

# Press Brake Tooling

## Rolla-V Product Range

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# 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.**

### ROLLA-V MATERIALS

Inserts	All models	Through hardened up to HRC60. 70 Rockwell available on request.
Body	All models	42CrMo4 tensile strength 1100-1200M/mm <sup>2</sup> surface hardened to HRC55

**Non-standard insert materials and HRC values are available for specific applications - please call us**

# 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

				A	B	C
	max. load capacity (t/ft)	material thickness (mm)	min. bending angle	tonnage required (t)	B min. outside flange (mm)	C max. outside radius
<b>XT1</b>	50 (17t/ft)	0.3 (.012")	60°	5.0 (6tn)	3.2 (.126")	2.2 (.087")
<b>Non-adjustable style</b> Max recommended thickness 1.2 mm	50 (17t/ft)	0.8 (.031")	60°	13.0 (14tn)	3.2 (.126")	2.2 (.087")
	50 (17t/ft)	1.2 (.047")	60°	30.0 (33tn)	3.2 (.126")	2.2 (.087")
<b>XT2</b>	70 (24t/ft)	0.5 (.020")	60°	5.0 (6tn)	6.1 (.240")	4.1 (.161")
<b>Non-adjustable style</b> Max recommended thickness 2.3 mm	70 (24t/ft)	1.0 (.039")	60°	10.0 (11tn)	6.1 (.240")	4.1 (.161")
	70 (24t/ft)	2.0 (.079")	60°	33.0 (36tn)	6.1 (.240")	4.1 (.161")
<b>Model 1</b>	100 (34t/ft)	0.7 (.028")	40°	5.0 (6tn)	4.2 (.165")	3.0 (.118")
<b>Non-adjustable style</b> Max recommended thickness 1.5 mm (2.0 mm thickness may be possible)	100 (34t/ft)	1.1 (.043")	35°	13.0 (14tn)	4.2 (.165")	2.6 (.102")
	100 (34t/ft)	1.5 (.059")	35°	27.0 (30tn)	4.2 (.165")	2.2 (.087")
<b>Model 2</b>	150 (50t/ft)	2.0 (.079")	59°	21.0 (23tn)	9.3 (.366")	6.0 (.236")
<b>Non-adjustable style</b> Max recommended thickness 3.0 mm (4.0 mm thickness may be possible)	150 (50t/ft)	3.0 (.118")	47°	55.0 (61tn)	9.3 (.366")	5.0 (.197")
	150 (50t/ft)	3.2 (.126")	47°	65.0 (72tn)	9.3 (.366")	4.8 (.189")
<b>Model 2.5</b>	250 (84t/ft)	2.0 (.079")	46°	10.0 (11tn)	18.6 (.732")	13.2 (.520")
<b>Non-adjustable style</b> Max recommended thickness 5.0 mm (6.0 mm may be possible)	250 (84t/ft)	4.0 (.157")	46°	47.0 (52tn)	18.6 (.732")	12.0 (.472")
	250 (84t/ft)	6.0 (.236")	55°	82.0 (90tn)	18.6 (.732")	10.8 (.425")
<b>Model 3</b>	250 (84t/ft)	2.0 (.079")	68°	7.0 (8tn)	22.5 (.886")	13.9 (.547")
<b>Non-adjustable style</b> Max recommended thickness 6.0mm (8.0 mm may be possible)	250 (84t/ft)	4.0 (.157")	47°	34.0 (38tn)	22.5 (.886")	11.9 (.469")
	250 (84t/ft)	6.0 (.236")	50°	90.0 (99tn)	22.5 (.886")	9.9 (.390")
<b>Model 3.5</b>	250 (84t/ft)	6.0 (.236")	75°	44.0 (49tn)	39.0 (1.535")	20.0 (.787")
<b>Non-adjustable style</b> Max recommended thickness 10 mm (12.0 mm thickness may be possible)	250 (84t/ft)	8.0 (.315")	75°	85.0 (94tn)	39.0 (1.535")	20.0 (.787")
	250 (84t/ft)	10.0 (.394")	75°	145.0 (160tn)	39.0 (1.535")	20.0 (.787")
<b>Model 4</b>	300 (101t/ft)	6.0 (.236")	78°	26.0 (29tn)	56.6 (2.228")	36.4 (1.433")
<b>Non-adjustable style</b> Max recommended thickness 16.0 mm	300 (101t/ft)	8.0 (.315")	76°	50.0 (55tn)	56.6 (2.228")	36.4 (1.433")
	300 (101t/ft)	12.0 (.472")	73°	129.0 (142tn)	56.6 (2.228")	36.4 (1.433")

Adjustable models	Min / Max (mm)	Max Load (t)
<b>RVHD2</b>	16 - 30 (.630-1.181")	200 (67t/ft)
<b>RVHD2.5</b>	28 - 69 (1.102-2.717")	250 (84t/ft)
<b>RVHD3</b>	38 - 110 (1.496-4.311")	350 (118t/ft)
<b>RVHD4</b>	69 - 220 (2.717-8.661")	350 (118t/ft)

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.

## For thinner gauge material

- Thickness  
0.3mm - 1.2mm (.012-.047")
- Standard Lengths  
50mm , 100mm, 200mm and 500mm
- Minimum Flange  
2.7mm (.106")
- Maximum Capacity  
50 Tonnes (55tn)

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

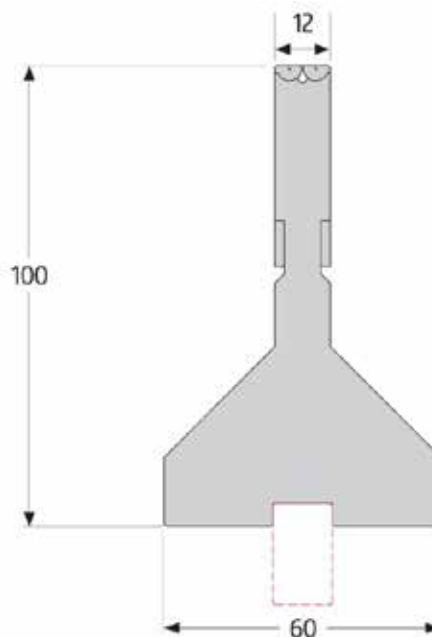
These tools are ideal for thin materials with short flanges or intricate components .

	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
Model XT1 fixed style	50 (17t/ft)	0.3 (.012")	60°	5.0 (6tn)	3.2 (.126")	2.2 (.087")
	50 (17t/ft)	0.8 (.031")	60°	13.0 (14tn)	3.2 (.126")	2.2 (.087")
	50 (17t/ft)	1.2 (.047")	60°	30.0 (33tn)	3.2 (.126")	2.2 (.087")

Max. recommended thickness = 1.2mm (.047")

Equivalent V size 4.5mm (.177")

## XT1



500mm	5.5 kg (12lbs)
100mm	1.0 kg (2lbs)

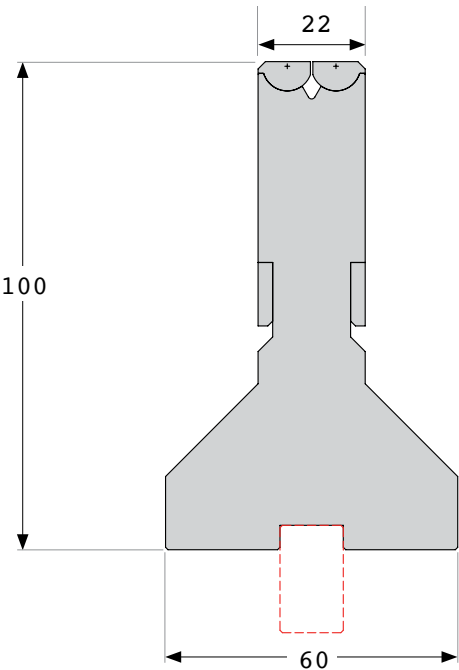
For thinner gauge material

- Thickness  
0.5mm - 2.3mm (.020-.091")
- Standard Lengths  
50mm , 100mm, 200mm and 500mm
- Minimum Flange  
4.9mm (.193")
- Maximum Capacity  
70 Tonnes (77tn)



	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
Model XT2 fixed style	70 (24t/ft)	0.5 (.020")	60°	5.0 (6tn)	6.1 (.240")	4.1 (.161")
	70 (24t/ft)	1.0 (.039")	60°	10.0 (11tn)	6.1 (.240")	4.1 (.161")
	70 (24t/ft)	2.0 (.079")	60°	33.0 (36tn)	6.1 (.240")	4.1 (.161")

Max. recommended thickness = 2.3mm (.091")  
Equivalent V size 8.6mm (.339")



500mm	8.0 kg (18lbs)
100mm	1.6 kg (4lbs)

# Model 1

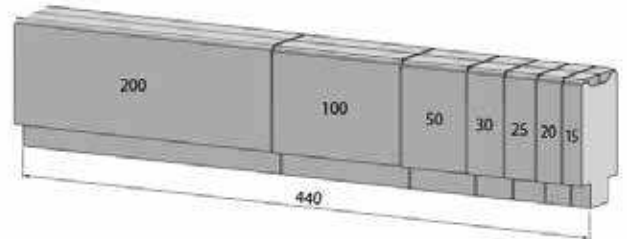
■ Castellated inserts to give more contact area

■ **Standard Lengths**

500mm, 100mm and 440mm segmented

■ **Segmented**

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

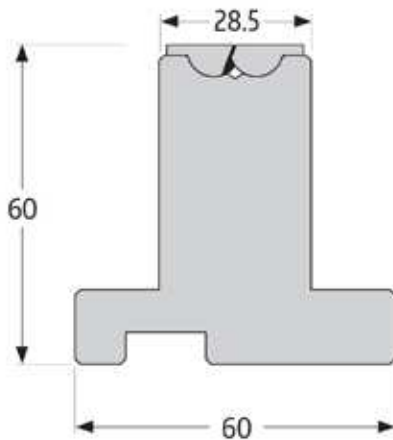


	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
<b>Model 1 fixed style</b>	100 (34t/ft)	0.7 (.028")	40°	5.0 (6tn)	4.2 (.165")	3.0 (.118")
	100 (34t/ft)	1.1 (.043")	35°	13.0 (14tn)	4.2 (.165")	2.6 (.102")
	100 (34t/ft)	1.5 (.059")	35°	27.0 (30tn)	4.2 (.165")	2.2 (.087")

Max. recommended thickness = 1.5mm (2.0mm thickness may be possible) (.059", .079" may be possible)

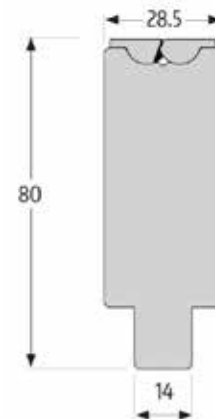
Equivalent V size 7mm (.276")

## RVP60- 1



500mm 6.9 kg (15lbs)  
 440mm segmented 6.1 kg (13lbs)  
 100mm 1.4 kg (3lbs)

## RVS80- 1

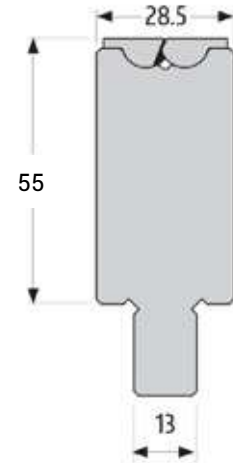


500mm 6.3 kg (14lbs)  
 440mm segmented 5.8 kg (13lbs)  
 100mm 1.3 kg (3lbs)

# Model 1



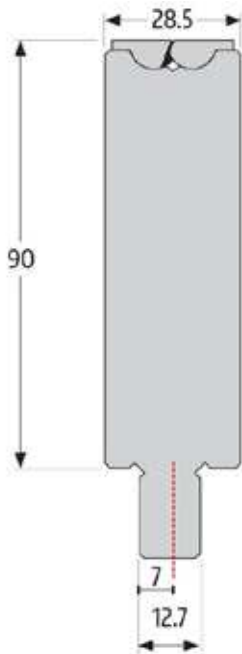
RVT55- 1



500mm  
440mm segmented  
100mm

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

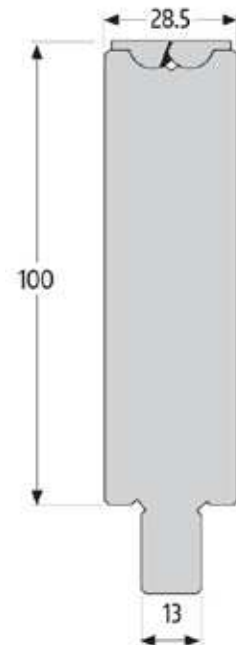
RVT90- 1



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)



# Model 2

## ■ Standard Lengths

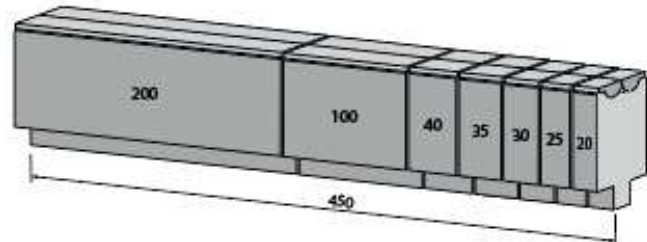
500mm, 250mm, 100mm and 450 segmented

## ■ Segmented

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

## ■ Segmented

'Upgrade Kit' available - segments at 25mm, 45mm and 50mm

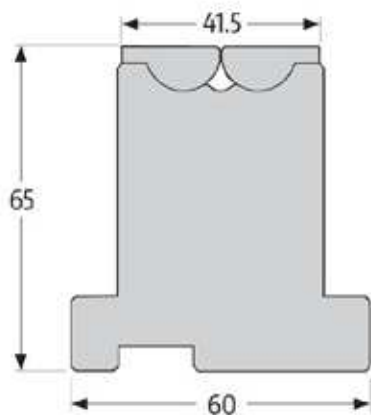


	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
<b>Model 2</b> <b>fixed style</b>	150 (50t/ft)	2.0 (.079")	59°	21.0 (23tn)	9.3 (.336")	6.0 (.226")
	150 (50t/ft)	3.0 (.118")	47°	55.0 (61tn)	9.3 (.336")	5.0 (.197")
	150 (50t/ft)	3.2 (.126")	47°	65.0 (72tn)	9.3 (.336")	4.8 (.189")

Max. recommended thickness = 3.0mm (4.0mm thickness may be possible) (.118", .157" may be possible)

Equivalent V size 13mm (.512")

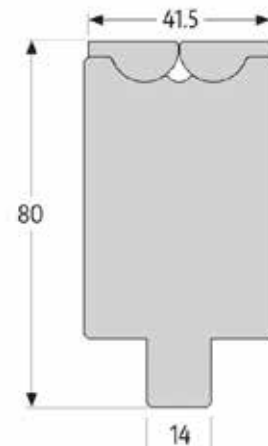
## RVP65- 2



500mm  
450mm segmented  
100mm

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

## RVS80- 2



500mm  
470mm segmented  
100mm

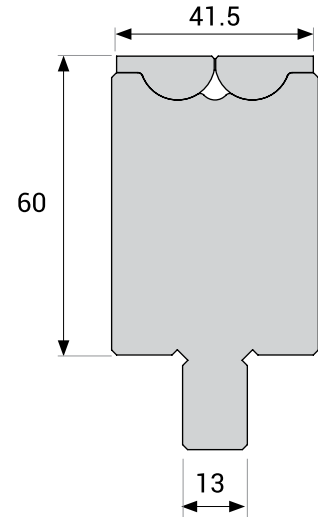
8.3 kg (18lbs)  
7.8 kg (17lbs)  
1.7 kg (4lbs)



# Model 2

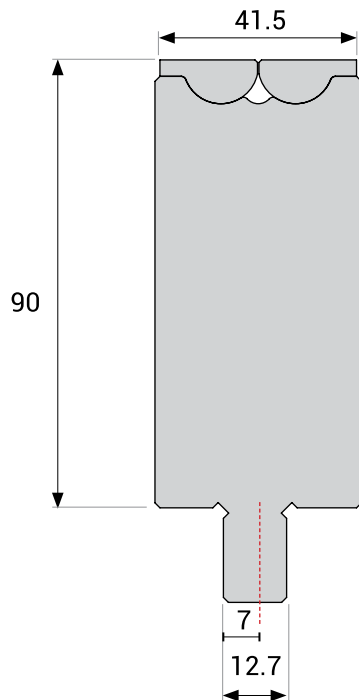


**RVT60- 2**



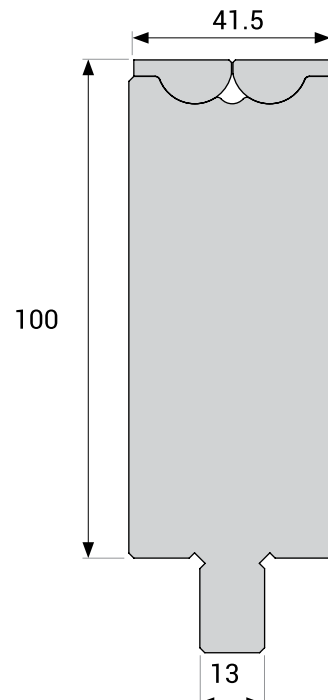
500mm	7.9 kg (17lbs)
450mm segmented	7.4 kg (16lbs)
100mm	1.6 kg (4lbs)

**RVT90- 2**



500mm	11.3 kg (25lbs)
450mm segmented	10.6 kg (23lbs)
100mm	2.2 kg (5lbs)

**RVT100- 2**



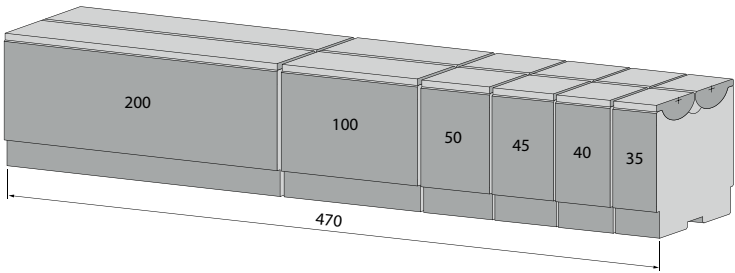
500mm	12.4 kg (27lbs)
450mm segmented	11.7 kg (26lbs)
100mm	2.5 kg (6lbs)

# Model 2.5

■ **Standard Lengths**  
500mm, 250mm and 470mm segmented

■ **Segmented**  
470mm lengths include: 200mm, 100mm, 50mm, 45mm, 40mm, 35mm

■ **Segmented**  
'Upgrade Kit' available - segments at 25mm, 30mm and 45mm



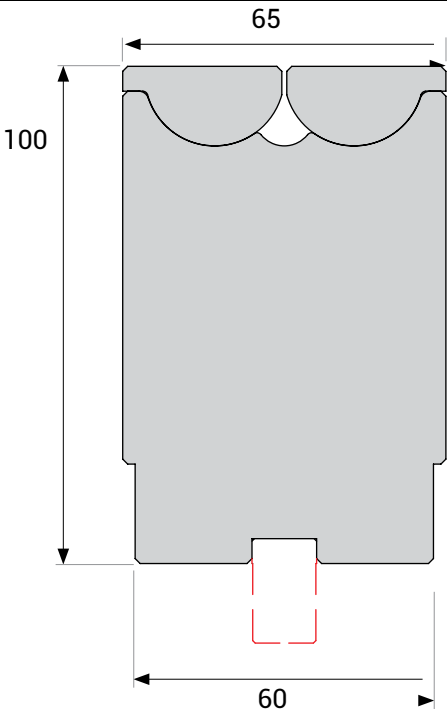
Optional inserts can be hardened up to 70 HRC on request

	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
Model 2.5 fixed style	250 (84t/ft)	2.0 (.079")	46°	10.0 (11tn)	18.6 (.732")	13.2 (.520")
	250 (84t/ft)	4.0 (.157")	46°	47.0 (52tn)	18.6 (.732")	12.0 (.472")
	250 (84t/ft)	6.0 (.236")	55°	82.0 (90tn)	18.6 (.732")	10.8 (.425")

Max. recommended thickness = 5.0mm (6.0mm thickness may be possible) (.197", .236" may be possible)  
Equivalent V size 25mm (.984")

## RVM- 2.5

Available with any  
base or Tang Fitting



500mm  
470mm segmented  
100mm

22.0 kg (48lbs)  
21.0 kg (46lbs)  
4.4 kg (10lbs)

## Model 2.5



# On-site

Demonstrations available



You will be able to test our tools on site and find out exactly how our range can work for you. For more details please call us at 866.322.8665

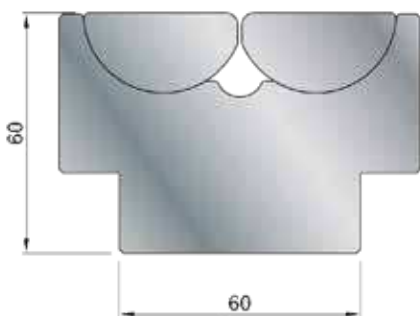
# Model 3



## Generation 1

- Maximum material thickness: 8.0mm (.315")
- Maximum outside radius @ 90°: 23mm (.906")
- Maximum outside flange: 24.3mm (.956")
- Maximum bend angle (included): 75°
- Tonnage capacity: 250t/m (84t/ft)

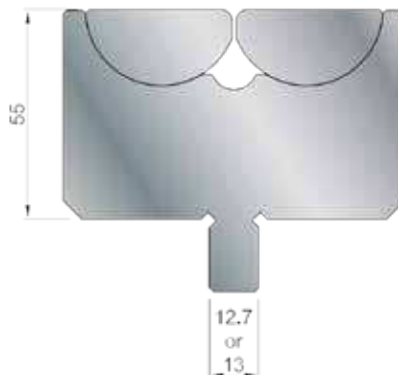
RVP60



500mm  
455mm segmented

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

RVT55



500mm  
455mm segmented

20.6 kg (45lbs)  
18.7 kg (41lbs)

RVT100



500mm  
455mm segmented

30.9 kg (68lbs)  
28.5 kg (63lbs)

# Model 3

## Standard Lengths

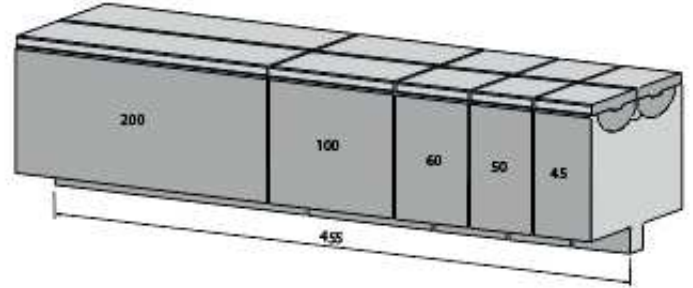
500mm, 250mm and 455 segmented

## Segmented

455mm lengths include: 200mm, 100mm, 60mm, 50mm, 45mm

## Tang Sizes - RVM70-3

60mm, 13mm, 12.7mm, 12.7mm offset



Optional inserts can be hardened up to 70 HRC on request

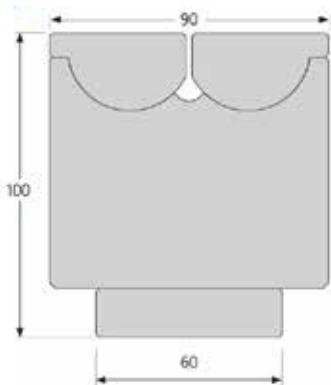
	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
Model 3 fixed style	250 (84t/ft)	2.0 (.079")	68°	7.0 (8tn)	22.5 (.866")	13.9 (.547")
	250 (84t/ft)	4.0 (.157")	47°	34.0 (38tn)	22.5 (.866")	11.9 (.469")
	250 (84t/ft)	6.0 (.236")	50°	90.0 (99tn)	22.5 (.866")	9.9 (.390")

Max. recommended thickness = 6.0mm (8.0mm thickness may be possible) (.236", .315" may be possible)

Equivalent V size 30mm (1.181")

## Generation 2

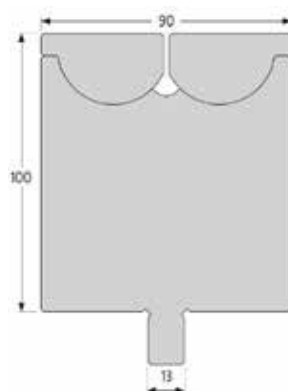
### RVP100- 3



500mm  
455mm segmented  
100mm

28.8 kg (63lbs)  
26.2 kg (58lbs)  
5.8 kg (13lbs)

### RVT100- 3

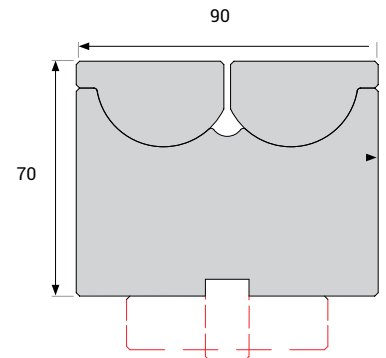


500mm  
455mm segmented  
100mm

30.9 kg (68lbs)  
28.5 kg (63lbs)  
6.2 kg (14lbs)

### RVM70-3

Available with any  
base or Tang Fitting



500mm  
455mm segmented  
100mm

20.6 kg (45lbs)  
18.7 kg (41lbs)  
4.2 kg (9lbs)

# Model 3.5

■ **Tang Fittings**  
Available to suit all manufacturers' machines

■ **Standard Lengths**  
500mm and 250mm

■ **Tang Sizes**  
60mm, 13mm, 12.7mm, 12.7mm offset



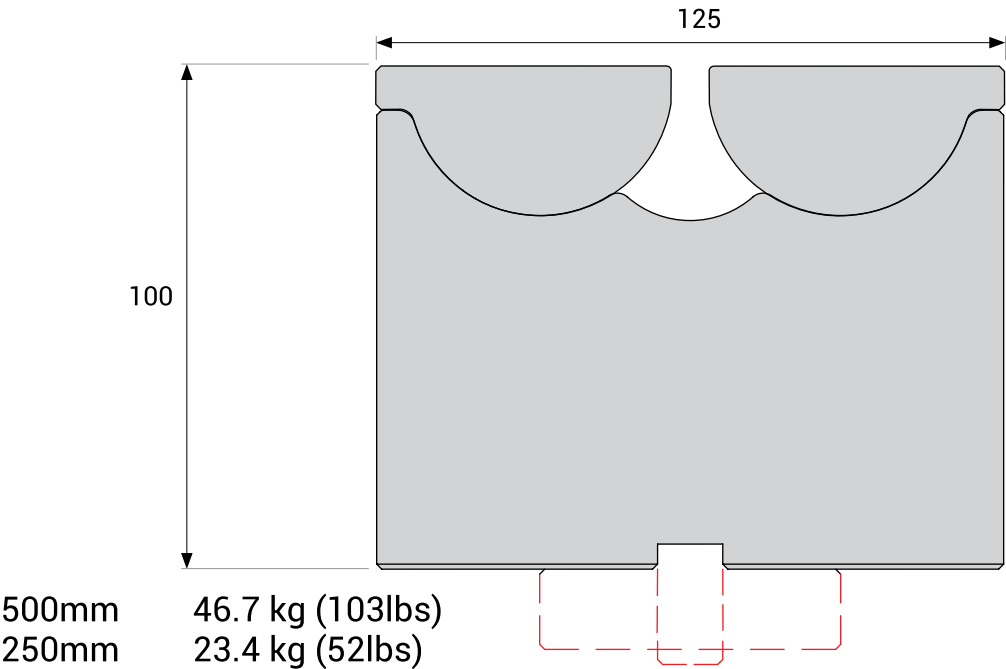
Optional inserts can be hardened up to 70 HRC on request

	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
Model 3.5 fixed style	250 (84t/ft)	6.0 (.236")	75°	44.0 (49tn)	39.0 (1.535")	20.0 (.787")
	250 (84t/ft)	8.0 (.315")	75°	85.0 (94tn)	39.0 (1.535")	20.0 (.787")
	250 (84t/ft)	10.0 (.394")	75°	145.0 (160tn)	39.0 (1.535")	20.0 (.787")

Max. recommended thickness = 10.0mm (12.0mm thickness may be possible) (.394", .472" may be possible)  
Equivalent V size 55mm (2.165")

## RVM- 3.5

Available with any  
base or Tang Fitting





# Model 4

## ■ Tang Fittings

Available to suit all manufacturers' machines

## ■ Standard Lengths

500mm and 250mm

## ■ Tang Sizes

60mm, 13mm, 12.7mm, 12.7mm offset

Optional inserts can be hardened up to 70 HRC on request



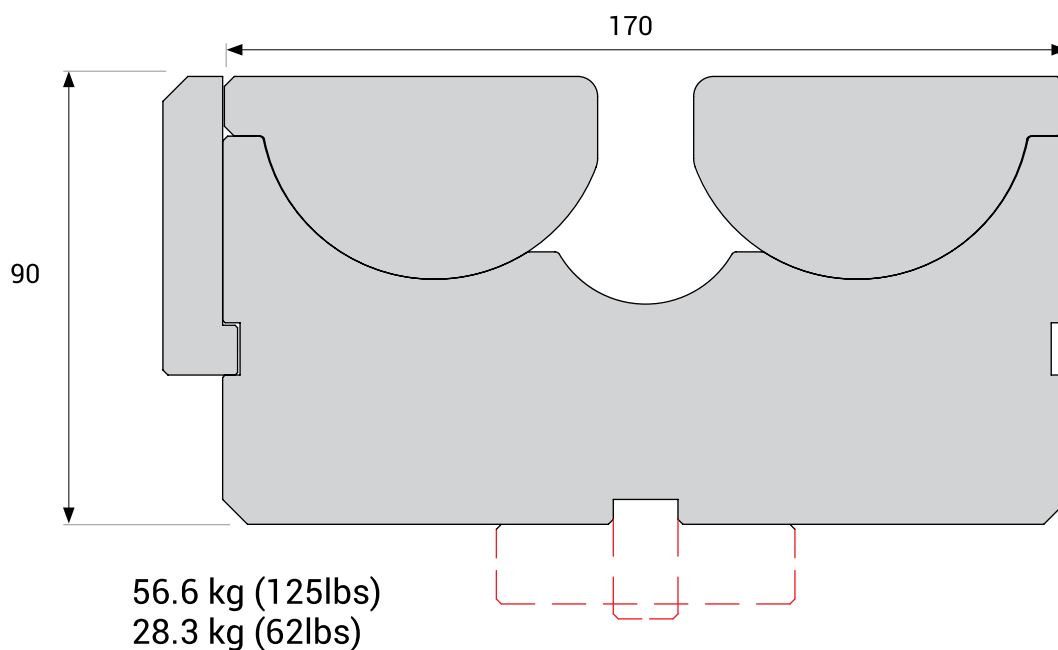
	max. load capacity (t/m)	material thickness (mm)	min. bending angle	tonnage required (t)	min. outside flange (mm)	max. outside radius
Model 4 fixed style	300 (101t/ft)	6.0 (.236")	78°	26.0 (29tn)	56.6 (2.228")	36.4 (1.433")
	300 (101t/ft)	8.0 (.315")	76°	50.0 (55tn)	56.6 (2.228")	36.4 (1.433")
	300 (101t/ft)	12.0 (.472")	73°	129.0 (142tn)	56.6 (2.228")	36.4 (1.433")

Max. recommended thickness = 16.0mm (.630")

Equivalent V size 76mm (2.992")

## RVM90- 4

Available with any base or Tang Fitting



500mm  
250mm

56.6 kg (125lbs)  
28.3 kg (62lbs)

Please remember to order your required Tang.



# Applications

## Special Rolla-V range

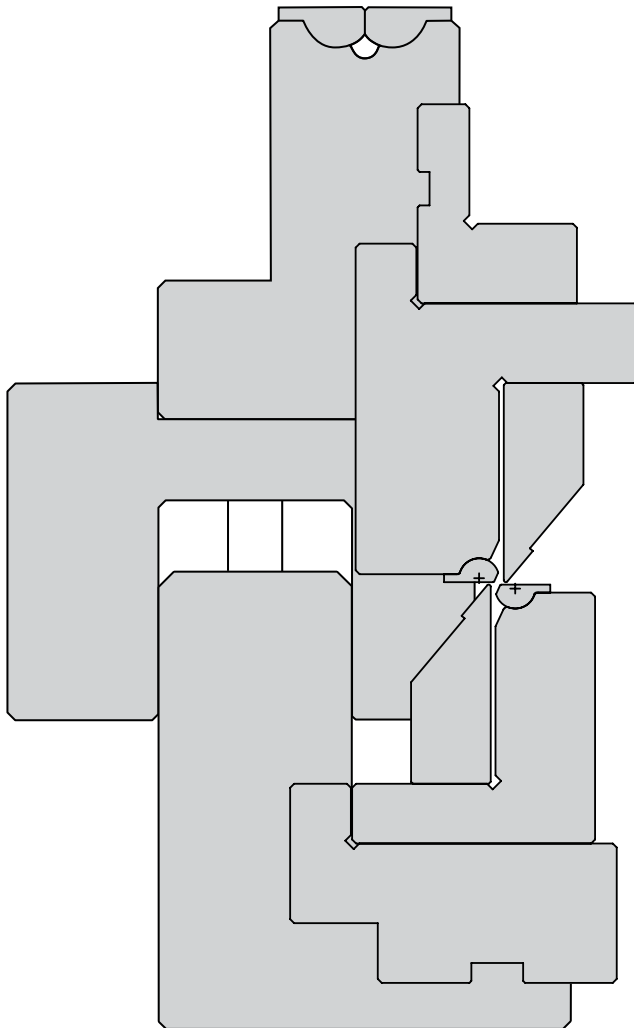
### Hemming & Joggle (Z) Tools

- 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

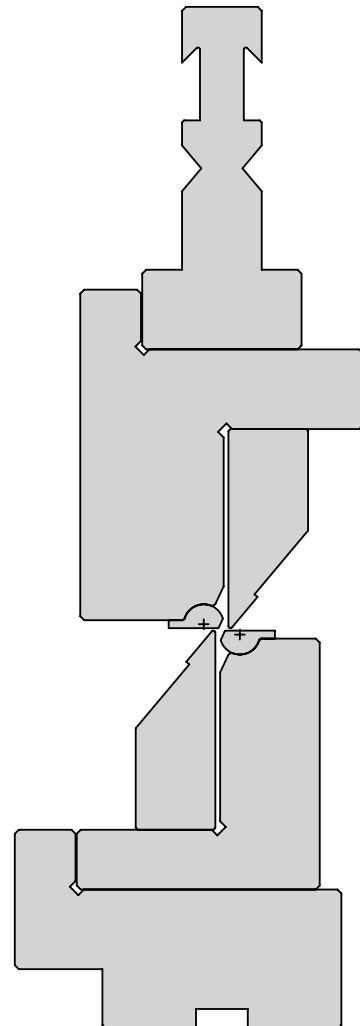
**These products are made to order your to specification.**

**Please call to discuss your individual requirements.**

**Hemming Tool**



**Adjustable Joggle**



# Squaring Arm

## Magnetic

- 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



# Adjustable

## Rolla-V Range

### Non-standard lengths available to order

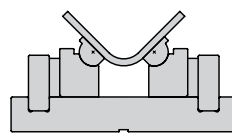
- Several fixed sizes are offered as well as adjustable models which are ideal for heavy plate or large radius work.
- Standard lengths 500mm and 250mm
- These tools are usually used for bending thicker materials or making large radius components.
- Specific material specifications vary greatly so it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

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

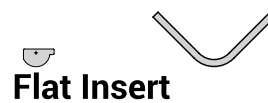
eg. flaring or hole distortion is much reduced with these tools, but is influenced by specific material type

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

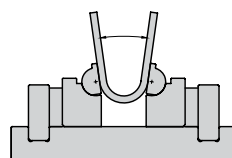
**Please call us to discuss specific applications!**



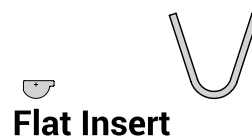
**V-Bending**



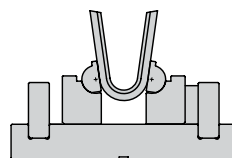
**Flat Insert**



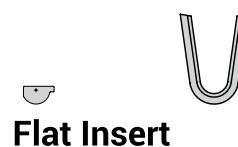
**Radius Bending**



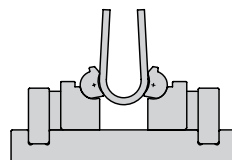
**Flat Insert**



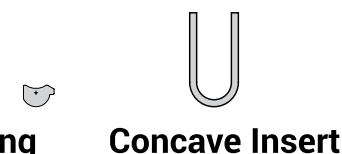
**Conical Bending**



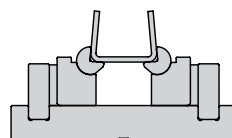
**Flat Insert**



**Radius Overbending**



**Concave Insert**

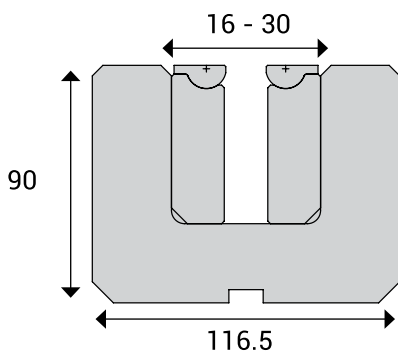


**U-Bending**



**V-Insert**

### RVHD2

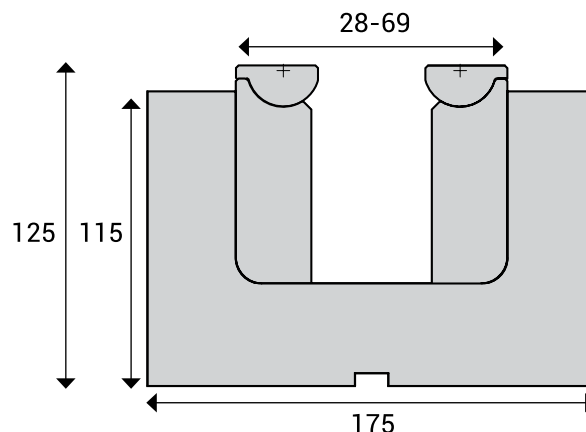


500mm  
250mm

33.6 kg (74lbs)  
16.8 kg (37lbs)

Maximum recommended thickness 5mm

### RVHD2.5



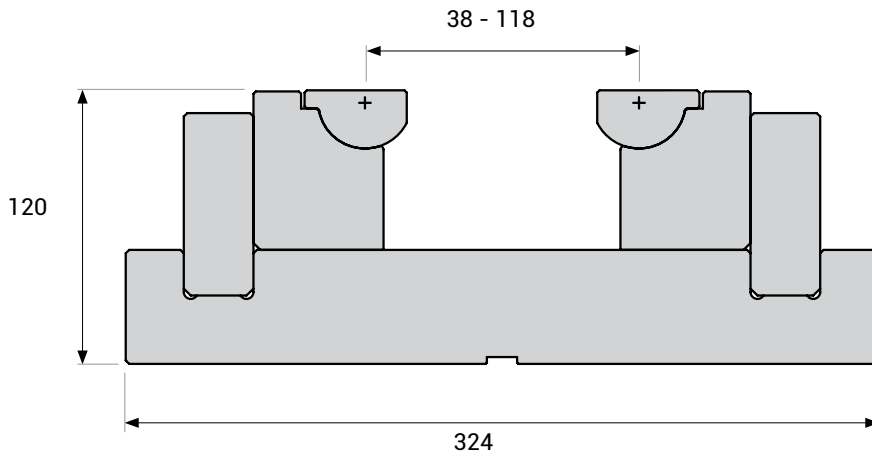
500mm  
250mm

67.5 kg (149lbs)  
33.8 kg (75lbs)

Maximum recommended thickness 10mm

# Adjustable

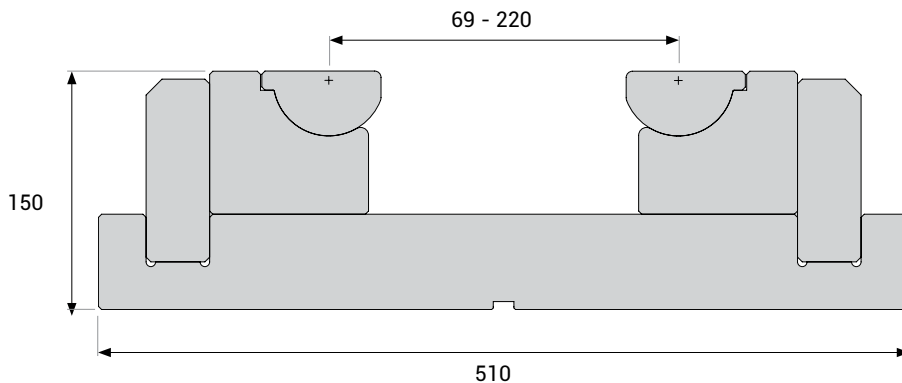
## Rolla-V Range



### RVHD3

500mm	98.0 kg (216lbs)
250mm	49.0 kg (108lbs)

Maximum recommended thickness  
20mm (.787")



### RVHD4

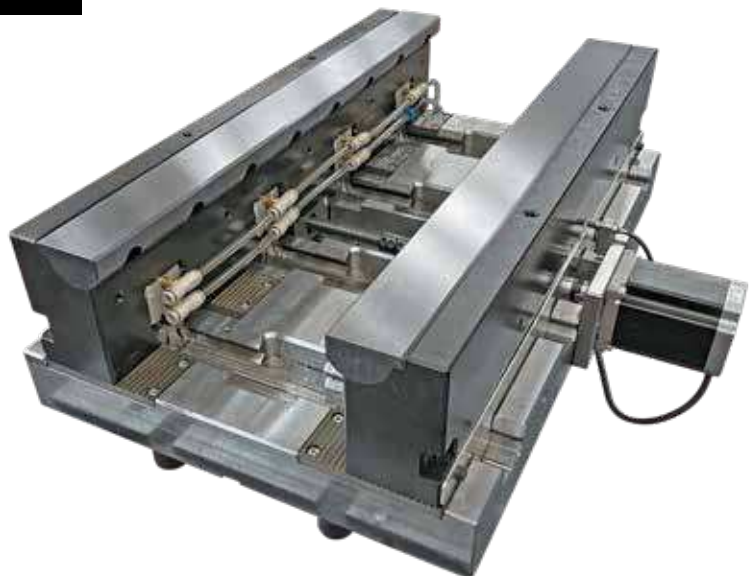
500mm	200.0 kg (441lbs)
250mm	100.0 kg (220lbs)

Maximum recommended thickness  
30mm (1.181")

## Modular CNC Controlled Rolla-V

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](mailto:Sales@fabsupplyinc.com)

**[WWW.FABSUPPLYINC.COM](http://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.**

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