1DVSA
ONE SIDE TWO SIDES

SUPREMEline

Compatible only with Rolleri Nesting Guide Assembly.

ANTISLUG DIES



1DNSR 1DWSR
ONE SIDE TWO SIDES

POWERline

SUPREMEline

EXTREMEline



DIE SHIM PACKAGES

AD2H5S	0.5 mm	5 pcs
AD2HAS	1.0 mm	5 pcs
AD2HBS	1.5 mm	5 pcs

RI
D



D-STATION - METRIC STYLE LUBRICATED

RI

TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"

GUIDE ASSEMBLY

- *
1DAXB
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH

- *
1DPRB 1DPSB
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH SHIM PACKAGES

AD3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 38.

STRIPPER

- *
1DSRB 1DSSB
- SUPREMEline**

STRIPPER ALPHA

- *
1DSRP 1DSSP
- SUPREMEline**

Compatible with Amada Alpha Guide Assembly



ANTISLUG DIES

- *
1DDRR 1DDSR
- POWERline**
- SUPREMEline**
- EXTREMEline**

STRIPPER OEM

- *
1DSRO 1DSSO
- SUPREMEline**

Compatible with Amada ABS bolt-on stripper Guide Assembly

DIE SHIM PACKAGES

AD2H5S	0.5 mm	5 pcs
AD2HAS	1.0 mm	5 pcs
AD2HBS	1.5 mm	5 pcs



D-STATION - METRIC STYLE LUBRICATED NESTING



TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"

GUIDE ASSEMBLY



1DYXB
ONE SIDE

POWERline

Also available as TWO SIDES

PUNCH



1DPRB 1DPSB

POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AD3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 38.

STRIPPER



1DMSA 1DVSA
ONE SIDE TWO SIDES

SUPREMEline

Compatible only with Rolleri Nesting Guide Assembly.

ANTISLUG DIES



1DNSR 1DWSR
ONE SIDE TWO SIDES

POWERline

SUPREMEline

EXTREMEline

DIE SHIM PACKAGES

AD2H5S	0.5 mm	5 pcs
AD2HAS	1.0 mm	5 pcs
AD2HBS	1.5 mm	5 pcs



RI
D



D-STATION - WT STYLE

RI

TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"

GUIDE ASSEMBLY

- *
- 1DAXU
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH

- *
- 1DPRU 1DPSU
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH SHIM PACKAGES

AD3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



STRIPPER

- *
- 1DSRU 1DSSU
- SUPREMEline**

Compatible only with WT Style Stripper Guide Assembly



ANTISLUG DIES

- *
- 1DDRR 1DDSR
- POWERline**
- SUPREMEline**
- EXTREMEline**



DIE SHIM PACKAGES

AD2H5S	0.5 mm	5 pcs
AD2HAS	1.0 mm	5 pcs
AD2HBS	1.5 mm	5 pcs



D-STATION - MT STYLE



TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"

GUIDE ASSEMBLY



1DAXM



POWERline

SUPREMEline

EXTREMEline

PUNCH



1DPRM

1DPSM



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AD3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



RI
D

STRIPPER



1DSRM

1DSSM



SUPREMEline

Compatible only with Mate Ultra Style Stripper Guide Assembly



ANTISLUG DIES



1DDRR

1DDSR



POWERline

SUPREMEline

EXTREMEline

DIE SHIM PACKAGES

AD2H5S	0.5 mm	5 pcs
AD2HAS	1.0 mm	5 pcs
AD2HBS	1.5 mm	5 pcs

STRIPPER



1DSRA

1DSSA



SUPREMEline






D-STATION

RI

TOT. H = 211 MM | TOOL Ø MAX. = 88.9 MM - 3 1/2"

INSERT HOLDER
METRIC STYLE

✓ *

1DHYA


SUPREMEline



M-12 fixing bolt



PUNCH INSERT
METRIC STYLE

✓ *

1DISA

POWERline

SUPREMEline

EXTREMEline

INSERT HOLDER
METRIC STYLE LUBRICATED

✓ *

1DHYB


SUPREMEline



M-14 fixing bolt



PUNCH INSERT
METRIC STYLE LUBRICATED

✓ *

1DISB

POWERline

SUPREMEline

EXTREMEline

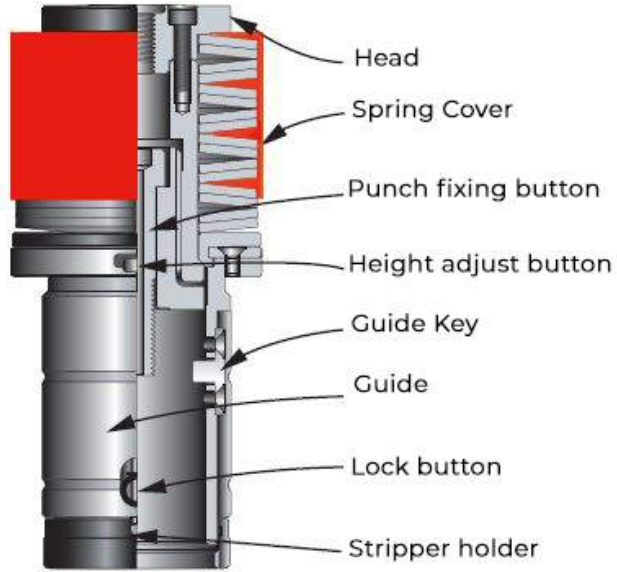
Amada Alpha Style insert available





SPECIFICATION - TOPLINE GUIDE SET

1. Please use lubricated punch for this guide set. Punch fixing bolt has small hole for oil through.
2. Please use lubricated stripper plate for this guide set.
3. For ensuring accuracy, with the exception of the stripper holder, please do not disassemble. Please send to ROLLERI when maintain or repair guide set.



RI
D

HOW TO ASSEMBLE OR DISASSEMBLE PUNCH



1. Insert the punch into the guide.
2. Insert hexagonal I wrench from head side and tighten the punch fixing bolt.



3. Set the stripper holder, and make sure the stripper holder locked perfectly. Please see reverse side for details.



*The procedure of disassemble is the reverse of this procedure.

NOTE

Please make sure that stripper holder is perfectly locked before use.

HOW TO ADJUST PUNCH HEIGHT



1. Set the height adjust button to "adjust mode".



2. Fixing the guide and rotate the head to adjust height.
[▼ direction: punch height extends]
[▲ direction: punch height shrinks]



3. Rotate the head and align the stripper plate and the cutting edge of the punch.
4. Rotate the head in the "▲" direction and adjust the punch height to certain length.



- [E-Station: adjust 5 step of "adjust mark". (half round)]
- [D-Station: adjust 10 step of "adjust mark". (one round)]
- [C-Station: adjust 5 step of "adjust mark". (half round)]

5. Set the height adjust button to "Lock mode".
6. Rotate the head and the guide lightly and make sure that it is locked properly.

ROLLERI TYPE R1 - E-STATION

TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

▼ COMPATIBILITY

Amada
 Amada ABS
 Wilson HP
 Wilson HP WLS
 Mate Ultra Tec

METRIC STYLE	42
METRIC STYLE NESTING	43
METRIC STYLE LUBRICATED	44
METRIC STYLE LUBRICATED NESTING	45
WT STYLE	46
MT STYLE	47
INSERT HOLDERS AND PUNCHES INSERTS	48
EXTREME LINE GUIDE SET TOOL MANUAL	49



PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	Hard (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (< 1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of pun- ch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

GUIDE ASSEMBLY

E-STATION	POWERline	SUPREMEline	EXTREMEline
METRIC STYLE AND METRIC STYLE LUBRICATED	Not Adjustable	Punch Length Adjustment	Punch length adjustment and quick stripper exchange system
WT STYLE LUBRICATED	Punch Length Adjustment	Easy Length Adjustment System	Punch length adjustment and quick stripper exchange system
MT STYLE	Punch Length Adjustment	Easy Length Adjustment System	Punch length adjustment and quick stripper exchange system



E-STATION - METRIC STYLE

RI

TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

GUIDE ASSEMBLY



1EAXA



POWERline

SUPREMEline

EXTREMEline

PUNCH



1EPRA

1EPSA*



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AE3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 48.

STRIPPER



1ESRA

1ESSA*



SUPREMEline

ANTISLUG DIES



1EDRR

1EDSR



POWERline

SUPREMEline

EXTREMEline



DIE SHIM PACKAGES

AE2H5S	0.5 mm	5 pcs
AE2HAS	1.0 mm	5 pcs
AE2HBS	1.5 mm	5 pcs



E-STATION - METRIC STYLE NESTING



TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

GUIDE ASSEMBLY

- ✓ *
1EYYA
ONE SIDE
POWERline

Also available as TWO SIDES

PUNCH

- ✓ *
1EPRA 1EPSA
POWERline
SUPREMEline
EXTREMEline

PUNCH SHIM PACKAGES

AE3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



RI
E

Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 48.

STRIPPER

- ✓ *
1EMSA 1EVSA
ONE SIDE TWO SIDES
SUPREMEline

Compatible only with Rolleri Nesting Guide Assembly

ANTISLUG DIES

- ✓ *
1ENSR 1WSR
ONE SIDE TWO SIDE
POWERline
SUPREMEline
EXTREMEline



DIE SHIM PACKAGES

AE2H5S	0.5 mm	5 pcs
AE2HAS	1.0 mm	5 pcs
AE2HBS	1.5 mm	5 pcs



E-STATION - METRIC STYLE LUBRICATED

RI

TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

GUIDE ASSEMBLY

- *
- 1EAXB
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH

- *
- 1EPRB 1EPSB
- POWERline**
- SUPREMEline**
- EXTREMEline**

PUNCH SHIM PACKAGES

AE3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 48.

STRIPPER

- *
- 1ESRB 1ESSB
- SUPREMEline**

STRIPPER ALPHA

- *
- 1ESRP 1ESSP
- SUPREMEline**

Compatible with Amada Alpha Guide Assembly



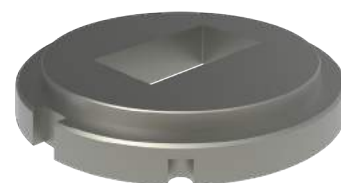
ANTISLUG DIES

- *
- 1EDRR 1EDSR
- POWERline**
- SUPREMEline**
- EXTREMEline**

STRIPPER OEM

- *
- 1ESRO 1ESSO
- SUPREMEline**

Compatible with Amada ABS bolt-on Stripper Guide Assembly



DIE SHIM PACKAGES

AE2H5S	0.5 mm	5 pcs
AE2HAS	1.0 mm	5 pcs
AE2HBS	1.5 mm	5 pcs



E-STATION - METRIC STYLE LUBRICATED NESTING



TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

GUIDE ASSEMBLY

- ✓ *
1EYXB
ONE SIDE
POWERline

Also available as TWO SIDES

PUNCH

- ✓ *
1EPRB 1EPSB
POWERline
SUPREMEline
EXTREMEline

PUNCH SHIM PACKAGES

AE3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



RI
E

Otherwise, it's possible to use INSERT HOLDER and PUNCH INSERT.

See page 48.

STRIPPER

- ✓ *
1EMSB 1EVSB
ONE SIDE TWO SIDES
SUPREMEline

Compatible only with Rolleri Nesting Guide Assembly

ANTISLUG DIES

- ✓ *
1ENSR 1WSR
ONE SIDE TWO SIDES
POWERline
SUPREMEline
EXTREMEline

DIE SHIM PACKAGES

AE2H5S	0.5 mm	5 pcs
AE2HAS	1.0 mm	5 pcs
AE2HBS	1.5 mm	5 pcs





E-STATION - WT STYLE

RI

TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

GUIDE ASSEMBLY

- *
1EAXU
POWERline
- SUPREMEline**
- EXTREMEline**

PUNCH

- *
1EPRU 1EPSU
POWERline
- SUPREMEline**
- EXTREMEline**

PUNCH SHIM PACKAGES

AE3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



STRIPPER

- *
1ESRU 1ESSU
SUPREMEline

Compatible only with WT Style Stripper Guide Assembly

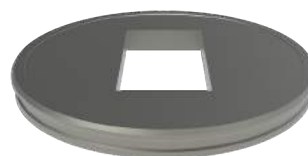
ANTISLUG DIES

- *
1EDRR 1EDSR
POWERline
- SUPREMEline**
- EXTREMEline**



DIE SHIM PACKAGES

AE2H5S	0.5 mm	5 pcs
AE2HAS	1.0 mm	5 pcs
AE2HBS	1.5 mm	5 pcs



E-STATION - MT STYLE



TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

GUIDE ASSEMBLY



1EAXM



POWERline

SUPREMEline

EXTREMEline

PUNCH



1EPRM

1EPSM



POWERline

SUPREMEline

EXTREMEline

PUNCH SHIM PACKAGES

AE3HPS	Set	5 pcs
0.3 - 0.5 - 1.0 - 1.5 mm		



RI
E

STRIPPER



1ESRM

1ESSM



SUPREMEline

Compatible only with Mate Ultra Style Stripper Guide Assembly



ANTISLUG DIES



1EDRR

1EDSR



POWERline

SUPREMEline

EXTREMEline



STRIPPER



1ESRA

1ESSA



SUPREMEline



DIE SHIM PACKAGES

AE2H5S	0.5 mm	5 pcs
AE2HAS	1.0 mm	5 pcs
AE2HBS	1.5 mm	5 pcs




E-STATION

R1

TOT. H = 211 MM | TOOL Ø MAX. = 114.3 MM - 4 1/2"

INSERT HOLDER
METRIC STYLE

✓

*

1EHYA

SUPREMEline




M-12 fixing bolt



PUNCH INSERT
METRIC STYLE

✓

*

1EISA

POWERline

SUPREMEline

EXTREMEline

INSERT HOLDER
METRIC STYLE LUBRICATED

✓

*

1EHYB

SUPREMEline




M-14 fixing bolt



PUNCH INSERT
METRIC STYLE LUBRICATED

✓

*

1EISB

POWERline

SUPREMEline

EXTREMEline

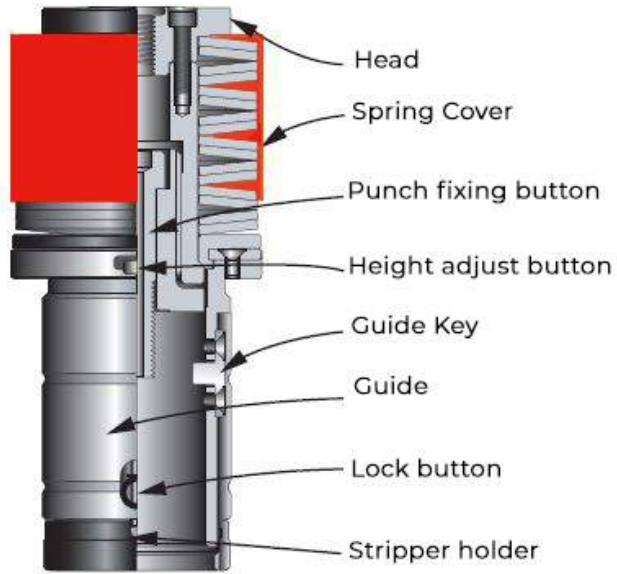
Amada Alpha Style insert available





SPECIFICATION - TOPLINE GUIDE SET

1. Please use lubricated punch for this guide set. Punch fixing bolt has small hole for oil through.
2. Please use lubricated stripper plate for this guide set.
3. For ensuring accuracy, with the exception of the stripper holder, please do not disassemble. Please send to ROLLERI when maintain or repair guide set.



RI
E

HOW TO ASSEMBLE OR DISASSEMBLE PUNCH



1. Insert the punch into the guide.
2. Insert hexagonal I wrench from head side and tighten the punch fixing bolt.
3. Set the stripper holder, and make sure the stripper holder locked perfectly. Please see reverse side for details.



*The procedure of disassemble is the reverse of this procedure.

NOTE

Please make sure that stripper holder is perfectly locked before use.

HOW TO ADJUST PUNCH HEIGHT



1. Set the height adjust button to "adjust mode".
2. Fixing the guide and rotate the head to adjust height.
[▼ direction: punch height extends]
[▲ direction: punch height shrinks]
3. Rotate the head and align the stripper plate and the cutting edge of the punch.
4. Rotate the head in the "▲" direction and adjust the punch height to certain length.

[E-Station: adjust 5 step of "adjust mark". (half round)]
[D-Station: adjust 10 step of "adjust mark". (one round)]
[C-Station: adjust 5 step of "adjust mark". (half round)]

5. Set the height adjust button to "Lock mode".
6. Rotate the head and the guide lightly and make sure that it is locked properly.

ROLLERI TYPE R1 - MULTITOOL

▼ COMPATIBILITY

Amada
Amada ABS
Wilson HP
Wilson HP WLS
Mate Ultra Tec
Matrix

WT Style MTX3IR	52
WT Style MT3RI	53
WT Style MTX8IR	54
WT Style MT8RI	55
WT Style MT20i-8	56
MT Style MT24MM	57
MT Style MT16MM	58
MT Style MT8MM	59
MT Style MTE4	60
MT Style XMTE4	61
MT Style MTE6	62
MT Style XMTE6	63
MT Style MTE10 Ø24 mm	64
MT Style MTE10 Ø8 mm	65
MT Style XMTE10 Ø24 mm	66
MT Style XMTE10 Ø12,7 mm	67
MT Style MT24MM MTX	68



PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	Hard (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (< 1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)



MULTITOOL MTX3IR - WT STYLE

RI

TOOL Ø MAX. = 31.75 MM

COMPATIBLE WITH: BAYKAL | DURMA | ERMAKSAN | FINN-POWER | TAILIFT | YAWEI

COMPATIBLE MULTITOOL: WILSON TOOL MTX3RI

PUNCH

*

63PRI 63PSI

✓

POWERline

SUPREMEline

EXTREMEline

H = 100.5 | Ø = 31.75



PUNCH - LUBRICATED

*

63BRI 63BSI

✓

POWERline

SUPREMEline

EXTREMEline

H = 100.5 | Ø = 31.75



STRIPPER

*

63SRI 63SSI

✓

SUPREMEline

H = 6.9 | Ø = 38.05

DIE

*

63DRI 63DSI

✓

POWERline

SUPREMEline

EXTREMEline

H = 30 | Ø = 47.6



DIE SHIMS

AB2H5S	0.5 mm	10 pcs
AB2HAS	1.0 mm	10 pcs
AB2HBS	1.5 mm	10 pcs
AB2HMS	Set	15 pcs



MULTITOOL MT3RI - WT STYLE



TOOL Ø MAX. = 31.75 MM

COMPATIBLE WITH: BAYKAL | DURMA | ERMAKSAN | FINN-POWER | TAILIFT | YAWEI

COMPATIBLE MULTITOOL: WILSON TOOL MT3IR

<p>PUNCH</p> <p> *</p> <p>63PRR 63PSR</p> <p>✓</p> <p>POWERline</p> <hr/> <p>SUPREMEline</p> <hr/> <p>EXTREMEline</p> <hr/> <p>H = 100.5 ø = 31.75</p>		<p>PUNCH - LUBRICATED</p> <p> *</p> <p>63BRR 63BSR</p> <p>✓</p> <p>POWERline</p> <hr/> <p>SUPREMEline</p> <hr/> <p>EXTREMEline</p> <hr/> <p>H = 100.5 ø = 31.75</p>
---	--	--



<p>STRIPPER</p> <p> *</p> <p>63SRR 63SSR</p> <p>✓</p> <p>SUPREMEline</p> <hr/> <p>H = 6.35 ø = 40</p>
--

<p>DIE</p> <p> *</p> <p>63DRR 63DSR</p> <p>✓</p> <p>SUPREMEline</p> <hr/> <p>H = 15.1 ø = 47.62</p> <p>DIE SHIMS</p> <table border="1"> <tr> <td>AB2H5S</td> <td>0.5 mm</td> <td>10 pcs</td> </tr> <tr> <td>AB2HAS</td> <td>1.0 mm</td> <td>10 pcs</td> </tr> <tr> <td>AB2HBS</td> <td>1.5 mm</td> <td>10 pcs</td> </tr> <tr> <td>AB2HMS</td> <td>Set</td> <td>15 pcs</td> </tr> </table>	AB2H5S	0.5 mm	10 pcs	AB2HAS	1.0 mm	10 pcs	AB2HBS	1.5 mm	10 pcs	AB2HMS	Set	15 pcs	
AB2H5S	0.5 mm	10 pcs											
AB2HAS	1.0 mm	10 pcs											
AB2HBS	1.5 mm	10 pcs											
AB2HMS	Set	15 pcs											

R1
m



MULTITOOL MTX8IR - WT STYLE

RI

TOOL Ø MAX. = 12.7 MM

COMPATIBLE WITH: BAYKAL | DURMA | ERMAKSAN | FINN-POWER | TAILIFT | YAWEI

COMPATIBLE MULTITOOL: WILSON TOOL MTX8IR

PUNCH

*

68PRI 68PSI

✓

POWERline

SUPREMEline

EXTREMEline

H = 118 | Ø = 15.85



PUNCH - LUBRICATED

*

68BRI 68BSI

✓

POWERline

SUPREMEline

EXTREMEline

H = 118 | Ø = 15.85



STRIPPER

*

68SRI 68SSI

✓

POWERline

H = 6.9 | Ø = 19

DIE

*

68DRI 68DSI

✓

POWERline

SUPREMEline

EXTREMEline

H = 30 | Ø = 25.4



DIE SHIMS

AA2H5S	0.5 mm	10 pcs
AA2HAS	1.0 mm	10 pcs
AA2HBS	1.5 mm	10 pcs
AA2HMS	Set	15 pcs

MULTITOOL MT8RI - WT STYLE



TOOL Ø MAX. = 16 MM

COMPATIBLE WITH: FINN-POWER

COMPATIBLE MULTITOOL: WILSON TOOL MT 8 STATIONS (OLD DESIGN)

WILSON TOOL MT 8 STATIONS (NEW DESIGN), MT8RI

**PUNCH
NEW DESIGN WITH KEYSLOT**



68PRR 68PSR



POWERline

SUPREMEline

EXTREMEline

H = 100 | ϕ = 16

WILSON TOOL MT 8 STATIONS FOR

NISSHINBO (NEW DESIGN),

MT8I, MT8RI

MATRIX 8/16 R MMX



**PUNCH - LUBRICATED
OLD STYLE WITH PIN**



68PRV 68PSV



POWERline

SUPREMEline

EXTREMEline

H = 100 | ϕ = 16

WILSON TOOL MT 8 STATIONS

FOR NISSHINBO (OLD DESIGN)



STRIPPER



68SRR 68SSR



SUPREMEline

H = 76 | ϕ = 26.85

DIE



68DRR 68DSR



EXTREMEline

H = 17.6 | ϕ = 25.4



R1
m



MULTITOOL MT20I-8 - WT STYLE

R1

TOOL Ø MAX. = 8 MM

COMPATIBLE WITH: FINN-POWER

COMPATIBLE MULTITOOL: WILSON TOOL MT20I

PUNCH	
	*
6DPRW	6DPSW
POWERline	
SUPREMEline	
EXTREMEline	
H = 100 Ø = 8	



STRIPPER	
	*
6DSRW	6DSSW
SUPREMEline	
H = 6 Ø = 16	



DIE	
	*
6DDRW	6DDSW
EXTREMEline	
H = 17 Ø = 16	



MULTITOOL MT24MM - MT STYLE



TOOL Ø MAX. = 24 MM

COMPATIBLE WITH: FINN-POWER

COMPATIBLE MULTITOOL: MATE MT 6-24, MT 8-24

PUNCH



66PR2 66PS2



POWERline

SUPREMEline

EXTREMEline

H = 70 | ø = 24



STRIPPER



66SR2 66SS2



SUPREMEline

H = 10.5 | ø = 30



DIE



66DR2 66DS2



EXTREMEline

H = 24 | ø = 31

DIE SHIMS

A62N1S	0.1 mm	6 pcs
A62N2S	0.2 mm	6 pcs
A62N5S	0.5 mm	6 pcs







MULTITOOL MT16MM - MT STYLE

R1



TOOL Ø  MAX. = 16 MM



COMPATIBLE WITH: FINN-POWER

COMPATIBLE MULTITOOL: MATE MT 8-16, MT 10-16

PUNCH	
	 *
6UPR1	6UPS1
<input checked="" type="checkbox"/>	
POWERline	
SUPREMEline	
EXTREMEline	
H = 70 ϕ = 16	



STRIPPER	
	 *
6USR1	6USS1
<input checked="" type="checkbox"/>	
SUPREMEline	
H = 8 ϕ = 25	

DIE	
	 *
6UDR1	6UDS1
<input checked="" type="checkbox"/>	
EXTREMEline	
H = 24 ϕ = 25	
DIE SHIMS	
A62M1S	0.1 mm 10 pcs
A62M2S	0.2 mm 10 pcs
A62M5S	0.5 mm 10 pcs



MULTITOOL MT8MM - MT STYLE



TOOL Ø MAX. = 8 MM

COMPATIBLE WITH: FINN-POWER

COMPATIBLE MULTITOOL: MATE MT 20-8, MT 24-8

PUNCH

6SPR8	6SPS8*
POWERline	
SUPREMEline	
EXTREMEline	

H = 70 | ø = 8



STRIPPER

6SSR8	6SSS8*
SUPREMEline	

H = 6 | ø = 16

DIE

6SDR8	6SDS8*
EXTREMEline	
H = 17 ø = 16	
DIE SHIMS	
A62R1S	0.1 mm 24 pcs
A62R2S	0.2 mm 24 pcs
A62R5S	0.5 mm 24 pcs
DIE SHIMS	
A62S1S	0.1 mm 24 pcs
A62S2S	0.2 mm 24 pcs
A62S5S	0.5 mm 24 pcs



R1
m





MULTITOOL MTE4 - MT STYLE

R1

TOOL Ø  MAX. = 31.75 MM



COMPATIBLE WITH: EUROMAC | FINN-POWER

COMPATIBLE MULTITOOL: MATE MTE4, ULTRA IMT3, ULTRA MT3



PUNCH	
	 *
64PRE	64PSE
POWERline	
SUPREMEline	
EXTREMEline	

H = 100.5 | Ø = 31.75



STRIPPER	
	 *
64SRE	64SSE
SUPREMEline	

H = 6.9 | Ø = 38.05

DIE	
	 *
64DRE	64DSE
POWERline	

H = 30 | Ø = 47.6

DIE SHIMS

AB2H5S	0.1 mm	10 pcs
AB2HAS	0.2 mm	10 pcs
AB2HBS	0.5 mm	10 pcs
AB2HMS	Set	15 pcs



MULTITOOL XMTE4 - MT STYLE



TOOL Ø MAX. = 31.75 MM
 COMPATIBLE WITH: EUROMAC
 COMPATIBLE MULTITOOL: MATE XMTE4

PUNCH

64PRX	64PSX*
POWERline	
SUPREMEline	
EXTREMEline	

H = 100.5 | $\phi = 31.75$



STRIPPER

64SRX	64SSX*
SUPREMEline	

H = 11 | $\phi = 38.05$

DIE

64DRX	64DSX*
POWERline	

H = 30 | $\phi = 47.6$



DIE SHIMS

AB2H5S	0.5 mm	10 pcs
AB2HAS	1.0 mm	10 pcs
AB2HBS	1.5 mm	10 pcs
AB2HMS	Set	15 pcs

R1
m



MULTITOOL MTE6 - MT STYLE

R1

TOOL Ø MAX. = 24 MM
COMPATIBLE WITH: EUROMAC
COMPATIBLE MULTITOOL: MATE MTE6

PUNCH	
	*
66PRE	66PSE
POWERline	
SUPREMEline	
EXTREMEline	
H = 70 ø = 24	



STRIPPER	
	*
66SRE	66SSE
SUPREMEline	
H = 10,5 ø = 30	

DIE	
	*
66DRE	66DSE
EXTREMEline	
H = 24 ø = 31	
DIE SHIMS	
A62N1S	0.1 mm 6 pcs
A62N2S	0.2 mm 6 pcs
A62N5S	0.5 mm 6 pcs



MULTITOOL XMTE6 - MT STYLE



TOOL Ø MAX. = 24 MM
 COMPATIBLE WITH: EUROMAC
 COMPATIBLE MULTITOOL: MATE XMTE6

PUNCH

*
 66PRX 66PSX
POWERline
SUPREMEline
EXTREMEline

H = 100 | ø = 24



PUNCH HEAD ADJUSTABLE

*
 66HXX
SUPREMEline



ADJUSTABLE PUNCH

*
 66JRX 66JSX
POWERline
SUPREMEline
EXTREMEline

H = 80.5 | ø = 24



STRIPPER

*
 66SRX 66SSX
SUPREMEline

H = 10.5 | ø = 30



DIE

*
 66DRX 66DSX
EXTREMEline

H = 24 | ø = 31



DIE SHIMS

A62N1S	0.1 mm	6 pcs
A62N2S	0.2 mm	6 pcs
A62N5S	0.5 mm	6 pcs



R1
m



MULTITOOL MTE10 Ø24MM - MT STYLE



R1

TOOL Ø  MAX. = 24 MM
COMPATIBLE WITH: EUROMAC
COMPATIBLE MULTITOOL: MATE MTE10

PUNCH	
	 *
6UPRG	6UPSG
POWERline	
SUPREMEline	
EXTREMEline	



H = 70 | ø = 24



STRIPPER	
	 *
6USRG	6USSG
SUPREMEline	

H = 10,5 | ø = 30



DIE	
	 *
6UDRG	6UDSG
EXTREMEline	

H = 24 | ø = 31

DIE SHIMS		
A62N1S	0.1 mm	6 pcs
A62N2S	0.2 mm	6 pcs
A62N5S	0.5 mm	6 pcs



MULTITOOL MTE10 Ø8MM - MT STYLE



TOOL Ø MAX. = 8 MM
 COMPATIBLE WITH: EUROMAC
 COMPATIBLE MULTITOOL: MATE MTE10

PUNCH

6UPRP 6UPSP

✓

POWERline

SUPREMEline

EXTREMEline

H = 70 | ø = 8



R1
m

STRIPPER

6USRP 6USSP

✓

SUPREMEline

H = 6 | ø = 16

DIE

6UDRP 6UDSP

✓

EXTREMEline

H = 17 | ø = 16

DIE SHIMS

A62R1S	0.1 mm	24 pcs
A62R2S	0.2 mm	24 pcs
A62R5S	0.5 mm	24 pcs

DIE SHIMS

A62S1S	0.1 mm	24 pcs
A62S2S	0.2 mm	24 pcs
A62S5S	0.5 mm	24 pcs





MULTITOOL XMTE10 Ø24MM - MT STYLE

R1

TOOL Ø MAX. = 24 MM

COMPATIBLE WITH: EUROMAC

COMPATIBLE MULTITOOL: MATE XMTE10

PUNCH

6UPRL 6UPSL

✓

POWERline

SUPREMEline

EXTREMEline

H = 100 | ϕ = 24



PUNCH HEAD ADJUSTABLE

6UHL

✓

SUPREMEline



ADJUSTABLE PUNCH

6UJRL 6UJSL

✓

POWERline

SUPREMEline

EXTREMEline

H = 80.5 | ϕ = 24



STRIPPER

6USRL 6USSL

✓

SUPREMEline

H = 10.5 | ϕ = 30



DIE

6UDRL 6UDSL

✓

EXTREMEline

H = 24 | ϕ = 31



DIE SHIMS

A62N1S	0.1 mm	6 pcs
A62N2S	0.2 mm	6 pcs
A62N5S	0.5 mm	6 pcs



MULTITOOL XMTE10 Ø12.7MM - MT STYLE



TOOL Ø MAX. = 12.7 MM

COMPATIBLE WITH: EUROMAC

COMPATIBLE MULTITOOL: MATE XMTE10

PUNCH

*

6UPRS 6UPSS

✓

POWERline

SUPREMEline

EXTREMEline

H = 100 | ø = 16

PUNCH HEAD ADJUSTABLE

*

6UHXS

✓

SUPREMEline

ADJUSTABLE PUNCH

*

6UJRS 6UJSS

✓

POWERline

SUPREMEline

EXTREMEline

H = 80.5 | ø = 16

STRIPPER

*

6USRS 6USSS

✓

SUPREMEline

H = 7 | ø = 19

DIE

*

6UDRS 6UDSS

✓

EXTREMEline

H = 20 | ø = 20

DIE SHIMS

A62Y1S	0.1 mm	24 pcs
A62Y2S	0.2 mm	24 pcs
A62Y5S	0.5 mm	24 pcs

R1
m





MULTITOOL MT24MM MMX - MT STYLE

R1



TOOL Ø  MAX. = 24 MM

COMPATIBLE WITH: DURMA



COMPATIBLE MULTITOOL: MATRIX 6/24 R MMX

PUNCH	
	 *
66PRM	66PSM
POWERline	
SUPREMEline	
EXTREMEline	
H = 113,5 Ø = 24	



STRIPPER	
	 *
66SRM	66SSM
SUPREMEline	
H = 15 Ø = 30	



DIE	
	 *
66DRM	66DSM
SUPREMEline	
H = 31 Ø = 24	



DIE SHIMS		
A62N1S	0,1 mm	6 pcs
A62N2S	0,2 mm	6 pcs
A62N5S	0,5 mm	6 pcs





R1
m



ROLLERI TYPE R1 - ACCESSORIES

▼ COMPATIBILITY

with Thick Turret punching machine

EJECTORS, ALIGNMENT TOOLS AND ADAPTERS	72
ADAPTERS	73
ADAPTERS AND URETHANE STRIPPERS STICKERS	74
ADD-ONS	75

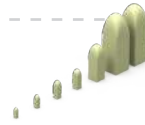


R1



PUNCH URETHANE EJECTOR

✓	D1.7 mm	D2.2 mm	D3 mm	D3.35 mm	D6 mm	D9.7 mm	D10 mm	Mix Set
SUPREMEline	AXPJC	AXPJD	AXPJE	AXPJF	AXPJG	AXPJH	AXPJI	AXUJM



ALIGNMENT TOOL SINGLE TRACK MACHINE SET

A-STATION

✓

AATCS

SUPREMEline



ALIGNMENT TOOL SINGLE TRACK MACHINE SET

B-STATION

✓

ABTCS

SUPREMEline



ALIGNMENT TOOL SINGLE TRACK MACHINE SET

C-STATION

✓

ACTCS

SUPREMEline



ALIGNMENT TOOL SINGLE TRACK MACHINE SET

D-STATION

✓

ADTCS

SUPREMEline





ALIGNMENT TOOL SINGLE TRACK MACHINE SET

E-STATION



AETCS

SUPREMEline



PUNCH ADAPTER B/A



ARPAS

SUPREMEline



DIE ADAPTER B/A



ARDAS

SUPREMEline

PUNCH ADAPTER C/B



ASPAS

SUPREMEline



DIE ADAPTER C/B



ASDAS

SUPREMEline

R1



PUNCH ADAPTER D/B



ATPAS

SUPREMEline



DIE ADAPTER D/B



ATDAS

SUPREMEline



PUNCH ADAPTER D/C



AFPASS

SUPREMEline



DIE ADAPTER D/C



AFDASS

SUPREMEline



**URETHANE STRIPPERS
STICKERS MARK FREE**



Set ABMIS

10 pcs **SUPREMEline**

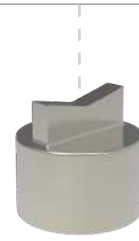
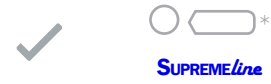




ROOFTOP SHEAR



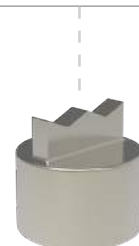
INVERTED ROOFTOP SHEAR



FOUR WAY SHEAR



DOUBLE VALLEY SHEAR



DIE LOCK SLUG



REDUCED MILLED LAND



EXTRA KEY SLOT



R1

EXTRA BACK TAPER PUNCH



DIE CLEARANCE < 0.1



PUNCH WIDTH SIZE < 1.5



DIE SIZE < 2



ROLLERI TYPE R2 - STANDARD

▼ COMPATIBILITY

Trumpf

STANDARD TOOLS ROUND	78 - 83
SIZE 0	78
SIZE 1	79
SIZE 2	80 - 81
SMART TOOLS	82 - 83
STANDARD TOOLS SQUARE	84 - 89
SIZE 0	84
SIZE 1	85
SIZE 2	86 - 87
SMART TOOLS	88 - 89
STANDARD TOOLS RECTANGLE	90 - 95
SIZE 0	90
SIZE 1	91
SIZE 2	92 - 93
SMART TOOLS	94 - 95
STANDARD TOOLS OBOURD	96 - 101
SIZE 0	96
SIZE 1	97
SIZE 2	98 - 99
SMART TOOLS	100 - 101



R2

PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	Hard (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (<1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)



SIZE 0 - STANDARD ROUND

R2

D: $\emptyset = 0 - 6.00$ mm | $\emptyset = 6.01 - 10.50$ mm



PUNCH CHUCKS

✓	D (mm)	D (mm)
	0-6.00	6.01-10.50
	2AKXD	2BKXD

POWERline

PUNCH INSERT

SHORT

✓	D (mm)	D (mm)
	0-6.00	6.01-10.50
	2ANRS	2BNRS

POWERline

SUPREMEline

EXTREMEline

PUNCH INSERT

LONG

✓	D (mm)	D (mm)
	0-6.00	6.01-10.50
	2ANRL	2BNRL

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

✓	D (mm)
	76.20
	22SRE

SUPREMEline

STRIPPER

MACHINE GROUP H-I WITH BEVEL

✓	D (mm)
	76.20
	22SRB

SUPREMEline



DIE SIZE 1

✓	D (mm)
	0-30.00
	2IDRD

POWERline

EXTREMEline



DIE SHIMS

B11H3S	0.3 mm	1 pcs
B11H5S	0.5 mm	1 pcs
B11HAS	1.0 mm	1 pcs
B12HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		



PUNCH INSERT	
SHORT	
✓	D (mm) 150-30.00
	23PRS
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH INSERT	
LONG	
✓	D (mm) 150-30.50
	23PRL
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH INSERT	
WHISPER	
✓	D (mm) 150-30.50
	23PRW
	POWERline
	SUPREMEline
	EXTREMEline



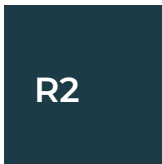
STRIPPER	
MACHINE GROUP E-F-G	
✓	D (mm) 76.20
	22SRE
	SUPREMEline



STRIPPER	
MACHINE GROUP H-I WITH BEVEL	
✓	D (mm) 76.20
	22SRB
	SUPREMEline



DIE SIZE 1		
✓	D (mm) 0-30.00	
	21DRD	
	POWERline	
	EXTREMEline	
DIE SHIMS		
B11H3S	0.3 mm	1 pcs
B11H5S	0.5 mm	1 pcs
B11HAS	1.0 mm	1 pcs
B12HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		





SIZE 2 - STANDARD ROUND 40/51

R2

D: $\varnothing = 30.01 - 40.00$ mm | $\varnothing = 40.01 - 51.00$ mm

PUNCH

SHORT



D (mm) D (mm)
30.01-40.00 40.01-51.00

24PRS 25PRS

POWERline

SUPREMEline

EXTREMEline



PUNCH

LONG



D (mm) D (mm)
30.01-40.00 40.01-51.00

24PRL 25PRL

POWERline

SUPREMEline

EXTREMEline



PUNCH

WHISPER



D (mm) D (mm)
30.01-40.00 40.01-51.00

24PRW 25PRW

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20

22SRE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20

22SRB

SUPREMEline



DIE SIZE 2



D (mm) 0-76.20

22DRD

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		



D: Ø = 51.01 - 60.00 MM | Ø = 60.01 - 76.20 MM

PUNCH		
SHORT		
✓	D (mm)	D (mm)
	51.01-60.00	60.01-76.20
	26PRS	28PRS
	<i>POWERline</i>	
	<i>SUPREMEline</i>	
	<i>EXTREMEline</i>	



PUNCH		
LONG		
✓	D (mm)	D (mm)
	51.01-60.00	60.01-76.20
	26PRL	28PRL
	<i>POWERline</i>	
	<i>SUPREMEline</i>	
	<i>EXTREMEline</i>	



PUNCH		
WHISPER		
✓	D (mm)	D (mm)
	51.01-60.00	60.01-76.20
	26PRW	28PRW
	<i>POWERline</i>	
	<i>SUPREMEline</i>	
	<i>EXTREMEline</i>	



STRIPPER	
MACHINE GROUP E-F-G	
✓	D (mm) 76.20
	22SRE
	<i>SUPREMEline</i>



STRIPPER	
MACHINE GROUP H-I WITH BEVEL	
✓	D (mm) 76.20
	22SRB
	<i>SUPREMEline</i>



DIE SIZE 2		
✓	D (mm) 0-76.20	
	22DRD	
	<i>POWERline</i>	
	<i>EXTREMEline</i>	
DIE SHIMS		
B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		



R2



SMART TOOLS - ROUND 30/40

R2

D: Ø = 1.50 - 30.50 mm | Ø = 30.51 - 40.00 mm

INSERT HOLDER



D (mm)
0 - 40,00
0°-45°-90°

224XH

EXTREMEline



PUNCH INSERT



SHORT

D (mm) D (mm)
1.50-30.50 30.51-40.00

23NRR 24NRR

SUPREMEline

EXTREMEline



PUNCH INSERT



LONG

D (mm) D (mm)
1.50-30.50 30.51-40.00

23NRN 24NRN

SUPREMEline

EXTREMEline

PUNCH INSERT



WHISPER

D (mm) D (mm)
1.50-30.50 30.51-40.00

23NRG 24NRG

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20

22SRE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20

22SRB

SUPREMEline



DIE SIZE 1



D (mm) 0-30.00

21DRD

POWERline

EXTREMEline



DIE SIZE 1



D (mm) 0-76.20

22DRD

POWERline

EXTREMEline



DIE SHIMS

B11H3S	0.3 mm	1 pcs
B11H5S	0.5 mm	1 pcs
B11HAS	1.0 mm	1 pcs
B12HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm



D: Ø = 40.01 - 60.00 mm | Ø = 60.01 - 72.00 mm | Ø = 72.01 - 76.00 mm



INSERT HOLDER	
✓	D (mm) 40.51-76.20 0°-90° 227XH EXTREMEline

PUNCH INSERT			
SHORT			
✓	D (mm) 40.01-60.00	D (mm) 60.01-72.00	D (mm) 72.01-76.00
	26NRR	27NRR	28NRR
	SUPREMEline		
	EXTREMEline		



PUNCH INSERT			
LONG			
✓	D (mm) 40.01-60.00	D (mm) 60.01-72.00	D (mm) 72.01-76.00
	26NRN	27NRN	28NRN
	SUPREMEline		
	EXTREMEline		

PUNCH INSERT			
WHISPER			
✓	D (mm) 40.01-60.00	D (mm) 60.01-72.00	D (mm) 72.01-76.00
	26NRG	27NRG	28NRG
	SUPREMEline		
	EXTREMEline		



STRIPPER	
MACHINE GROUP E-F-G	
✓	D (mm) 76.20 22SRE SUPREMEline



STRIPPER	
MACHINE GROUP H-I WITH BEVEL	
✓	D (mm) 76.20 22SRB SUPREMEline



DIE SIZE 2	
✓	D (mm) 0-30.00 22DRD POWERline EXTREMEline



DIE SIZE 2	
✓	D (mm) 0-76.20 22DRD POWERline EXTREMEline



DIE SHIMS		
B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

DIE SHIMS		
B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

R2



SIZE 0 - STANDARD SQUARE

R2

L: □ = 0 - 6.00 MM | □ = 6.01 - 10.50 MM



PUNCH CHUCKS

✓	D (mm)	D (mm)
	0-6.00	6.01-10.50
	2AKXD	2BKXD

POWERline

PUNCH INSERT

SHORT

✓	D (mm)	D (mm)
	0-6.00	6.01-10.50
	2ANQS	2BNQS

POWERline

SUPREMEline

EXTREMEline

PUNCH INSERT

LONG

✓	D (mm)	D (mm)
	0-6.00	6.01-10.50
	2ANQL	2BNQL

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

✓	D (mm)	76.20
		22SQE

SUPREMEline

STRIPPER

MACHINE GROUP H-I WITH BEVEL

✓	D (mm)	76.20
		22SQB

SUPREMEline



DIE SIZE 1

✓	D (mm)	0-30.00
		2IDQD

POWERline

EXTREMEline



DIE SHIMS

B11H3S	0.3 mm	1 pcs
B11H5S	0.5 mm	1 pcs
B11HAS	1.0 mm	1 pcs
B12HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		



PUNCH INSERT	
SHORT	
✓	D (mm) 1.50-20.00
	23PQS
	<i>POWERline</i>
	<i>SUPREMEline</i>
	<i>EXTREMEline</i>



PUNCH INSERT	
LONG	
✓	D (mm) 1.50-20.00
	23PQL
	<i>POWERline</i>
	<i>SUPREMEline</i>
	<i>EXTREMEline</i>



PUNCH INSERT	
WHISPER	
✓	D (mm) 1.50-20.00
	23PQW
	<i>POWERline</i>
	<i>SUPREMEline</i>
	<i>EXTREMEline</i>



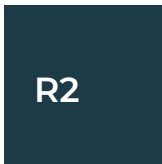
STRIPPER	
MACHINE GROUP E-F-G	
✓	D (mm) 76.20
	22SQE
	<i>SUPREMEline</i>



STRIPPER	
MACHINE GROUP H-I WITH BEVEL	
✓	D (mm) 76.20
	22SQB
	<i>SUPREMEline</i>



DIE SIZE 1		
✓	D (mm) 0-30.00	
	21DQD	
	<i>POWERline</i>	
	<i>EXTREMEline</i>	
DIE SHIMS		
B11H3S	0.3 mm	1 pcs
B11H5S	0.5 mm	1 pcs
B11HAS	1.0 mm	1 pcs
B12HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		





SIZE 2 - STANDARD SQUARE 28/35

R2

L: □ = 20.01 - 28.00 mm | □ = 28.01 - 35.00 mm

PUNCH

SHORT

D (mm) D (mm)
20.01-28.00 28.01-35.00

24PQS 25PQS

POWERline

SUPREMEline

EXTREMEline



PUNCH

LONG

D (mm) D (mm)
20.01-28.00 28.01-35.00

24PQL 25PQL

POWERline

SUPREMEline

EXTREMEline



PUNCH

WHISPER

D (mm) D (mm)
20.01-28.00 28.01-35.00

24PQW 25PQW

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

D (mm) 76.20

22SQE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL

D (mm) 76.20

22SQB

SUPREMEline



DIE SIZE 2

D (mm) 0-76.20

22DQD

POWERline

EXTREMEline



DIE SHIMS

B21H3S 0.3 mm 1 pcs

B21H5S 0.5 mm 1 pcs

B21HAS 1.0 mm 1 pcs

B22HSS Set 3 pcs

0.3 mm + 0.5 mm + 1.0 mm

SIZE 2 - STANDARD SQUARE 42/53

L: □ = 35.01 - 42.00 mm | □ = 42.01 - 53.80 mm



PUNCH	
SHORT	
✓	D (mm) D (mm) 35.01-42.00 42.01-53.80
	26PQS 28PQS
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH	
LONG	
✓	D (mm) D (mm) 35.01-42.00 42.01-53.80
	26PQL 28PQL
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH	
WHISPER	
✓	D (mm) D (mm) 35.01-42.00 42.01-53.80
	26PQW 28PQW
	POWERline
	SUPREMEline
	EXTREMEline



STRIPPER	
MACHINE GROUP E-F-G	
✓	D (mm) 76.20
	22SQE
	SUPREMEline



STRIPPER	
MACHINE GROUP H-I WITH BEVEL	
✓	D (mm) 76.20
	22SQB
	SUPREMEline



DIE SIZE 2		
✓	D (mm) 0-76.20	
	22DQD	
	POWERline	
	EXTREMEline	
DIE SHIMS		
B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		



R2



SMART TOOLS - SQUARE 30/40

R2

L: □ = 1.5 - 20.00 mm | □ = 20.01 - 28.00 mm

INSERT HOLDER



D (mm)	D (mm)
0 - 40,00	40.01-76.20
0°-45°-90°	0°-90°

224XH 227XH

EXTREMEline



PUNCH INSERT



SHORT

D (mm)	D (mm)
1.50-20.00	20.01-28.00

23NQR 24NQR

SUPREMEline

EXTREMEline



PUNCH INSERT



LONG

D (mm)	D (mm)
1.50-20.00	20.01-28.00

23NQN 24NQN

SUPREMEline

EXTREMEline

PUNCH INSERT



WHISPER

D (mm)	D (mm)
1.50-20.00	20.01-28.00

23NQG 24NQG

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20

22SQE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20

22SQB

SUPREMEline



DIE SIZE 1



D (mm) 0-30.00

21DQD

POWERline

EXTREMEline



DIE SIZE 1



D (mm) 0-76.20

22DQD

POWERline

EXTREMEline

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm



L: □ = 28.01 - 35.00 mm | □ = 35.01 - 42.00 mm | □ = 42.01 - 53.80 mm



INSERT HOLDER

✓	D (mm) 0 - 40.00 0°-45°-90°	D (mm) 40.01-76.20 0°-90°
---	-----------------------------------	---------------------------------

224XH 227XH

EXTREMEline

PUNCH INSERT

SHORT

✓	D (mm) 28.01-35.00	D (mm) 35.01-42.00	D (mm) 42.01-53.80
---	-----------------------	-----------------------	-----------------------

26NQR 27NQR 28NQR

SUPREMEline

EXTREMEline



PUNCH INSERT

LONG

✓	D (mm) 28.01-35.00	D (mm) 35.01-42.00	D (mm) 42.01-53.80
---	-----------------------	-----------------------	-----------------------

26NQN 27NQN 28NQN

SUPREMEline

EXTREMEline

PUNCH INSERT

WHISPER

✓	D (mm) 28.01-35.00	D (mm) 35.01-42.00	D (mm) 42.01-53.80
---	-----------------------	-----------------------	-----------------------

26NQG 27NQG 28NQG

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20

22SQE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20

22SQB

SUPREMEline



DIE SIZE 2



D (mm) 0-30.00

21DQD

POWERline

EXTREMEline



DIE SIZE 2



D (mm) 0-76.20

22DQD

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm



SIZE 0 - STANDARD RECTANGLE

R2

D: = 0 - 6.00 mm | = 6.01 - 10.50 mm



PUNCH CHUCKS



D (mm)	D (mm)
0-6.00	6.01-10.50
2AKXD	2BKXD

POWERline

PUNCH INSERT

SHORT



D (mm)	D (mm)
0-6.00	6.01-10.50
2ANES	2BNES

POWERline

SUPREMEline

EXTREMEline



PUNCH INSERT

LONG



D (mm)	D (mm)
0-6.00	6.01-10.50
2ANEL	2BNEL

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20
22SEE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20
22SEB

SUPREMEline



DIE SIZE 1



D (mm) 0-30.00
2IDED

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

SIZE 1 - STANDARD RECTANGLE

D:  = 1.50 - 30.50 MM



PUNCH	
SHORT	
✓	D (mm) 1.50-30.50
	23PES
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH	
LONG	
✓	D (mm) 1.50-30.00
	23PEL
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH	
WHISPER	
✓	D (mm) 1.50-30.50
	23PEW
	POWERline
	SUPREMEline
	EXTREMEline



STRIPPER	
MACHINE GROUP E-F-G	
✓	D (mm) 76.20
	22SEE
	SUPREMEline



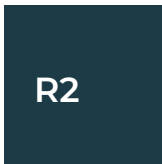
STRIPPER	
MACHINE GROUP H-I WITH BEVEL	
✓	D (mm) 76.20
	22SEB
	SUPREMEline



DIE SIZE 1	
✓	D (mm) 0-30.00
	2IDED
	POWERline
	EXTREMEline



DIE SHIMS		
B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		



R2



SIZE 2 - STANDARD RECTANGLE 40/50

R2

D: = 30.51 - 40.00 mm | = 40.01 - 50.80 mm

PUNCH

SHORT



D (mm) D (mm)
30.51-40.00 40.01 - 50.80

24PES 25PES

POWERline

SUPREMEline

EXTREMEline



PUNCH

LONG



D (mm) D (mm)
30.51-40.00 40.01 - 50.80

24PEL 25PEL

POWERline

SUPREMEline

EXTREMEline



PUNCH

WHISPER



D (mm) D (mm)
30.51-40.00 40.01 - 50.80

24PEW 25PEW

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20

22SEE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20

22SEB

SUPREMEline



DIE SIZE 2



D (mm) 0-76.20

22DED

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

SIZE 2 - STANDARD RECTANGLE 60/76



D: = 50.81 - 60.00 mm | = 60.01 - 76.20 mm

PUNCH

SHORT

D (mm) D (mm)
50.81-60.00 60.01-76.20

26PES 28PES

POWERline

SUPREMEline

EXTREMEline



PUNCH

LONG

D (mm) D (mm)
50.81-60.00 60.01-76.20

26PEL 28PEL

POWERline

SUPREMEline

EXTREMEline



PUNCH

WHISPER

D (mm) D (mm)
50.81-60.00 60.01-76.20

26PEW 28PEW

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

D (mm) 76.20

22SEE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL

D (mm) 76.20

22SEB

SUPREMEline



DIE SIZE 2

D (mm) 0-76.20

22DED

POWERline

EXTREMEline



DIE SHIMS

B21H3S 0.3 mm 1 pcs

B21H5S 0.5 mm 1 pcs

B21HAS 1.0 mm 1 pcs

B22HSS Set 3 pcs

0.3 mm + 0.5 mm + 1.0 mm



SMART TOOLS - RECTANGLE 30/40

R2

D: = 1.50 - 30.50 MM | = 30.51 - 40.00 MM



INSERT HOLDER



D (mm)	D (mm)
0 - 40.00	40.01-76.20
0°-45°-90°	0°-90°

224XH 227XH

EXTREMEline

PUNCH INSERT

SHORT



D (mm)	D (mm)
1.50-30.50	30.51-40.00

23NER 24NER

SUPREMEline

EXTREMEline



PUNCH INSERT

LONG



D (mm)	D (mm)
1.50-30.50	30.51-40.00

23NEN 24NEN

SUPREMEline

EXTREMEline

PUNCH INSERT

WHISPER



D (mm)	D (mm)
1.50-30.50	30.51-40.00

23NEG 24NEG

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20

22SEE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20

22SEB

SUPREMEline



DIE SIZE 1



D (mm) 0-30.00

21DED

POWERline

EXTREMEline



DIE SIZE 1



D (mm) 0-76.20

22DED

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

SMART TOOLS - RECTANGLE 60/72/76



D: = 40.01 - 60.00 MM | = 60.01 - 72.00 MM | = 72.01 - 76.00 MM



INSERT HOLDER

✓	D (mm) 0 - 40,00 0°-45°-90°	D (mm) 40.01-76.20 0°-90°
---	-----------------------------------	---------------------------------

224XH 227XH

EXTREMEline

PUNCH INSERT

SHORT

✓	D (mm) 40.01-60.00	D (mm) 60.01-72.00	D (mm) 72.01-76.00
---	-----------------------	-----------------------	-----------------------

26NER 27NER 28NER

SUPREMEline

EXTREMEline



PUNCH INSERT

LONG

✓	D (mm) 40.01-60.00	D (mm) 60.01-72.00	D (mm) 72.01-76.00
---	-----------------------	-----------------------	-----------------------

26NEN 27NEN 28NEN

SUPREMEline

EXTREMEline

PUNCH INSERT

WHISPER

✓	D (mm) 40.01-60.00	D (mm) 60.01-72.00	D (mm) 72.01-76.00
---	-----------------------	-----------------------	-----------------------

26NEG 27NEG 28NEG

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

D (mm) 76.20

22SEE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL

D (mm) 76.20

22SEB

SUPREMEline



DIE SIZE 2

D (mm) 0-30.00

2IDED

POWERline

EXTREMEline



DIE SIZE 2

D (mm) 0-76.20

22DED

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm



SIZE 0 - STANDARD OBOUND

R2

D: $\varnothing = 0 - 6.00 \text{ mm}$ | $\varnothing = 6.01 - 10.50 \text{ mm}$



PUNCH CHUCKS



D (mm)	D (mm)
0-6.00	6.01-10.50
2AKXD	2BKXD

POWERline

PUNCH INSERT



SHORT

D (mm)	D (mm)
0-6.00	6.01-10.50
2ANOS	2BNOS

POWERline

SUPREMEline

EXTREMEline



PUNCH INSERT



LONG

D (mm)	D (mm)
0-6.00	6.01-10.50
2ANOL	2BNOL

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G



D (mm) 76.20

22SOE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL



D (mm) 76.20

22SOB

SUPREMEline



DIE SIZE 1



D (mm) 0-30.00

2IDOD

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm

SIZE 1 - STANDARD OBOURD

D: $\varnothing = 1.50 - 30.50$ MM



PUNCH	
SHORT	
✓	D (mm) 1.50-30.50
	23POS
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH	
LONG	
✓	D (mm) 1.50-30.50
	23POL
	POWERline
	SUPREMEline
	EXTREMEline



PUNCH	
WHISPER	
✓	D (mm) 1.50-30.50
	23POW
	POWERline
	SUPREMEline
	EXTREMEline



STRIPPER	
MACHINE GROUP E-F-G	
✓	D (mm) 76.20
	22SOE
	SUPREMEline



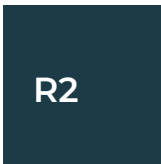
STRIPPER	
MACHINE GROUP H-I WITH BEVEL	
✓	D (mm) 76.20
	22SOB
	SUPREMEline



DIE SIZE 1	
✓	D (mm) 0-30.00
	2IDOD
	POWERline
	EXTREMEline



DIE SHIMS		
B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		



R2



SIZE 2 - STANDARD OBROUND 40/50

R2

D: $\varnothing = 30.51 - 40.00 \text{ mm}$ | $\varnothing = 40.01 - 50.80 \text{ mm}$

PUNCH INSERT

SHORT

D (mm) D (mm)
30.51-40.00 40.01-50.80

24POS 25POS

POWERline

SUPREMEline

EXTREMEline



PUNCH INSERT

LONG

D (mm) D (mm)
30.51-40.00 40.01-50.80

24POL 25POL

POWERline

SUPREMEline

EXTREMEline



PUNCH INSERT

WHISPER

D (mm) D (mm)
30.51-40.00 40.01-50.80

24POW 25POW

POWERline

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

D (mm) 76.20

22SOE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL

D (mm) 76.20

22SOB

SUPREMEline



DIE SIZE 2

D (mm) 0-76.20

22DED

POWERline

EXTREMEline



DIE SHIMS

B21H3S 0.3 mm 1 pcs

B21H5S 0.5 mm 1 pcs

B21HAS 1.0 mm 1 pcs

B22HSS Set 3 pcs

0.3 mm + 0.5 mm + 1.0 mm

SIZE 2 - STANDARD OBROUND 60/76

D:  = 50.81 - 60.00 MM |  = 60.01 - 76.20 MM



PUNCH

SHORT

✓	D (mm)	D (mm)
	50.81-60.00	60.01-76.20
	26POS	28POS
	POWERline	
	SUPREMEline	
	EXTREMEline	



PUNCH

LONG

✓	D (mm)	D (mm)
	50.81-60.00	60.01-76.20
	26POL	28POL
	POWERline	
	SUPREMEline	
	EXTREMEline	



PUNCH

WHISPER

✓	D (mm)	D (mm)
	50.81-60.00	60.01-76.20
	26POW	28POW
	POWERline	
	SUPREMEline	
	EXTREMEline	



STRIPPER

MACHINE GROUP E-F-G

✓	D (mm)	76.20
	22SOE	
	SUPREMEline	



STRIPPER

MACHINE GROUP H-I WITH BEVEL

✓	D (mm)	76.20
	22SOB	
	SUPREMEline	



DIE SIZE 2

✓	D (mm)	0-76.20
	22DOD	
	POWERline	
	EXTREMEline	



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		





SMART TOOLS - OBROUND 30/40

R2

D: = 1.50 - 30.50 MM | = 30.51 - 40.00 MM

INSERT HOLDER

✓	D (mm)	∅ (mm)
	0 - 40,00	40.01-76.20
	0°-45°-90°	0°-90°
	224XH	227XH

EXTREMEline



PUNCH INSERT

SHORT

✓	D (mm)	D (mm)
	1.50-30.50	30.51-40.00
	23NOR	24NOR

POWERline

EXTREMEline



PUNCH INSERT

LONG

✓	D (mm)	D (mm)
	1.50-30.50	30.51-40.00
	23NON	24NON

POWERline

EXTREMEline

PUNCH INSERT

WHISPER

✓	D (mm)	D (mm)
	1.50-30.50	30.51-40.00
	23NOG	24NOG

POWERline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

✓	D (mm)	76.20
	22SOE	

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL

✓	D (mm)	76.20
	22SOB	

SUPREMEline



DIE SIZE 1

✓	D (mm)	0-30.00
	21DOD	

POWERline

EXTREMEline



DIE SIZE 1

✓	D (mm)	0-76.20
	22DOD	

POWERline

EXTREMEline

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm



D: = 40.01 - 60.00 MM | = 60.01 - 72.00 MM | = 72.01 - 76.00 MM

INSERT HOLDER

D (mm)	ø (mm)
0 - 40,00	40.01-76.20
0°-45°-90°	0°-90°

224XH 227XH

EXTREMEline



PUNCH INSERT

SHORT

D (mm)	D (mm)	D (mm)
40.01-60.00	60.01-72.00	72.01-76.00

26NOR 27NOR 28NOR

SUPREMEline

EXTREMEline



PUNCH INSERT

LONG

D (mm)	D (mm)	D (mm)
40.01-60.00	60.01-72.00	72.01-76.00

26NON 27NON 28NON

SUPREMEline

EXTREMEline

PUNCH INSERT

WHISPER

D (mm)	D (mm)	D (mm)
40.01-60.00	60.01-72.00	72.01-76.00

26NOG 27NOG 28NOG

SUPREMEline

EXTREMEline



STRIPPER

MACHINE GROUP E-F-G

D (mm) 76.20

22SOE

SUPREMEline



STRIPPER

MACHINE GROUP H-I WITH BEVEL

D (mm) 76.20

22SOB

SUPREMEline



DIE SIZE 2

D (mm) 0-30.00

21DOD

POWERline

EXTREMEline



DIE SIZE 2

D (mm) 0-76.20

22DOD

POWERline

EXTREMEline



DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

0.3 mm + 0.5 mm + 1.0 mm

DIE SHIMS

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs

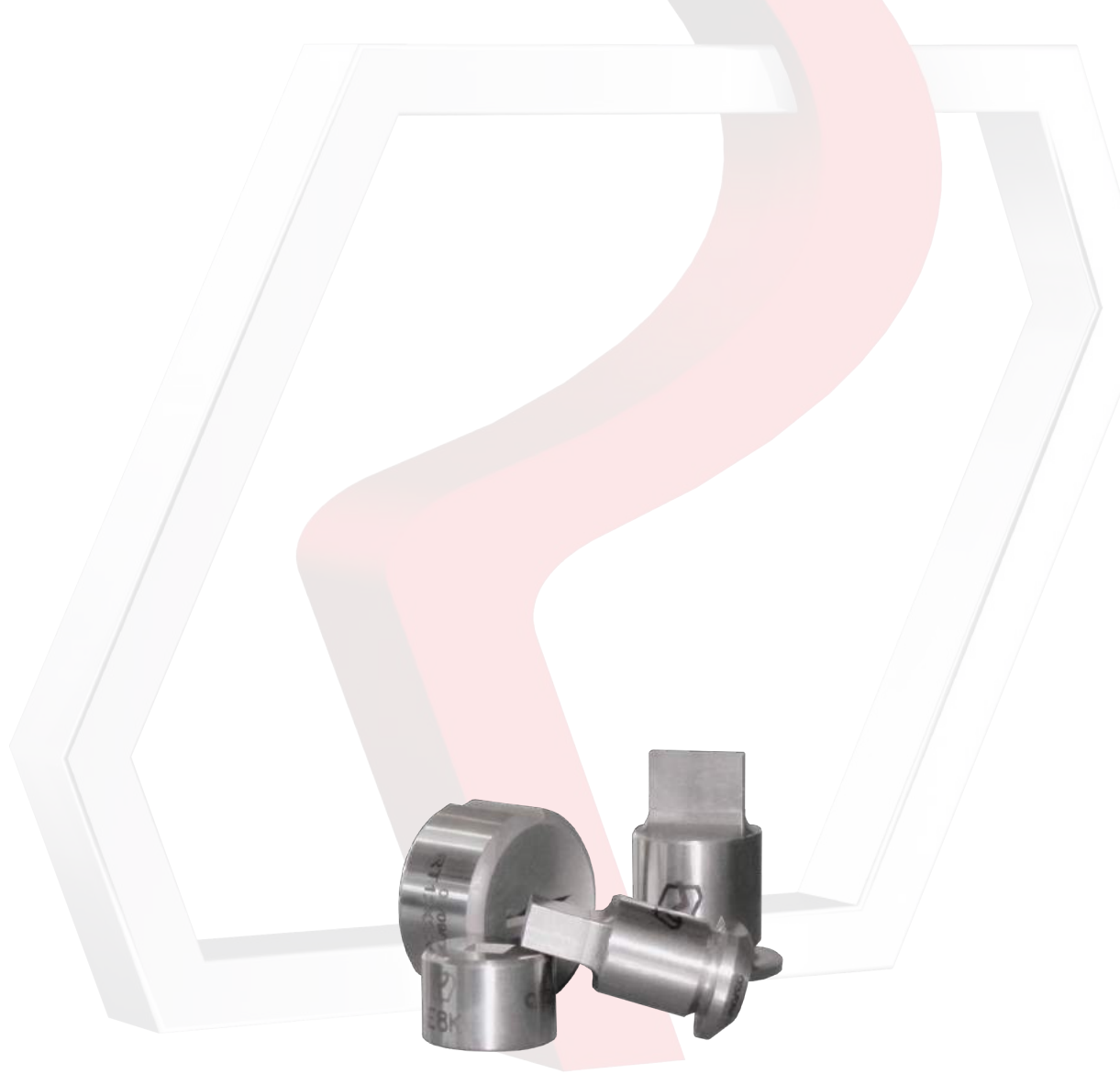
0.3 mm + 0.5 mm + 1.0 mm

ROLLERI TYPE R2 - MULTITOOL

▼ COMPATIBILITY

Trumpf

5 STATIONS	110
10 STATIONS	111
4 STATIONS	112
6 STATIONS	113



PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	Hard (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (<1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

R2
m



MULTITOOL 5 STATIONS

R2



UPPER ASSEMBLY

		*
95UXT		
SUPREMEline		

PUNCH				
<input checked="" type="checkbox"/>				
	95PRT	95PQT	95PET	95PST*
POWERline				
SUPREMEline				
EXTREMEline				



STRIPPER

		*
95MXT		
SUPREMEline		

DIE				
<input checked="" type="checkbox"/>				
	95DRT	95DQT	95DET	95DST*
POWERline				
SUPREMEline				
EXTREMEline				



LOWER ASSEMBLY

		*
95LXT		
SUPREMEline		





UPPER ASSEMBLY

*
 9UUXT
SUPREMEline

PUNCH

*
 9UPRT 9UPQT 9UPET 9UPST
POWERline
SUPREMEline
EXTREMEline



STRIPPER

*
 9UMXT
SUPREMEline

DIE

*
 9UDRT 9UDQT 9UDET 9UDST
POWERline
SUPREMEline
EXTREMEline



LOWER ASSEMBLY

*
 9ULXT
SUPREMEline

R2
m



MULTITOOL 4 STATIONS

R2



UPPER ASSEMBLY

		*
94UXT		
<i>SUPREMEline</i>		

PUNCH

<input checked="" type="checkbox"/>				
	94PRT	94PQT	94PET	94PST*
<i>POWERline</i>				
<i>SUPREMEline</i>				
<i>EXTREMEline</i>				



DIE

<input checked="" type="checkbox"/>				
	94DRT	94DQT	94DET	94DST*
<i>POWERline</i>				
<i>SUPREMEline</i>				
<i>EXTREMEline</i>				




LOWER ASSEMBLY

		*
94LXT		
<i>SUPREMEline</i>		









UPPER ASSEMBLY





-    *
- 96UXT
- SUPREMEline**

PUNCH

-     *
- 96PRT 96PQT 96PET 96PST
- POWERline**
- SUPREMEline**
- EXTREMEline**




DIE

-     *
- 96DRT 96DQT 96DET 96DST
- POWERline**
- SUPREMEline**
- EXTREMEline**



LOWER ASSEMBLY

-    *
- 96LXT
- SUPREMEline**



ROLLERI TYPE R2 - SLITTING TOOLS

▼ COMPATIBILITY

Trumpf

SLITTING TOOLS ROOFTOP	110 - 111
SLITTING TOOLS CTF	112 - 113



PUNCHES AND DIES

TOOL LINES	POWERline	SUPREMEline	EXTREMEline
HIT RATE APPLICATION	Normal (<250 H.P.M.)	High (250~600 H.P.M.)	Extreme (>600 H.P.M.)
MACHINE TYPE	Mechanic	Hydraulic	Servo Electric / High Speed Hydraulic
MATERIAL TYPE - TOUGHNESS	Easy (Tensile Strength 7~25 kg/mm ²)	Medium (Tensile Strength 22~45 kg/mm ²)	Hard (Tensile Strength >45 kg/mm ²)
MATERIAL THICKNESS	Thin (<1,5 mm)	Medium (1.5~3mm)	Thick (> 3 mm)
PUNCHING OPERATION	Full Hit	Partial Hit (>50% of punch surface)	Nibbling
AMOUNT OF HITS FOR THE JOB	Small (<5000 hits)	Medium (5000~10000 hits)	Big (>10000 hits)

R2
S



SLITTING TOOLS ROOFTOP

30 x 5 MM | 56 x 5 MM

R2



PUNCH ASS. (NO BLADE)



22GYT

SUPREMEline

WITH INTEGRATED ALIGNMENT RING

PUNCH INSERT ROOFTOP - RECTANGLE

SIZE 2

D (mm) D (mm)
30 x 5 56 x 5

2SRET 2TRET



POWERline

SUPREMEline

EXTREMEline



PUNCH INSERT ROOFTOP - SPECIAL SHAPE

SIZE 2

D (mm) D (mm)
0 - 30 30 - 56

2VRAT 2WRAT



POWERline

SUPREMEline

EXTREMEline



DIE INSERT SPECIAL SHAPE

SIZE 2 - 1 PIECE

D (mm) D (mm)
30 x 5 56 x 5

2SIAT 2TIAT



SUPREMEline



DIE INSERT RECTANGLE

SIZE 2 - 2 PIECES

D (mm)
56 x 5

2T2ET



SUPREMEline

SIZE 2 - 1 PIECE

D (mm) D (mm)
30 x 5 56 x 5

2SIET 2TIET



SUPREMEline



DIE ASS.



D (mm)
30 x 5 - 56 x 5

22TYT

SUPREMEline

NO BLADE

110 * Standard Shapes:



Delivery within 48h



Please ask for delivery time

SLITTING TOOLS ROOFTOP

76.2 x 5 MM



PUNCH ASS. (NO BLADE)	
✓	22GYT SUPREMEline
WITH INTEGRATED ALIGNMENT RING	

PUNCH INSERT ROOFTOP - RECTANGLE

SIZE 2	
	D (mm) 76.2 x 5
✓	2URET POWERline SUPREMEline EXTREMEline



PUNCH INSERT ROOFTOP - SPECIAL SHAPE

SIZE 2	
	D (mm) 56 x 76.2
✓	2ZRAT POWERline SUPREMEline EXTREMEline



DIE INSERT SPECIAL SHAPE

SIZE 2 - 1 PIECE	
	D (mm) 76.2 x 5
✓	2UIAT SUPREMEline



DIE INSERT RECTANGLE

SIZE 2 - 2 PIECES	
	D (mm) 76.2 x 5
✓	2U2ST SUPREMEline
SIZE 2 - 1 PIECE	
	D (mm) 76.2 x 5
✓	2UIET SUPREMEline



DIE ASS.

	D (mm) 76.2 x 5
✓	22VYT SUPREMEline

DIE ASS.

	D (mm) 76.2 x 5
✓	22UYT SUPREMEline



NO BLADE



SLITTING PUNCH

SIZE 2 - 56 x 5



2TCEP




POWERline

SUPREMEline

EXTREMEline

WITH INTEGRATED URETHANE STRIPPER

SLITTING PUNCH
SIZE 2 - 56 x 5



2TCEM

✓

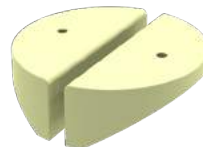
POWERline

SUPREMEline

EXTREMEline



WITHOUT INTEGRATED URETHANE STRIPPER



CTF URETHANE INSERT

SIZE 2 - 56 x 5



2THEC



SUPREMEline

CTF SCREWS
PER PAIR

2TWZC

✓

SUPREMEline





SLITTING PUNCH
SIZE 2 - 76.2 x 5



2UCEP



POWERline

SUPREMEline

EXTREMEline

WITH INTEGRATED URETHANE STRIPPER



SLITTING PUNCH

SIZE 2 - 76.2 x 5



2UCEM

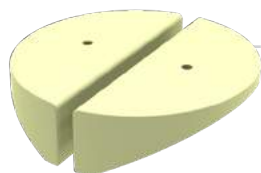


POWERline

SUPREMEline

EXTREMEline

WITHOUT INTEGRATED URETHANE STRIPPER



CTF URETHANE INSERT

SIZE 2 - 76.2 x 5



2UHEC



SUPREMEline

CTF SCREWS

PER PAIR



2UWZC

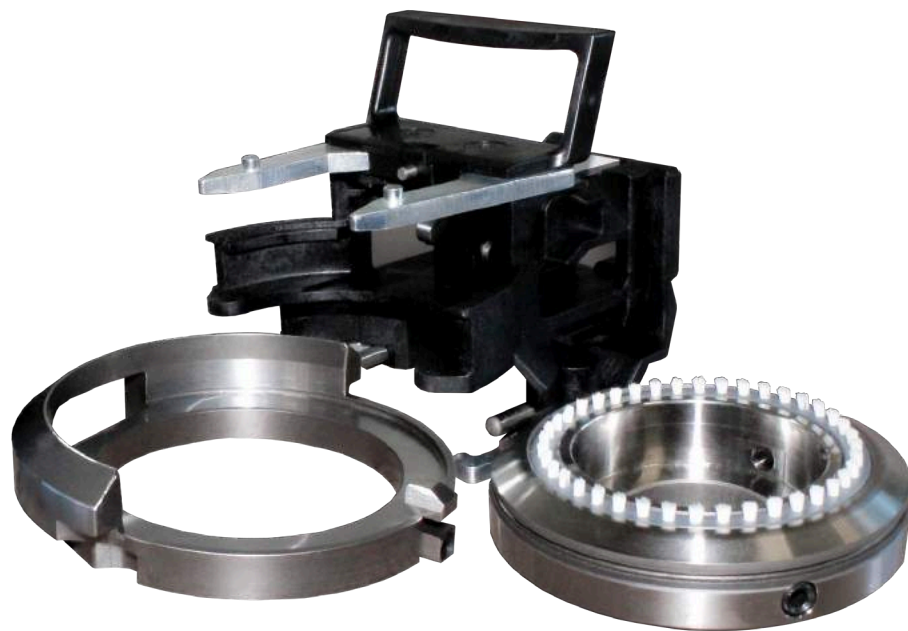
SUPREMEline

ROLLERI TYPE R2 - ACCESSORIES

▼ COMPATIBILITY

Trumpf

TRUMPF STYLE CARTRIDGE ASSEMBLY	118
TRUMPF STYLE DIE SHOE ASSEMBLY	118
ALIGNMENT FIXTURE TRUMPF STYLE	118
ALIGNMENT RINGS	119
SIZE 1/2 DIE ADAPTER	119



R2




ACCESSORIES


R2



TRUMPF STYLE CARTRIDGE ASSEMBLY - SIZE 2


 B2CHS
POWERline

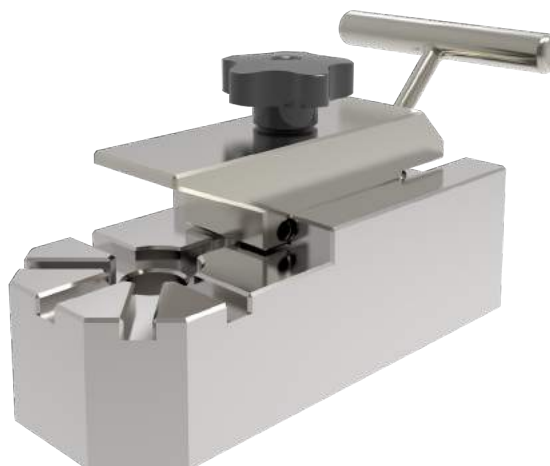
TRUMPF STYLE DIE SHOE ASSEMBLY - SIZE 2

 B2SHS
POWERline



ALIGNMENT FIXTURE TRUMPF STYLE - SIZE 2

 B2FH5
POWERline





SIZE 1/2 DIE ADAPTER



B2ZHS

POWERline

ALIGNMENT RING SIZE 1



B1RHS

POWERline



ALIGNMENT RING SIZE 2



B2RHS

POWERline



DIE SHIM SIZE 1

B11H3S	0.3 mm	1 pcs
B11H5S	0.5 mm	1 pcs
B11HAS	1.0 mm	1 pcs
B12HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

DIE SHIM SIZE 2

B21H3S	0.3 mm	1 pcs
B21H5S	0.5 mm	1 pcs
B21HAS	1.0 mm	1 pcs
B22HSS	Set	3 pcs
0.3 mm + 0.5 mm + 1.0 mm		

DIE SHIM MT5

B6151S	0.1 mm	1 pcs
B6152S	0.2 mm	1 pcs
B6153S	0.3 mm	1 pcs
B6155S	0.5 mm	1 pcs
B615MS	Set	4 pcs
0.1 mm + 0.2 mm + 0.3 mm + 0.5 mm		

DIE SHIM MT10

B6101S	0.1 mm	1 pcs
B6103S	0.3 mm	1 pcs
B6105S	0.5 mm	1 pcs
B610MS	Set	3 pcs
0.1 mm + 0.3 mm + 0.5 mm		

SPECIAL TOOLS

IN THE FOLLOWING CHAPTER YOU WILL FIND EXAMPLES OF SPECIAL WORKING MADE WITH ROLLERI TOOLS.

TO RECEIVE YOUR CUSTOMIZED TOOL:

1. PRINT OR SCAN THE PAGE WITH THE WORKING MOST SUITABLE TO YOUR NEEDS;
2. FILL THE PAGE WITH INFORMATION REQUESTED;
3. SEND IT TO SALES@ROLLERI.IT.

WE WILL BE GLAD TO PROPOSE THE SOLUTION MOST SUITABLE TO YOUR NEEDS!

CENTER POINT FORM UP/FORM DOWN	120
EXTRUSION FORM UP/FORM DOWN	121
HALF SHEAR FORM UP/FORM DOWN	122
EMBOSS (DIMPLE) FORM UP/FORM DOWN	123
COUNTERSINK FOR SCREW FORM UP/FORM DOWN	124
LANCE & FORM	125
EMBOSS (LARGE EMBOSS) FORM UP/FORM DOWN	126
EKO (KNOCK OUT) FORM UP/FORM DOWN	127
SINGLE BRIDGE FORM UP/FORM DOWN	128
LOUVER FORM UP	129
CLUSTER TOOL REPLACEMENT INSERT STYLE	130
THREAD FORM UP / FORM DOWN	131



Spe



Name

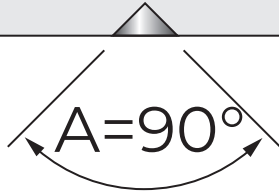
Company

Tel.

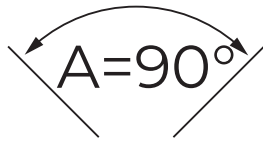
Email

Fill the form according to your needs and send it to: sales@rolleri.it

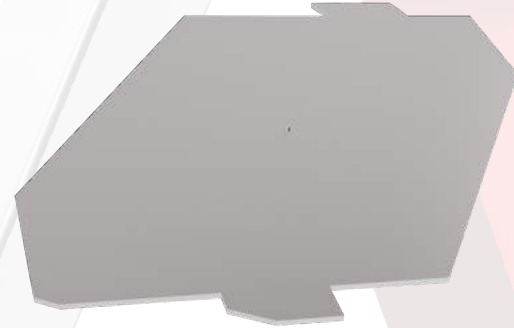
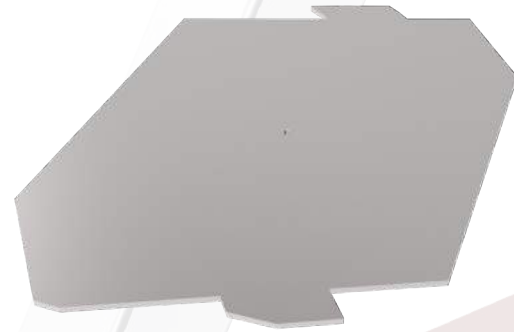
CENTER POINT FORM UP/FORM DOWN



Center point form up



Center point form down



Forming process of making conical recess (center point). Used for locator, landmark and so on.

INFORMATION NEEDED:

CENTER POINT

QUESTIONS, CHANGES, COMMENTS HERE:

Form up or form down?	
∅ A	
∅ B	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine (ex: Amada - Pega 357)	



Name

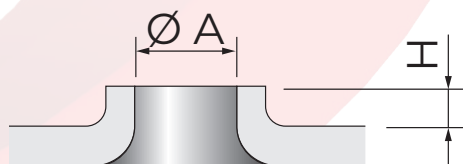
Company

Tel.

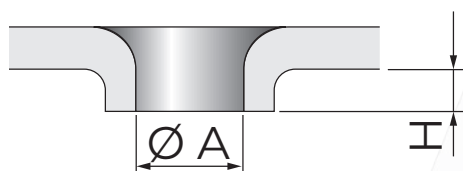
Email

Fill the form according to your needs and send it to: sales@rolleri.it

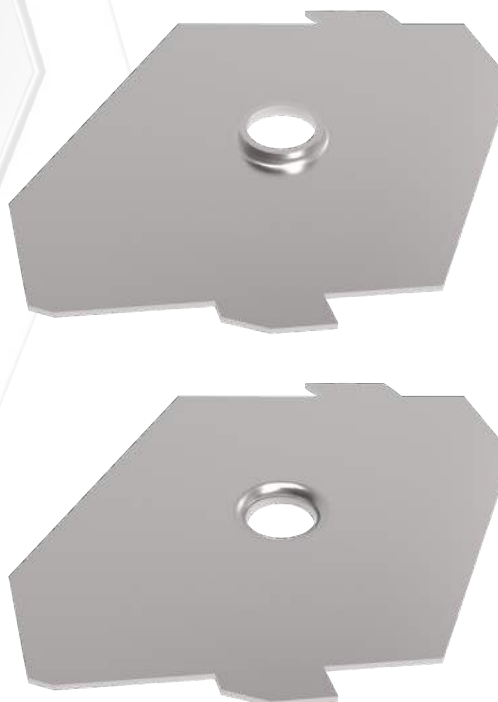
EXTRUSION FORM UP/FORM DOWN



Extrusion form up



Extrusion form down



Forming process of making tubes of threading for screw. Threading for screw and increased bearing area for tubes. Specific tool coating and treatment available for your specific application, ask to our expert at sales desk for a tailor-made consult.

INFORMATION NEEDED:

EXTRUSION

QUESTIONS, CHANGES, COMMENTS HERE:

Form up or form down?	
A	
H	
If DIA > 6.35mm TOL=	+/-
Tapping? Roll Form (Self Tapper) or Thread Cut (Machine Screw)	
Materyal type: (ex: Aluminium)	
Material thickness: (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	

Spe



Name

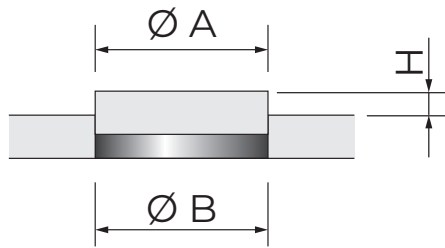
Company

Tel.

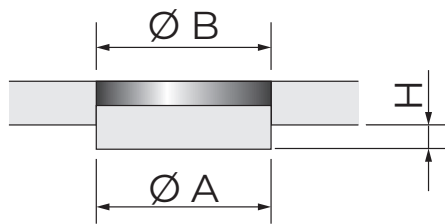
Email

Fill the form according to your needs and send it to: sales@rolleri.it

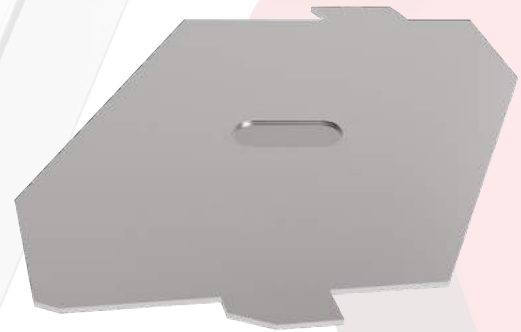
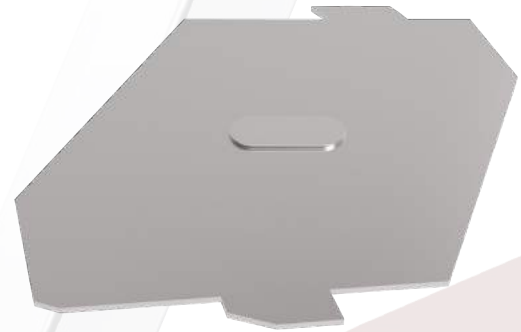
HALF SHEAR FORM UP



Half shear form up



Half shear form down



Forming process of pierce half of material thickness. Used for locator or stopper.

INFORMATION NEEDED:

HALF SHEAR

QUESTIONS, CHANGES, COMMENTS HERE:

Form up or form down?	
A	
B	
H	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	



Name

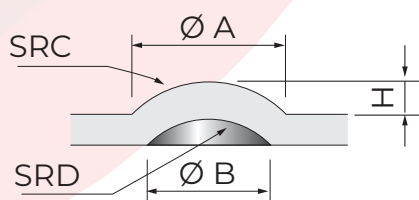
Company

Tel.

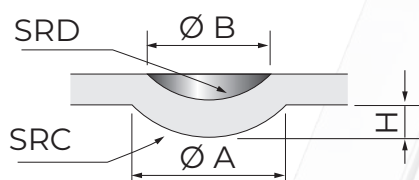
Email

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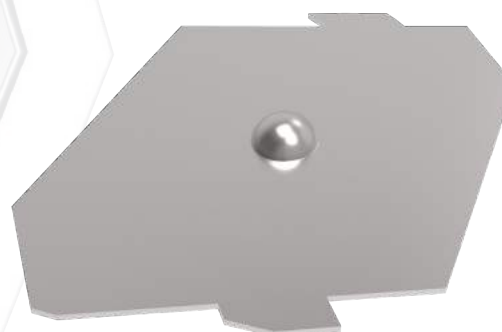
EMBOSS (DIMPLE) FORM UP/FORM DOWN



Emboss form up



Emboss form down



Forming process of embossing material like dimple. Used for locator or decorative pattern of the material.

INFORMATION NEEDED:

EMBOSS (DIMPLE)

QUESTIONS, CHANGES, COMMENTS HERE:

Form up or form down?	
A	
B	
H	
SRD	
SRC	
Top or bottom of sheet dimensions	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	

Spe



Name

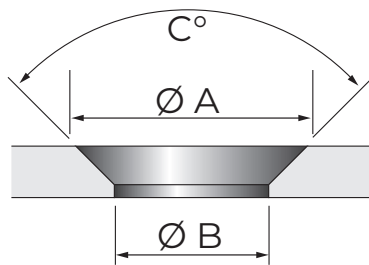
Company

Tel.

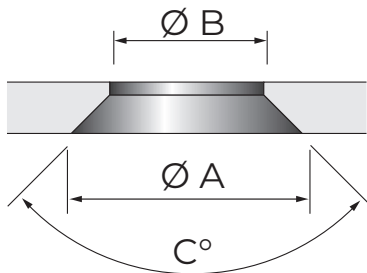
Email

Fill the form according to your needs and send it to: sales@rolleri.it

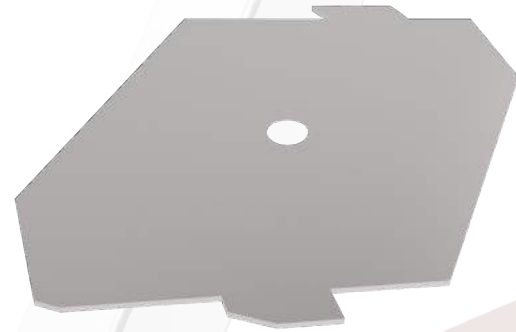
COUNTERSINK FOR SCREW (CHAMFERING) FORM UP/FORM DOWN



Countersink form up



Countersink form down



Forming process of making a chamfer to material. Used for sink a countersunk screw head, make chamfer to a corner after punching, guide of tapping.

INFORMATION NEEDED:

COUNTERSINK FOR SCREW	QUESTIONS, CHANGES, COMMENTS HERE:
Angle (C°)	
B	
A	
Form up or form down	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	



Name

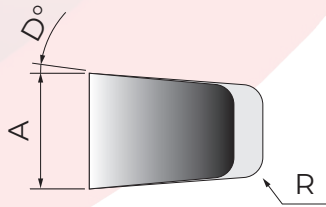
Company

Tel.

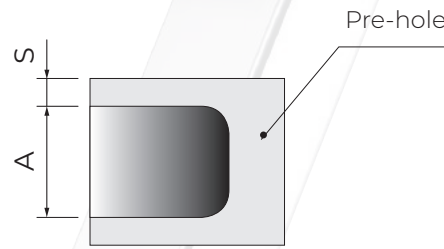
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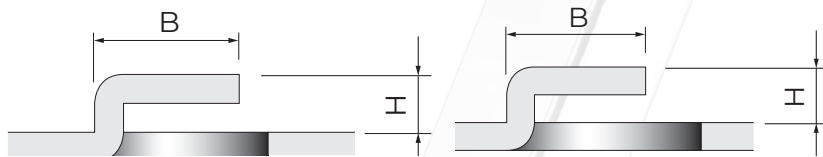
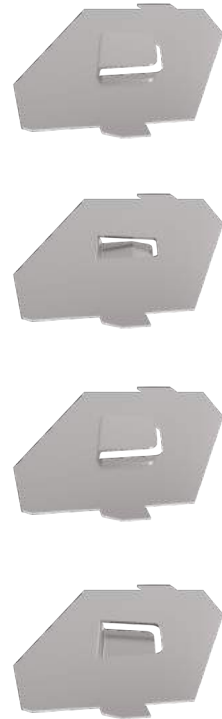
LANCE & FORM



Forming without pre-hole



Forming after pre-hole



Forming process of lance like Z figure. Used for hook, locator and stopper.

INFORMATION NEEDED:

LANCE & FORM

QUESTIONS, CHANGES, COMMENTS HERE:

Angle (D°)	
B	
H	
A	
S	
R	
Form up or form down?	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	

Spe



Name

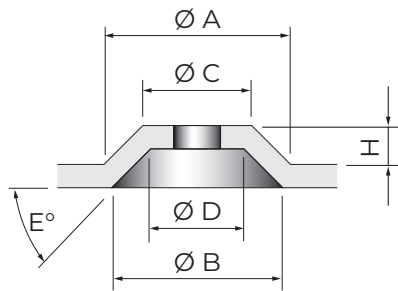
Company

Tel.

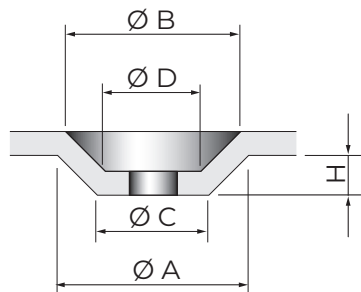
Email

Fill the form according to your needs and send it to: sales@rolleri.it

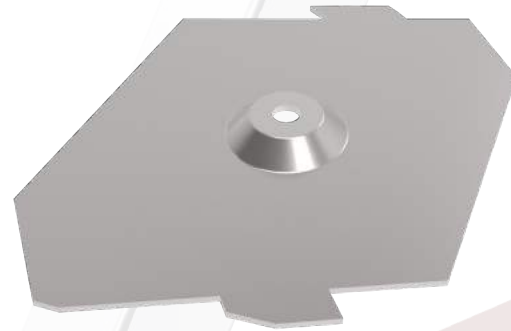
EMBOSS (LARGE EMBOSS) FORM UP/FORM DOWN



Large emboss form up



Large emboss form down



Forming process to produce raised or sunken shape. Used for sinking a head of bolts or nuts. Used for the seat of the product.

INFORMATION NEEDED:

LARGE EMBOSS

QUESTIONS, CHANGES, COMMENTS HERE:

Form up or form down	
A	
B	
C	
D	
H	
E°	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	



Name

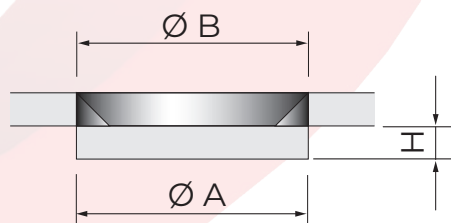
Company

Tel.

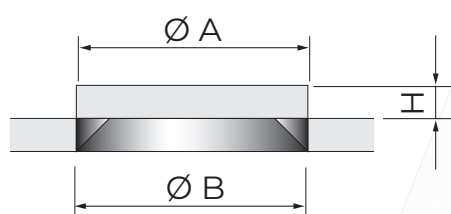
Email

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EKO (KNOCK OUT) FORM UP/ FORM DOWN



EKO (knock out) form up



EKO (knock out) form down



Forming process of piercing a hole and keep the slug on the sheet metal by tabs. When using a hole, remove the slug using screwdriver.

INFORMATION NEEDED:

EKO (KNOCK OUT)

Form up or form down	
A	
B	
H	
Actual diameter	
Actual size shape	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	

QUESTIONS, CHANGES, COMMENTS HERE:

Spe



Name

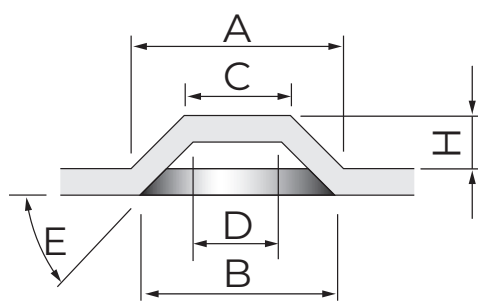
Company

Tel.

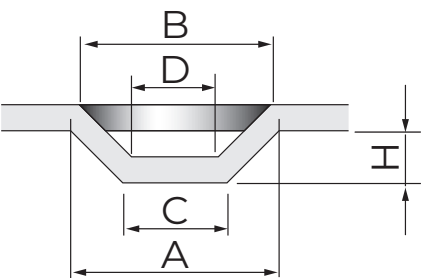
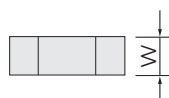
Email

Fill the form according to your needs and send it to: sales@rolleri.it

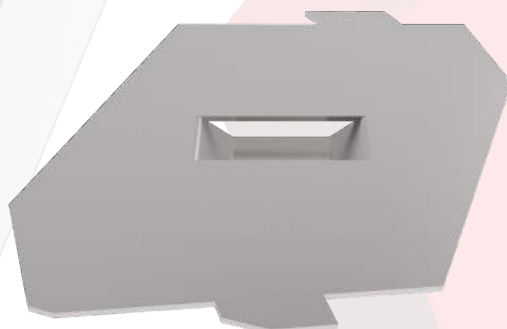
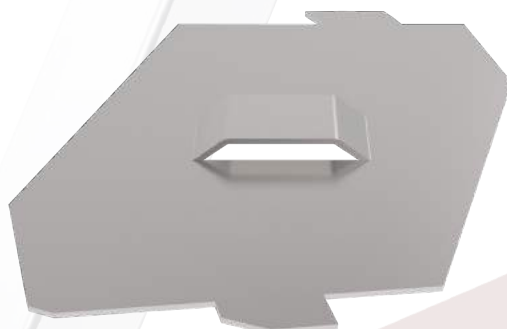
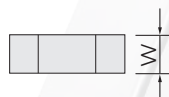
SINGLE BRIDGE FORM UP/FORM DOWN



Single bridge form up



Single bridge form down



Forming process of lance like a bridge.

INFORMATION NEEDED:

SINGLE BRIDGE

QUESTIONS, CHANGES, COMMENTS HERE:

Form up or form down	
A	
B	
C	
D	
H	
W	
E°	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	



Name

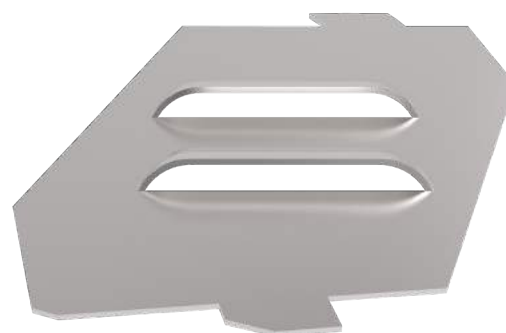
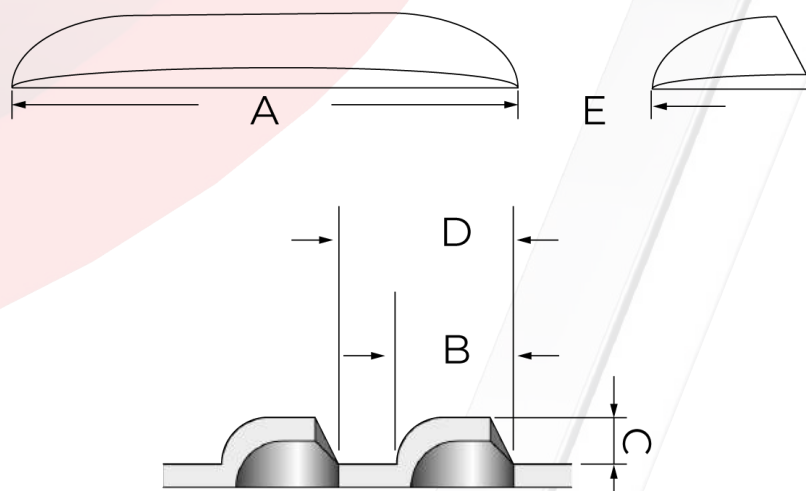
Company

Tel.

Email

Fill the form according to your needs and send it to: sales@rolleri.it

LOUVER FORM UP



Forming process of louver to create an opening. Used to provide air flow or ventilation.

INFORMATION NEEDED:

LOUVER

A	
B	
C	
D	
E	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	

QUESTIONS, CHANGES, COMMENTS HERE:

.....

Spe



Name

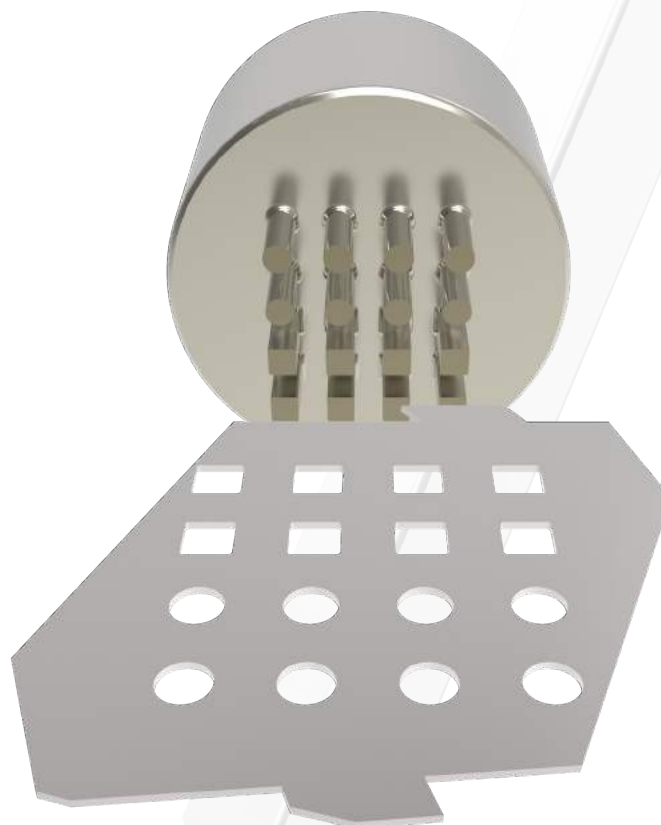
Company

Tel.

Email

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CLUSTER TOOL REPLACEMENT INSERT STYLE



INFORMATION NEEDED:

CLUSTER TOOL REPLACEMENT INSERT STYLE		QUESTIONS, CHANGES, COMMENTS HERE:
Rounds	∅	
Shape (8 x 4 Rectangle)		
Total of Shape		
Material type: (ex: Aluminium)		
Material Thickness (ex: 1.6 mm)		
Machine: (ex: Amada - Pega 357)		
Hole Distances C - C X Axis		
Hole Distances C - C Y Axis		



Name

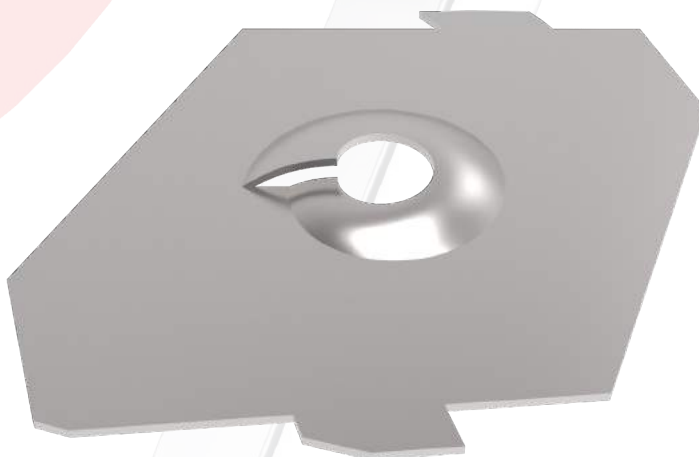
Company

Tel.

Email

Fill the form according to your needs and send it to: sales@rolleri.it

THREAD FORM UP / FORM DOWN



The thread form may require these tools:

1. A pre-punch
2. Thread form (possibly with built in coin)
3. Separate coin tool (very rare for thick material).

INFORMATION NEEDED:

LOUVER

Machine screw or sheet metal scrow	
Thread size and type	
Form up or form down	
Material type: (ex: Aluminium)	
Material Thickness (ex: 1.6 mm)	
Machine: (ex: Amada - Pega 357)	

QUESTIONS, CHANGES, COMMENTS HERE:

Spe

VARIOUS INFORMATION

MODULE 1: SPECIFICATION OF ROLLERI TOOLING	134
MODULE 2: TECHNICAL INFORMATION	137
MODULE 3: ORDERING GUIDE	140
MODULE 4: MAINTENANCE AND GRINDING MACHINE	146













ROLLERI











Sheet Metal Academy


















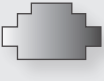



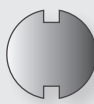
VARIOUS SHAPE

STANDARD SHAPE			WITH RADIUS CORNER	CORNER ROUNDING
Round (RO)	Square (SQ)	Rectangle (RE)	Square with radius corners	CN-42
				
Obround (OB)	Single D (SD)	Double D (DD)	Rectangle with radius corners	CN-41
				

Note : Square and Rectangle punch corner has small radius (R0.2) for prevent crack of punch tip. If it is not necessary, please inform us.

SPECIAL SHAPES (CLASS-1)				
				
				

SPECIAL SHAPES (CLASS-2)				
				
				

SPECIAL SHAPES (CLASS-3)				
				
				


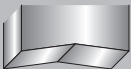

SPECIAL SHAPES (CLASS-4)

More complicated figure.

When make order, please inform to us the center position of the tool.

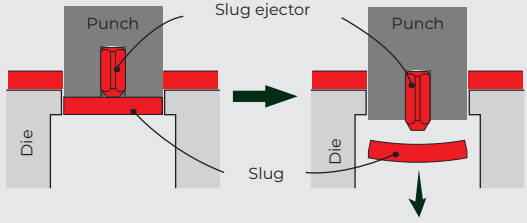
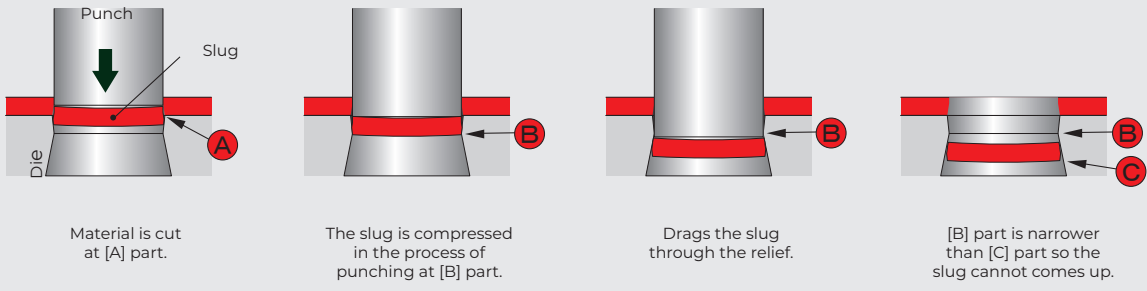
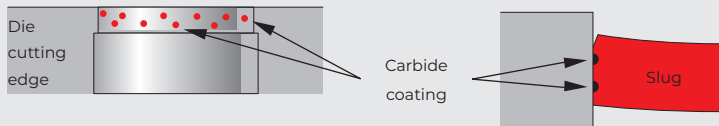

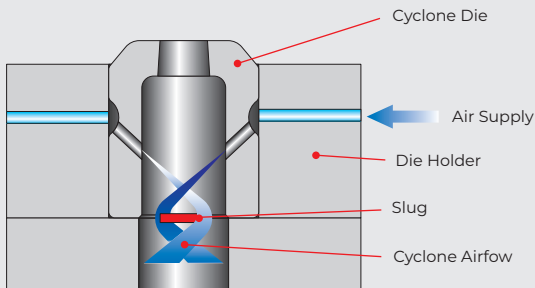
Rolleri is possible to produce other than this form list, please contact us.

SHEAR ANGLE TYPE FOR PUNCH

ROOF TOP SHEAR		To reduce tonnage and noise by added angle 2°(or 5°) at punch shear.
INVERSE ROOF TOP SHEAR		To prevent touch of punch and die when use as shearing punch tool. It is possible to cross Inverse Roof Shape shear angle when order square.
CONCAVE SHEAR		To prevent touch of punch and die when use as shearing punch tool. It is possible to cross Inverse Roof Shape shear angle when order square.

Note : Without notation, station C(2") and D(3-1/2") are going to be at punch. Station E(4-1/2") will be added roof top shear.

PREVENT SLUG PULLING

<p>PUNCH</p>	<p>SLUG EJECTOR</p> <p>Slug ejector push down the slug. It will be installed on round punches with ϕ over 4 mm and for shaped punches with ϕ over 6 mm as standard. Please contact us if you need to process thick or hard material sheets with small punch diameter.</p> 
	<p>SLUG CATCHER DIE</p> <p>Standard shapes and special shapes have this function as standard. (Except: Blank type, with dies with dimension/diameter below 2 mm, with punches with heels and when die clearance below 0.1 mm)</p> 
<p>DIE</p>	<p>DEPOSITRON PROCESS</p> <p>Put electrical super hard spot onto inside of die hole except clearance 0.1 mm. Standard on die diameter $\phi 2 \sim \phi 4.5$</p> 
	<p>STRAIGHT WITH TAPER DIE</p> <p>we advise to use this kind of die when blanking (where the slug is the final product) with dies with dimension/diameter below 2 mm, with punches with heels and when die clearance below 0.1 mm.</p> 
	<p>CYCLONE DIE (COMPATIBLE WITH AMADA POWER VACUUM DIE)</p> <p>Cyclone die has small inclined holes to provide cyclone airflow to make a strong vacuum area under the die. This vacuum helps to prevent slug pulling problems. This function is working only with machines with this optional.</p> 



ROLLERI ORIGINAL COATING

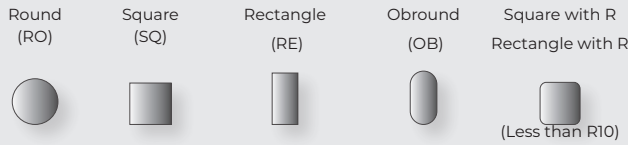
SUPER DRY PUNCH (SDP)

Perfect tool for stainless steel!

This is our best tool. Incredible durability and defeated the common sense that „Stainless is hard to process“.

This tool is suitable for night time unattended operation and dry (no oil lubrication on the sheet metal) condition punching.

Super Dry Punch (SDP) is available with only the following shapes.



LONG LIFE PUNCH (RLP)

Most efficient in long life and cost!

High performance for all purpose, especially for mild steel, galvanized steel with high corrosion resistance!

Special shapes are also available for this treatment.



HARD PUNCH (RHP)

Ultra cost performance tool for reasonable price!

Reasonable price and suitable for all purpose.

RHP shows high performance reducing adhesion and galling which is more likely to be caused by processing Aluminum and Coated steel sheet.



Total Performance	Punch type	Aptitude			
		Stainless steel (SUS)	Mild steel (SPCC)	Aluminum	Galvanized
<div style="text-align: center;">  </div>	Super Dry Punch (SDP)	★★★★★	★★★★★	★	★★★
	Long life Punch (RLP)	★★★★	★★★★★	★★★★★	★★★★★
	Hard Punch (RHP)	★★★	★★★★	★★★★★	★★★★
	HSS	★★	★★★	★★★	★★★
	D2	★	★	★★	★

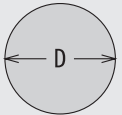
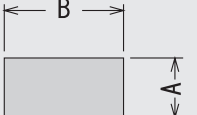
CALCULATE PUNCHING FORCE (TONNAGE)

Tonnage capacity is different depending on machines.

Use the calculation formula below to prevent the problems of over tonnage.

$$\text{Tonnage (ton)} = \frac{\text{Circumference (mm)} \times \text{Material thickness (mm)} \times \text{Shear resistance (kg/mm}^2\text{)}}{1000}$$

Circumference

ROUND	SHAPED
Diameter x 3.14	(Length dimension + Width dimension) x 2
	
Circumference = D x 3.14	Circumference = (A + B) x 2

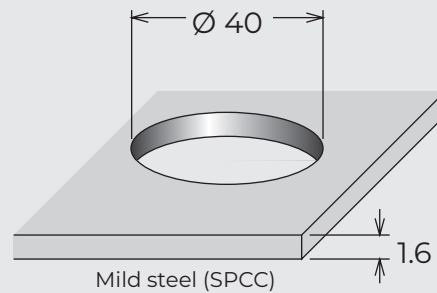
Shear resistance by material

MATERIAL	SHEAR RESISTANCE (KG/MM ²)
Mild Steel	26~35
SS400	33~42
Stainless Steel	52~56
Aluminum	7~16
Copper	18~30
Brass	22~40

Calculation example

The tonnage when piercing Ø40 to Mild Steel T=1.6 mm.

$$\frac{\text{Circumference} \times \text{Material Thickness} \times \text{Shear Resistance}}{1000} = \frac{40 \times 3.14 \times 1.6 \times 35}{1000}$$



DIE CLEARANCE

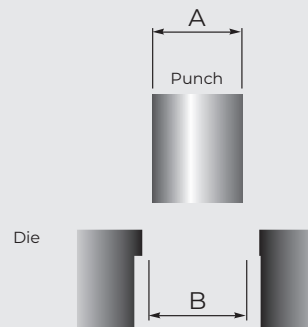
Die clearance is...

Die clearance is difference between punch diameter and die diameter.

$$\text{Die clearance} = B - A$$

Recommended die clearance

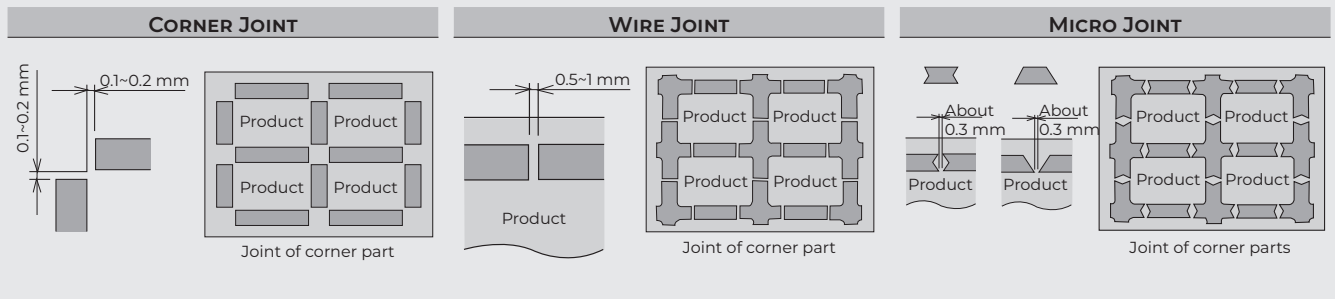
$$\text{Die clearance} = \text{Material thickness} \times \text{Clearance Ratio}$$



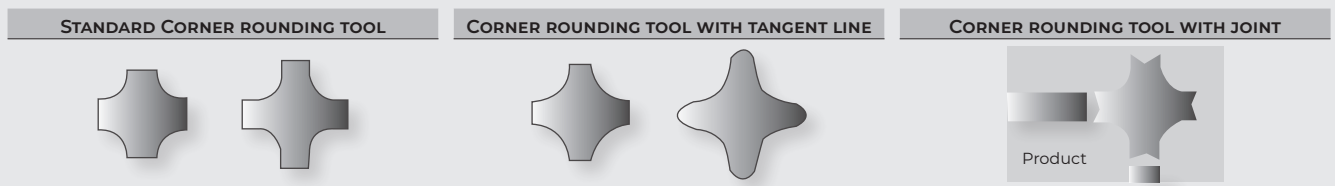
Material	Clearance Ratio	Material Thickness					
		0.5~1.0	1.2	1.5	2.0	2.3	3.2
Mild steel	0.15	0.15	0.2	0.25	0.3	0.4	0.5
Stainless steel	0.2	0.2	0.25	0.3	0.4	0.5	0.6
Aluminum	0.1	0.15	0.15	0.15	0.2	0.25	0.35
Copper	0.1	0.15	0.15	0.15	0.2	0.25	0.35



JOINT METHOD



CORNER ROUNDING

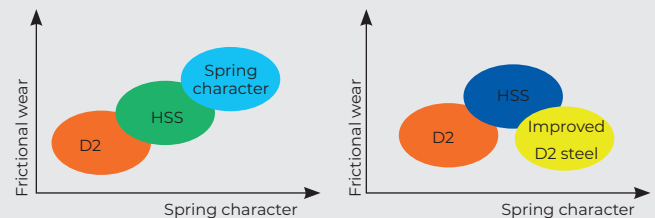


MATERIAL DIFFERENCE

1. WE USE THE BEST QUALITY HIGH SPEED STEEL MATERIALS FOR PUNCH

Rolleri uses powder type high speed steel for punch body.*
Structure of this material is very much fine and does not have unevenness of ingredient.
Shock resistant ratio is double strong and frictional wear is 50% better than standard high speed steel (HSS).

*Thick turret tooling only, but there are some excluded items.



2. EVEN D2 STEEL (SKD-11) IS DIFFERENT FROM STANDARD

a) Rolleri uses improved D2 steel for die.

This material has twice of spring character and hardness is higher than general D2 steel. (HRC 58 to 60) Also much better anti-chipping and crack than standard D2 steel.

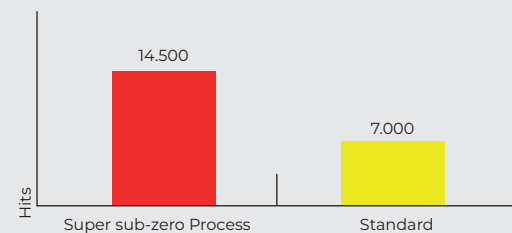
This improved D2 steel has good performance for wire EDM because material does not have residual stress in the material.

b) Rolleri uses super sub-zero heat treatment process on D2 steel for standard punch.

Material is put into -130cent degree just after heat treatment. This process gives material structure fine and better for stability and hardness. Normally sub-zero process is done only for precision equipment or gages.

PUNCHING TEST:

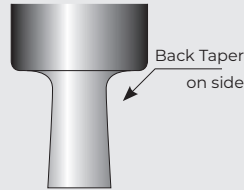
Silicon steel plate 0.35 mm thickness, Punch material is D2 steel (SKD-11)



SPECIFICATION DIFFERENCE

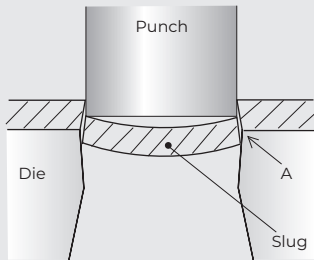
1. BACK TAPER ON SIDE OF THE PUNCH.

This specification makes better performance for less touching area and less sticking material on the side face of punch body.

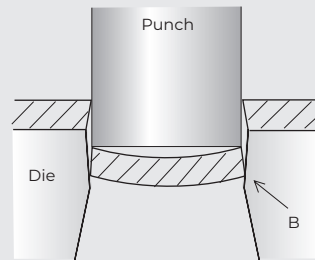


2. ROLLERI TOOL IS USING SLUG CATCHER SHAPE FOR DIE AS STANDARD SPECIFICATION

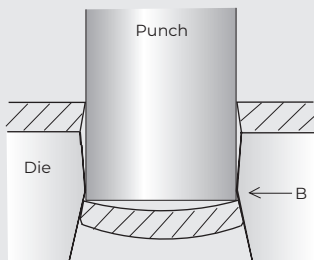
This specification is effective to prevent the slug from coming up.



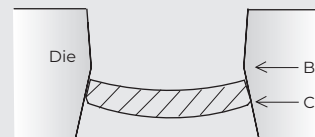
(1) Material is cut at A position.



(2) Slug is pushed and pressed to coming process to B position.



(3) After slug is lower than position B, scrap is released to the scrap box.



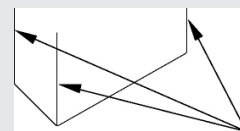
(4) Area of B position is smaller than C position therefore slug would not come up to upper area.

3. MINUTE CORNER R ON THE PUNCHING SIDE EDGES.

Rolleri put the minute corner R on the edge of the punching side edges because this corner is the weakest point of shaped tools. After put small R on the corner tool life is much longer and prevent the unusual wear of the punch body.



Example of damage of the corner

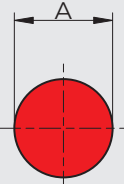
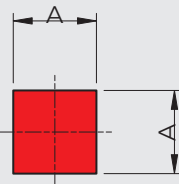
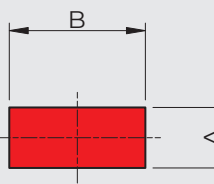
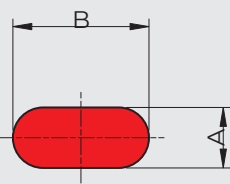


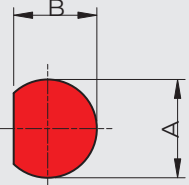
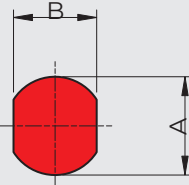
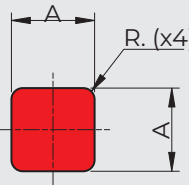
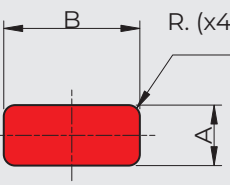
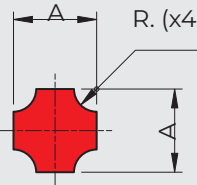
Put the minute corner R on the edge of the punching side edges



THE WAY TO INSTRUCT A REQUIRED DIMENSION AND SHAPE

Please instruct your required shape and dimension based on the table below. If your required shape is not showed on the table below, please send us a drawing.

Punch shape	Round (RO)	Square (SQ)	Rectangle (RE)	Asola (OB)
Figure of punch shape				
Way to instruct	$\varnothing A$	$A \times A$	$A \times B$	$A \times B$
Example	$\varnothing 10$	10×10	5×20	5×20

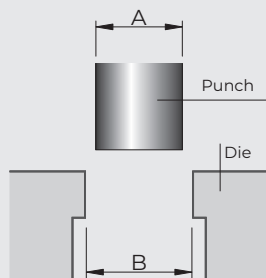
SD	WD	Square with radius	Rectangle with radius	CN-42
				
$\varnothing A \times B$	$\varnothing A \times B$	$A \times A R=C$	$A \times B R=C$	$A \times A R=C$
$\varnothing 20 \times 16$	$\varnothing 20 \times 16$	$10 \times 10 R=2$	$6 \times 20 R=1.5$	$10 \times 10 R=4$

Example instruction for ordering

	RE with radius (Punch shape)	$6 \times 20 R=1.5$ (Size)	
--	---------------------------------	-------------------------------	--

THE WAY TO INSTRUCT CLEARANCE

When instruct the clearance, unless otherwise specified, this shall mean both side clearance.



Name of clearance	Detail
Both side	$B - A$
Single Side	$(B - A) \div 2$
Clearance included	B dimension

	Dimension description	Punch dimension	Die dimension
Clearance for both sides	$\varnothing 20 C=0.3$	$\varnothing 20$	$\varnothing 20.3$
Minus clearance	$\varnothing 20 \text{ minus } C=0.3$	$\varnothing 19.7$	$\varnothing 20$

HOW TO CALCULATE THE CLEARANCE

Please refer to the table on the right to calculate the clearance.

Clearance (both side) = material thickness x clearance ratio

- 1) 1.4 times to be added to the calculation result for material thickness over 3.2 mm.
- 2) The minimum clearance is depending on machines. Please refer to a specification for your machine.
- 3) Please ask our expert at sales desk for any additional info you may need.

Material	Clearance ratio
Cold rolled steel	0.15
Hot rolled steel	
Structure steel	
Stainless steel (soft)	0.2
Stainless steel (hard)	
Aluminium (soft)	0.1
Aluminium (hard)	
Copper (soft)	
Copper (hard)	0.15
Brass (soft)	
Brass (hard)	0.2

STANDARD SHAPES AND KEY LOCATIONS

Key locations will be based on the table below unless otherwise instructed.
(Die view from the top of a die. Bottom of the figure will be the basis key.)

Thick turret type	RE	OB	SD	WD	Thin turret type	RE	OB	SD	WD
1/2" 1-1/4"					1/2" 1-1/4"				
2"					2"				
3-1/2" 4-1/2"					3-1/2"				

Murata 114 type	RE	OB	SD	WD
Bst ~ Jst				

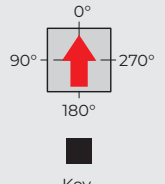
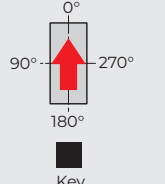
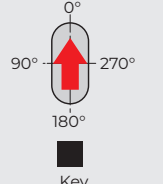
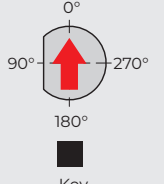
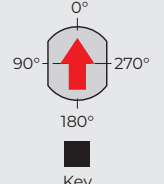
ADVICE

- 1) Clamp direction and the basis key direction would be different depending on machines. Also, punch key and die key would be the opposite direction in some case.
- 2) Please indicate a punch angle if required tool needs special angle setting.
- 3) Please indicate the basis key position that viewing from the top of die for special shapes.

HOW TO INSTRUCT FOR THE SPECIAL ANGLE SETTING

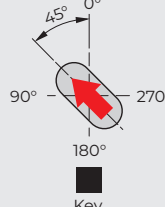
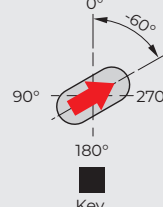
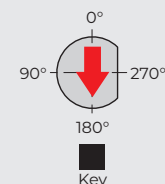
Please refer to the table below for the special angle setting.

Instruction drawing of the special angle setting (K=0° Viewing from the top of die)

SQ	RE	OB	SD	WD
				

Example of the special angle setting (Viewing from the top of die).

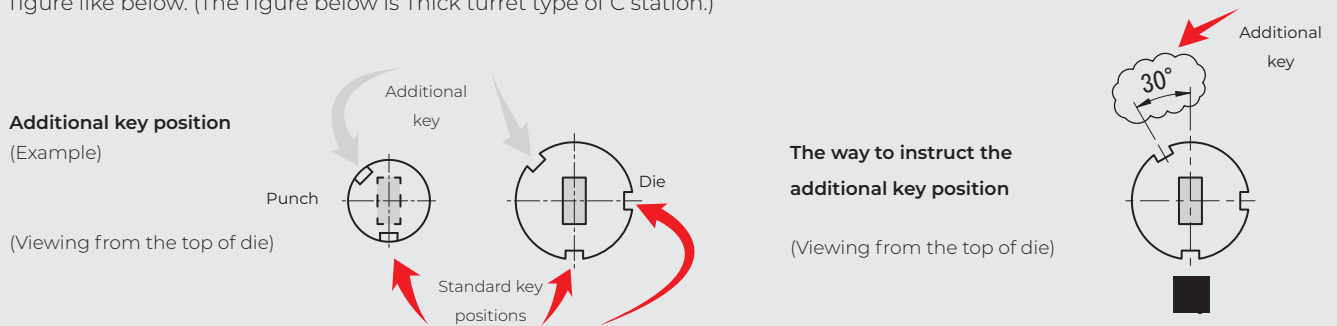
Please indicate the required angle with directional indicator, counter clockwise is [+], clockwise is [-].

								
OB (shapes)	6 x 20 (dimensions)	K=45° (angle)	OB (shapes)	6 x 20 (dimensions)	K=-60° (angle)	SD (shapes)	Ø 16 x 14 (dimensions)	K=180° (angle)

- 1) Please refer to our technical guidance for Rolleri standard key direction. Please use the table above for only ordering non-standard angles.
- 2) Please confirm the right angle on the machine, programming and tools.

ADDITIONAL KEY

The key position can be added to standard key position for customer demands. Additional key might not be acceptable depending on machines and tool station size. Additional key position should be instructed on the figure like below. (The figure below is Thick turret type of C station.)



4-WAY KEY POSITION

We also produce 4-way key position which allows to use 0°, 90°, 180° and 270°. Please take an advantage of 4-way key for special shapes and forming tool except round shape which does not need any additional key.

ADVICE... ABOUT TURRET KEY




Turret key would be wore when it used for a long time. It creates serious problem, such as burrs or galling. We recommend to replace or maintain the turret key regularly.

After replace the turret key, turret should be aligned.



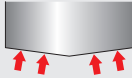
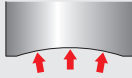
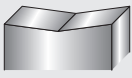
We produce alignment tools for that time. Please ask about it to our sales desk anytime.

SELECT THE BEST SPEC. OF PUNCH BODY FROM OUR VARIETY OF TOOL SPEC.

Please refer to the table below for select the best spec. of punch body.

Grade	Specication	Characteristics
High performance 	Super Dry Punch (SDP)	SDP is treated with special electrical discharge process to harden internal structure of punch edge which is totally different from simple surface coating. Also, SDP is the best treatment for non-lubrication punching. It shows higher performance for stainless steel than any other tooling. SDP can be treated to RO, SQ, RE and OB shape. 
	Hard Punch (RHP)	RHP is modification treatment to HSS material. Surface of punch tip is very smooth which prevent from adhesion and wear.
	High Speed Steel (HSS)	Compared with the D2, it is a material with excellent impact resistance, toughness and abrasion resistance.
Cost performance 	D2	Standard steel commonly available with reasonable pricing.

Shear is good for reduce tonnage, reduce slug pulling and reduce noise.

Shear option	Characteristics
Roof top shear 	Best shear for punching with maximum tonnages. RollerI standard angle of shear is 2° or 5°. Easy to sharpened up.
Concave shear 	Best shear for slitting and nibbling because it inverts stresses. More susceptible to breakage because of a sharp focal point for stresses when piercing thick material. Difficult to sharpen without dedicated jigs.  In case of roof top shear  In case of concave shear
Inverted shear 	

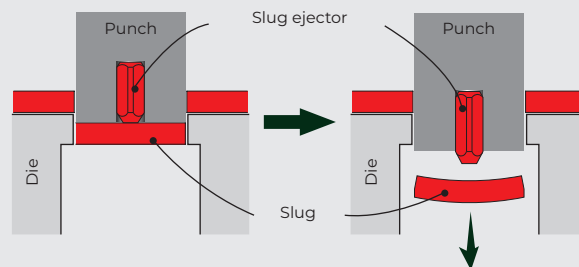
Flat punch tip (no shear) is fine for A and B station tool since tonnage would be small. For blanking process, at punch tip should be used.

SLUG EJECTOR

The slug ejector is good for slug pulling problem.

It will be installed to over Ø4 for RO and over 6 width for shaped as our standard. Please process without slug ejector when processing thick sheet with small punch dimension. In that case, please instruct us "No need slug ejector".

PUSHING SLUG MECHANISM BY SLUG EJECTOR:



MINUTES CORNER "R" ON PUNCH TIP

RE and SQ shape punch have the minute corner R on punch edge about R=0.2. it is useful to prevent chipping problems.

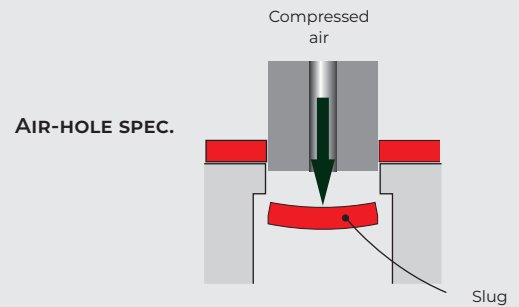
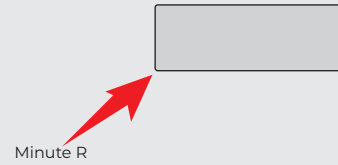
COATING TREATMENT (RLP)

We produce other coating solution besides SDP and RHP.



Coating option	Characteristics
Rolleri RLP-HPL	<p>Rolleri RLP-HPL technology was designed to give a universal answer to the more traditional processes giving the tools a constant efficiency and performance at the highest levels.</p> <p>The particular characteristics of this layer are the extraordinary tenacity (thanks to the introduction of the Carbon within the layer) and the ability to express itself at its best in different applications, and specifically on highly resistant materials, like <u>Stainless Steel</u>.</p> <p>RLP-HPL coating achieves the highest levels of adherence, making even more cohesive the combination tool + coating.</p> <p>The highly compact layer of RLP-HPL is able to express in its 3 microns thickness high hardness values that represent a solid barrier against wear ensuring extraordinary performance.</p> <p>Furthermore, its structure "multilayer" is composed of several hundreds of different layers that give better control of structural stress.</p>
Rolleri RLP - Zinc Free	<p>Double coating Rolleri RLP-Zinc Free merges the already extraordinary performance of RLP-HPL, with self-lubricating and anti-adhesive layer based on MoS₂ (Molybdenum Disulphide).</p> <p>Developed in aerospace from the need to find an alternative to traditional lubricants, revealed excellent properties that have made him, as a result, very interesting for a variety of application fields.</p> <p>This is a coating with a very low coefficient of friction, and it's able to release traces of wear lubricants (that is no abrasive particles are created by the wear of the coating).</p> <p>When working on particularly rough surfaces, Rolleri RLP-Zinc Free gradually becomes smoother during use.</p> <p>Due to these properties this treatment is particularly indicated not only to work with high resistance materials, but also for processing on galvanized sheet, aluminum or copper, because it is able to prevent "galling" process. RLP-Zinc Free can be easily re-coated.</p>

MINUTE CORNER R ON THE PUNCH TIP OF SQ AND RE SHAPE PUNCHES:



AIR-HOLE INSIDE PUNCH BODY

Slug is pushed out by compressed air, which comes out from an air-hole located at the center of body punch.

SELECT A DIE SPEC.

Please refer to the spec. explanation to select the best tools for you.

Dies material





2 kinds of material are available for our dies.

1. D2 (Improved D2 material which is much more durable than alternative D2 material.)
2. HSS (high speed steel)

Improved D2 material has increased its toughness and anti-chipping. Improved D2 is our standard unless otherwise instructed. Please try our premium high speed steel (HSS) material when considering anti-wear.

Cutting edge

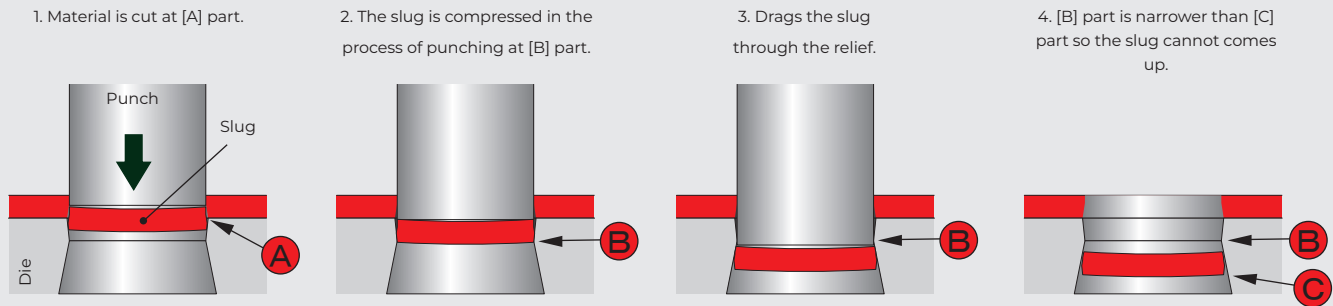
Rolleri standard cutting edge

Name of cutting edge	Shape of cutting edge	Specifications	Applications
Straight edge with straight relief		Both edge part and relief part are straight.	For round shape
Slug catcher (SC)		Constricting taper on cutting position. Best shape for slug pulling.	For shaped and special shapes
All taper		All tapered	
Straight edge with taper relief		Cutting edge is straight. Relief part is tapered.	For blanking, Heel tool, Dies with less than 0.1 mm clearance for shaped

SLUG PULLING SOLUTION

Slug catcher die

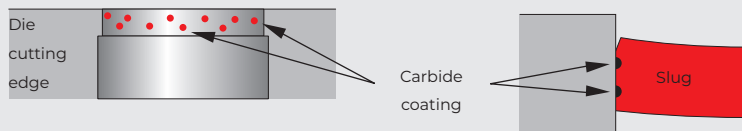
This is the ideal solution for slug pulling problem. Constrict taper on the cutting position of dies which slugs would be squeezed past pressure point.



Depositron treatment

Slug it's not allowed to come up thanks to electrical discharges on the cemented carbide on the cutting edge of a die.

Round dies, $\varnothing 2.5$ - $\varnothing 4.5$ are treated with the depositron as standard. We recommend our standard spec. dies for aluminum or if clearance is less than 0.1 mm.



THE IMPORTANCE OF PROPER MAINTENANCE FOR A GOOD TOOL PERFORMANCE

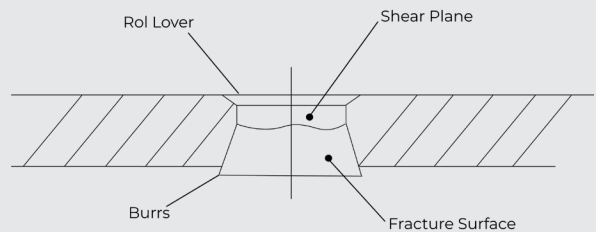
In RollerI we believe that once the selection of the good tool is made accordingly to your application, only if you run proper tool maintenance you can reach the performance target you expect and see the R.O.I. of your tool inventory.

All our tools (and most of the tool you have in your tool inventory) are made by High-Quality Special steel for tools, and because of this you must follow some specific procedures to regrind them.

Most of our customers believe that the less they regrind tools, the most will run in the machine the longer they will last and are strongly convinced to save money. But due to our experience this is not correct, and in order to help you to understand better this very important concept, we kindly ask you to have a look at the following charts and explanation.

In case of punching hole, tool is dull as the number of hits increase, and it cause serious problem to the products:

- Increase rollover.
- Increase burrs.
- Surface accuracy of the shear plane is reduced.
- Dimensions accuracy is reduced.
- A warp in a material.

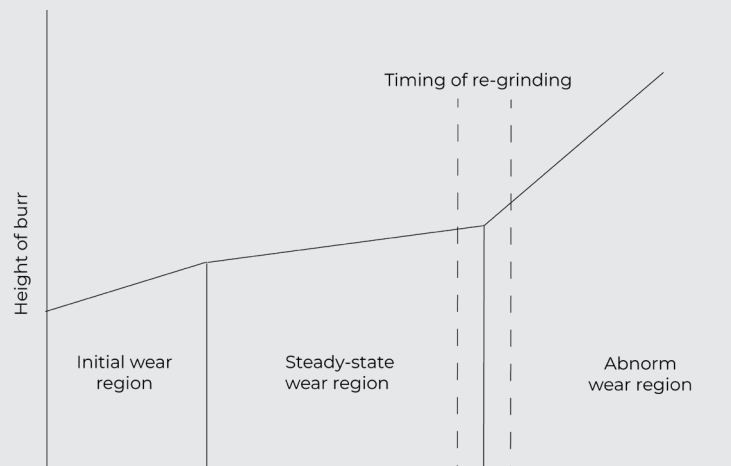


Generally, the timing of re-grinding is determined by the height of the burr, which should be greater than or equal to the allowable burr height of the product. Increment of burr comes from the wear of the cutting edge and the wear depends on the type of material; in general, the wear of cutting edge is faster when the material shear load is large and yield stress is large.

Aluminium < Mild steel < Stainless steel

Considering product quality and machine life, punch and die should be sharpened frequently. More tool dull, more burrs and rollover increase. Tool dull quickly when processing resistant material, such as stainless steel. Resistant force increases if waiting until tool are really dull and it leads to:

- Bad product quality.
- Tooling would be broken by increasing of resistant force.





Incorrect Sharpening	
Radius on Cutting Edge	Number of Hits
0,15 mm	80.000
0,30 mm	40.000
0,45 mm	20.000
0,60 mm	10.000
0,75 mm	5.000
Material Removed 0,75 mm	Tot. Hits 155.000

This is normally what happen to punch if you wait to regrind it once the bore on punched holes get a height that you can clearly feel with fingers once you touch them (basically your finger get stuck by the bore), and it means that Punch Corner Radius is around 0,50~0,65mm.

But we found that for being able to get the higher tool performance, you have to regrind once the corner radius on punch tip is around 0,15mm.

And if you follow this procedure, the situation you will get will be like as follow:

Correct Sharpening	
Radius on Cutting Edge	Number of Hits
Regrind	
0,15 mm	80.000
Regrind	
0,15 mm	40.000
Regrind	
0,15 mm	20.000
Regrind	
0,15 mm	10.000
Regrind	
0,15 mm	5.000
Regrind	
Material Removed 0,75 mm	Tot. Hits 400.000

More than DOUBLE tool life when regularly and frequently sharpened!

By removing same amount of material from punch (0,75mm) and making 400.000 hits instead of 155.000 hits, you will save more than 50% on punching tools purchased. Tool will last more than double compare to normal, and the machine will run more, so your production cost will also be lower.

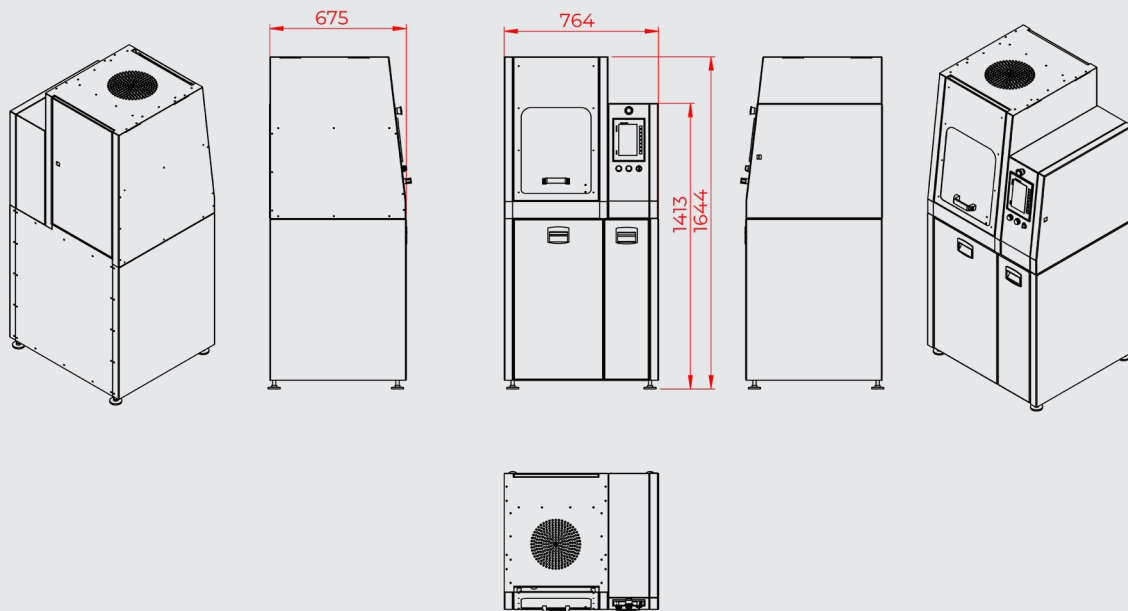
This can be possible because the tool gives its best inside this amount of radius wear, so at the end the more frequent you regrind the tools, the longer they will last.



Tools sharpening can give back to a punch all features as first purchased, but the machine that should be used for regrinding tool is also very important as all our tools (and most of the tool you have in your tool's inventory) are made of High-Quality Special steel, so you must follow some specific procedures for regrind these tools in a proper way and avoid to damage them. You must use coolant when grinding, if you do not punch edge would be cracked easily, polishing by hand after grinding is necessary to remove burrs on punch edge that is naturally generated by re-sharpening operation, and always demagnetized the tools before bringing them back to storage.

This machine should be designed specific for punching tool, and it's mean that should respect some specific criteria for regrind speed, tool coolant and structure.





- Robust construction
- Fully Aluminum constructed grinding area
- Sensorless Automatic height sensing of tools (never need any adjustment)
- High Capacity Cooling Tank with triple filtration
- Easy To Use Siemens Touch Screen HMI
- Sliding door with Security switch
- No additional accessories needed for tool clamping
- Straight and angular grinding
- Tool Drawer
- Pressure controlled grinding
- Automatic grinding speed adjustment
- Illuminated Grinding Area
- Security sensor equipped doors
- High Quality Grinding Wheel

If your tools are sharpened correctly:

- Flatter sheets
- Less Noise
- Less stress on tool and machine
- Increased holes quality
- Tools lasting longer
- Reducing new tools purchasing amount
- Saving money



Please contact our sales department at sales@rolleri.it for understand more about this machine features, and also about the regrind service provided with this machine we may offer to our customer, because is better send the tool to be regrind properly instead of damaging the tool due to an improper regrind procedure.



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Malaysia

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OUR COMPANY

BORN IN 1987 AS FAMILY-OWNED COMPANY, ROLLERI SPA HAS BECOME, IN A FEW YEARS, AN IMPORTANT REFERENCE POINT FOR ALL THOSE WHO DEAL WITH SHEET METAL BENDING. THE COMBINATION OF PASSION, DYNAMISM, EXPERIENCE AND RESEARCH OF NEW SOLUTIONS HAVE ALLOWED THE COMPANY TO DEVELOP THE BRAND INTERNATIONALLY.

"WE WERE BORN AT THE END OF 80'S, WITH THE IDEA TO BRING OUR TOOLS THROUGHOUT ITALY, BUT OVER THE YEARS WE EXCEEDED EXPECTATIONS" CLAIM PROUD FRANCESCO AND MARCO ROLLERI, OWNERS OF THE COMPANY.

ROLLERI SPA, LOCATED IN THE PROVINCE OF PIACENZA, PRODUCES STANDARD AND SPECIAL TOOLS FOR PRESS BRAKES AND PUNCHING MACHINES. LIKE TODAY, THANKS TO THE COLLABORATION OF TRUSTED PARTNERS, IT'S ABLE TO GUARANTEE A COVERAGE IN EACH MARKET AND A FAST AND RELIABLE SERVICE.

IN 2016 THE PRODUCTION CAPACITY HAS FURTHER INCREASED THANKS TO THE PURCHASE OF A NEW ESTABLISHMENT AND THE ENLARGEMENT OF THE COMPREHENSIVE MACHINERY.





MANUFACTURING

BESIDES MANUFACTURING MANY SPECIAL TOOLS, OUR RESEARCH AND DEVELOPMENT TEAM ALSO DESIGNS NEW TOOL SOLUTIONS IN ORDER TO INCREASE YOUR PRODUCTIVITY.

TECHNICIANS AND ENGINEERS DEVELOP FOR YOU CONVENIENT AND PRACTICAL SOLUTIONS. WE WORK WITH HIGHLY COMPLEX 3D SIMULATION MODELS AND WE ARE ABLE TO CREATE FORMING EXAMPLES OF VARIOUS APPLICATIONS, GUARANTEEING YOU A QUICK RESPONSE SUITABLE FOR ANY NEED.

RAW MATERIAL IS PROVIDED BY QUALIFIED SUPPLIERS AND CHEMICAL COMPOSITION CORRESPONDS TO INTERNATIONAL STANDARDS.

THEREFORE, RAW MATERIAL YIELD AND TENSILE STRENGTH ARE GUARANTEED.

WE HAVE SPECIFIC AND UNIQUE SURFACE TREATMENT AND COATING THAT GRANT AND INCREDIBLE DURABILITY AND DEFEATED THE COMMON SENSE THAT "STAINLESS IS HARD TO PROCESS".

THESE TOOL OPTIONS ARE SUITABLE FOR NIGHT TIME UNATTENDED OPERATION AND DRY (NO OIL LUBRICATION ON THE SHEET METAL) CONDITION PUNCHING.



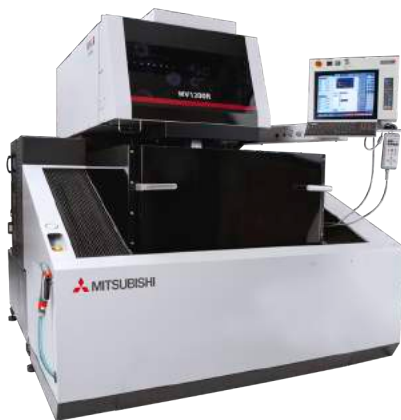
QUALITY

ROLLERI IS ISO 9001:2015 CERTIFIED. FOR US, BEING YOUR SUPPLIER MEANS HELPING YOU TO FIND THE BEST AND MOST CONVENIENT TOOL AND TO DEVELOP A LARGE NUMBER OF BENDING AND PUNCHING SOLUTIONS. FURTHERMORE, WE OFFER TRAINING FOR YOUR BENDING DEPARTMENT EMPLOYEES.

DURING THE PRODUCTION PROCESS, EVERY SINGLE PUNCH PRESS TOOL PRODUCED BY ROLLERI IS MARKED WITH A UNIQUE CODE, WHICH ENABLES TO IDENTIFY THE PRODUCTION LOT, FOR A BETTER TRACEABILITY. THIS ENABLES US TO CERTIFY THAT ALL ROLLERI TOOLS OF THE SAME MODEL IN THE MARKET HAVE EXACTLY THE SAME DIMENSIONS (TOLLERANCES, MATERIAL AND SURFACE FINISCHING, OVERALL QUALITY...).

OUR QUALITY CONTROL DEPARTMENT CHECKS AND TESTS EVERY SINGLE TOOL AFTER A COMPLETE PRODUCTION CYCLE.





OUR MACHINERY

CNC-GRINDING MACHINE

OUR NEW CNC GRINDING MACHINE IS A BENCHMARK IN THE WORLD OF CNC GRINDING: IT GUARANTEES THE HIGHEST POSSIBLE PRECISION AND SUPERIOR SURFACE FINISH OF THE RESULTING PRODUCT.

CNC-TURNING CENTRE

OUR NEW CNC TURNING CENTRE, WITH ITS ACCURACY, RELIABILITY AND ROBUSTNESS, IS ABLE TO GRANT A VERY HIGH PRECISION AND A VERY LOW ROUGHNESS. THANKS TO ITS FLEXIBILITY AND SPEED, WE CAN SATISFY A LARGE VARIETY OF CUSTOMIZATION.

EDM

BY USING ELECTRO-DISCHARGE MACHINES, ROLLERI CAN MACHINE HARDENED AND TOUGH MATERIALS. THIS PROCESS IS BASED ON THE DEFINITION OF THE TOOL SHAPE WITH A HIGH PRECISION CAD SOFTWARE AND THE MANUFACTURING OF SIMPLE AND COMPLICATED SHAPES.

CNC-FINISHING MACHINE

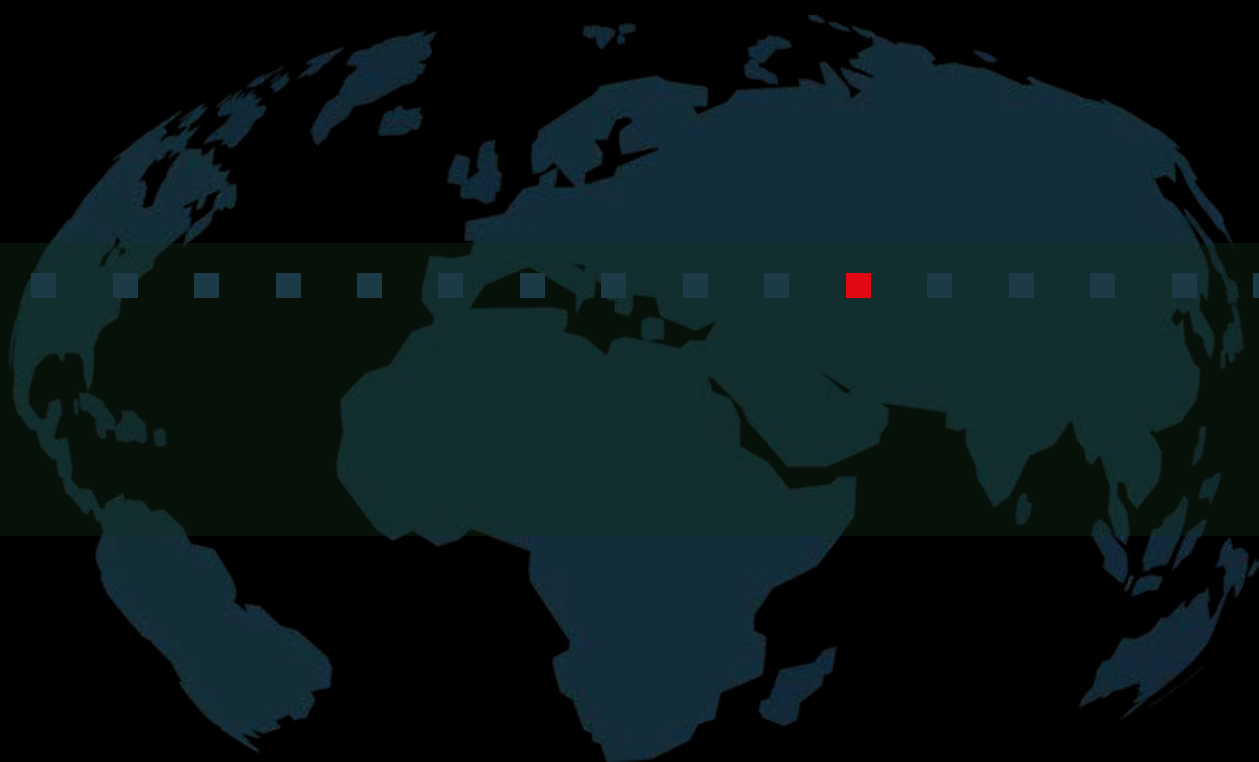
OUR CNC PROFESSIONAL GRINDING MACHINES GUARANTEE HIGH PRECISION (TOLERANCE OF ± 0.01 MM), ACCURATE PARALLELISM AND REPEATABILITY.







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