

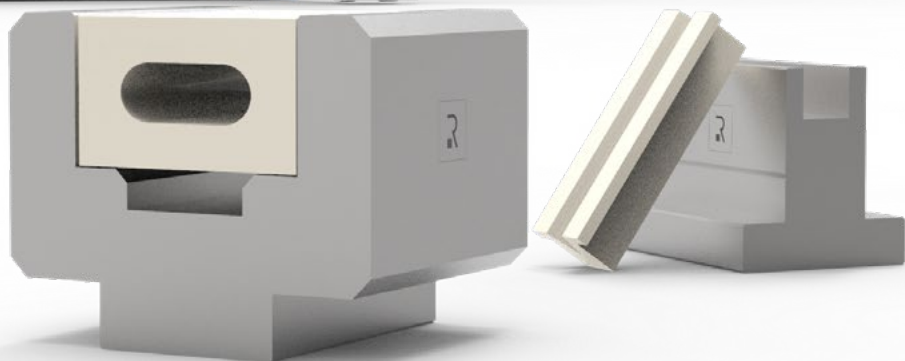
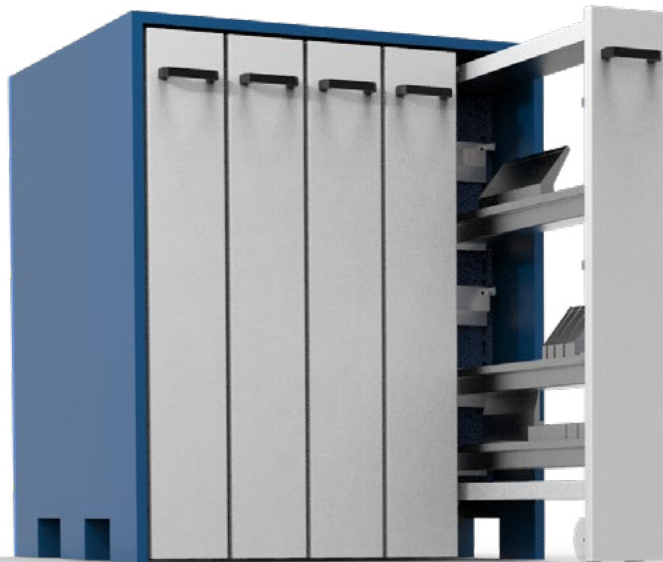
# ROLLERI

TOOLING LAB

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

## BENDING

MARK FREE BENDING  
ACCESSORIES





ISO 9001 - ISO 45001  
CERTIFIED  
COMPANY



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

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



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



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



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

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



## BENDING TOOLS

### R1 TOOLS TYPE

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

### R2-R3 TOOLS TYPE

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

### R4 TOOLS TYPE

Compatible with press brakes: LVD

### R5 TOOLS TYPE

Compatible with press brakes: American

### R6 TOOLS TYPE

Compatible with press brakes: Hämmerle-Bystronic

### R7 TOOLS TYPE

Compatible with press brakes: Colly

### R8 TOOLS TYPE

Compatible with press brakes: Colgar

### R9 TOOLS TYPE

Compatible with press brakes: Gasparini (axial)

### R10 TOOLS TYPE

Compatible with press brakes: Ajial Axial

### Rx TOOLS TYPE

Compatible with press brakes: EHT, Ursviken and Weinbrenner

### ROLLERI TECH, MODIFICATIONS AND SERVICES

Compatible with all types of press brakes

### CLAMPING SYSTEMS, INTERMEDIATES AND ADAPTERS

Compatible with all types of press brakes

### ROLLA-V AND SPECIAL DIES

Compatible with all types of press brakes

### MARK FREE BENDING AND ACCESSORIES

Compatible with all types of press brakes

## PANEL BENDING TOOLS

## SHEAR BLADES

## PUNCHING TOOLS

### R1 TOOLS TYPE

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

### R2 TOOLS TYPE

Compatible with Trumpf punching machines

### RS TOOLS TYPE

Compatible with Salvagnini punching machines

### SPECIAL TOOLS

Compatible with different types of punching machines

### ACCESSORIES

Compatible with different types of punching machines

### IRON WORKER

Iron cutting tools

## LASER CONSUMABLES

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



# 6 MARK FREE

8 - ROLL PRIME

9 - ROLFILM AND TENSIONER

10 - POLYURETHANE INSERTS AND HOLDERS

13 - SYNTHETIC DIES

# 16 ACCESSORIES

18 - TOOLING CABINETS: EXPLANATION

19 - TOOLING CABINETS STANDARD SERIE

22 - TOOLING CABINETS TOP SERIE

24 - TOOLING TROLLEY

25 - TOOLING TROLLEY

26 - BENDING BOX

26 - SHEET METAL POSITIONING

30 - MANUAL TOOL CHANGE SYSTEM

32 - EASY PRESS

**A**  
 ARM 835-4 19  
 ARM 835-5 19  
 ARM 1060-4 20  
 ARM 1060-4.13 19  
 ARM 1060-4-CV 20  
 ARM 1060-4-T 21  
 ARM 1060-4-T-CV 21  
 ARM 1060-5 20  
 ARM 1060-5.13 19  
 ARM 1060-5-CV 20  
 ARM 1060-5-T 21  
 ARM 1060-5-T-CV 21  
 AS 27  
 AS FIX 27  
 A-TR 24

**B**  
 BOX 26  
 B-LIGHT 01 29  
 B-TR 24

**C**  
 CT 9

**E**  
 EASY PRESS 32

**G**  
 GM 25X25 11  
 GM 50X50 11  
 GM 75X50 12  
 GM 100X50 12  
 GMF 25X25X10 11  
 GMF 50X50X25 11  
 GMF 75X50X20 12  
 GMF 100X50X20 12

**I**  
 INS14.06.30 14  
 INS14.06.45 14  
 INS14.06.60 14  
 INS14.06.88 14  
 INS14.08.30 14  
 INS14.08.45 14  
 INS14.08.60 14  
 INS14.08.88 14  
 INS14.10.45 14  
 INS14.10.60 14  
 INS14.10.88 14  
 INS20.06.30 14, 15  
 INS20.06.45 14, 15  
 INS20.06.60 14, 15  
 INS20.06.88 14, 15  
 INS20.08.30 14, 15  
 INS20.08.45 14, 15  
 INS20.08.60 14, 15  
 INS20.08.88 14, 15  
 INS20.10.30 14, 15  
 INS20.10.45 14, 15  
 INS20.10.60 14, 15

**L**  
 LASER TRACKER 28

**M**  
 MPG25 11  
 MPG50 11  
 MPG75 12  
 MPG100 12  
 MSA.D 26  
 MSA.S 26

**P**  
 PSTCON25 10  
 PSTCON50 10  
 PSTCON75 10  
 PSTCON100 10

**R**  
 RIF500 27  
 RIF1000 27  
 RIF1500 27  
 ROLFILM 3-0.4-100 9  
 ROLFILM 3-0.4-150 9  
 ROLFILM 3-0.6-150 9  
 ROLFILM 3-0.6-200 9  
 ROLFILM 3-2-150 9  
 ROLFILM 10-0.4-100 9  
 ROLFILM 10-0.4-150 9  
 ROLFILM 10-0.6-150 9

**S**  
 SPACE-UP 30

**T**  
 TMN95.20 15  
 TN80.14 14  
 TN80.20 14  
 TN80.30 15  
 T-TR 24

**U**  
 UC-13-1 19, 20  
 UC-13-2 19, 20  
 UC-20-1 19, 20  
 UC-20-2 19, 20  
 UL-13-1 19, 20  
 UL-13-2 19, 20  
 UL-13-3 19, 20  
 UL-13-4 19, 20  
 UL-20-1 19, 20  
 UL-20-2 19, 20  
 UL-20-3 19, 20  
 UL-20-4 19, 20  
 UT-1 21  
 UT-2 21  
 UT-3 21  
 UT-4 21  
 UV-1 21  
 UV-2 21  
 UV-3 21  
 UV-4 21

**W**  
 WKH102 22, 23  
 WKH103 22, 23  
 WKH502 22  
 WKH504 22  
 WKS001 SET A 22  
 WKS003 SET A 22  
 WKS006 SET A 23  
 WKS013 SET A 22  
 WKS033 SET A 22  
 WKS035 SET A 23  
 WKS335 SET A 23  
 WSW582 25  
 WSW583 PLUS 25

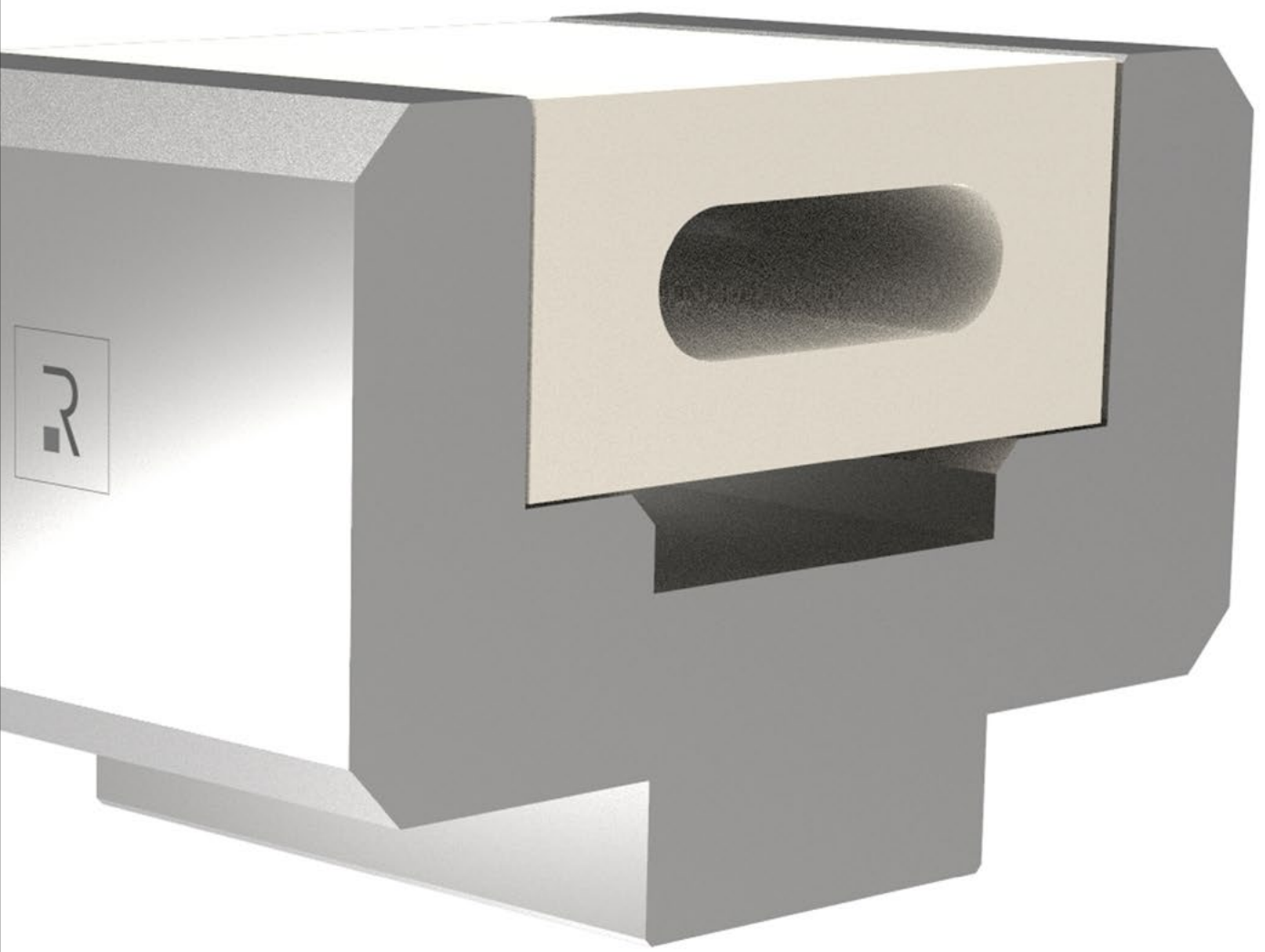
**ROLFILM 10-0.6-200 9**  
**ROLFILM 10-2-150 9**  
**ROLFILM 20-0.4-100 9**  
**ROLFILM 20-0.4-150 9**  
**ROLFILM 20-0.6-150 9**  
**ROLFILM 20-0.6-200 9**  
**ROLFILM 20-2-150 9**  
**ROLFILM 30-0.4-100 9**  
**ROLFILM 30-0.4-150 9**  
**ROLFILM 30-0.6-150 9**  
**ROLFILM 30-0.6-200 9**  
**ROLFILM 30-2-150 9**  
**ROLL PRIME 20.17 8**

# MARK FREE

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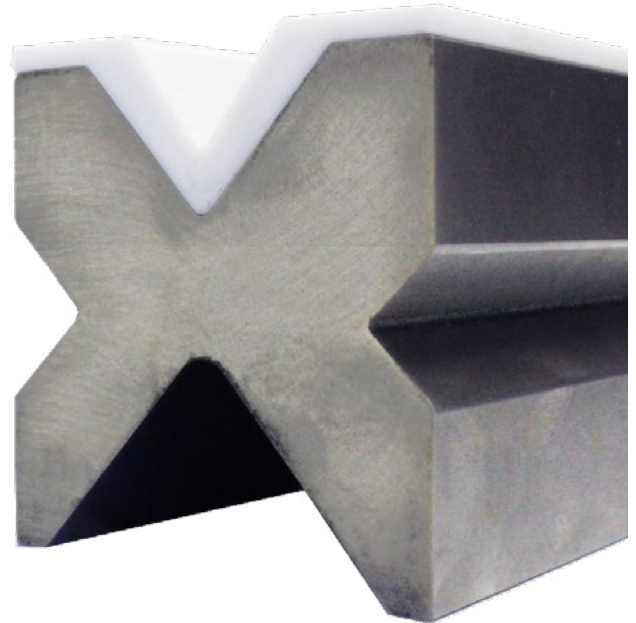
Avoiding sheet metal marks like scratches and abrasions during bending is very difficult. Such a problem arises when bending stainless steel, aluminium and prepainted sheet metal.

Rolleri offers different solutions to avoid such marks in the friction areas between sheet metal and die.



Rolleri's constant research for innovation brought us towards the 3D printing world, the future of manufacturing. Roll Prime is the solution for applications which require mark-free sheet metal, reduced delivery time and dimensional precision: thanks to FDM technology (Fused Deposition Modelling) we are able to produce tools and inserts made of special plastic material, completely adaptable to customer's needs with halved production lead time compared to traditional technology.

- Totally Mark-free bending
- Halved production lead time
- 30-40% lower costs than a classic special tool
- Ideal for Rapid Prototyping
- Ideal for small production batches
- Bending result repeatability
- Easy handling thanks to 85% lower weight



### TOOLS

Thanks to an infinite choice of shapes, we are able to study specific solutions for every customer, with the possibility of rapid prototyping. Roll Prime tools are the right solution to produce small batches or samples, as they have between 30% and 40% lower costs and shorter delivery time than conventional tools.



### INSERTS

Roll Prime inserts are an innovation in mark-free bending: thanks to their special composition they can guarantee total absence of marks on sheet metal, giving repeatable and long-lasting results, removing all the annoying problems of classic bending foils. With our technology we are able to propose highly customizable solutions, so it is possible to design inserts which are fully adaptable to your tools.



Scan the QRCode or click on it and watch the video to discover more about ROLL PRIME TOOLS



Scan the QRCode or click on it and watch the video to discover more about ROLL PRIME tools.



One of the most common ways to avoid sheet metal marks during bending is the use of ROLFILM. Rolfilm is a foil available with different thickness, which is positioned between sheet metal and die.

The choice of one rolfilm thickness or the other depends on the sheet metal thickness to be bent. In order to find out more about it, we recommend you write to tecnico@rolleri.it.

Minimum thickness is 0.4mm (0.02") whereas maximum thickness is 2.0mm (0.08").

Such film is also available with different width: 100mm, 150mm and 200mm (3.94", 5.90" and 7.87").

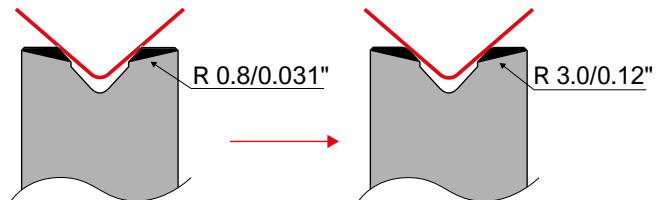
By shifting Rolfilm along X axis, you can use its whole surface; if for example you use a V20 die, you have at least 15-20 bending positions in the same film portion before moving the foil forward. Rolfilm rolls are available of 3m, 10m, 20m and 30m. Thanks to this possibility you can buy the length you need.

A very useful accessory to use the whole Rolfilm width is CT, a pair of tensioners. Each tensioner is mounted at one end of dies with a clamp tightened to die stem. In the upper part of CT you can insert Rolfilm.

Both tensioners mounted opposite to each other are fundamental to set the proper foil tension for correct use.

ROLFILM has very good elastic and compression properties. For this reason CNC setup correction needed are limited.

In order to improve foil operational life by bending on the same foil portion, you can use Rolfilm with dies with bigger radius (for example T dies CLASSIC - TR dies).



**Standard T-Die**  
with small radius on the V opening causes visible bending marks

**T-Die TR**  
with an enlarged radius on the V opening reduces visibly the bending marks

**ROLFILM**

Model	Thickness		Width		Lenght	
	mm	in	mm	in	m	in
Rolfilm 3-0.4-100	0.4	0.016	100	3.94	3	118.11
Rolfilm 10-0.4-100	0.4	0.016	100	3.94	10	393.7
Rolfilm 20-0.4-100	0.4	0.016	100	3.94	20	787.4
Rolfilm 30-0.4-100	0.4	0.016	100	3.94	30	1181.1
Rolfilm 3-0.4-150	0.4	0.016	150	5.91	3	118.11
Rolfilm 10-0.4-150	0.4	0.016	150	5.91	10	393.7
Rolfilm 20-0.4-150	0.4	0.016	150	5.91	20	393.7
Rolfilm 30-0.4-150	0.4	0.016	150	5.91	30	787.4
Rolfilm 3-0.6-150	0.6	0.024	150	5.91	3	118.11
Rolfilm 10-0.6-150	0.6	0.024	150	5.91	10	393.7
Rolfilm 20-0.6-150	0.6	0.024	150	5.91	20	787.4
Rolfilm 30-0.6-150	0.6	0.024	150	5.91	30	1181.1
Rolfilm 3-0.6-200	0.6	0.024	200	7.87	3	118.11
Rolfilm 10-0.6-200	0.6	0.024	200	7.87	10	393.7
Rolfilm 20-0.6-200	0.6	0.024	200	7.87	20	787.4
Rolfilm 30-0.6-200	0.6	0.024	200	7.87	30	1181.1
Rolfilm 3-2-150	2.0	0.079	150	5.91	3	118.11
Rolfilm 10-2-150	2.0	0.079	150	5.91	10	393.7
Rolfilm 20-2-150	2.0	0.079	150	5.91	20	787.4
Rolfilm 30-2-150	2.0	0.079	150	5.91	30	1181.1



**CT**



per piece 6 kg

Tensioner



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



Scan the QRcode or click on it and watch the video to discover more about MARK FREE bending.

Polyurethane inserts and their holders have been designed to give a good quality solution when bending large-radii.

Such solution provides two important advantages: mark-free profile and precise radius.

A polyurethane insert can be compressed in the middle during bending and can wrap sheet metal around a radius tool.

Actually it works like a die deforming according to punch radius.

Please notice that the maximum sheet metal thickness to be used for this application is 2mm.

Rolleri offers different polyurethane inserts with different dimensions according to the needed radius.

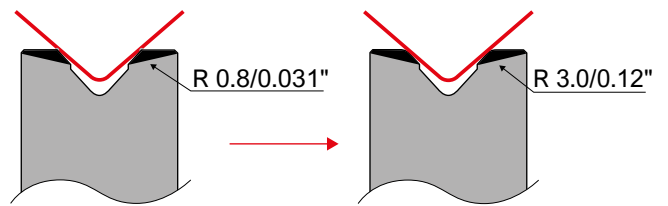
As far as profile angle is concerned, we can offer full inserts (for wider profile angle) or inserts with a hole, which can undergo bigger compression and can bend narrower angles.

Holders have to limit polyurethane insert deformations, so that its deformation happens only according to punch radius.

Each insert has its own holder, so that deformations are guided.

The last element to take into consideration is PSTCON: a pair of plates to close inserts at both ends to avoid uncontrolled deformations in this areas.

Such insert deformation at the ends may cause profile and angle deformations, as angle may be more open in the last 100mm (3.94"). This solution is usually used with radius tool holders in chapters R1, R2, R3 and R4 with their respective radius tools.



Standard T-Die with small radius on the V opening causes visible bending marks

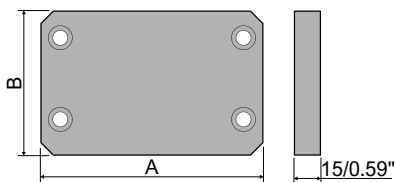
T-Die TR with an enlarged radius on the V opening reduces visibly the bending marks

PSTCON - COVER PLATE

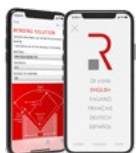
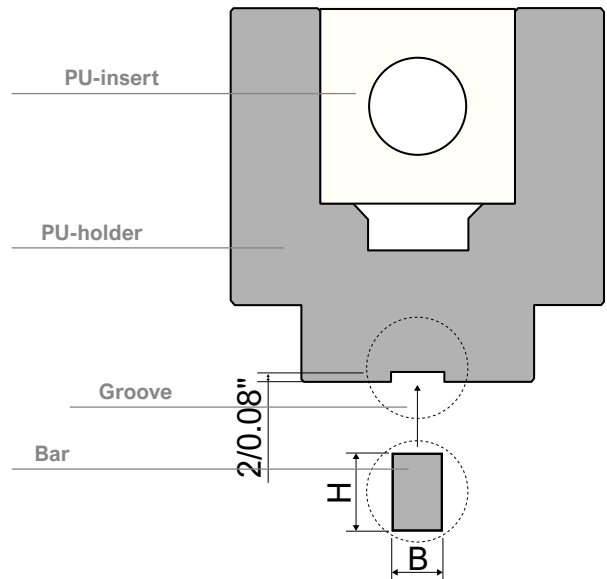
	A mm	A in	B mm	B in	
PSTCON25	58	2.28	58	2.28	1.2 kg
PSTCON50	108	4.25	75	2.95	0.8 kg
PSTCON75	123	4.84	80	3.15	1.0 kg
PSTCON100	153	6.02	80	3.15	1.2 kg



C45: 560-710 N/mm<sup>2</sup>



Tang modification example



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

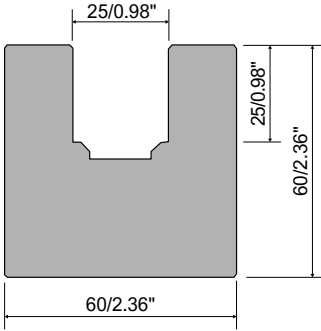


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**MPG25**

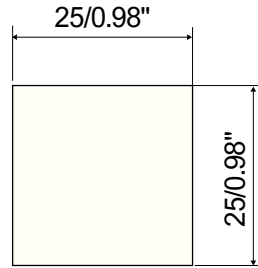
835 mm 32.87" 18.5 kg  
415 mm 16.34" 9.2 kg

C45: 560-710 N/mm<sup>2</sup>



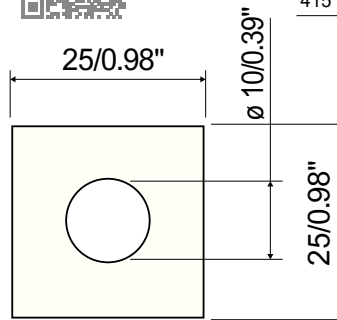
**GM 25X25**

835 mm 32.87" 0.6 kg  
415 mm 16.34" 0.3 kg



**GMF 25X25X10**

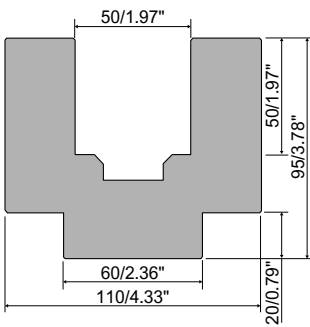
835 mm 32.87" 0.6 kg  
415 mm 16.34" 0.3 kg



**MPG50**

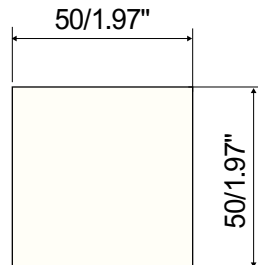
835 mm 32.87" 46.0 kg  
415 mm 16.34" 22.5 kg

C45: 560-710 N/mm<sup>2</sup>



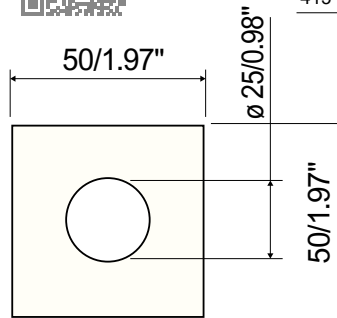
**GM 50X50**

835 mm 32.87" 2.5 kg  
415 mm 16.34" 1.2 kg



**GMF 50X50X25**

835 mm 32.87" 2.5 kg  
415 mm 16.34" 1.2 kg



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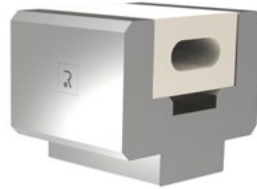
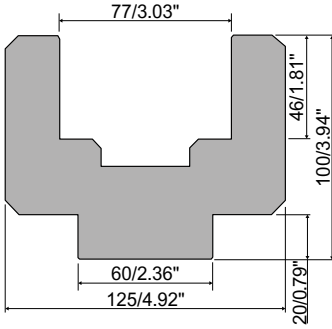


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**MPG75**

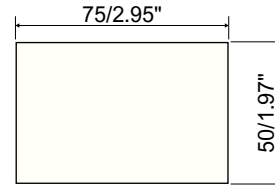
835 mm 32.87" 46.0 kg  
415 mm 16.34" 22.5 kg

C45: 560-710 N/mm<sup>2</sup>



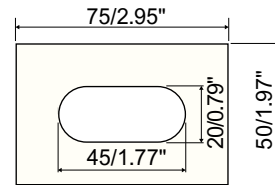
**GM 75X50**

835 mm 32.87" 3.5 kg  
415 mm 16.34" 1.7 kg



**GMF 75X50X20**

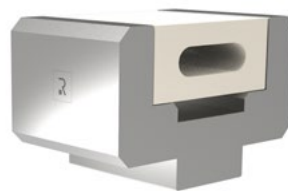
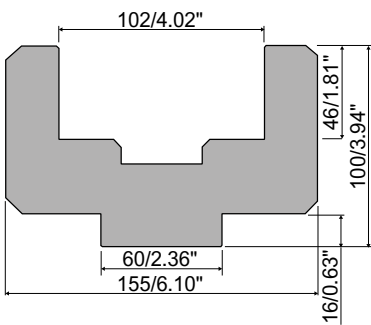
835 mm 32.87" 3.5 kg  
415 mm 16.34" 1.7 kg



**MPG100**

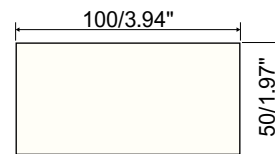
835 mm 32.87" 55.0 kg  
415 mm 16.34" 27.5 kg

C45: 560-710 N/mm<sup>2</sup>



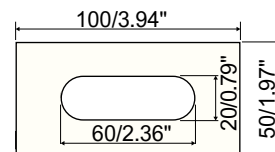
**GM 100X50**

835 mm 32.87" 2.5 kg  
415 mm 16.34" 1.2 kg



**GMF 100X50X20**

835 mm 32.87" 3.0 kg  
415 mm 16.34" 2.2 kg



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Create your account on [www.rolleritools.com](http://www.rolleritools.com)  
You can visit [mark free bending](#) section to discover many useful solutions on how to obtain sheet metal without signs of friction.

A solution to avoid sheet metal marks is the use of nylon inserts and their holders.

These nylon inserts have a V opening in the middle similar to standard dies V opening. The main difference is the material, which in this case is nylon in order to reduce sheet metal friction while sliding into the V opening. In this case the surface contact is soft and therefore it doesn't scratch sheet metal.

Each insert is available with V opening ranging from 6mm to 16mm (0.24" to 0.63") and according to the bending angle you can choose angle 88°, 60°, 45° and 30°. Inserts are always positioned in precise holders, so that they have no space to move freely.

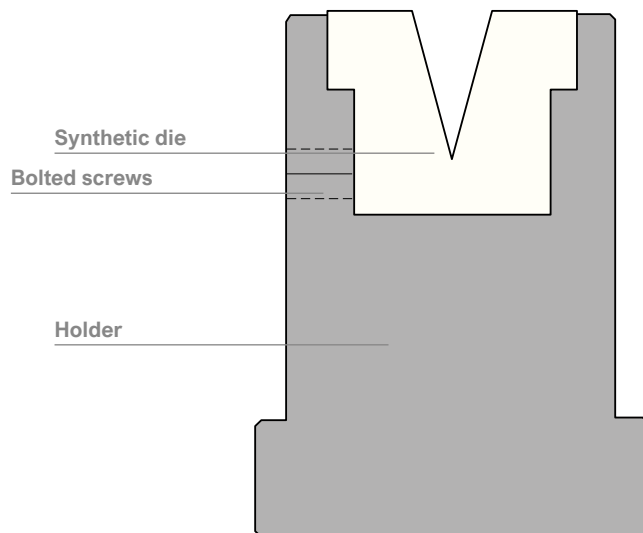
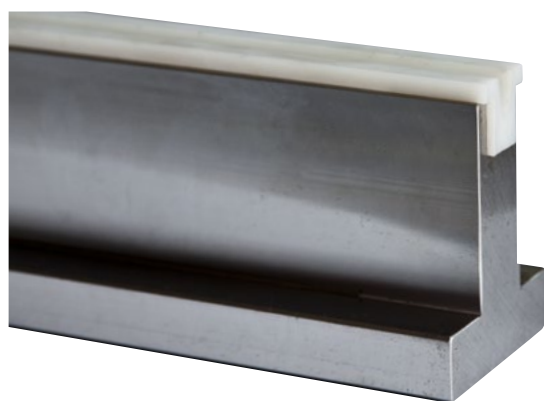
On holder operator's side there are fixing screws to clamp inserts properly.

Insert outside dimensions are 14mm, 20mm, 30mm (0.55", 0.79", 1.18") and they have been studied in order to bear the necessary tonnage according to the sheet metal to be bent.

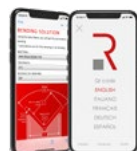
Such a solution is recommended to bend profiles with bends and counterbends, as you can use die stem for the negative bend.

In order to set press brake CNC up, we supply dxf drawing like for conventional tooling.

Press brake operator should control bending angle frequently and set corrections caused by slight wear of insert radius, especially when insert is new.



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



### Download Rolleri Bending App

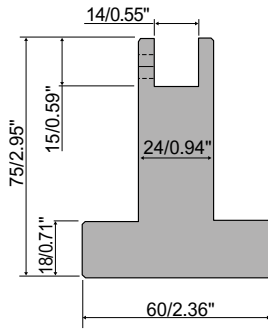
You will have access to our online store where you can get what you need. You will also get our sheet metal unfolding software for free and our bending rule.

**TN80.14**

835 mm 32.87" 15.0 kg  
415 mm 16.34" 7.5 kg

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

R1 type

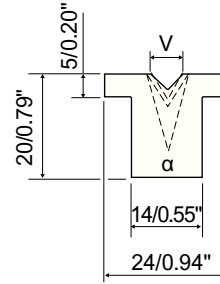


**INS14...**

835 mm 32.87" 0.30 kg  
415 mm 16.34" 0.15 kg

200 kN/m max.

		V mm	V in
INS14.06.88	88°	6	0.24
INS14.08.88	88°	8	0.31
INS14.10.88	88°	10	0.39
INS14.06.60	60°	6	0.24
INS14.08.60	60°	8	0.31
INS14.10.60	60°	10	0.39
INS14.06.45	45°	6	0.24
INS14.08.45	45°	8	0.31
INS14.10.45	45°	10	0.39
INS14.06.30	30°	6	0.24
INS14.08.30	30°	8	0.31

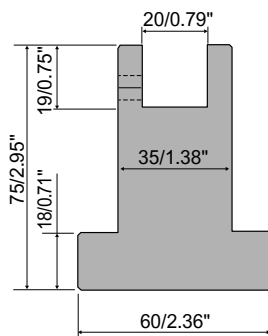


**TN80.20**

835 mm 32.87" 19.0 kg  
415 mm 16.34" 9.5 kg

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

R1 type

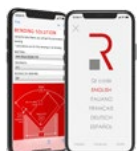
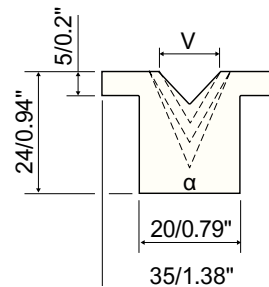


**INS20...**

835 mm 32.87" 0.4 kg  
415 mm 16.34" 0.2 kg

200 kN/m max.

		V mm	V in
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39



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

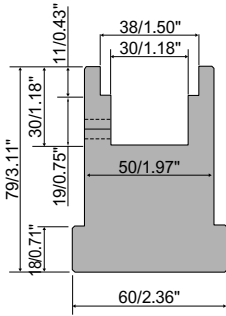
**TN80.30**

835 mm 32.87" 25.0 kg  
415 mm 16.34" 12.5 kg



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

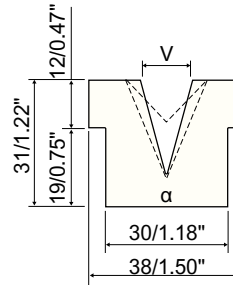
R1 type



**INS30...**

835 mm 32.87" 0.5 kg  
415 mm 16.34" 0.3 kg

200 kN/m max.



		V mm	V in
INS30.06.88	88°	6	0.24
INS30.08.88	88°	8	0.31
INS30.10.88	88°	10	0.39
INS30.12.88	88°	12	0.47
INS30.16.88	88°	16	0.63
INS30.20.88	88°	20	0.79
INS30.25.88	88°	25	0.98
INS30.06.60	60°	6	0.24
INS30.08.60	60°	8	0.31
INS30.10.60	60°	10	0.39
INS30.12.60	60°	12	0.47
INS30.16.60	60°	16	0.63
INS30.20.60	60°	20	0.79
INS30.06.45	45°	6	0.24
INS30.08.45	45°	8	0.31
INS30.10.45	45°	10	0.39
INS30.12.45	45°	12	0.47
INS30.16.45	45°	16	0.63
INS30.20.45	45°	20	0.79
INS30.06.30	30°	6	0.24
INS30.08.30	30°	8	0.31
INS30.10.30	30°	10	0.39
INS30.12.30	30°	12	0.47
INS30.16.30	30°	16	0.63

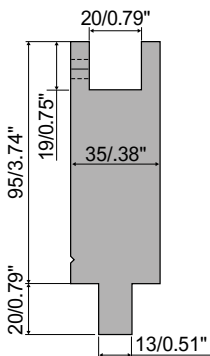
**TMN95.20**

835 mm 32.87" 12.0 kg  
415 mm 16.34" 6.0 kg



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

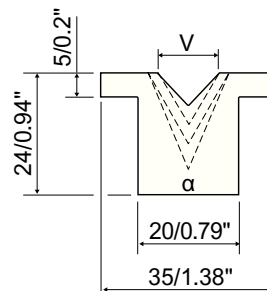
R2/R3 type



**INS20...**

835 mm 32.87" 0.4 kg  
415 mm 16.34" 0.2 kg

200 kN/m max.



		V mm	V in
INS20.06.88	88°	6	0.24
INS20.08.88	88°	8	0.31
INS20.10.88	88°	10	0.39
INS20.12.88	88°	12	0.47
INS20.16.88	88°	16	0.63
INS20.06.60	60°	6	0.24
INS20.08.60	60°	8	0.31
INS20.10.60	60°	10	0.39
INS20.12.60	60°	12	0.47
INS20.16.60	60°	16	0.63
INS20.06.45	45°	6	0.24
INS20.08.45	45°	8	0.31
INS20.10.45	45°	10	0.39
INS20.12.45	45°	12	0.47
INS20.06.30	30°	6	0.24
INS20.08.30	30°	8	0.31
INS20.10.30	30°	10	0.39



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# ACCESSORIES

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A wide range of Rolleri accessories, useful both during the bending process, storage and press brake setup.



ROLLERI

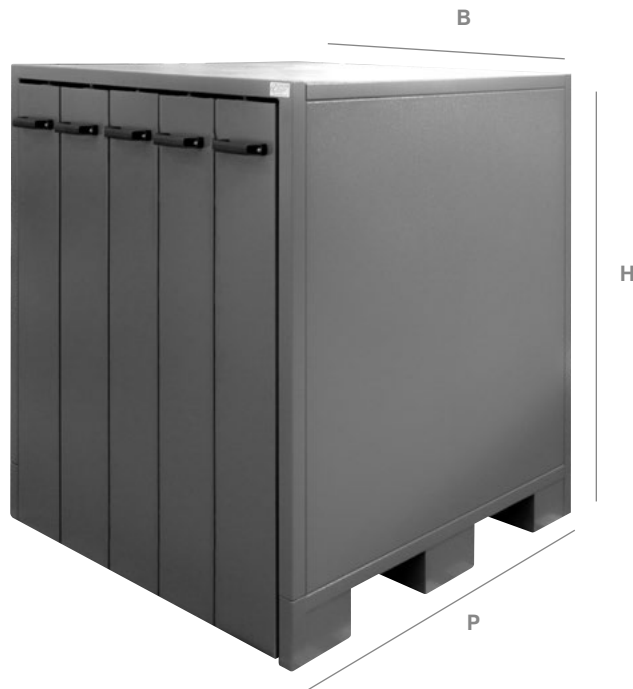
SPACE UP



- Protection against contamination and damage
- Easy access to tools
- Clear and tidy storage
- Grooves in the construction to position easily the cabinet by means of fork lift trucks
- Shelves with variable positioning into drawers
- Two different lines: Standard and Top
- Various colors available on request

	STANDARD series	TOP series
Structure thickness	1.5 mm <i>0.59 in</i>	3.0 mm <i>0.118 in</i>
Max.drawer load	250-280 kg	900 kg
Compatibility	Check model	Universal
Drawer closing	With handle	With independent lock
Structure holes	Check model	Hole pitch 25mm

B = width  
h = height  
p = depth



Scan the QRCode or click on it and watch the video to discover more about TOOLING CAMBINETS STANDARD SERIES.



Scan the QRCode or click on it and watch the video to discover more about TOOLING CAMBINETS TOP SERIES.



**ARM 835-4**



B	H	P	Drawers
850 mm	1240 mm	1050 mm	
33.46"	48.82"	41.34"	4 (CS-1) 271 kg

280 kg max./drawer  
 Max. tool length = 835 mm 32.87 in  
 Approx. 20 m of tools  
 Tools tang 13 mm 0.51 in

UC-13-1	13
UL-13-3	4



**ARM 835-5**



B	H	P	Drawers
850 mm	1240 mm	1050 mm	
33.46"	48.82"	41.34"	5 (CS-1) 271 kg

280 kg max./drawer  
 Max. tool length = 835 mm 32.87 in  
 Approx. 25 m of tools  
 Tools tang 13 mm 0.51 in

UC-13-1	20
UL-13-3	5



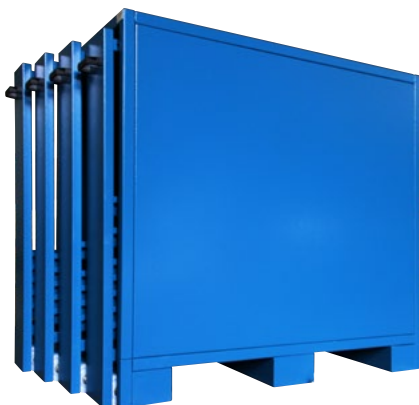
**ARM 1060-4.13**



B	H	P	Drawers
850 mm	1240 mm	1360 mm	
33.46"	48.82"	53.54"	4 (CS-2) 340 kg

250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/39 m of tools  
 Tools tang 13 mm 0.51"

UL-13-4	20
---------	----



**ARM 1060-5.13**



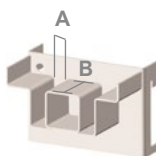
B	H	P	Drawers
850 mm	1240 mm	1360 mm	
33.46"	48.82"	53.54"	5 (CS-1) 400 kg

250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 32.5/52 m of tools  
 Tools tang 13 mm 0.51"

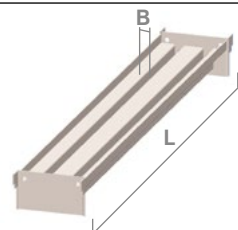
UL-13-4	25
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	L mm	L in	A mm	A in	B mm	B in	
UC-13-1	125	4.92"	13	0.51"	76	2.99"	0.5 kg
UC-13-2	250	9.84"	13	0.51"	232	9.13"	1.0 kg
UC-20-1	125	4.92"	20	0.79"	76	2.99"	0.5 kg
UC-20-2	250	9.84"	20	0.79"	232	9.13"	1.0 kg



	L mm	L in	B mm	B in	
UL-13-1	270	10.63"	13	0.51"	1.2 kg
UL-13-2	580	22.83"	13	0.51"	2.5 kg
UL-13-3	1050	41.34"	13	0.51"	4.6 kg
UL-13-4	1360	53.54"	13	0.51"	6.0 kg
UL-20-1	270	10.63"	20	0.79"	1.4 kg
UL-20-2	580	22.83"	20	0.79"	3.2 kg
UL-20-3	1050	41.34"	20	0.79"	5.8 kg
UL-20-4	1360	53.54"	20	0.79"	7.5 kg



**ARM 1060-4**

B	H	P	Drawers
850 mm	1240 mm	1360 mm	
33.46"	48.82"	53.54"	4 (CS-2) 340 kg



250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/39 m of tools  
 Tools tang 20 mm 0.79"

UC-20-2	16
UL-20-4	4



**ARM 1060-4-CV**

B	H	P	Drawers
850 mm	1240 mm	1360 mm	
33.46"	48.82"	53.54"	4 (CS-2) 351 kg



250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/39 m of tools  
 Tools tang 20 mm 0.79"

UC-20-1	20
UL-20-4	10



**ARM 1060-5**

B	H	P	Drawers
1040 mm	1240 mm	1360 mm	
40.94"	48.82"	53.54"	5 (CS-2) 400 kg



250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 32.5/52 m of tools  
 Tools tang 20 mm 0.79"

UC-20-2	20
UL-20-4	5



**ARM 1060-5-CV**

B	H	P	Drawers
850 mm	1240 mm	1360 mm	
40.94"	48.82"	53.54"	5 (CS-2) 490 kg

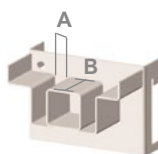


250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 32.5/52 m of tools  
 Tools tang 20 mm 0.79"

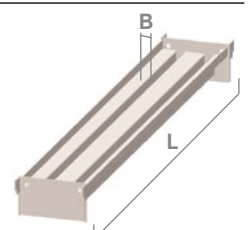
UC-20-1	30
UL-20-4	10



	L mm	L in	A mm	A in	B mm	B in	
UC-13-1	125	4.92"	13	0.51"	76	2.99"	0.5 kg
UC-13-2	250	9.84"	13	0.51"	232	9.13"	1.0 kg
UC-20-1	125	4.92"	20	0.79"	76	2.99"	0.5 kg
UC-20-2	250	9.84"	20	0.79"	232	9.13"	1.0 kg



	L mm	L in	B mm	B in	
UL-13-1	270	10.63"	13	0.51"	1.2 kg
UL-13-2	580	22.83"	13	0.51"	2.5 kg
UL-13-3	1050	41.34"	13	0.51"	4.6 kg
UL-13-4	1360	53.54"	13	0.51"	6.0 kg
UL-20-1	270	10.63"	20	0.79"	1.4 kg
UL-20-2	580	22.83"	20	0.79"	3.2 kg
UL-20-3	1050	41.34"	20	0.79"	5.8 kg
UL-20-4	1360	53.54"	20	0.79"	7.5 kg





**ARM 1060-4-T**



B	H	P	Drawers
850 mm	1240 mm	1360 mm	
33.46"	48.82"	53.54"	4 (CS-2) 340 kg

250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 20.8/31.2 m of tools  
 Tools tang 13 mm 0.51"-20 mm 0.79"

UL-13-4	8
UT-4	8



**ARM 1060-4-T-CV**



B	H	P	Drawers
850 mm	1240 mm	1360 mm	
33.46"	48.82"	53.54"	4 (CS-2) 395 kg

250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 20.8/31.2 m of tools  
 Tools tang 13 mm 0.51"-20 mm 0.79"

UC-13-1	16
UT-4	8



**ARM 1060-5-T**



B	H	P	Drawers
1040 mm	1240 mm	1360 mm	
40.94"	48.82"	53.54"	5 (CS-2) 400 kg

250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/41.6 m of tools  
 Tools tang 13 mm 0.51"-20 mm 0.79"

UL-13-4	10
UT-4	10



**ARM 1060-5-T-CV**



B	H	P	Drawers
850 mm	1240 mm	1360 mm	
40.94"	48.82"	53.54"	5 (CS-2) 400 kg

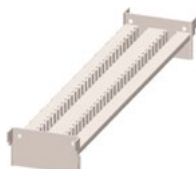
250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/41.6 m of tools  
 Tools tang 13 mm 0.51"-20 mm 0.79"

UC-13-1	24
UT-4	8



	L mm	L in	
UT-1	270	10.63"	1.4 kg
UT-2	580	22.83"	3.2 kg
UT-3	1050	41.34"	5.8 kg
UT-4	1360	53.54"	7.5 kg

Suitable for punches with safety pins



	L mm	L in	
UV-1	270	10.63"	1.0 kg
UV-2	580	22.83"	2.0 kg
UV-3	1050	41.34"	4.3 kg
UV-4	1360	53.54"	5.5 kg



**WKS013 SET A**

B	H	P	Drawers
660 mm	1240 mm	1050 mm	3
33.46"	48.82"	40.33"	3



900 kg max./drawer			
Max. tool length = 850 mm 33.46"	<b>WKH102</b>	9	
Approx. 16 m of tools	<b>WEB360</b>	3	
For all tang	<b>TRB360</b>	12	



**WKS033 SET A**

B	H	P	Drawers
660 mm	1240 mm	1300 mm	3
33.46"	48.82"	51.18"	3



900 kg max./drawer			
Max. tool length = 1050 mm 40.33"	<b>WKH103</b>	9	
Approx. 19 m of tools	<b>WEB366</b>	3	
For all tang	<b>TRB360</b>	15	



**NEW**

**WKS001 SET A**

B	H	P	Drawers
1040 mm	1240 mm	1050 mm	5
40.94"	48.82"	40.33"	5



900 kg max./drawer			
Max. tool length = 850 mm 33.46"	<b>WKH102</b>	15	
Approx. 16 m of tools	<b>WEB360</b>	5	
For all tang	<b>TRB360</b>	25	



**WKS003 SET A**

B	H	P	Drawers
850 mm	1240 mm	1300 mm	5
40.94"	48.82"	51.18"	5

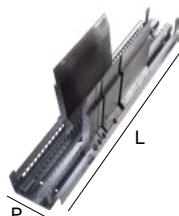


900 kg max./drawer			
Max. tool length = 1050 mm 40.33"	<b>WKH103</b>	15	
Approx. 33 m of tools	<b>WEB366</b>	5	
For all tang	<b>TRB360</b>	25	



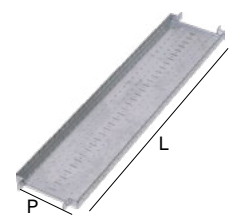
	L mm	L in	P mm	P in
<b>WKH102</b>	180	7.08"	1050	41.33"
<b>WKH103</b>	180	7.08"	1300	51.18"

Bending tools retainer



	L mm	L in	P mm	P in
<b>WKH502</b>	180	7.08"	1050	41.33"
<b>WKH504</b>	180	7.08"	1300	51.18"

Universal trays





**WKS035 SET A**



B	H	P	Drawers
1040 mm	1620 mm	1050 mm	
40.94"	63.77"	40.33"	5

900 kg max./drawer	WKH103	20
Max. tool length = 850 mm 33.46"	WEB366	5
Approx. 44 m of tools	TRB360	25
For all tang		

**WKS335 SET A**



B	H	P	Drawers
660 mm	1620 mm	1300 mm	
25.98"	63.77"	51.18"	3

900 kg max./drawer	WKH103	12
Max. tool length = 1050 mm 40.33"	WEB366	3
Approx. 19 m of tools	TRB366	5
For all tang		

**NEW**



**WKS006 SET A**



B	H	P	Drawers
1040 mm	2140 mm	1300 mm	
40.94"	84.25"	51.18"	5

900 kg max./drawer	WKH103	20
Max. tool length = 1050 mm 40.33"	Universal trays	10
Approx. 44 m of tools	Storage box	60
For all tang	WKH830	1



	L mm	L in	P mm	P in
WKH102	180	7.08"	1050	41.33"
WKH103	180	7.08"	1300	51.18"

Retainer for measurements tools and small parts:

WEB360 included n° 4 TRB360

WEB366 included n° 5 TRB360



Partition plate





**A-TR**

B	H	P	Drawers
1060 mm	1520 mm	1160 mm	30 108 kg
41.73"	59.84"	45.66"	



250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/39 m of tools

For R1 tools

**T-TR**

B	H	P	Drawers
1060 mm	1520 mm	1160 mm	21 175 kg
41.73"	59.84"	45.66"	



250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/39 m of tools

For R2 tools

**B-TR**

B	H	P	Drawers
1060 mm	1520 mm	1160 mm	21 135 kg
41.73"	59.84"	45.66"	



250 kg max./drawer  
 Max. tool length = 1060 mm 41.73"  
 Approx. 26/39 m of tools

For R3 tools



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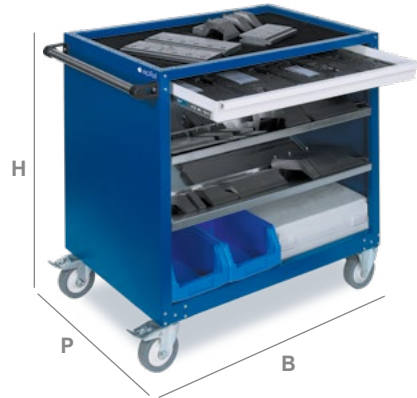
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**WSW582**



B	H	P	Drawer
582 mm	922 mm	922 mm	1
22.91"	36.29"	36.29"	
<b>Sloped shelves</b>			2
<b>Non-slip mat</b>			1
<b>Fixed castors</b>			2
<b>Guided rollers with brake</b>			2



**WSW583 PLUS**



B	H	P	Drawer
582 mm	922 mm	922 mm	1
22.91"	36.29"	36.29"	
<b>Sloped shelves</b>			2
<b>Tools retainer</b>			3
<b>Fixed castors</b>			2
<b>Guided rollers with brake</b>			2



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



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### BOX

1.6 kg



It contains all the useful tools for press brake operators

- PRECISION DIGITAL CALIBER
- SET SQUARE
- ANGLE MEASURING DEVICE



## Sheet metal positioning

### MSA

MSA.D	Right	per piece	1.4 kg
MSA.S	Left	per piece	1.4 kg



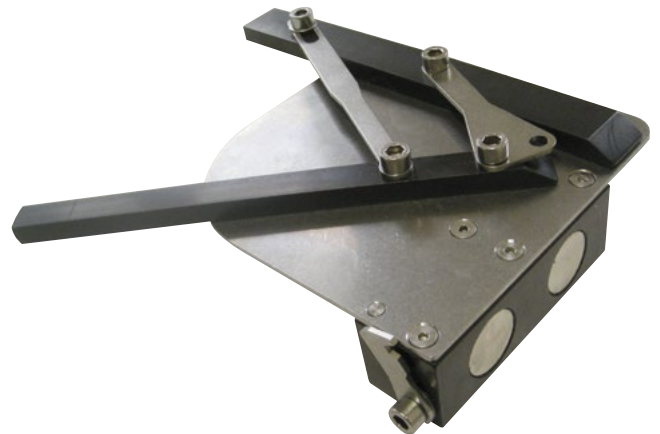
MSA is a very useful tool for the correct sheet metal positioning.

When do you need it?

When according to the profile to be bent, sheet metal should refer to only one backgauge. In this way the bending line can have the correct angle in relation to the outside edge because sheet metal can lay against 2 fix points for a repetitive bending result.

MSA is adjustable in order to position sheet metal at different angles. Thanks to this and to backgauges, we can guarantee precise profiles even when they have small dimensions.

MSA is very easy to be used and it is clamped directly to die stem by means of very strong magnets. We offer MSA.D to have a reference lever on the right handside of sheet metal and MSA.S to have it on the left handside of sheet metal.



Scan the QRCode or click on it and watch the video to discover more about MAGNETIC SQUARING ARMS.



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

**AS**

3.5 kg

Lateral gauges



AS is a very useful tool for the correct sheet metal positioning.

When do you need it?

When according to the profile to be bent, sheet metal should refer to only one backgauge. In this way the bending line can have the correct angle in relation to the outside edge because sheet metal can lay against 2 fix points for a repetitive bending result.

AS is adjustable and this means that thanks to the goniometer and the rear gauge, we can also manage small sheet metal sheets with absolute precision. It is a very simple system to use and it is mounted directly on the stem of the die.

**RIF**

L mm L in

RIF500	500	19.68	7.0 kg
RIF1000	1000	39.37	12.0 kg
RIF1500	1500	59.05	17.0 kg



RIF is a front reference tool for sheet metal even of big dimensions. It is a support mounted directly to the front part of a press brake table and thanks to slotted holes drilled to the fixing plates, it can be adjusted in height to make sure it is always at the same height of the dies mounted.

A millimeter ruler goes all along RIF support to position front stops properly. On the same RIF you may have more stops for different bending sequences. Such stops have been designed not to interfere with the bending process when they are not in use.

Furthermore, to position sheet metal more precisely, you can use micrometric stop, which has centesimal adjustment precision.

RIF supports are available in different lengths and can be mounted single or in pair.

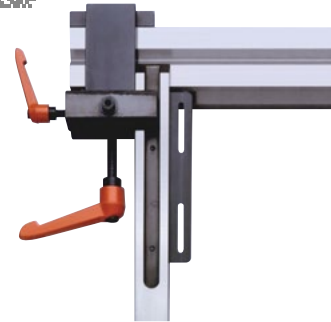


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**AS FIX**

3.0 kg



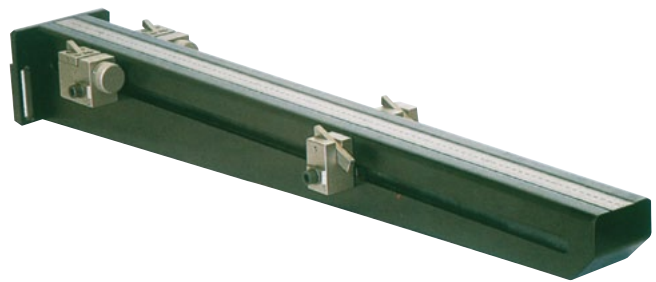
AS FIX is a very useful tool for the correct sheet metal positioning.

When do you need it?

When according to the profile to be bent, sheet metal should refer to only one backgauge. In this way the bending line will be perfectly at 90° in relation to the outside edge.

AS FIX is a fix reference point and it can guarantee precise profiles even when they have small dimensions.

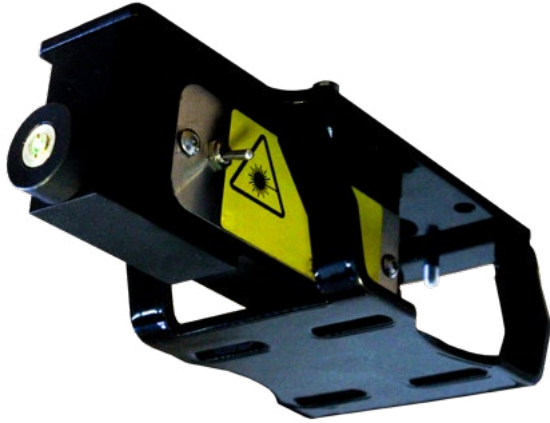
AS FIX is very easy to be used and it is clamped directly to die stem.



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

## LASER TRACKER

	L mm	L in
Holder	600	23.63"
Laser Tracker	-	-

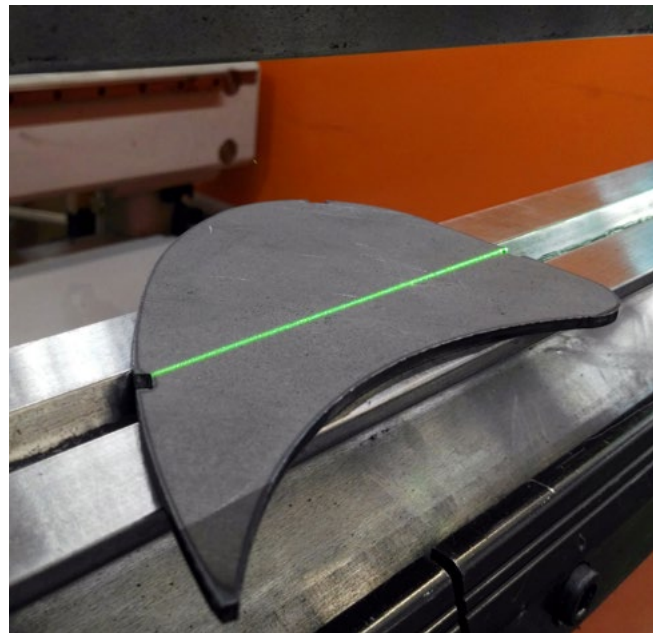
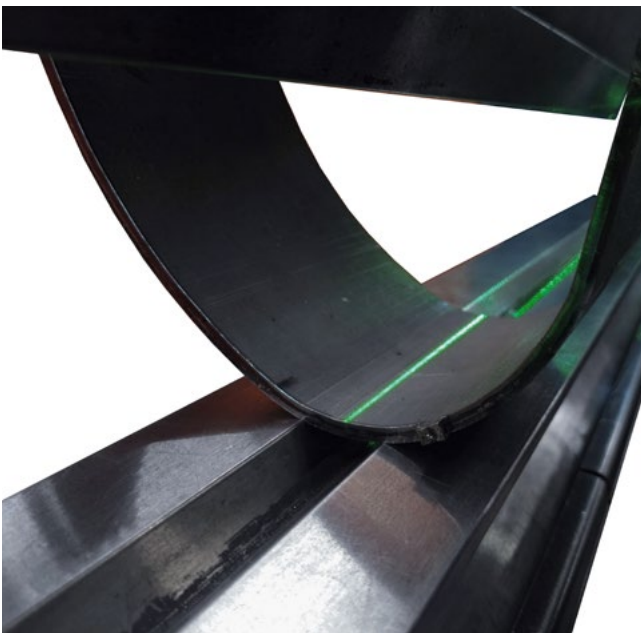


There will be no need of some steps of programming and the accuracy will be instantly millimetric.

- Execution speed and accuracy
- Universal simple installation
- Compact and functional design
- Reliable result also in multi-station

Ideal for:

- Rolling
- Conic bending (funnels and hoppers)
- Dressing cycle (transverse stiffeners for thin panels)
- Irregular profiles difficult to be leant to posterior backgauges
- Marked bending (e.g: laser marking or other reference with marks)



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## B-LIGHT 01



- With B-LIGHT 01 more than 67% time saved in sheet metal positioning
- Extremely versatile as it can be mounted and removed very easily and quickly
- Battery-powered
- Universal: suitable for any press brake model
- It can be used in different press brakes thanks to its easy and quick positioning
- Ideal to work in long press brakes by using one device which is perfectly aligned or by using two devices mounted at both ends of the press brake

## LASER TECHNICAL FEATURES

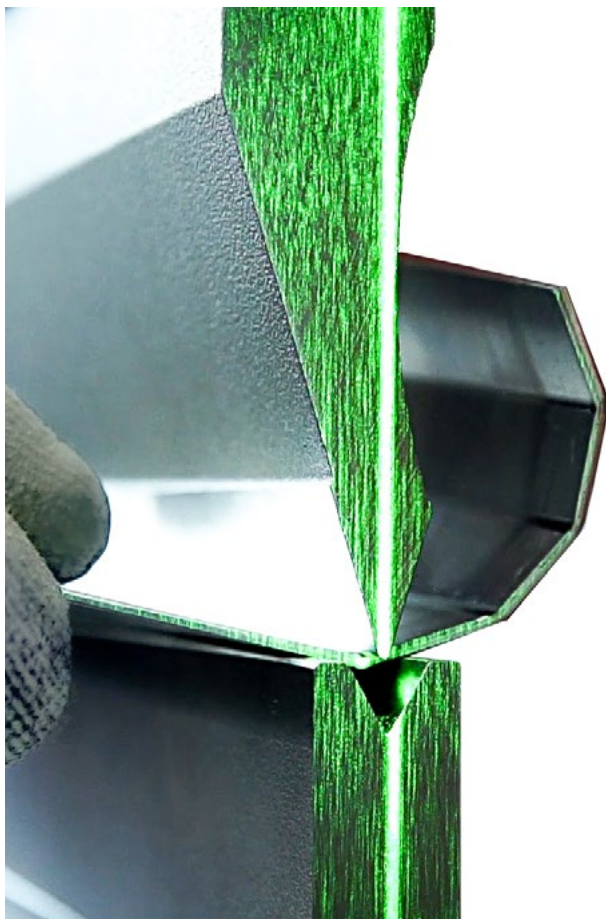
Wavelength	532 nm
Output power	<5 mW
Output method	continuous
Input voltage	3,7 V DC
Working current	<300mA (<600mA for 50mW device)
Working temperature	20°C-30°C
Beam	line (90° opening)
Divergence	1.4 mrad
Average lifetime	>4000 ore
Casing material	brass
Length	31 mm
Diameter	12 mm

## BATTERY TECHNICAL FEATURES

Battery charger	Keenstone 26650 Universal with 2 slot
Screen	LCD
Included batteries	2 rechargeable batteries
Batteries	Li-Ion SAMSUNG INR18650-35E 3,6V 3000

## DURATION OF LASER BEAM VISIBILITY

Continuous duration	10 hours each
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Scan the QRCode or click on it and watch the video to discover more about B-LIGHT 01.



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**SPACE-UP**

Height	from 2400mm to 7000mm (step 1m)
Min shelf distance:	25 mm
Shelf width	1.300 mm
Shelf depth	425 mm
Max. shelf load	350 kg
Max. total gross load	25.000 kg
Max. material height to be stored	650 mm
Speed	up to 190 cycles/hour according to configuration
Operator interface	touch screen 10,4" (Copilot)
Limited energy consumption	1,2 kW/h (h=7.000 mm)
Power supply	single-phase (230V) and three-phase (400V)

**INTERFACE WITH PRESS BRAKE, PUNCHING MACHINE AND LASER CUTTING MACHINE**

A fully organized storage system with 3 different procedures to control material flow between Space-Up and workshop.

Every stored item can be protected with a password to control better access and picking. Space-Up is equipped with a control panel for any operation or research but the same operations can be carried out by any other computer.

Thanks to new generation press brake CNC, machine programme can be wireless forwarded to Space Up, which automatically prepares the necessary tooling. Rolleri tool list is preloaded.

**INFORMATION ABOUT TOOLING STATUS**

An operator can check all picking and returning operations for each item stored in Space Up and calculate how long such item has been out of it.

Thanks to this, you can set an alert to schedule tooling maintenance. Let's make an example: we know that a hemming die needs spring replacement after 100 working hours.

After 80 hours, Space Up sends an alert to remind springs and screw replacement. This function works for press brake as well as punching tooling, so that all maintenance regrinding operations can be scheduled. This function enables longer tooling operational life and better cutting and bending precision.

A very important activity carried out by Space Up is recording tooling costs: thanks to this, tooling inventory is always available and updated at any time.

**PICKING AND LOAN FUNCTION**

Space Up is programmed to manage tooling loans, which have to be returned and every time an operator returns a tool, he has to record tool status. Thanks to this function, every item stored meets quality requisites to start a new project.

You can set "non-conform" shelves or "quarantine" shelves for tools no longer in good conditions. After check (which can be scheduled with an automatic alert), such tools can be moved their final shelf.

Space Up can also manage stock level and minimum stock and send automatic alerts to improve stock. This function is very useful especially for consumables for laser cutting machines.

**ACCESS CONTROL**

Every operator has a username and a badge. In this way every operator can pick tools he is authorized to, so the risk of unauthorized picking is avoided. During picking and returning, Space Up display shows tool code and image in order to help the operator.

All operations and real-time-availability can be checked remotely too, in order to schedule machine workload properly according to tooling availability.

**SHELF VERSATILITY**

Every shelf is designed for the different items it has to contain. Its ergonomics is studied to enable the proper storage of press brake and punching tools.

Furthermore, you can have pre-configured shelves to store laser and welding consumables. In general, shelf positioning is very flexible and versatile. Space Up software automatically checks shelf height in order to position it properly in Space Up: in this way shelves with necessary tools to the same production will be always close to each other to reduce waiting time during picking and returning to a minimum.

**VISUAL AID**

Space Up display shows the operator shelf layout highlighting the position of the tool to be picked or returned. Thanks to this function, the operator is always helped and can avoid any mistake and save time.



Find out more about SPACE-UP by clicking on the QRCode or scanning it.



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

Space-Up is much more than an automatic storage system. It can provide useful information about tools by interfacing with the machines: information about tool status, position, about the operator who took them, about the value of the stock.



Modular system  
up to 7m (1m modules)

Toothed belt  
reinforced self-centering  
steel

TOUCH SCREEN interface  
integrated

Emergency button

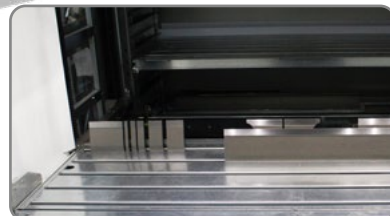
Alphanumeric LED bar

Picking end button

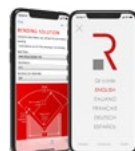
3000 mm (standard)

1675 mm

1685 mm



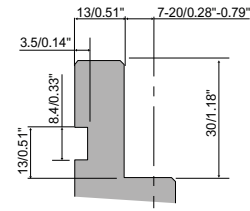
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Download Roller Bending App

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

EASY PRESS manual press brake doesn't need any specific tooling nor connection to any power supply and therefore it is very versatile.



TECHNICAL INFORMATION

	Standard	Super six
Weight without tooling	111 Kg	120 Kg
Bending force	Max 6.5 Ton	Max 6.5 Ton
Bending length	Max 415 mm	Max 415 mm
Throat depth	100 mm	165 mm
Max.stroke	Max 110 mm	Max 110 mm
Distance between upper beam and table	Max 180 mm	Max 250 mm
Backgauge X-axis stroke	Max 200 mm	Max 200 mm
Standard R1 type tools	●	●
Promecam base	60 mm	60 mm
Use with manual lever	●	●
Use with footpedal	○	○
Oil used	DTE 24 type	DTE 24 type
Pedal pneumatic pressure	6 bar	6 bar
Pedal-press brake connection cable	2.5-3 m with female connection ¼ gas	2.5-3 m with female connection ¼ gas

● = standard ○ = on request



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



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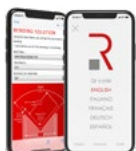
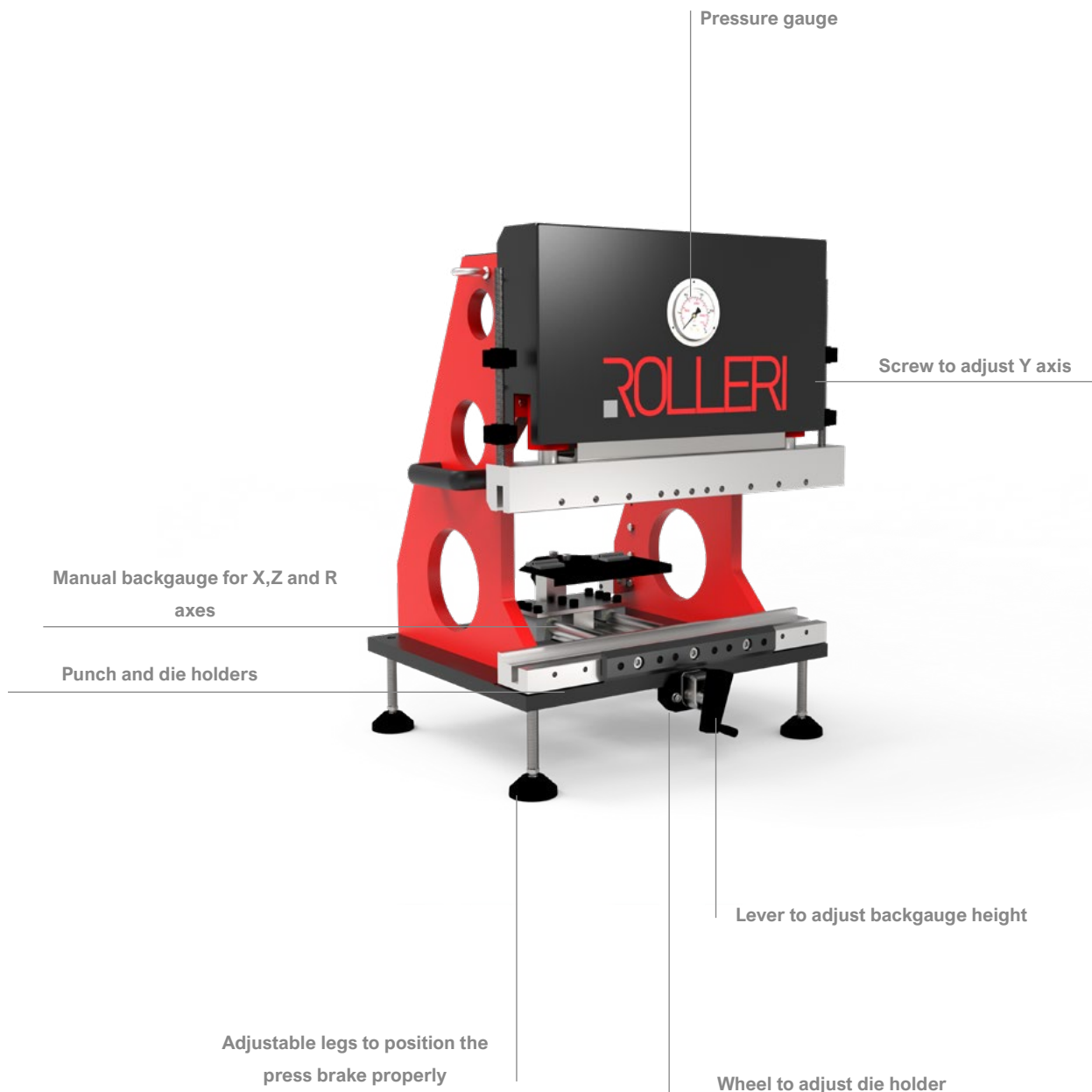
### MAINTENANCE

Being manual and without an electric system, Easy Press needs little maintenance.



Every month it needs to:

- check oil level in pump tank on the right side. In case oil level lowers, feed with hydraulic oil.
- check screws and operating lever to find possible mechanical damages.

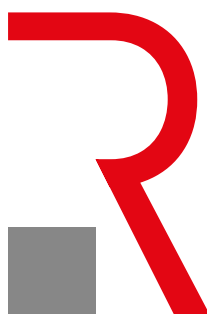


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