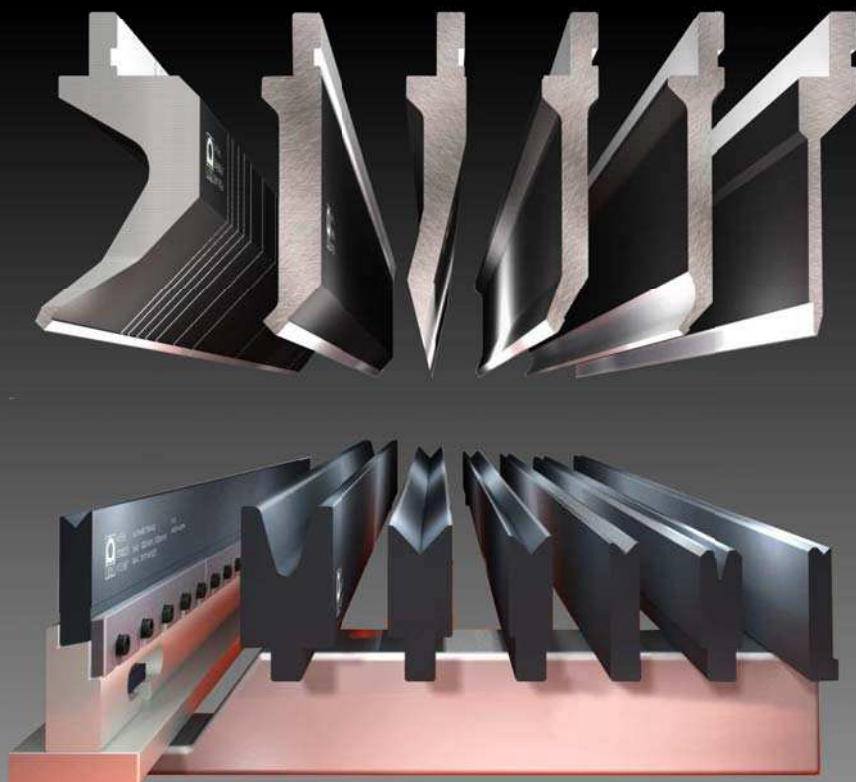


SOLUTION

BENDING TECHNOLOGY



BENDING TOOLS



New A.F.H.

 **AMADA**[®]

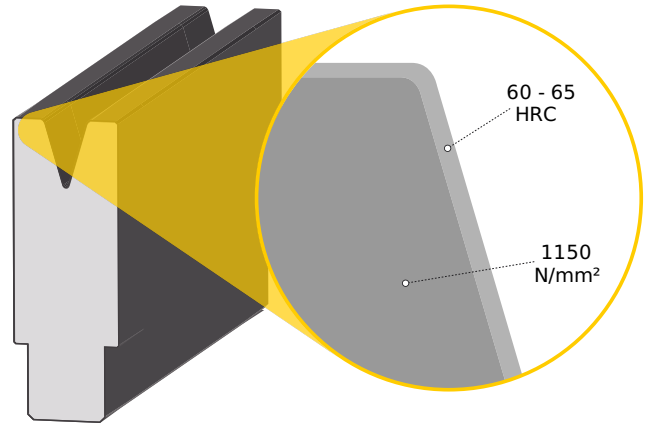
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Optimal protection & highest wear resistance

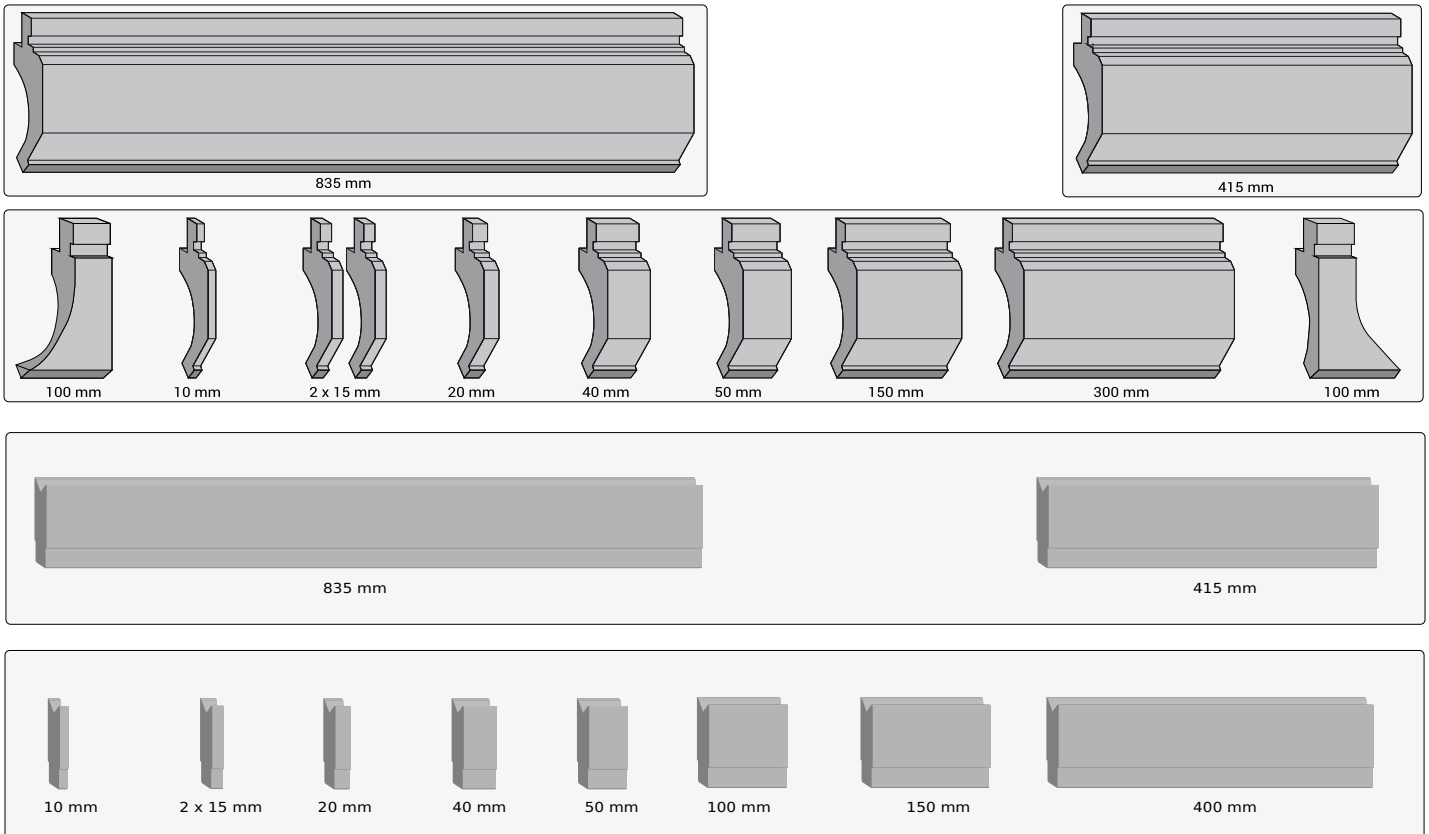
AMAN/IT® Press Brake Toolings have the best qualities for applications where very high wear and extreme load bearing occur.

- provides highest wear resistance on the tool surface (HRC 60-65)
- lowers the friction on the shoulder radii (by compound layer lubricity)
- has high tensile strength - 1150 N/mm²
- adds corrosion resistance to tooling



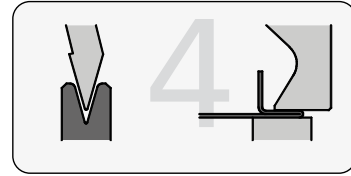
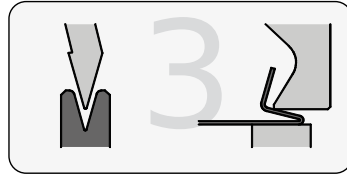
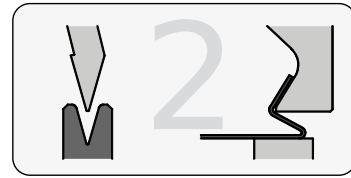
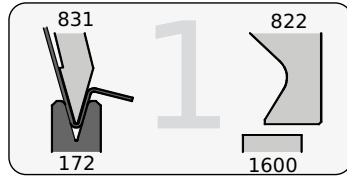
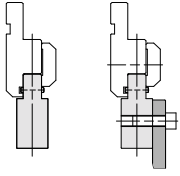
Tool type	Tip Angle	Maximum pressure	Production date
	00406 88° R0.6 (.024) (32.874)	ALLOWABLE TONNAGE MAX: 1000kN/m {100 ton/m} MAX: 30 TON/FOOT	A-8A MADE IN AUSTRIA
Length mm (inch)	Tip radius / V-Size mm (inch)		Country of origin

Available lengths



Note

- Staged offset tools are reversible and can be mounted on a punch or die holder
- Use with holder 0282 for H=90mm and with 0582 for H=120mm punch height
- Two of each code are required when ordering a punch and die set



Air bending force chart

Mild steel

Die opening V	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200		
Minimum flange length b_{min}	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113			
Bending radius ir	0.7	1.0	1.1	1.3	1.6	2.0	2.3	2.6	3.0	3.3	4.0	5.0	6.5	8.0	10	13	16	20	26			
Thickness (t) →	0.5 mm	40	30																			
	0.6 mm	60	40	40	40																	
	0.8 mm		70	70	50	40																
	1.0 mm		110	100	80	70																
	1.2 mm			140	120	100	80	70	60													
	1.5 mm				170	150	130	110	90	80												
	2.0 mm						220	190	170	150	130	110										
	2.5 mm								280	250	220	180	140									
	3.0 mm									340	300	240	190	150								
	3.5 mm											330	260	200	160	130						
	4.0 mm											430	340	270	210	170						
	4.5 mm												440	340	270	210						
	5.0 mm												520	420	330	260	210					
	6.0 mm												750	600	480	380	300	240				
	7.0 mm															520	410	330	260			
	8.0 mm															850	680	530	430			
9.0 mm																670	540	430				
10 mm																850	670	530	420			
12 mm																	960	780	600	550		
15 mm																			950	750		

Air bending force chart for mild steel ($R_m \approx 450 \text{ N/mm}^2$)

Air bending force chart

Stainless steel

Die opening V	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	
Minimum flange length b_{min}	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	
Bending radius ir	0.7	1.0	1.1	1.3	1.6	2.0	2.3	2.6	3.0	3.3	4.0	5.0	6.5	8.0	10	13	16	20	26	33	41	
Thickness (t) →	0.5 mm	60	50																			
0.6 mm	90	60	60	60																		
0.7 mm	120	80	80	60	60																	
0.8 mm		110	110	80	70																	
0.9 mm		130	120	100	80	70																
1.0 mm		170	150	120	110	80																
1.2 mm			210	180	150	120	110	90														
1.5 mm						200	170	150	130	120												
2.0 mm						330	290	260	230	200	170											
2.5 mm								390	350	300	250	190										
3.0 mm									510	450	360	290	230									
4.0 mm											650	510	410	320	260							
5.0 mm												780	630	500	390	320						
6.0 mm													900	720	570	450	360					
8.0 mm															1020	810	650	510				
10 mm																1280	1010	800	630			
12 mm																	1440	1170	900	830		
15 mm																		1800	1410	1140		
20 mm																			2500	2080	1670	
25 mm																				3150	2550	
30 mm																						3600

Air bending force chart for stainless steel ($R_m \approx 700 \text{ N/mm}^2$)

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