

Precision Ground and Hardened
Press Brake Tooling

American Style

FAB
SUPPLY
INCORPORATED



American Style Press Brake Tooling

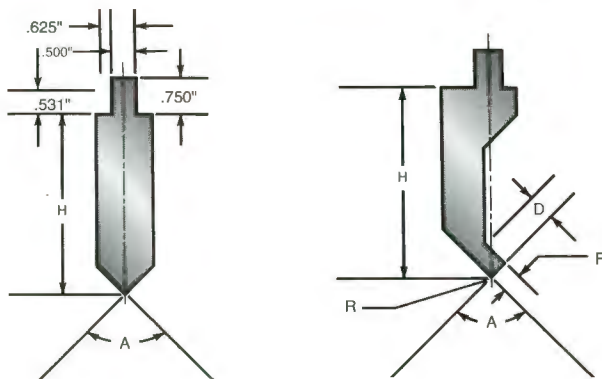
FAB SUPPLY's precision ground American style press brake tooling is designed to meet the exacting needs of today's high precision metal fabricator.

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

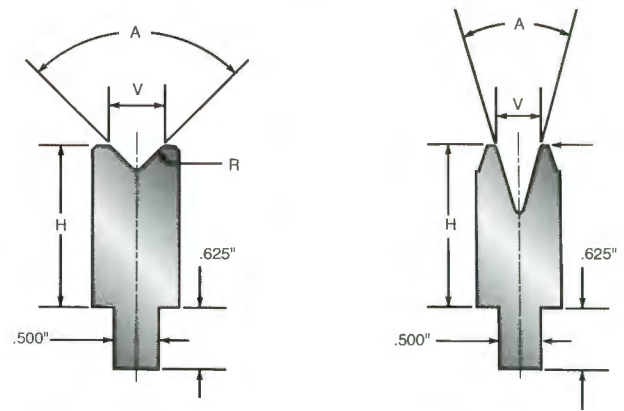
The critical tolerances of all tools are precision ground to within ± 0.0008 in. In addition, to ensure long lasting accuracy, this high quality tool steel is induction hardened to 50-56 HRC on all working surfaces. Available sectionalized as well as in standard lengths of 36 and 18 inches, this tooling 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.

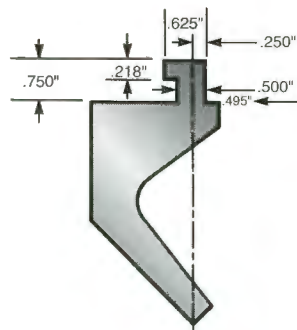
Punch Dimensions



Die Dimensions



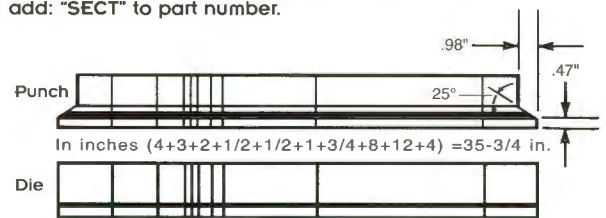
Safety Tang



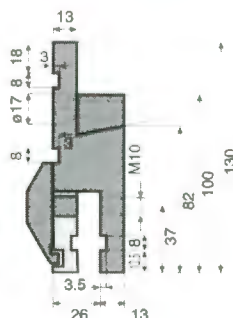
All punches are available with safety tang at no extra charge. Please specify safety tang or straight tang when ordering.

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 Holder

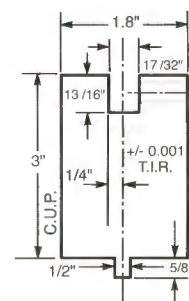


INT. AM/100

Protect your machine tool and increase its versatility.

Moveable clamp plate enables your European press brake to accept American and European style tooling.

Precision Ground Die Holder



88° and 90° Punches



EP1
H = 3.779
A = 90°
R = .010

22-16 GA.



EP2-90
H = 3.779
A = 90°
R = .060

16-11 GA.

EP2-88
H = 3.779
A = 88°
R = .060



EP1A-90
H = 3.779
A = 90°
R = .010

22-16 GA.

EP1A-88
H = 3.779
A = 88°
R = .010



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

20 GA.



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

18 GA.

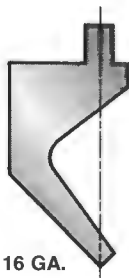
EGPB-88
H = 3.779
A = 88°
D = .551
F = .375
R = .015



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

14 GA.

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



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

16 GA.

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

88° and 90° Lower Dies



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

20 GA.



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

18 GA.

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



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

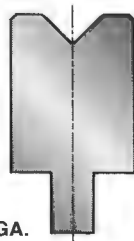
16 GA.



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

14 GA.

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



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

13 GA.

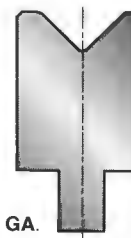
ELD88-3/4
H = 1.937
A = 88°
V = .750
R = .150



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

12 GA.

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



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

11 GA.

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

Acute Punches



EP28
H = 3.779
A = 28°
R = .030

22-16 GA.



EP30
H = 3.779
A = 30°
R = .060

14-11 GA.



EGP28
H = 5.125
A = 28°
R = .030

22-16 GA.

Acute Lower Dies



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

20 GA.



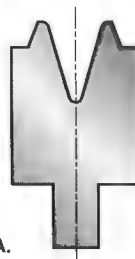
ELD30-3/8
H = 1.937
A = 30°
V = .375
R = .045

18 GA.



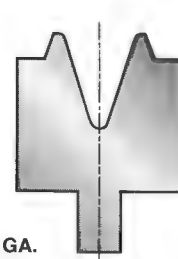
ELD30-1/2
H = 1.937
A = 30°
V = .500
R = .045

16 GA.



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

14 GA.



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

12 GA.

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 5/32"	6mm 1/4"	7mm 9/32"	8mm 5/16"	10mm 3/8"	12mm 1/2"	14mm 9/16"	16mm 5/8"	18mm 11/16"	20mm 3/4"	25mm 1"	32mm 1-1/4"	40mm 1-1/2"	50mm 2"	63mm 2-1/2"	80mm 3"	100mm 4"	125mm 5"	160mm 6"	200mm 8"	250mm 10"
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
GAUGE	Tons required per linear foot using air bend dies with these "V" die openings																				
DECIMAL																					
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																	59.9	39.9	31.9	22.1

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

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