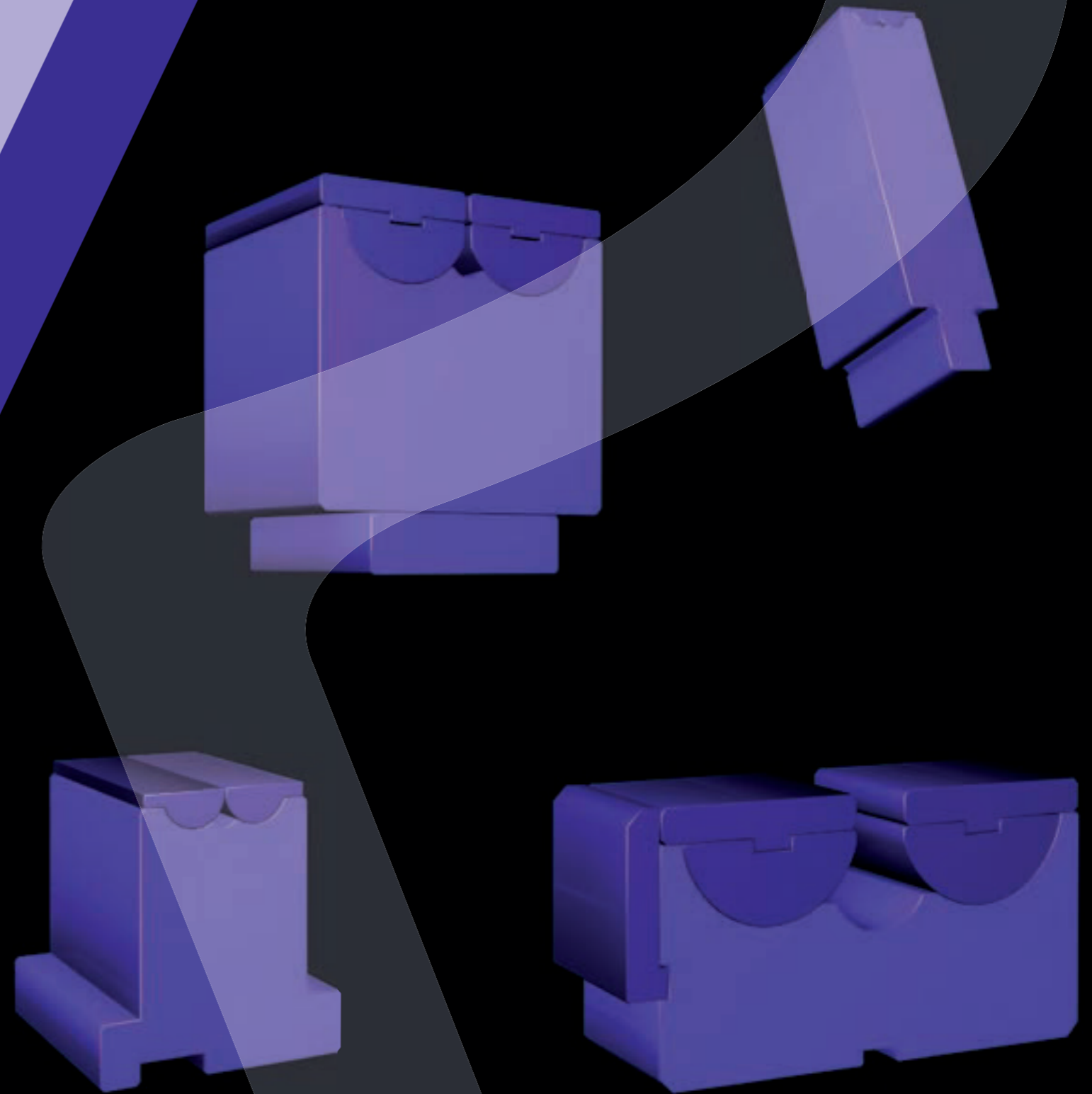


ROLLERI DIES ROLLA-V

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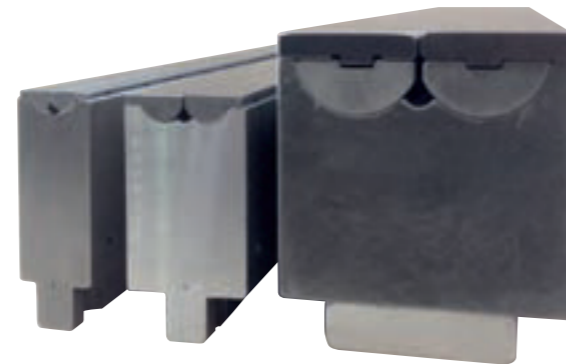


Compatibility

- RVP Dies (Models 1, 2, 3) are compatible with press brake machines (60 mm / 2.36 in die holder) from: ACL, Accurpress, Amada, Atlantic, Adira, Baykal, BL, Boutillon, Bystronic-Beyeler Euro-B, Coastone, Colgar, Dener, Durmazlar, Ermaksan, Farina, Gade, Gasparini, Gizelis, Haco, Hindustan, Iturrospe, Jfy, LFK, MVD, Newton, Prima Power, Promecam, Rico, Salvagnini, Schiavi, SMD, Sorg, Somo, Vimercati, Warcom, Yangli, Yawei, Ysd, etc.
- RVS Dies (Models 1, 2, 3) are compatible with press brake machines (14 mm / 0.55 in pins) from: Amada Single V style
- RVT Dies (Models 1, 2, 3) are compatible with press brake machines (12.7 mm / 0.50 in / 13 mm / 0.51 in pins) from: Bystronic, Hämmerle, Beyeler, Edwards, Safan, SMD, Trumpf
- RVT90 Dies (Models 1, 2, 3) are compatible with press brakes machines (12.7 mm / 0.50 in pins) from: LVD
- RVM Dies (Models 2.5, 3, 4) are compatible with all press brake machines (various die holders)
- all dies are compatible on other press brakes machines with the means of adapter-systems or customized die holders.

Our Advantages – Your Convenience

- high precision grounded
- Interchangability guaranteed
- exact Parallelism
- avoiding bending marks on the sheet metals
- minimum borders bending mark free
- no tool contamination throughout the bending of galvanized sheet metal or aluminum
- extremely short flanges
- less tool exchange
- ideal for diagonal or tapered edges



Material

The raw material is obtained from qualified suppliers which compose the chemical formulas according to international standards. Therefore, guaranteeing high resilience and tensile strength.

	Model	Material Type	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
Body	1 / 2 / 2.5 / 3 / 4	42CrMo4	1100-1200 N/mm ²	50 - 55 HRC
Inserts	1	Toolox 44	1450 N/mm ²	through hardened 44 HRC
Inserts	2 / 2.5 / 3 / 4	Toolox 33	1100 N/mm ²	55 - 58 HRC

• Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN.**

	Equivalent V size mm (in)	Material Thickness mm (in)	min. outside flange mm (in)	needed press force (kN)	max. tool load (kN/m)	min. bending angle
Model 1 Max. recommended thickness = 1.5 mm (0.06 in) (2.0 mm / 0.08 in possible)	8 (0.31)	0.70 (0.03)	3.0 (0.12)	60	1000	40°
		1.10 (0.04)	3.9 (0.15)	110	1000	35°
		1.50 (0.06)	4.2 (0.17)	260	1000	35°
Model 2 Max. recommended thickness = 3.0 mm (0.12 in) (4.0 mm / 0.15 in possible)	15 (0.59)	2.00 (0.08)	8.5 (0.33)	200	1500	59°
		3.00 (0.12)	9.3 (0.37)	460	1500	46°
		3.20 (0.13)	9.3 (0.37)	550	1500	47°
Model 2.5 Max. recommended thickness = 5.0 mm (0.20 in) (6.35 mm / 0.24 in possible)	28 (1.10)	3.00 (0.12)	18.7 (0.74)	230	2000	67°
		4.00 (0.16)	18.7 (0.74)	450	2000	60°
		5.00 (0.20)	18.7 (0.74)	770	2000	57°
Model 3 Max. recommended thickness = 6.3 mm (0.25 in) (8.0 mm / 0.31 in possible)	38 (1.50)	4.00 (0.16)	22.5 (0.89)	270	2500	47°
		6.00 (0.24)	22.5 (0.89)	800	2500	50°

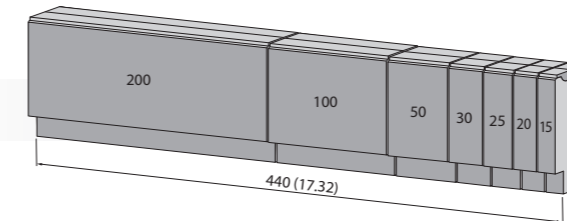
Tool lengths and sectioning

Standard

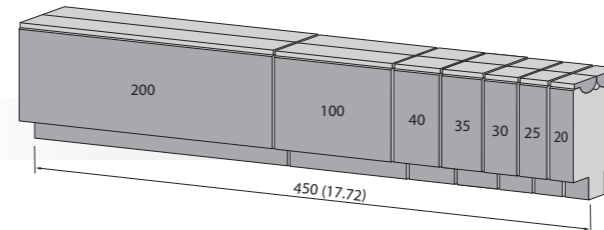


Segmented tools are delivered in complete sets. Single pieces are also available!
More lengths and sectionings are possible upon request.

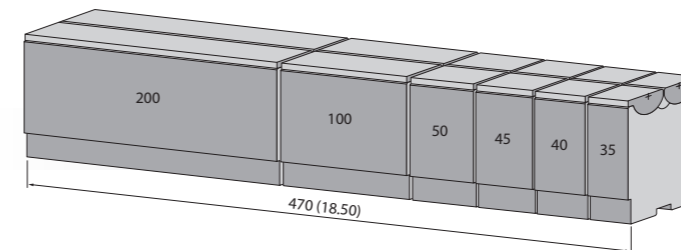
500 mm (19.68 in)
200 mm (7.87 in)



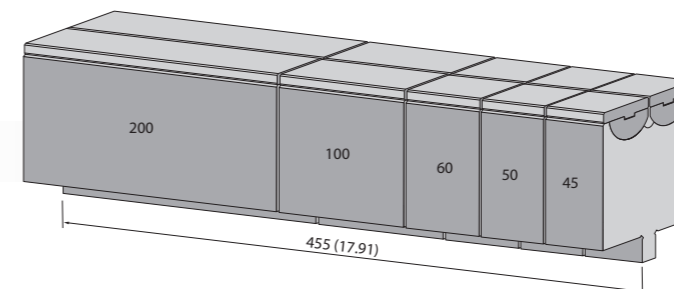
Model 1, 440 mm (17.32 in) segmented (7 segments)



Model 2, 450 mm (17.72 in) segmented (7 segments)



Model 2.5, 470 mm (18.50 in) segmented (6 segments)



Model 3, 455 mm (17.91 in) segmented (5 segments)



DIES ROLLA-V

Model 1

RVP60-1 1000 kN/m max.

NEW

500 mm	16.68 in	6.9 kg
440 mm segmented	17.32 in segmented	6.1 kg

42Cr: 1100-1200 N/mm²

RVS80-1 1000 kN/m max.

NEW

500 mm	16.68 in	6.3 kg
440 mm segmented	17.32 in segmented	5.8 kg

42Cr: 1100-1200 N/mm²

RVT55-1 1000 kN/m max.

NEW

500 mm	16.68 in	5.5 kg
440 mm segmented	17.32 in segmented	5.0 kg

42Cr: 1100-1200 N/mm²

RVT90-1 1000 kN/m max.

NEW

500 mm	16.68 in	8.5 kg
440 mm segmented	17.32 in segmented	7.8 kg

42Cr: 1100-1200 N/mm²

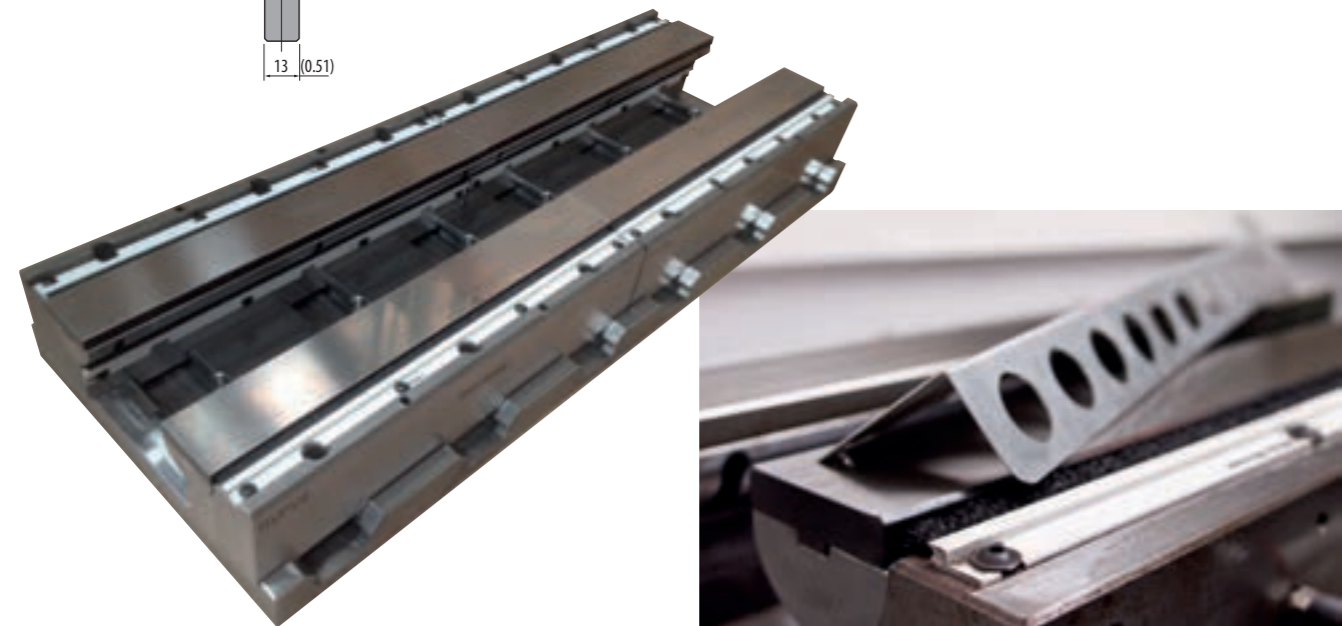
RVT100-1 1000 kN/m max.

NEW

500 mm	16.68 in	9.4 kg
440 mm segmented	17.32 in segmented	8.6 kg

42Cr: 1100-1200 N/mm²

Ideal for thick material!
Making the impossible, possible ...



DIES ROLLA-V

Model 2

RVP65-2 1500 kN/m max.

NEW

500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm²

RVS80-2 1500 kN/m max.

NEW

500 mm	16.68 in	8.3 kg
450 mm segmented	17.72 in segmented	7.8 kg

42Cr: 1100-1200 N/mm²

RVT60-2 1500 kN/m max.

NEW

500 mm	16.68 in	7.9 kg
450 mm segmented	17.72 in segmented	7.4 kg

42Cr: 1100-1200 N/mm²

RVT90-2 1500 kN/m max.

NEW

500 mm	16.68 in	11.3 kg
450 mm segmented	17.72 in segmented	10.6 kg

42Cr: 1100-1200 N/mm²

RVT100-2 1500 kN/m max.

NEW

500 mm	16.68 in	12.4 kg
450 mm segmented	17.72 in segmented	11.7 kg

42Cr: 1100-1200 N/mm²



Model 2.5

RVM2.5 2000 kN/m max.

NEW

500 mm	16.68 in	22.0 kg
470 mm segmented	18.50 in segmented	21.0 kg

42Cr: 1100-1200 N/mm²

Rolleri Videos

Use and application of Rolla-V dies
www.rolleritools.com/videos/rolla-v

DIES ROLLA-V

Model 3

RVP100-3 2500 kN/m max.

NEW

500 mm	16.68 in	28.8 kg
455 mm segmented	17.91 in segmented	26.2 kg

42Cr: 1100-1200 N/mm²

RVM70-3 2500 kN/m max.

NEW

500 mm	16.68 in	20.6 kg
455 mm segmented	17.91 in segmented	18.7 kg

42Cr: 1100-1200 N/mm²

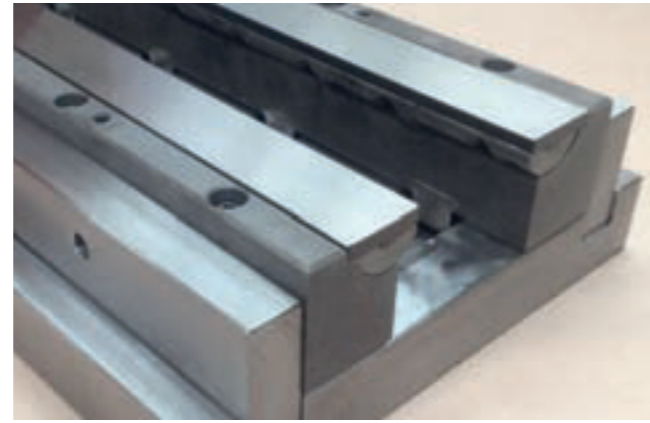
Possible Die Holders:
 - 60 mm (2.36 in)
 - 13 mm (0.51 in) pin
 - 12.7 mm (0.50 in) pin
 - 12.8 mm (0.50 in) offset pin

RVT100-3 2500 kN/m max.

NEW

500 mm	16.68 in	30.9 kg
455 mm segmented	17.91 in segmented	28.5 kg

42Cr: 1100-1200 N/mm²



Model 4

Our Advantages – Your Convenience

The **model 4 tools** and the **adjustable dies** are for bending thick material and large radii. Material specifications vary greatly, therefore no specific data can be given.

- Minimum borders are highly dependant on the squareness of the component.
- Enlargement and hole distortion will be greatly reduced, however will be influenced depending on the type of material
- Radius bending is strongly influenced by the elastic return of specific material and flange-size.

For advice please contact us!

RVM90-4 3000 kN/m max.

NEW

500 mm	16.68 in	56.6 kg
200 mm	7.87 in	22.7 kg

42Cr: 1100-1200 N/mm²

Possible Die Holders:
 - 60 mm (2.36 in)
 - 13 mm (0.51 in) pin
 - 12.7 mm (0.50 in) pin
 - 12.8 mm (0.50 in) offset pin

DIES ROLLA-V

Adjustable Dies



Our advantages – Your Convenience

- bending possible up to the thickness of 30 mm (1.18 in)
- inserts hardened
- no bending marks
- adjustable openings
 RVPV3 = 39-94 mm (1.54-3.70 in)
 RVHD3 = 39-118 mm (1.54-4.65 in)
 RVPV4 = 69-180 mm (2.72-7.09 in)
- bends laser-cut sheet metal without damaging the tool
- exact inner radius

RVPV3 2500 kN/m max.

NEW

500 mm	16.68 in	50.0 kg
200 mm	7.87 in	20.0 kg

42Cr: 1100-1200 N/mm²

RVHD3 3500 kN/m max.

NEW

500 mm	16.68 in	98.0 kg
200 mm	7.87 in	38.1 kg

42Cr: 1100-1200 N/mm²

RVHD4 4000 kN/m max.

NEW

500 mm	16.68 in	200.0 kg
200 mm	7.87 in	80.0 kg

42Cr: 1100-1200 N/mm²

- V-Bending
• flat inserts
- Radius-Bending
• flat inserts
- Conical Bending
• flat inserts
- Radius-Overbending
• concave inserts
- U-Bending
• V-inserts

Hemming- and Z-Tools

Hemming Tool

NEW

per piece	Price upon request
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Production according to your specifications

42Cr: 1100-1200 N/mm²

Joggle Tool

NEW

per piece	Price upon request
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Production according to your specifications

42Cr: 1100-1200 N/mm²