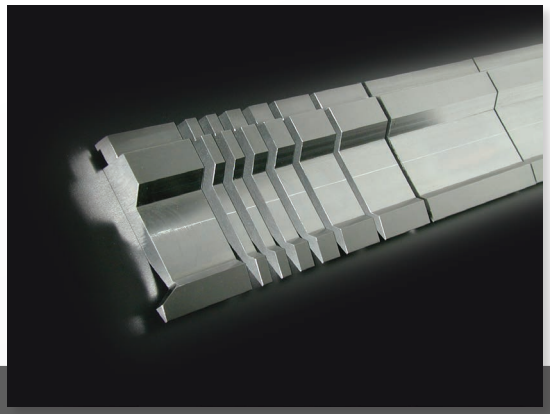
FAB SUPPLY INCORPORATED

QAS INTERNATIONAL
ISO 9001:2015
REGISTERED COMPANY
Certificate No. US1446



Precision Ground

PRESS BRAKE TOOLING

American Style

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American Style PRESS BRAKE TOOLING

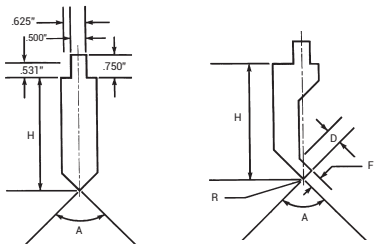
FAB SUPPLY'S **precision ground American style press brake tooling is designed to meet the exacting needs of today's high precision metal fabricator.**

Recommended for the forming of 22ga. to 11ga. mild steel, this tooling is manufactured to be extremely accurate, durable and easy to use.

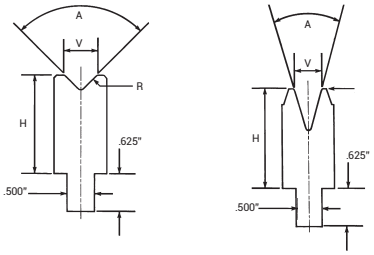
The critical tolerances of all tools are precision ground to within +/- 0.0008 in. In addition, to ensure long lasting accuracy, this high quality tool steel is induction hardened to 50-56 HRC on all working surfaces. Available sectionalized as well as in standard lengths of 36 and 18 inches, this tooling allows for a variety of fast, easy, one-man machine setups.

Precision tooling is a key element of optimal press brake performance, increases accuracy and efficiency and is the key to success.

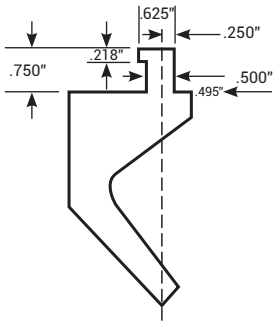
PUNCH DIMENSIONS



DIE DIMENSIONS



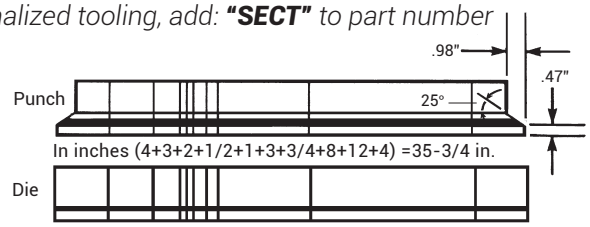
SAFETY TANG



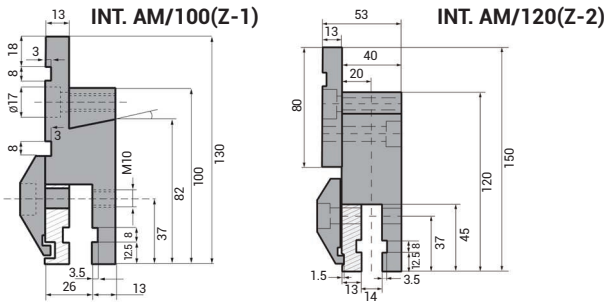
Safety Tangs are standard on all precision ground punches.

SECTIONALIZED TOOLING

Fab Supply's precision ground punches and dies are available sectionalized for convenience and efficiency. Ten matched pieces complete one set of tooling, as shown. When ordering sectionalized tooling, add: ***"SECT"*** *to part number*

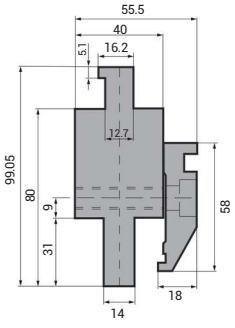


UNIVERSAL TOOL HOLDERS

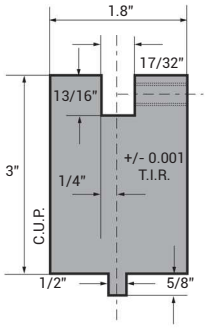


Enables your European press brake to accept American and European style tooling.

AMERICAN TO EURO PUNCH HOLDER



PRECISION GROUND DIE HOLDER



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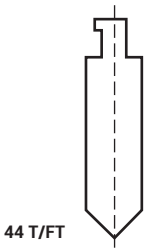
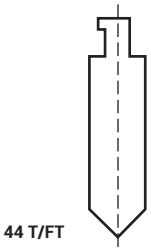
85°/88°/90° PUNCHES



EP1
H = 3.779
A= 90°
R = .010

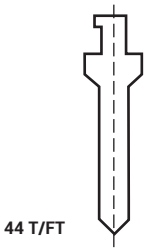
44 T/FT



EP2-90
H = 3.779
A= 90°
R = .060

EP2-88
H = 3.779
A= 88°
R = .060

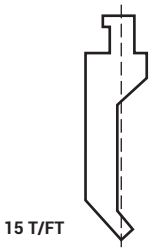
44 T/FT



EP1A-90
H = 3.779
A= 90°
R = .010

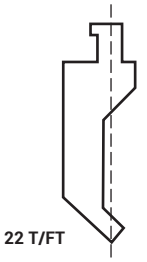
EP1A-88
H = 3.779
A= 88°
R = .010

44 T/FT



EGPA-90
H = 3.779
A= 90°
D = .437
F = .250
R = .015

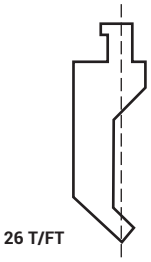
15 T/FT



EGPB-90
H = 3.779
A= 90°
D = .551
F = .375
R = .015

EGPB-88
H = 3.779
A= 88°
D = .551
F = .375
R = .015

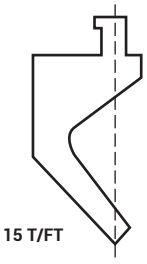
22 T/FT



EGPC-90
H = 3.779
A= 90°
D = .630
F = .500
R = .030

EGPC-88
H = 3.779
A= 88°
D = .630
F = .500
R = .030

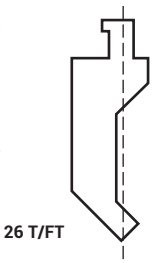
26 T/FT



EGP7A-90
H = 3.779
A= 90°
D = 1.812
F = .433
R = .030

EGP7A-88
H = 3.779
A= 88°
D = 1.812
F = .433
R = .030

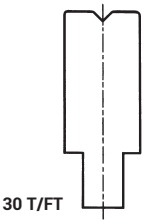
15 T/FT



EGPC-85
H = 3.779
A= 85°
D = .630
F = .500
R = .030

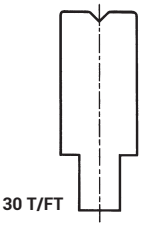
26 T/FT

88° AND 90° LOWER DIES



ELD90-1/4
H = 1.937
A= 90°
V = .250
R = .030

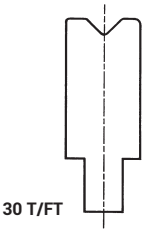
30 T/FT



ELD90-3/8
H = 1.937
A= 90°
V = .375
R = .045

ELD88-3/8
H = 1.937
A= 88°
V = .375
R = .045

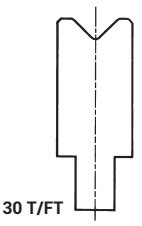
30 T/FT



ELD90-1/2
H = 1.937
A= 90°
V = .500
R = .060

ELD88-1/2
H = 1.937
A= 88°
V = .500
R = .060

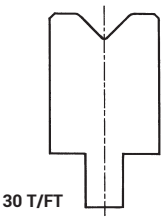
30 T/FT



ELD90-5/8
H = 1.937
A= 90°
V = .625
R = .075

ELD88-5/8
H = 1.937
A= 88°
V = .625
R = .075

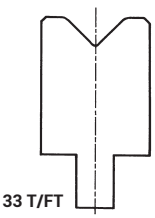
30 T/FT



ELD90-3/4
H = 1.937
A= 90°
V = .750
R = .150

ELD88-3/4
H = 1.937
A= 88°
V = .750
R = .150

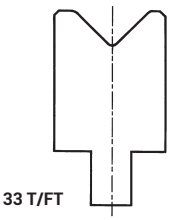
30 T/FT



ELD90-7/8
H = 1.937
A= 90°
V = .875
R = .150

ELD88-7/8
H = 1.937
A= 88°
V = .875
R = .150

33 T/FT



ELD90-1
H = 1.937
A= 90°
V = 1.000
R = .150

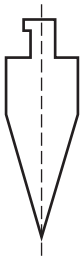
ELD88-1
H = 1.937
A= 88°
V = 1.000
R = .150

33 T/FT

ACUTE PUNCHES

EP28
H = 3.779
A= 28°
R = .030

26 T/FT



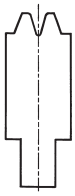
EP30
H = 3.779
A= 30°
R = .060

36 T/FT

EGP28
H = 5.125
A= 28°
R = .030

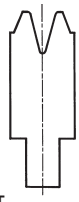
13 T/FT

ACUTE LOWER DIES



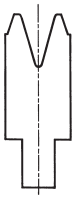
ELD30-1/4
H = 1.937
A= 30°
V = .250
R = .045

17 T/FT



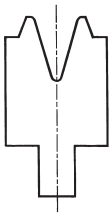
ELD30-3/8
H = 1.937
A= 30°
V = .375
R = .045

17 T/FT



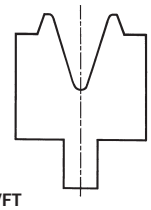
ELD30-1/2
H = 1.937
A= 30°
V = .500
R = .045

17 T/FT



ELD30-5/8
H = 1.937
A= 30°
V = .625
R = .060

17 T/FT



ELD34-7/8
H = 1.937
A= 34°
V = .875
R = .090

17 T/FT

Precision PRESS BRAKE TOOLING

AIR BENDING FORCE CHART - INCHES

The figures shown in bold print signify die openings equal to eight times the material thickness. These are recommended for average applications and will yield an inside radius equal to approximately 15% of the die opening. Required bending tonnage varies directly with the tensile strength of the material. Conversion factors for materials other than mild steel are available.

TONNAGES REQUIRED FOR AIR BENDING MILD STEEL (with tensile strength of 60,000 lbs. psi). For wider or narrower openings in same stock, refer to the numbers left or right of the recommended tonnage.

V		4mm	6mm	7mm	8mm	10mm	12mm	14mm	16mm	18mm	20mm	25mm	32mm	40mm	50mm	63mm	80mm	100mm	125mm	160mm	200mm	250mm
V(in)		0.157	0.236	0.276	0.315	0.394	0.472	0.551	0.630	0.709	0.787	0.984	1.260	1.575	1.969	2.480	3.150	3.937	4.921	6.299	7.874	9.843
MF		0.110	0.165	0.193	0.220	0.276	0.331	0.397	0.454	0.510	0.567	0.709	0.945	1.181	1.476	1.860	2.362	2.953	3.789	4.850	6.063	7.579
IR		0.026	0.039	0.046	0.052	0.066	0.079	0.092	0.105	0.118	0.131	0.164	0.210	0.262	0.328	0.413	0.525	0.656	0.820	1.050	1.312	1.640
GA.	DEC.	Tons required per linear foot using air bend dies with these"V" die openings																				
20	.036	5.3	**3.7**	3.1	2.6	2.1	1.8															
18	.048		6.7	5.9	4.7	**3.8**	2.8	2.5	1.9													
16	.060				7.6	6.1	**5.1**	4.1	3.6	3.2	2.8											
14	.075					11.1	8.1	6.9	**5.6**	4.9	4.2	3.0										
12	.105						15.1	13.1	11.1	9.3	**7.5**	5.4	4.1									
11	.120								15.9	13.1	9.9	**7.2**	5.1	3.9								
10	.135										11.9	9.1	6.3	4.8	3.1							
3/16	.188											24.1	14.9	**10.9**	7.6	5.8						
1/4	.250												30.1	20.1	**13.9**	10.6	8.6					
5/16	.313													36.1	25.1	**18.1**	12.9	10.1				
3/8	.375														37.9	28.1	**19.9**	14.9	11.1			
1/2	.500															52.1	39.1	**29.9**	21.9	16.1		
5/8	.625																70.1	52.1	**38.1**	27.1	19.9	15.1
3/4	.750																	92.0	68.0	**53.0**	36.3	27.0
1	1.0																			112.0	**76.0**	56.0

SAFETY WARNING

The press brake dies shown in this catalog should be used in strict compliance with all local, state and federal safety standards, as well as those outlined in the American National Standards Institute Bulletin A.N.S.I. #B11-3.

Press brake dies are never intended to be used in equipment without a means provided for preventing any and all body parts from entering or remaining in the die space at any time.

It is the user's responsibility to make certain that point of operation protection is effective and that all applicable safety requirements are met.

FAB SUPPLY INCORPORATED