

ROLLERI

TOOLING LAB

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

BENDING

R9 TOOLS TYPE
GASPARINI





ISO 9001 - ISO 45001
CERTIFIED
COMPANY



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Download Rolleri **Bending App**

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



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



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



Create your account on www.rolleritools.com
You can use Rolleri website to check the delivery time, request quotes, stay update with the news, check prices and place orders directly.



Click on the QR code or scan it to find prices and availability. Create your account on www.rolleritools.com



Check standard available sectioning.
You can also ask for customized tool sectioning. Contact sales@rolleri.it to ask for feasibility and for customized products.



Download Rolleri **Clamping App**

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



BENDING TOOLS

R1 TOOLS TYPE

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

R2-R3 TOOLS TYPE

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

R4 TOOLS TYPE

Compatible with press brakes: LVD

R5 TOOLS TYPE

Compatible with press brakes: American

R6 TOOLS TYPE

Compatible with press brakes: Hämmerle-Bystronic

R7 TOOLS TYPE

Compatible with press brakes: Colly

R8 TOOLS TYPE

Compatible with press brakes: Colgar

R9 TOOLS TYPE

Compatible with press brakes: Gasparini (axial)

R10 TOOLS TYPE

Compatible with press brakes: Ajial Axial

Rx TOOLS TYPE

Compatible with press brakes: EHT, Ursviken and Weinbrenner

ROLLERI TECH, MODIFICATIONS AND SERVICES

Compatible with all types of press brakes

CLAMPING SYSTEMS, INTERMEDIATES AND ADAPTERS

Compatible with all types of press brakes

ROLLA-V AND SPECIAL DIES

Compatible with all types of press brakes

MARK FREE BENDING AND ACCESSORIES

Compatible with all types of press brakes

PANEL BENDING TOOLS

SHEAR BLADES

PUNCHING TOOLS

R1 TOOLS TYPE

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

R2 TOOLS TYPE

Compatible with Trumpf punching machines

RS TOOLS TYPE

Compatible with Salvagnini punching machines

SPECIAL TOOLS

Compatible with different types of punching machines

ACCESSORIES

Compatible with different types of punching machines

IRON WORKER

Iron cutting tools

LASER CONSUMABLES

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



6 R9 TOOLS

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13-ADAPTERS

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GASP200.26.R6-30 12

GASP200.70.R3-30 12

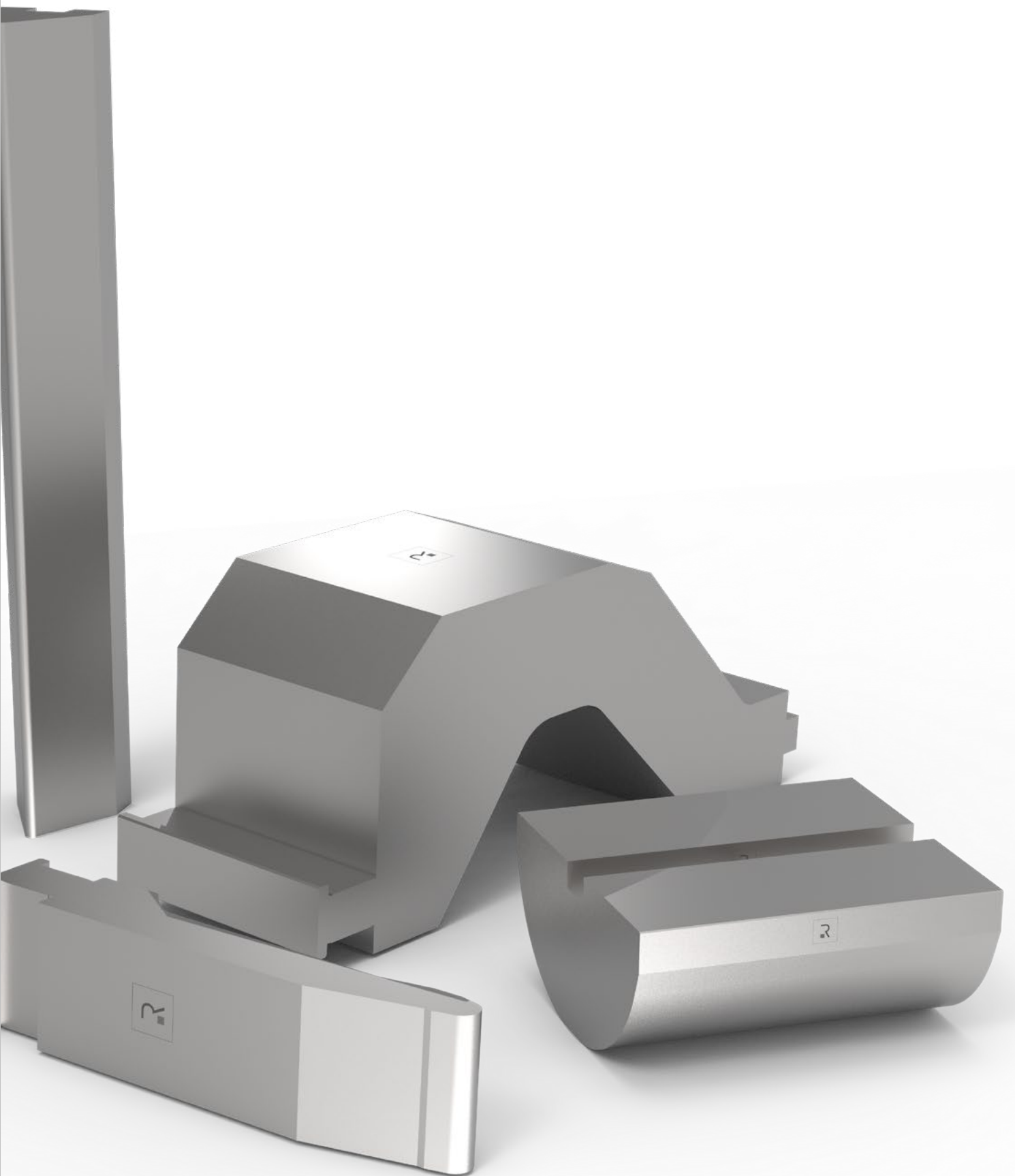
GASP293-16 9

R9

TOOLS

Gasparini

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



STANDARD LENGTH

PUNCHES

525 mm | 20.67"

RADIUS TOOLS HOLDERS

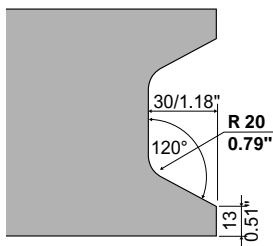
522 mm | 20.55"

RADIUS TOOLS

525 mm | 20.67"

HORN TYPES

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



SEGMENTATION

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

◀ = horn left ▶ = horn right

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



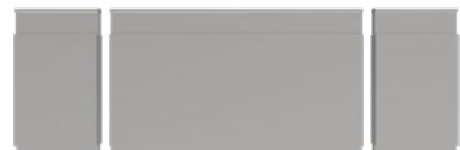
F: 500 mm - 19.68"
 mm: 100 - 300 - 100
 In: 3.94 - 11.81 - 3.94



F: 563 mm - 22.17"
 mm: 42-47-52-57-62-67-72-77-87
 In: 1.65-1.85-2.04-2.24-2.44-2.64-2.83-3.03-3.42



F: 491 mm - 19.33"
 mm: 97-297-97
 In: 3.82-11.69-3.82



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

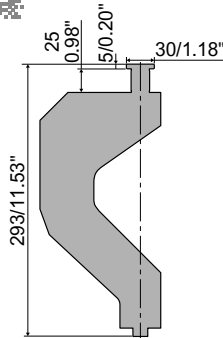


Rolleri **FREEZINC** is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation

GASP293-16

522 mm	20.55"	83 kg	
563 mm	22.17"	89.5 kg	F
491 mm	19.33"	78 kg	F

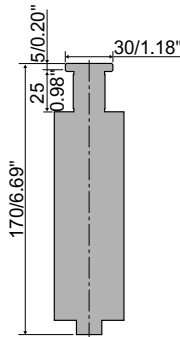
C45: 560-710 N/mm²
1000 kN/m max.



GASP170-16

522 mm	20.55"	24 kg	
563 mm	22.17"	4.5 kg	F
491 mm	19.33"	4.5 kg	F

C45: 560-710 N/mm²
1000 kN/m max.



F: 563 mm - 22.17"

mm: 42-57-52-57-62-67-72-77-87

In: 1.65-1.85-2.04-2.24-2.44-2.64-2.83-3.03-3.42



F: 491 mm - 19.33"

mm: 97-297-97

In: 3.82-11.69-3.82



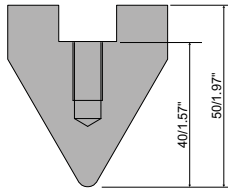
GASP40.60.03

525 mm	20.67"	4.7 kg	
590 mm	23.23"	5.3 kg	FX
500 mm	19.68"	4.5 kg	F



C45: 560-710 N/mm²
1000 kN/m max.

60°
R=3.0 mm
R=0.118 in



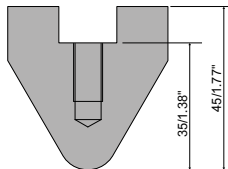
GASP35.60.08

525 mm	20.67"	4.7 kg	
590 mm	23.23"	5.3 kg	FX
500 mm	19.68"	4.5 kg	F



C45: 560-710 N/mm²
1000 kN/m max.

60°
R=8.0 mm
R=0.315 in



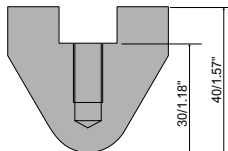
GASP30.60.11.5

525 mm	20.67"	4.2 kg	
590 mm	23.23"	4.7 kg	FX
500 mm	19.68"	4 kg	F



C45: 560-710 N/mm²
1000 kN/m max.

60°
R=11.5 mm
R=0.453 in



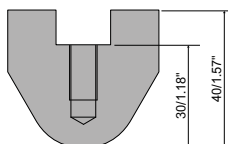
GASP30.60.16

525 mm	20.67"	4.7 kg	
590 mm	23.23"	5.3 kg	FX
500 mm	19.68"	4.5 kg	F



C45: 560-710 N/mm²
1000 kN/m max.

60°
R=16 mm
R=0.630 in



FX: 590 mm - 23.23"
mm: 45-50-55-60-65-70-75-80- 90
In: 1.77-1.97-2.16-2.36-2.56-2.75-2.95-3.15-3.54

F: 500 mm - 19.68"
mm: 100-300-100
In: 3.94-11.81-3.94



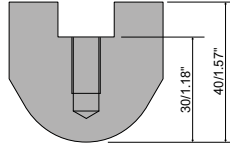
GASP30.60.20

525 mm	20.67"	5 kg	
590 mm	23.23"	5.6 kg	FX
500 mm	19.68"	4.3 kg	F



C45: 560-710 N/mm²
1000 kN/m max.

60°
R=20 mm
R=0.787 in



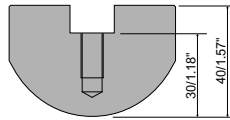
GASP30.60.32

525 mm	20.67"	7 kg	
590 mm	23.23"	7.8 kg	FX
500 mm	19.68"	6.7 kg	F



C45: 560-710 N/mm²
1000 kN/m max.

60°
R=32 mm
R=1.26 in



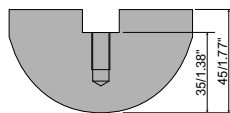
GASP35.40.40

525 mm	20.67"	10.5 kg	
590 mm	23.23"	11.8 kg	FX
500 mm	19.68"	10 kg	F



C45: 560-710 N/mm²
1000 kN/m max.

40°
R=40 mm
R=1.57 in



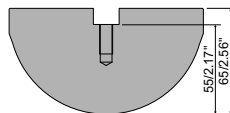
GASP55.40.60

525 mm	20.67"	24.7 kg	
590 mm	23.23"	27.4 kg	FX
500 mm	19.68"	23.2 kg	F



C45: 560-710 N/mm²
1800 kN/m max.

40°
R=60 mm
R=2.36 in



FX: 590 mm - 23.23"

mm: 45-50-55-60-65-70-75-80- 90

In: 1.77-1.97-2.16-2.36-2.56-2.75-2.95-3.15-3.54

F: 500 mm - 19.68"

mm: 100-300-100

In: 3.94-11.81-3.94

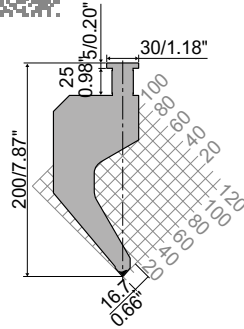


GASP200.70.R3-30

525 mm	20.67"	31.8 kg	
495 mm	19.49"	30 kg	F
500 mm	19.68"	30.3 kg	F

42Cr: 900-1150 N/mm²
1000 kN/m max.

70°
H=200 | R=3.0 mm
H=7.87 | R=0.118 in

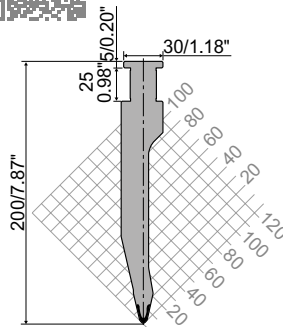


GASP200.26.R3-30

525 mm	20.67"	16.9 kg	
495 mm	19.48"	10.6 kg	F
500 mm	19.68"	10.7 kg	F

42Cr: 900-1150 N/mm²
1300 kN/m max.

26°
H=200 | R=3.0 mm
H=7.87 | R=0.118 in

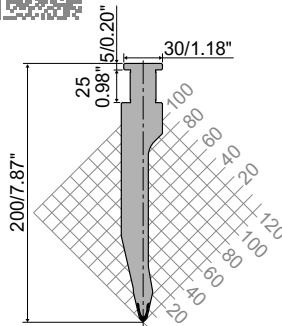


GASP200.26.R6-30

525 mm	20.67"	16.9 kg	
590 mm	23.23"	10.6 kg	FX
500 mm	19.68"	10.7 kg	F

42Cr: 900-1150 N/mm²
1300 kN/m max.

26°
H=200 | R=6.0 mm
H=7.87 | R=0.236 in



F: 495 mm-19.48"

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

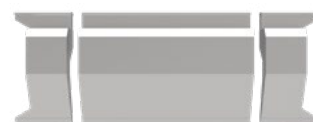
In: 0.98 - 1.18 - 1.37 - 1.57 - 1.77 - 1.97 - 3.94 - 9.84



F: 500 mm-19.68"

mm: 100 - 300 - 100

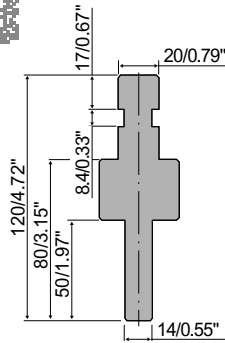
In: 3.94-11.81-3.94



AD14

150 mm 5.90" 3.2 kg

R9 → R1

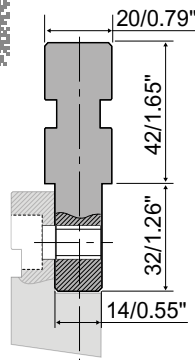
C45: 560-710 N/mm²
1000 kN/m max.W=82 | H=120 mm
W= 3.23 | H=4.72 in

AW14

835 mm 32.87" 8 kg

415 mm 16.34" 4 kg

805 mm 31.69" 7.7 kg F



Upper adapters have very precise dimensions and limited height. They are studied to be mounted directly to press brake upper beam and when mounted, they can host punches with a different tang than the original one. Such solution is very interesting when you have to retrofit a press brake: in a press brake with a special tang you can mount all standard tools in the catalogue.

Thanks to this operation, time and costs are reduced.

Adapter precision needs to have max +/-0.01mm tolerance, so that bending axis is precise and guaranteed. In this way you can get precise profiles, as distance between backgauges and die V center is also precise.

As far as dimensions is concerned, we have limited height not to lose too much daylight. AW adapters enable standard R1 type tools to be mounted in a press brake with a different tang.

They consist in small adapters as big as press brake tang and as long as the punch they have to be mounted with. They can be supplied in segmented version as well. Some holes are drilled and countersunk in punch tang, whereas some threaded holes are made in AW adapter so that they can be screwed together and become a single body.

In press brake CNC the total height of punch and adapter has to be set either manually or imported automatically from our DXF drawing. This system offers the possibility to use a wide range of standard R1 type punches and avoid using special tooling.



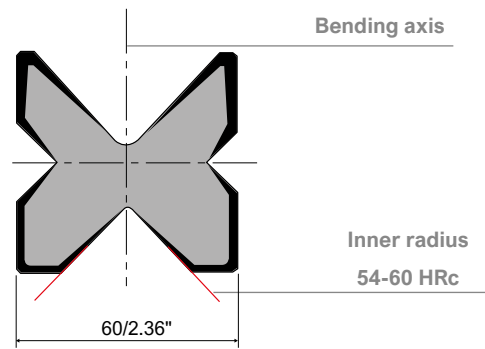
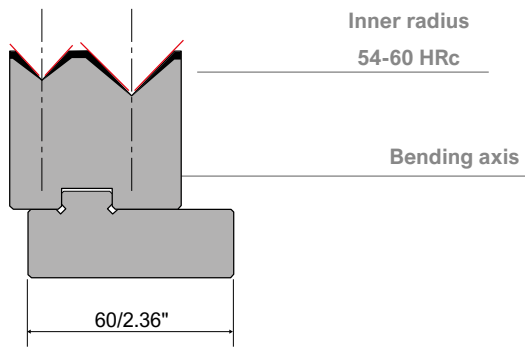
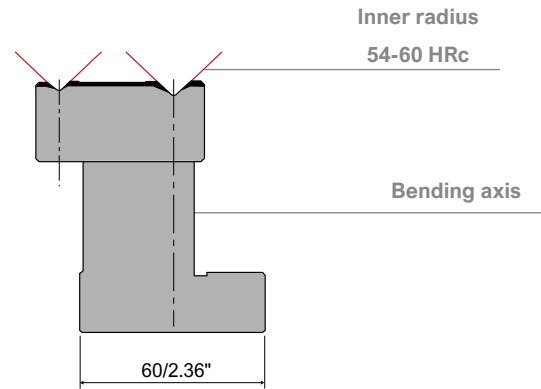
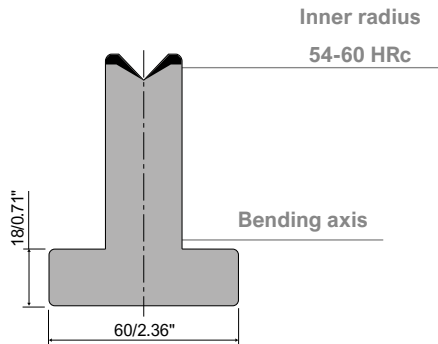
Download or request type R1 bending tools catalogue www.rolleritools.com/download-66100.html



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

STANDARD TANG

All dies R1 have base 60 mm 2.36", 90 mm 3.54" or 120 mm 4.72".



STANDARD LENGTH

	TOP Series	CLASSIC Series	A Series	AFH Series
525 mm 20.67"	●			
415 mm 16.34"		●	●	●
835 mm 32.87"		●	●	●
900 mm 35.43"		○	○	

○ Available only for some models



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

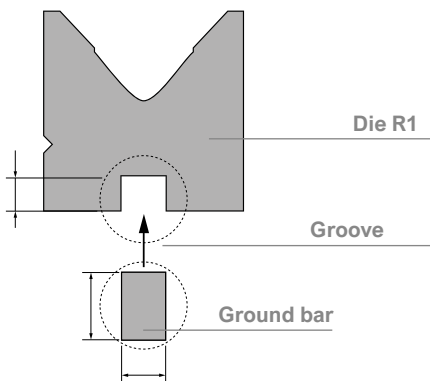


Rolleri **FREEZINC** is a surface treatment to avoid metal residues of galvanized steel or aluminium from remaining on tools during bending. Tools are also protected from oxidation

MODIFICATIONS WEDGE/BAR TAIL

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

Wedge/BarTail (W x H)		System
13 x 30 mm 0.51" x 1.18"	R2 R3	Bystronic-Beyeler, Safan, Trumpf,...
55 x 55 mm 2.16" x 2.16"	RX	EHT
12.7 x 29 mm 0.5" x 1.14"	R4	LVD
35 x 55 mm 1.37" x 2.16"	RX	Weinbrenner



SEGMENTATION

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

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



F: 805 mm - 31.69"
mm: 200-50-40-20-15-10
in: 7.87-1.96-1.57-0.78-0.59-0.39



FX: 795 mm - 31.29"
mm: 100-250-20-25-30-35-40-45-50 -200
in: 3.94-9.84-0.78-0.98-1.18-1.37-1.57-1.77-1.96-7.87



FC (serie A): 835 mm - 32.87"
mm: 10-15-20-40-50-100-200-400
in: 0.39-0.59-0.78-1.57-1.96" -7.87-15.75



F: 800 mm - 21.49"
mm: 100-300-150-50-40-20-15-10-100
in: 3.94-11.81-5.90-1.96-1.57-0.79-0.59-0.59-0.39-3.94



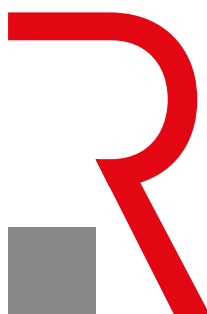
! Download or request type R1 bending tools catalogue to discover standard codes.



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



ROLLA-V dies are different from conventional dies as they have inserts which rotate and accompany sheet metal during the bending process. This system has several advantages, including the reduction of sheetmetal resistance against friction and of minimum flange.



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