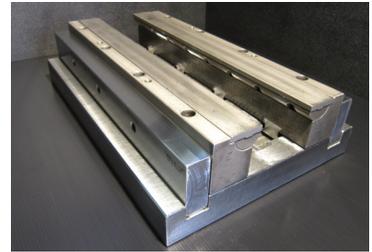


Rolla-V

THE NEXT GENERATION



PRESS BRAKE TOOLING

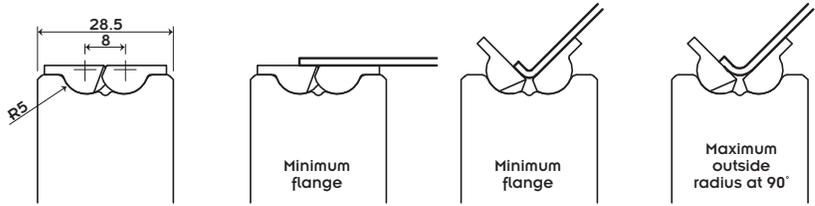
THE SOLUTION

Rolla-V Dies

- Improve productivity – eliminate secondary operations
- Control distortion of holes and slots near bend lines
- Consistently form short or tapered flanges

MODEL 1

- Maximum material thickness: 1.50mm (.059")
- Maximum outside radius @ 90°: 4.4mm (.173")
- Minimum outside flange: 3.0mm (.118")
- Maximum bend angle (included): 40°
- Tonnage capacity 100 t/m (35 tons/foot)



RVP60-1

500mm	6.9kg
440mm Seg*	6.1kg

RVS80-1

500mm	6.3kg
440mm Seg*	5.8kg

RVT55-1

500mm	5.5kg
440mm Seg*	5.0kg

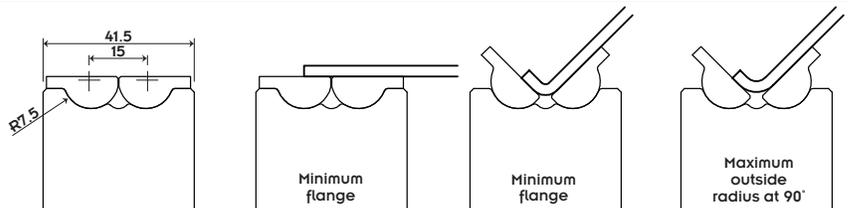
RVT100-1

500mm	9.4kg
440mm Seg*	8.6kg

*440mm sectionalized sets include the following lengths: 200mm, 100mm, 50mm, 30mm, 25mm, 20mm, and 15mm

MODEL 2

- Maximum material thickness: 3.40mm (.135")
- Maximum outside radius @ 90°: 9.0mm (.354")
- Minimum outside flange: 8.5mm (.335")
- Maximum bend angle (included): 59°
- Tonnage capacity 150 t/m (50 tons/foot)



RVP65-2

500mm	7.9kg
450mm Seg*	7.4kg

RVS80-2

500mm	8.3kg
450mm Seg*	7.8kg

RVT60-2

500mm	7.9kg
450mm Seg*	7.4kg

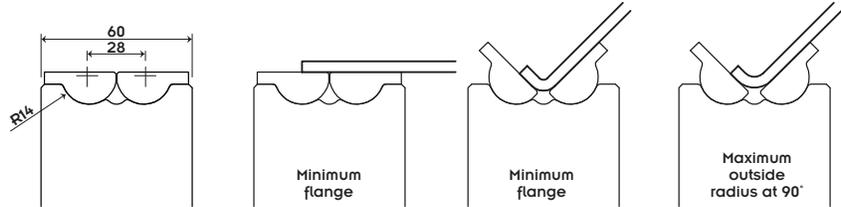
RVT100-2

500mm	12.4kg
450mm Seg*	11.7kg

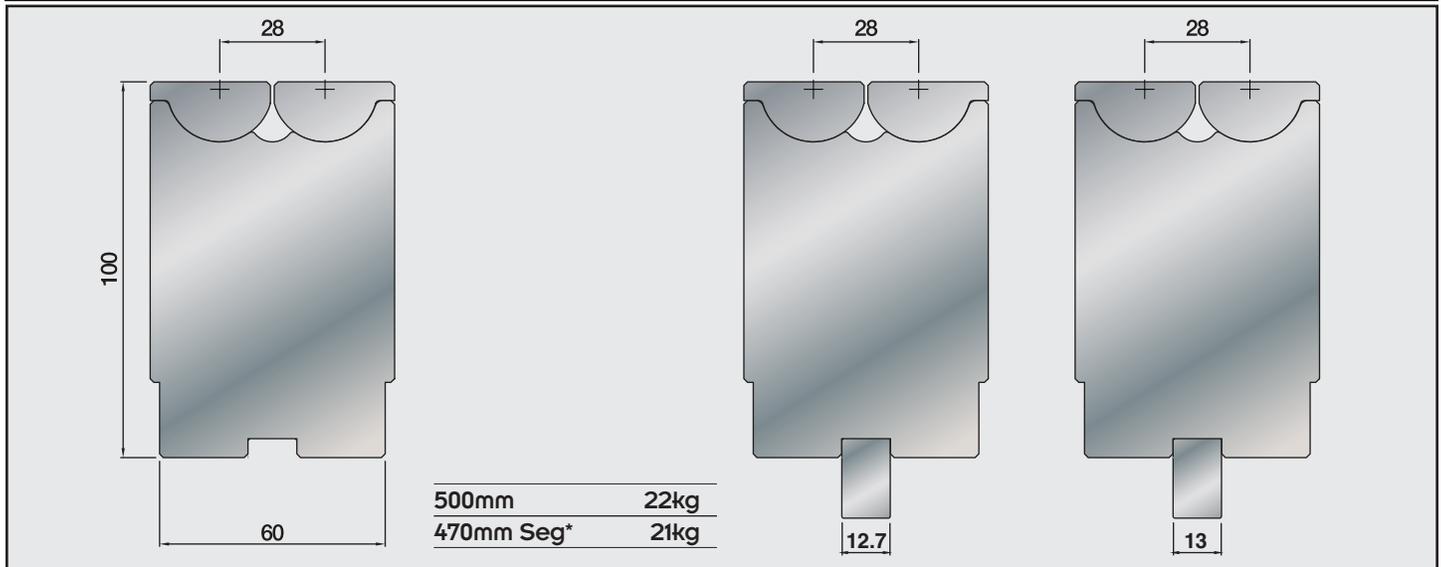
*450mm sectionalized sets include the following lengths: 200mm, 100mm, 40mm, 35mm, 30mm, 25mm, and 20mm

MODEL 2.5

- Maximum material thickness: 5.00mm (.197")
- Maximum outside radius @ 90°: 15.0mm (.590")
- Minimum outside flange: 16.8mm (.661")
- Maximum bend angle (included): 55°
- Tonnage capacity 250 t/m (84 tons/foot)



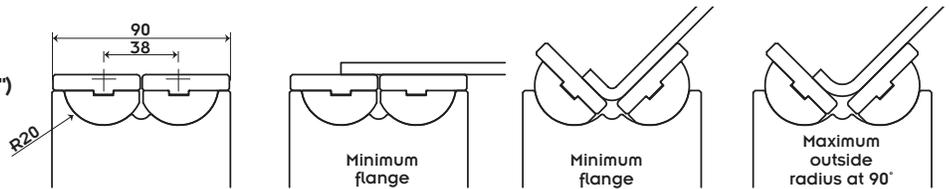
RVM100-2.5



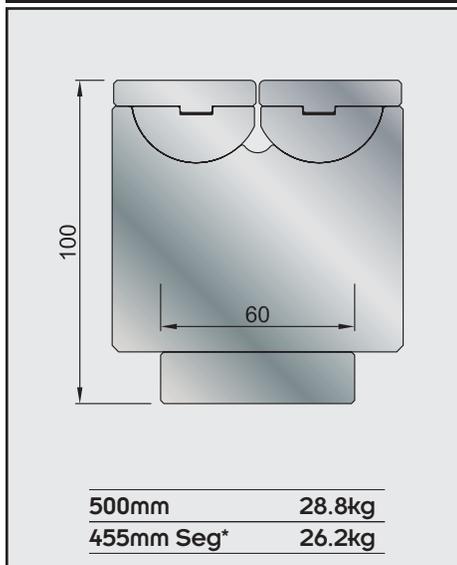
*470mm sectionalized sets include the following lengths: 200mm, 100mm, 50mm, 45mm, 40mm and 35mm

MODEL 3 (GENERATION 2)

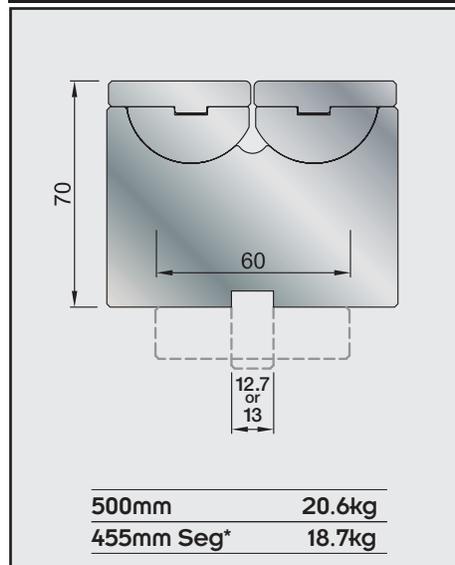
- Maximum material thickness: 6.35mm (.250")
- Maximum outside radius @ 90°: 18.0mm (.709")
- Minimum outside flange: 22.5mm (.886")
- Maximum bend angle (included): 50°
- Tonnage capacity 250 t/m (84 tons/foot)



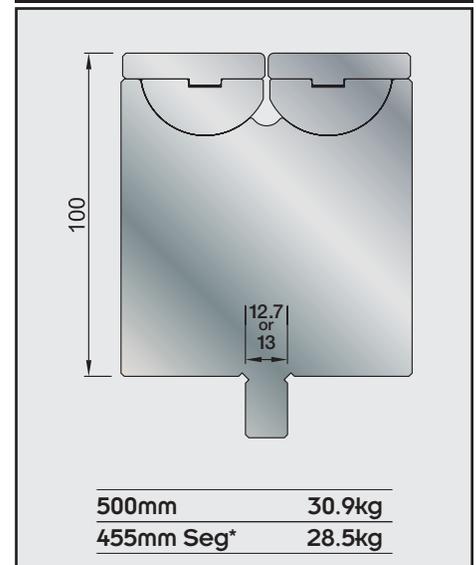
RVP100-3



RVM70-3



RVT100-3



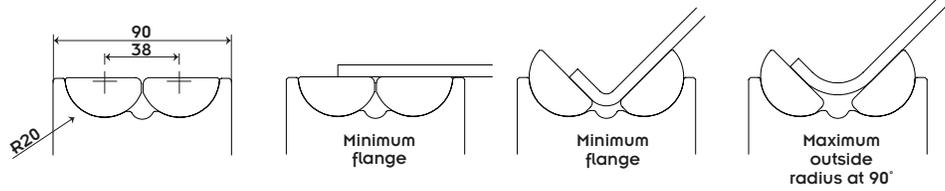
*455mm sectionalized sets include the following lengths: 200mm, 100mm, 60mm, 50mm, and 45mm

- Produce virtually mark-free parts
- Prevent cross-metal contamination
- Minimize die changes – form a wide range of material thicknesses with a single die



MODEL 3 (GENERATION 1)

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



RVP60

500mm	28.8kg
455mm Seg*	26.2kg

RVT55

500mm	20.6kg
455mm Seg*	18.7kg

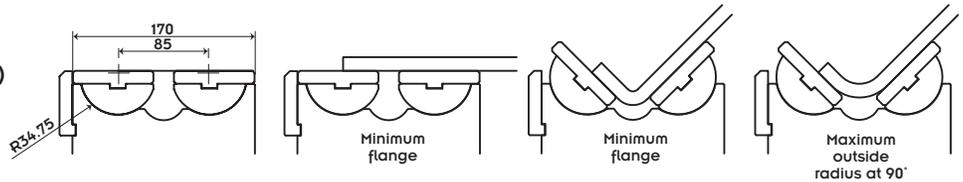
RVT100

500mm	30.9kg
455mm Seg*	28.5kg

*455mm sectionalized sets include the following lengths: 200mm, 100mm, 60mm, 50mm, and 45mm

MODEL 4

- Maximum material thickness: 12.70mm (.500")
- Maximum outside radius @ 90°: 40mm (1.575")
- Minimum outside flange: 55.0mm (2.16")
- Maximum bend angle (included): 75°
- Tonnage capacity 300 t/m (101 tons/foot)

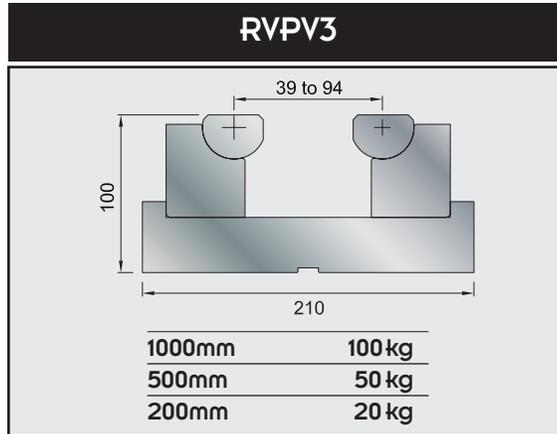


RVM90-4

500mm	56.6kg
200mm	22.7kg

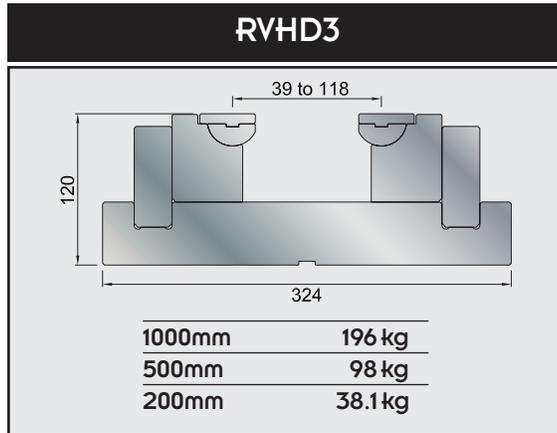
RVPV3 Adjustable

- Maximum material thickness: 12.7mm (.500")
- Maximum outside radius @ 90°: 45mm (1.772")
- Maximum bend angle: 180°
- Tonnage capacity 250 t/m (84 t/ft)



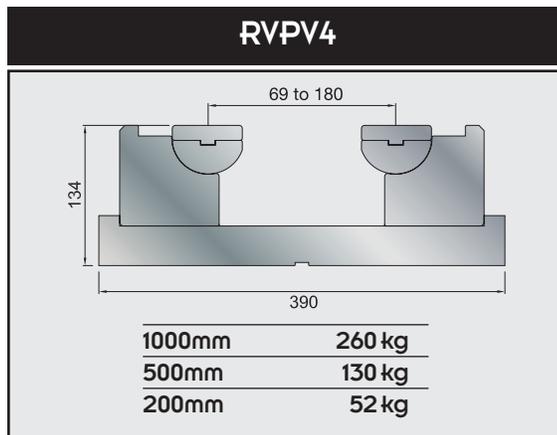
RVHD3 Adjustable

- Maximum material thickness: 16mm (.630")
- Maximum outside radius @ 90°: 65mm (2.560")
- Maximum bend angle: 180°
- Tonnage capacity 350 t/m (118 t/ft)



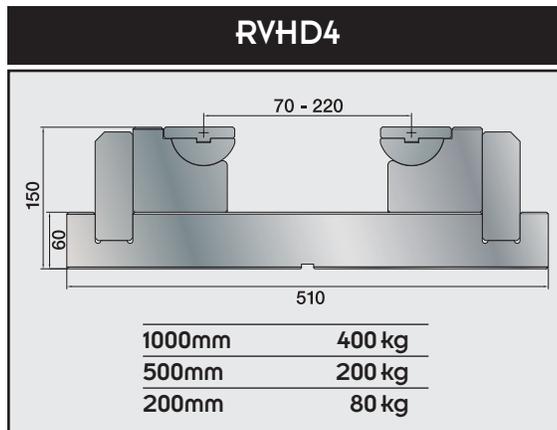
RVPV4 Adjustable

- Maximum material thickness: 30mm (1.18")
- Maximum outside radius @ 90°: 95mm (3.740")
- Maximum bend angle: 180°
- Tonnage capacity 350 t/m (118 t/ft)



RVHD4 Adjustable

- Maximum material thickness: 35mm (1.378")
- Maximum outside radius @ 90°: 135mm (5.315")
- Maximum bend angle: 180°
- Tonnage capacity 400 t/m (134 t/ft)



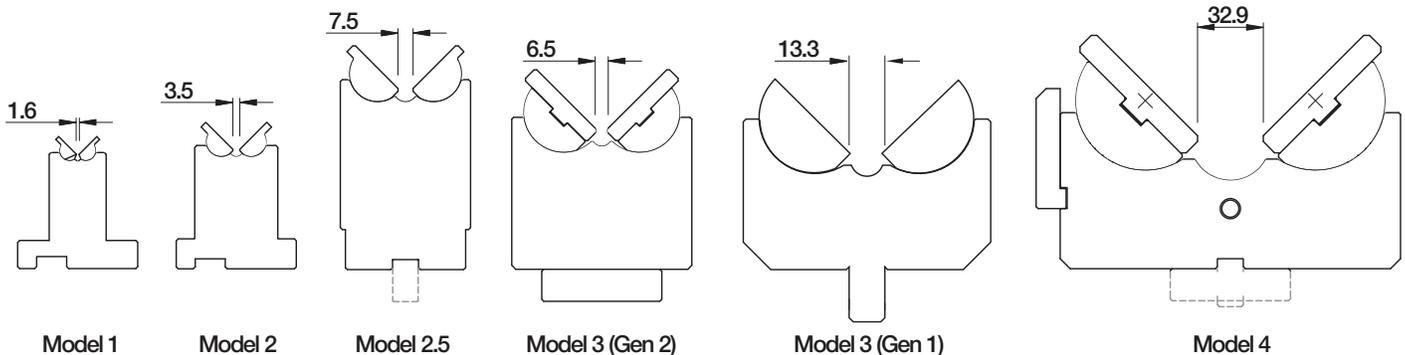
APPLICATION AND TECHNICAL DATA

	Material thickness	Minimum outside flange	Maximum tool load	Maximum outside radius at 90°	Maximum bend angle (included)
Model 1 Equivalent V size 7.2mm (.284") Maximum recommended thickness 1.5mm (2.0mm thickness is possible)*	.090mm (.036") 1.20mm (.048") 1.50mm (.059")	3.0mm (.118") 3.9mm (.153") 4.2mm (.165")	100t/m 35t/ft 100t/m 35t/ft 100t/m 35t/ft	4.4mm (.173") 4.4mm (.173") 4.4mm (.173")	40° 35° 35°
Model 2 Equivalent V size 13.9mm (.547") Maximum recommended thickness 3.4 mm (4.0mm is thickness possible)*	1.90mm (.074") 2.90mm (.105") 3.00mm (.118") 3.40mm (.135")	8.5mm (.335") 8.8mm (.347") 9.3mm (.366") 9.3mm (.366")	150t/m 50t/ft 150t/m 50t/ft 150t/m 50t/ft 150t/m 50t/ft	9.0mm (.354") 9.0mm (.354") 9.0mm (.354") 9.0mm (.354")	59° 46° 47° 47°
Model 2.5 Equivalent V size 25mm (1") Maximum recommended thickness 5mm (6.35mm thickness is possible)*	2.50mm (.090") 3.00mm (.118") 4.00mm (.157") 5.00mm (.197")	16.8mm (.665") 17.0mm (.669") 17.1mm (.673") 17.3mm (.681")	250t/m 84t/ft 250t/m 84t/ft 250t/m 84t/ft 250t/m 84t/ft	15.0mm (.590") 15.0mm (.590") 15.0mm (.590") 15.0mm (.590")	46° 46° 47° 55°
Model 3 Gen 2 Equivalent V size 33mm (1.30") Maximum recommended thickness 6.35mm (8.0mm thickness is possible)*	4.00mm (.157") 4.80mm (.189") 6.35mm (.250")	22.5mm (.886") 22.5mm (.886") 22.5mm (.886")	250t/m 84t/ft 250t/m 84t/ft 250t/m 84t/ft	18.0mm (.709") 18.0mm (.709") 18.0mm (.709")	47° 50° 50°
Model 3 Gen 1 Equivalent V size 36mm (1.42") Maximum recommended thickness 8.0mm	4.00mm (.157") 4.80mm (.189") 8.00mm (.315")	24.3mm (.956") 25.4mm (1.00") 26.5mm (1.043")	250t/m 84t/ft 250t/m 84t/ft 250t/m 84t/ft	23.0mm (.906") 23.0mm (.906") 23.0mm (.906")	75° 75° 75°
Model 4 Equivalent V size 85mm (3.35") Maximum recommended thickness 12.7mm	6.35mm (.250") 9.52mm (.375") 12.70mm (.500")	55.0mm (2.16") 55.0mm (2.16") 55.0mm (2.16")	300t/m 101t/ft 300t/m 101t/ft 300t/m 101t/ft	40.0mm (1.575") 40.0mm (1.575") 40.0mm (1.575")	75° 75° 75°

*Contact Fab Supply for instructions prior to attempting.

All tools must be used in compliance with all safety requirements as outlined by the American National Standards Institute Bulletin A.N.S.I #B11-3 as well as other local, state, and federal standards which may apply. www.fabsupplyinc.com

VEE GAP AT 90°



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