

Press Brake Tooling



Technical Spec.

The Rolla-V Range of Tools

Rolla-V dies are available to suit any manufacturer's machine.

Several fixed sizes are offered as well as adjustable models which are ideal for heavy plate or large radius work.

Appropriate insert materials are used to suit the typical applications for each size Rolla-V tool, although custom materials may be available on request.

Custom sizes and widths are also available for specific applications. Please call us to find out more.

Non-Standard lengths are available to order on all models

APPLICATION

RVP (models 1, 2 and 3) are 60mm clamping widths

Suitable for Amada, Atlantic, Adira, Bystronic Euro, Beyeler Euro-B, CR Electronic, Durmazlar, Ermaskan, Gasparini, Guifil, Haco, Promecam.

RVS (models 1, 2) are 14mm tang

Suitable for Amada style single V holder.

RVT (models 1, 2 and 3) are 12.7mm/13.0mm tang

Suitable for Bystronic, Hammerle, Beyeler, Edwards, Safan, SMB, Trumpf.

RVT90 (models 1, 2 and 3) are 12.7mm offset tang

Suitable for LVD with offset tang

RVM (models 2.5, 3, 3.5 and 4)

Universal clamping with base or tang - all styles are available - suitable for any machine brand.

If you cannot see your machine type listed here we can provide advice and make custom fittings to your specification - please call us.

Inserts

Advantages of Using Rolla-V

- Highly precision ground
- Modular
- Avoid traditional bending marks
- Minimal marking
- Extremely short flanges possible
- No tool material cross contamination
- Bend close to holes and cut-outs with no deformation
- Fewer tool changes
- Bends laser cut sheets with no tool damage
- Ideal for radius bending
- Exact inside radius
- Ideal for tapped or feathered edges
- Bends up to 30mm thick material (subject to model selected)

APPLICATION AND TECHNICAL DATA

Adjustable models	Min / Max (mm)	Max Load (t)	Adjustables are usually used for bending thick materials or for bending large radii - because specific material specs vary we do not provide detailed bend data. Flaring or hole distortion is much reduced, but is influenced by material specification. Radius work is greatly affected by spring-back of the specific material being bent. Minimum flange sizes are greatly affected by the squareness of the component edge.
RVHD2	16 - 30 (.630-1.181")	150 (50tn/ft)	
RVHD2.5	28 - 69 (1.102-2.717")	200 (67tn/ft)	
RVHD3	38 - 110 (1.496-4.311")	250 (84tn/ft)	
RVHD4	69 - 220 (2.717-8.661")	350 (118tn/ft)	

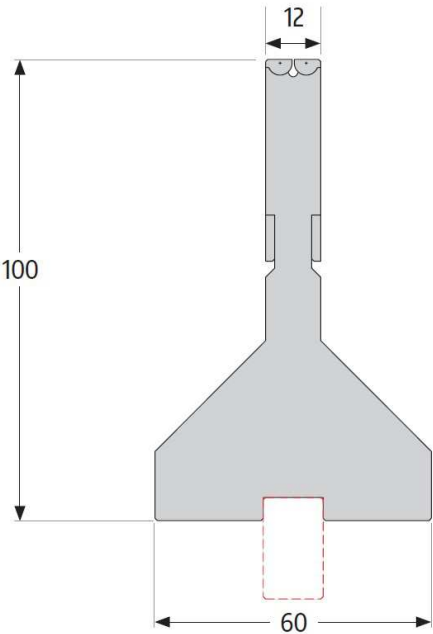
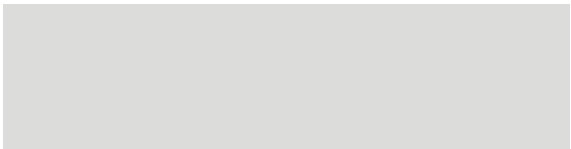
For thinner gauge material

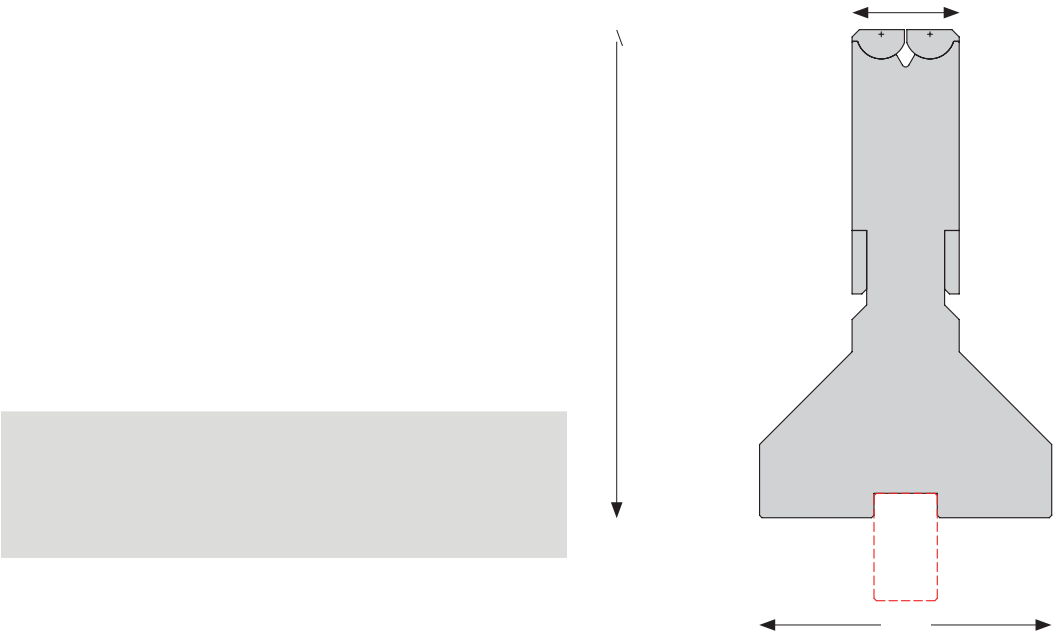
- Thickness
0.3mm - 1.2mm (.012-.047")
- Standard Lengths
50mm , 100mm, 200mm and 500mm
- Minimum Flange
3.2mm (.126")
- Maximum Capacity
50 Tonnes (55tn)

The latest addition to the Rolla-V family - The XT1 and XT2 are specifically made for thinner gauge material.

These tools are ideal for thin materials with short flanges or intricate components .

max. load capacity (t/m)	material thickness (mm)	min. bending angle	min. outside flange (mm)	max. outside radius (mm)





Model 1

Castellated inserts to give more contact area

Standard Lengths

500mm, 100mm and 440mm segmented

Segmented

440mm lengths include: 200mm, 100mm, 50mm, 30mm, 25mm, 20mm, 15mm

	max. load capacity (t/m)	material thickness (mm)	min. bending angle	min. outside flange (mm)	max. outside radius (mm)
Model 1 fixed style	100 (34tn/ft)	0.7 (.028")	40°	4.2 (.165")	3.0 (.118")
	100 (34tn/ft)	1.1 (.043")	35°	4.2 (.165")	2.6 (.102")
	100 (34tn/ft)	1.5 (.059")	35°	4.2 (.165")	2.2 (.087")

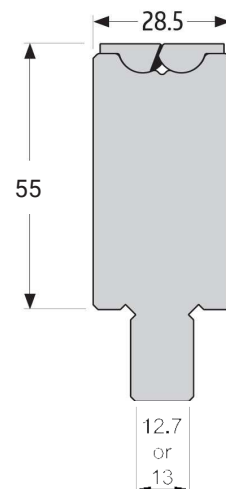
Equivalent V size 6.59mm (.259")

500mm	6.9 kg (15lbs)	500mm	6.3 kg (14lbs)
440mm segmented	6.1 kg (13lbs)	440mm segmented	5.8 kg (13lbs)
100mm	1.4 kg (3lbs)	100mm	1.3 kg (3lbs)

Model 1



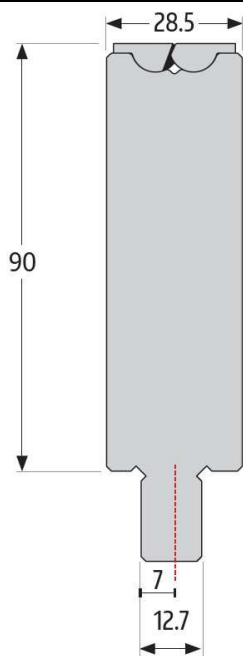
RVT55- 1



500mm
440mm segmented
100mm

5.5 kg (12lbs)
5.0 kg (11lbs)
1.1 kg (2lbs)

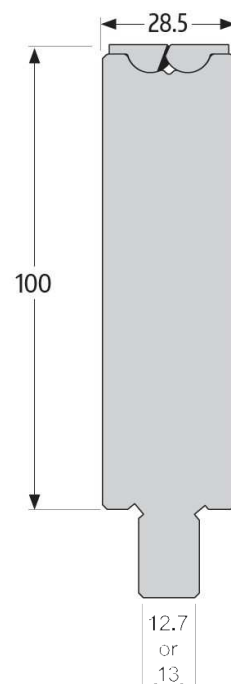
RVT90- 1



500mm
440mm segmented
100mm

8.5 kg (19lbs)
7.8 kg (17lbs)
1.7 kg (4lbs)

RVT100- 1



500mm
440mm segmented
100mm

9.4 kg (21lbs)
8.6 kg (19lbs)
1.8 kg (4lbs)

■ Standard Lengths

500mm, 250mm, 100mm and 450 segmented

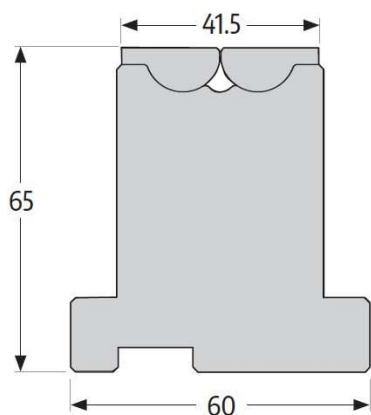
■ Segmented

450mm lengths include: 200mm, 100mm, 40mm, 35mm, 30mm, 25mm, 20mm

	max. load capacity (t/m)	material thickness (mm)	min. bending angle	min. outside flange (mm)	max. outside radius (mm)
Model 2 fixed style	150 (50tn/ft)	2.0 (.079")	59°	9.3 (.336")	6.0 (.226")
	150 (50tn/ft)	3.0 (.118")	47°	9.3 (.336")	5.0 (.197")
	150 (50tn/ft)	3.2 (.126")	47°	9.3 (.336")	4.8 (.189")

Equivalent V size 13.16mm (.518")

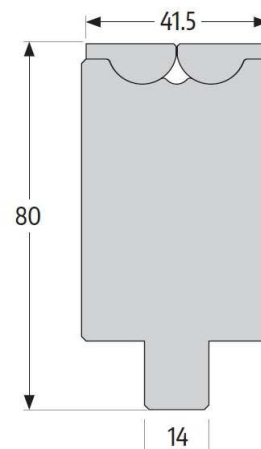
RVP65- 2



500mm
450mm segmented
100mm

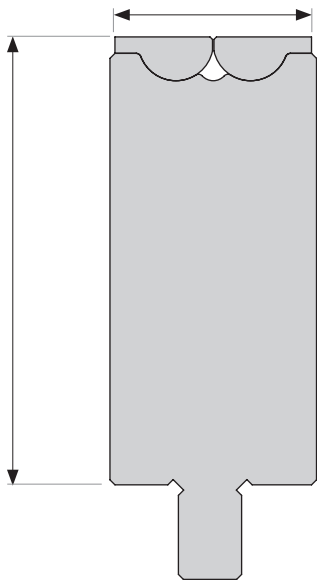
7.9 kg (17lbs)
7.4 kg (16lbs)
1.6 kg (4lbs)

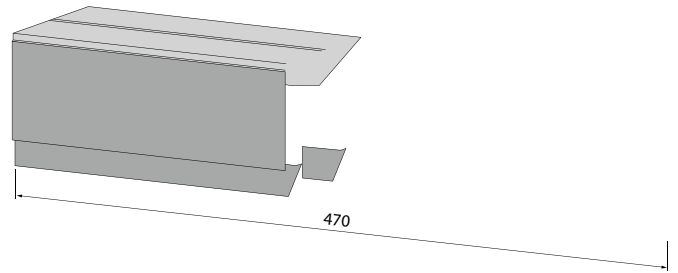
RVS80- 2



500mm
470mm segmented
100mm

8.3 kg (18lbs)
7.8 kg (17lbs)
1.7 kg (4lbs)





On-site

Demonstrations available



Model 3

	max. load capacity (t/m)	material thickness (mm)	min. bending angle	min. outside flange (mm)	max. outside radius (mm)
Model 3 Generation 1	250 (84tn/ft)	3.0 (.118")	75°	27.5 (1.082")	23.0 (.905")
	250 (84tn/ft)	4.0 (.157")	75°	27.5 (1.082")	22.0 (.866")
	250 (84tn/ft)	6.4 (.252")	75°	27.5 (1.082")	19.5 (.768")

500mm
455mm segmented

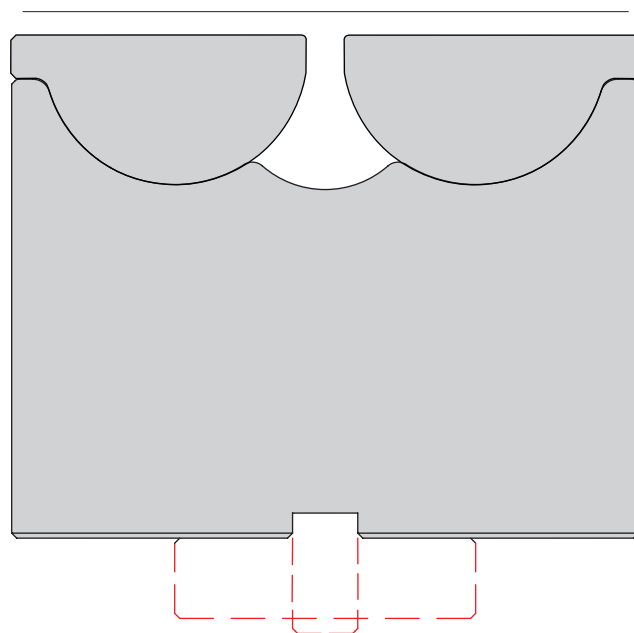
28.8 kg (63lbs)
26.2 kg (58lbs)

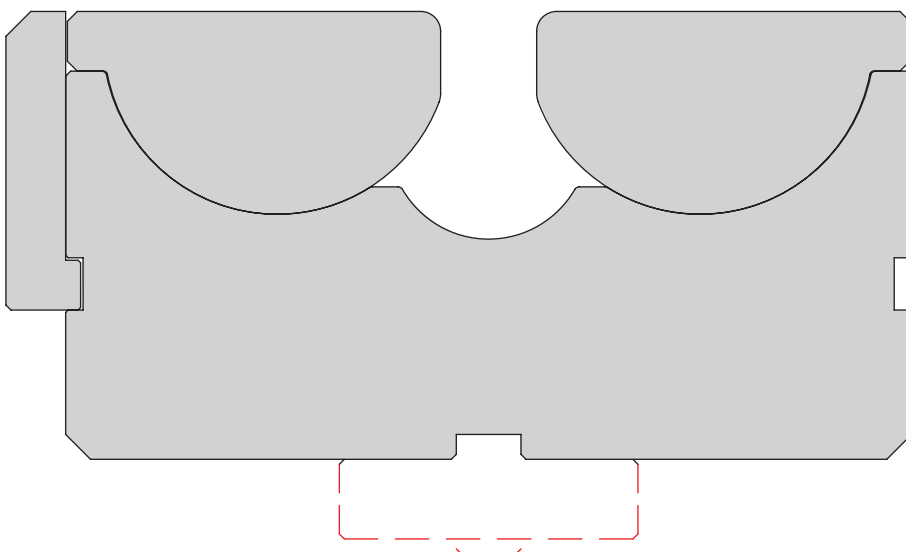
- **Standard Lengths**
500mm, 250mm and 455 segmented
- **Segmented**
455mm lengths include: 200mm, 100mm, 60mm, 50mm, 45mm
- **Tang Sizes - RVM70-3**
60mm, 13mm, 12.7mm, 12.7mm offset

	max. load capacity (t/m)	material thickness (mm)	min. bending angle	min. outside flange (mm)	max. outside radius (mm)
Model 3 Generation 2	250 (84tn/ft)	2.0 (.079")	68°	22.5 (.866")	13.9 (.547")
	250 (84tn/ft)	4.0 (.157")	50°	22.5 (.866")	11.9 (.469")
	250 (84tn/ft)	6.4 (.252")	50°	22.5 (.866")	9.5 (.374")

Equivalent V size 30.22mm (1.19")

500mm	28.8 kg (63lbs)	500mm	30.9 kg (68lbs)	500mm	20.6 kg (45lbs)
455mm segmented	26.2 kg (58lbs)	455mm segmented	28.5 kg (63lbs)	455mm segmented	18.7 kg (41lbs)
100mm	5.8 kg (13lbs)	100mm	6.2 kg (14lbs)	100mm	4.2 kg (9lbs)





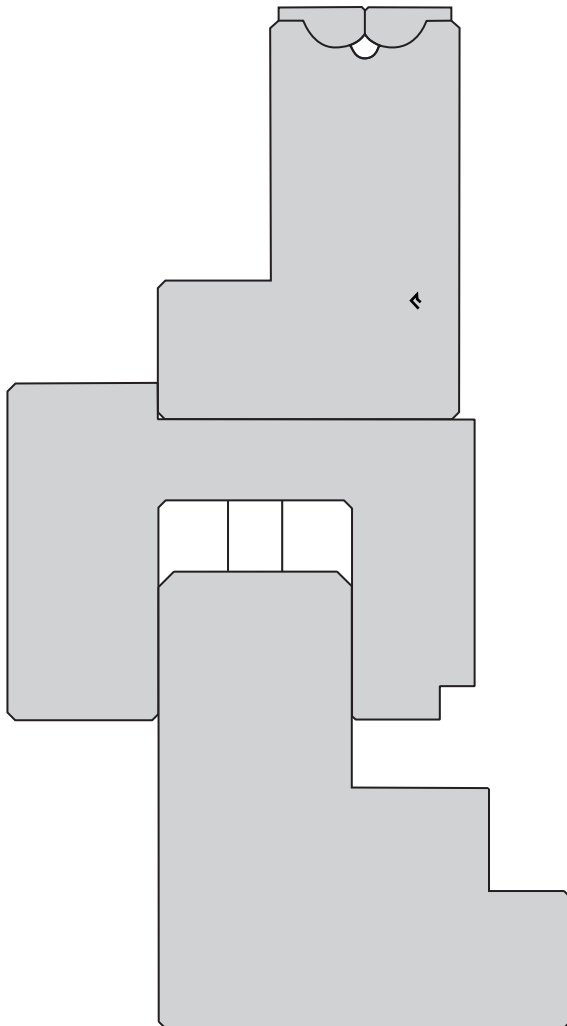
Hemming & Joggle (Z) Tools

- Achieve a small flange and minimize safety edge marking using the Rolla-V Hemming Tool
- Minimize Joggle Form marking
- Large range of Z folds available from one tool
- Contact us if you have special applications

These products are made to order your to specification.

Please call to discuss your individual requirements.

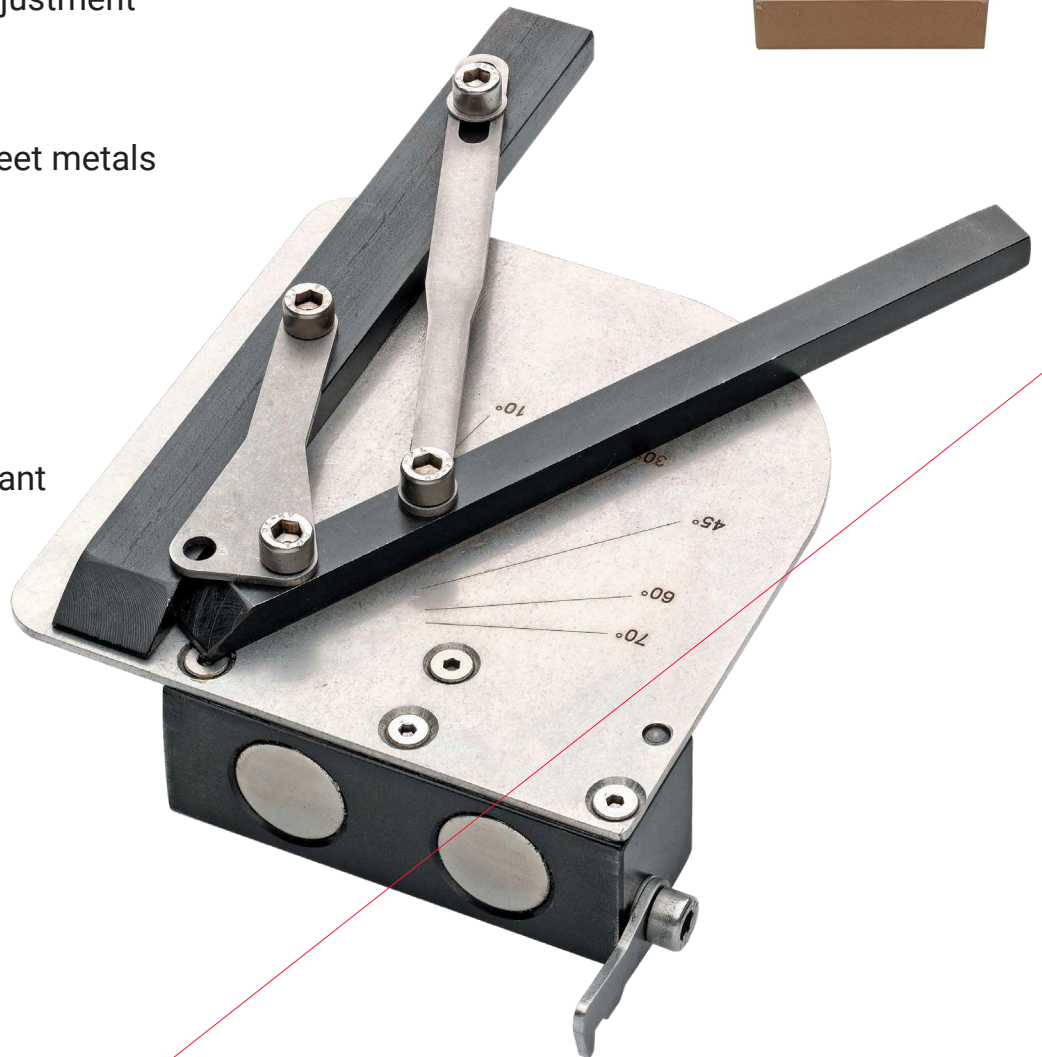
Hemming Tool



Adjustable Joggle

Squaring Arm

- Easy and fast positioning anywhere on the bottom dies
- Precise and flexible adjustability
- Adjustable angle stop/adjustment
- Mountable on all dies
- Ideal for long and thin sheet metals
- No obtrusive clamps
- Powerful magnets
- Laser marked angles
- Health and safety compliant



Non-standard lengths available to order

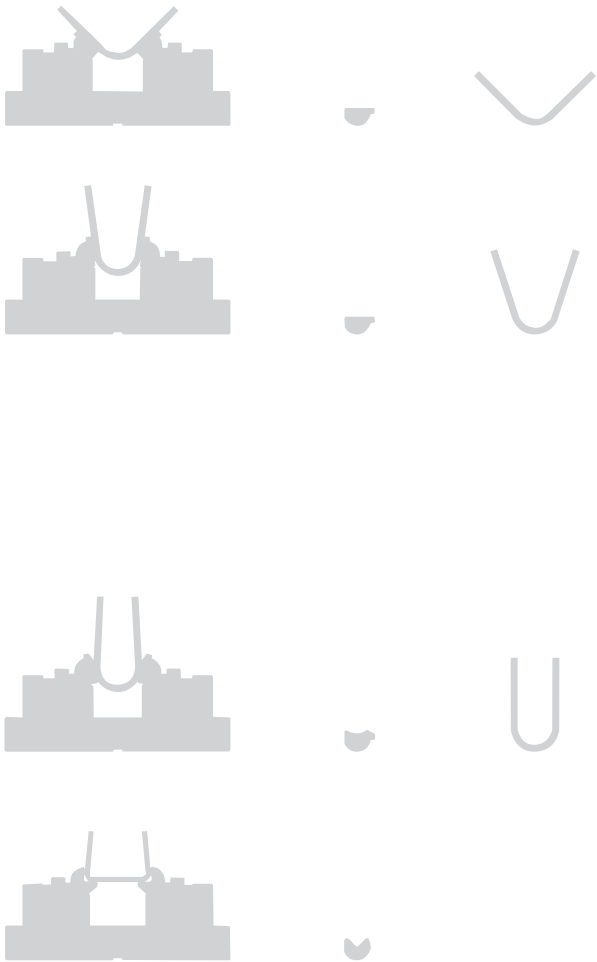
- Several fixed sizes are offered as well as adjustable models which are ideal for heavy plate or large radius work.
- Standard lengths 500mm and 250mm
- These tools are usually used for bending thicker materials or making large radius components.
- Specific material specifications vary greatly so it is not feasible to provide detailed data

eg. minimum flange sizes are greatly affected by squareness of component edge

eg. flaring or hole distortion is much reduced with these tools, but is influenced by specific material type

eg. radius work is greatly affected by springback of specific material and flange sizes

Please call us to discuss specific applications!

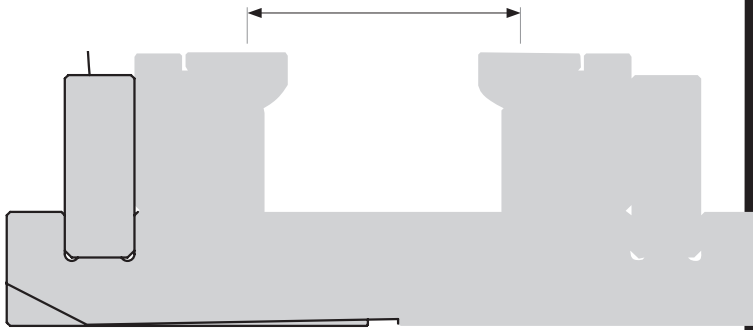


500mm 33.6 kg (74lbs)
250mm 16.8 kg (37lbs)

Maximum recommended thickness 5mm

500mm 67.5 kg (149lbs)
250mm 33.8 kg (75lbs)

Maximum recommended thickness 10mm



500mm	200.0 kg (441lbs)
250mm	100.0 kg (220lbs)

Maximum recommended thickness
30mm (1.181")

The world's first Modular
CNC Controlled, Pneumatic
Rolla-V Press Brake Tooling
Die, change the "V" size from
55mm wide up to 142mm with
a touch of one button.

Bend up to 20mm material.



This catalog illustrates our standard range of Rolla-V products.

If you do not see the product that you require, we can work together for a solution based on your specifications and needs.

Please call to discuss your individual requirements.

Call Us Today!

630.691.8665

Toll Free: 866.322.8665

Fax: 630.691.8667

Email: Sales@fabsupplyinc.com

WWW.FABSUPPLYINC.COM

About the company: Fab Supply is an ISO 9001 certified, full-service provider of press brake tooling and accessories. Products include precision ground tooling for all Trumpf, Bystronic, LVD and Amada Machines, Rolla-V, conventional tooling, adjustable press brake dies, tooling cabinets and safety products.

Fab Supply Inc.

2000 Bloomingdale Road, Unit 220

Glendale Heights IL 60139