

# *Toolspress*

*high quality tooling systems*



**tools  press**

**TRUMPF STYLE**

**Press Brake Tooling**

[www.toolspress.com](http://www.toolspress.com)  
VERSION 1.0

# tools press

## Spirito d'Innovazione

Toolspress è leader mondiale nella progettazione e produzione di utensili e sistemi di bloccaggio di alta qualità, per presse piegatrici. Realizziamo prodotti all'avanguardia ed innovativi, sfruttando 30 anni di esperienza ed un ampio programma di produzione, con più di mille modelli standard, che ci permettono di valutare e risolvere le problematiche proposte, ottimizzando i vostri sistemi di piegatura.

Toolspress è composta da Quattro importanti divisioni:

- Utensili Standard di Alta Precisione per Presse Piegatrici
- Utensili Speciali di Alta Precisione per Presse Piegatrici
- Sistemi di Bloccaggio per Presse Piegatrici
- Soluzioni Industriali per Presse Piegatrici
- Lame da cesoia

Queste quattro divisioni sono indipendenti e utilizzano le tecnologie più avanzate disponibili nel mercato mondiale, in questo modo possiamo garantire prodotti di alta qualità senza paragoni. La qualità Toolspress è ben conosciuta nel mercato mondiale da molti anni. I nostri clienti sono per noi partners tecnologici, grazie ad una stretta collaborazione, risolviamo e incrementiamo la loro performance di piegatura. Il mercato globale richiede sempre più tecnologia a prezzi molto competitivi e nel minor tempo possibile, per questi motivi la nostra società ricerca e sviluppa metodi di produzione che ci permettano di soddisfare le richieste dei nostri clienti.

## The Spirit of Innovation

Toolspress is a world-class designer and manufacturer of high-quality press brake tooling and clamping system. We provide the most innovative products in the fabricators industries. Through a great manufacturing program with more than thousand standard model, we are able to guide your choice of the best bending system in the fastest time, due to the long experience we got in 30th years.

Toolspress has four important divisions:

- Precision Ground Standard Press Brakes Tooling
- Precision Ground Special Press Brakes Tooling
- Press Brakes Clamping System
- Industrial Solutions for Press Brakes
- Shear blades

These four divisions are independent and both use the ultimate technologies in manufacturing process available in the world market, in this way we can guarantee high precision quality products with no comparison. Toolspress quality is very well known in the world market since many years. Ours customers are for us technological partners, in fact through a tight cooperation they let us solve and improve their bending performance. The global market needs always more and more technology to a very competitive prices in the shortest time. In this way our company develops manufacturing methods that allow us to meet our costumers requirements.

## The Spirit of Innovation

Toolspress® ist der weltweit führende Entwickler und Hersteller von qualitativ hochwertigen Abkantwerkzeugen und Werkzeug-Spannsysteme. Wir entwickeln und vertreiben die innovativsten Produkte im Bereich der Abkanttechnik. Durch unser großes Herstellungsprogramm mit über tausend Standardwerkzeugen sind wir in der Lage, das von Ihnen gewünschte Werkzeugsystem innerhalb kürzester Zeit zu liefern. Toolspress® verfügt über eine 30-jährige Erfahrung in der Abkanttechnik.

- Toolspress® hat vier wichtige Bereiche:
- Präzisions Standard Abkantwerkzeuge
  - Präzisions Spezial Abkantwerkzeuge
  - Spannsysteme für Abkantwerkzeuge
  - Industrielle Lösungen für Abkantpressen
  - Shear blades

Diese vier Bereiche sind unabhängig, aber alle nutzen die neuesten auf dem Weltmarkt verfügbaren Fertigungstechnologie. Auf diese Weise können wir hochpräzise Qualitätsprodukte ohne Kompromisse garantieren.

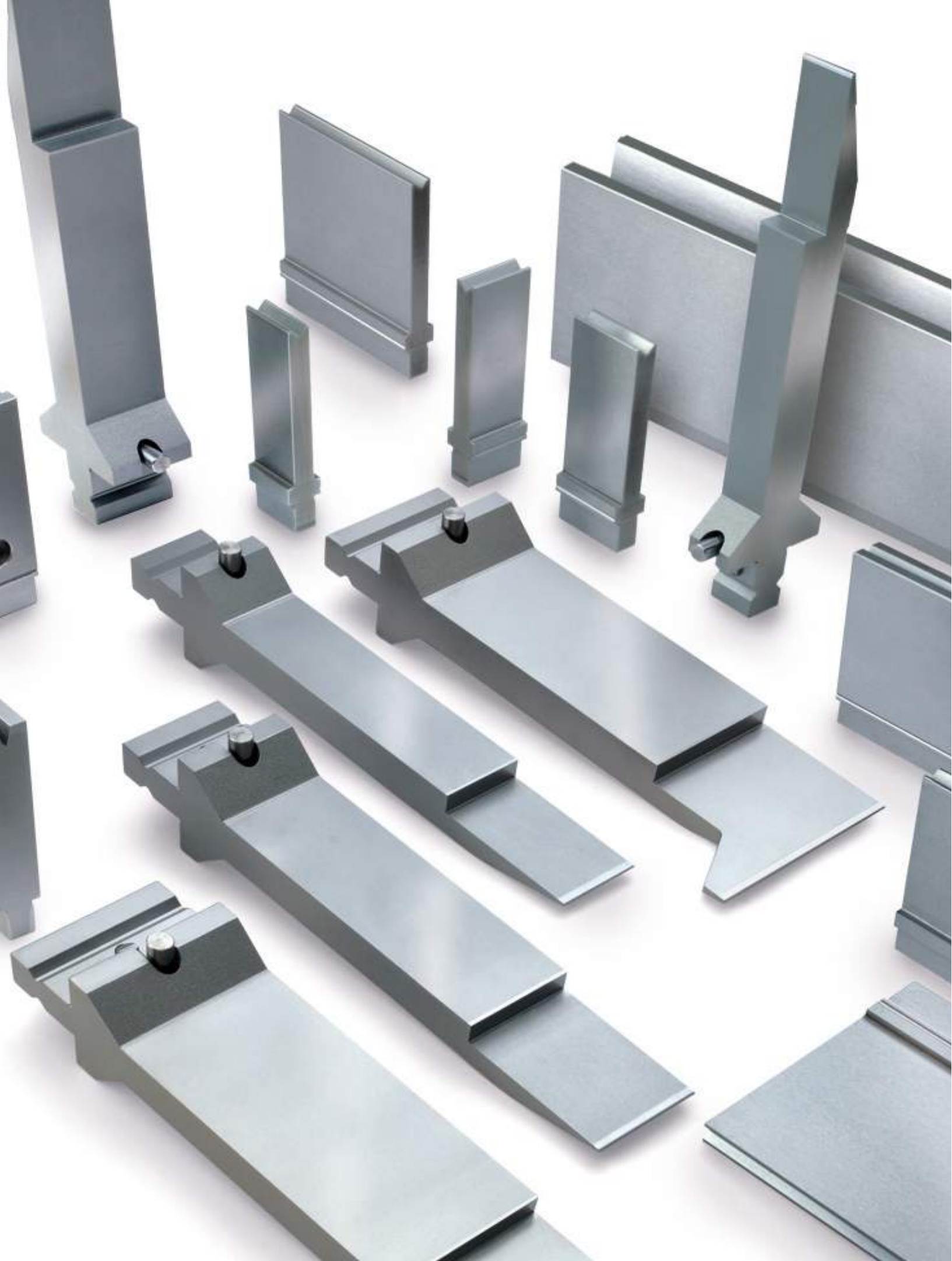
Die Qualität von Toolspress® ist seit Jahren auf dem Markt bekannt.

Für uns sind unsere Kunden technologische Partner.

In enger Zusammenarbeit werden Lösungen erreicht und Abkantleistungen verbessert. Die globalen Marktanforderungen fordern immer mehr Technologien, zu wettbewerbsfähigen Preisen, in kürzester Zeit. Daher entwickeln wir ständig neue Herstellungsverfahren, die es uns erlauben den Kundenanforderungen zu entsprechen.

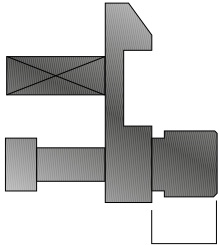
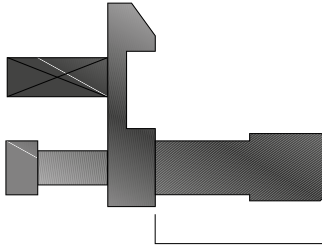
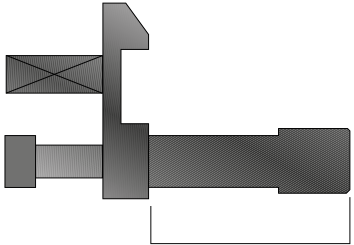
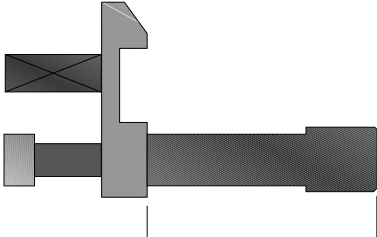
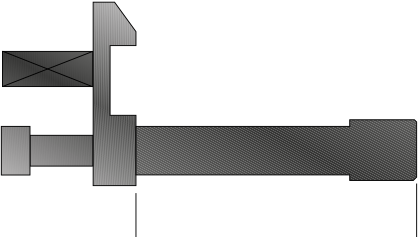


|                          |   |
|--------------------------|---|
| <b>Order</b>             | Minimum order is 100 €  |
| <b>Credit</b>            | All orders are subject to the approval of our credit department. If you are a new account, please furnish us with a bank reference and three supplier references. A credit limit will be imposed on new accounts until credit has been established. |
| <b>Payment</b>           | Terms are net 30 days.  |
| <b>Cancellation</b>      | In the event an order is cancelled, a charge will be made to cover labour, materials and overheads.   |
| <b>Returned Material</b> | A handling charge of 25% is made on all standard parts returned for credit. Written permission and shipping instructions must be obtained before the return of any material. Special tooling cannot be returned.                                    |
| <b>Claims</b>            | All claims for shortages must be made within 3 days of the invoice date.  |
| <b>Prices</b>            | Prices and specifications subject to change without prior notice.<br>E & O E. All prices are exclusive of VAT.  |
| <b>Delivery Charge</b>   | All orders are subject to a delivery charge.<br>Please call the sales desk for a delivery quotation.  |

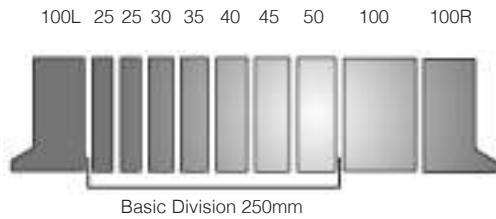
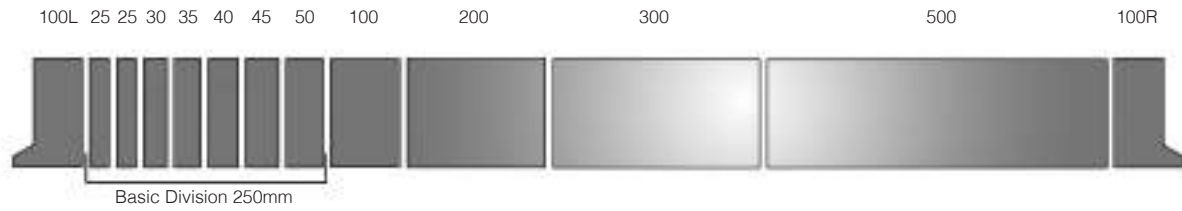




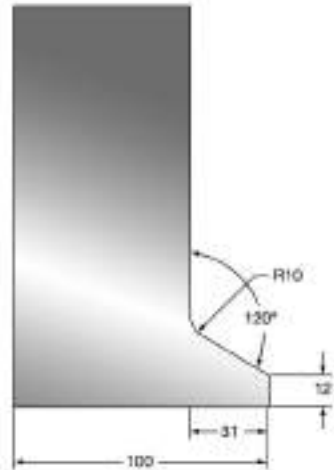
Buttons can be put in all punches with a weight below 12.7 kg

| Description   | Description  | Description   |
|---|--|---|
| Punch Button Assembly - 10mm  | Punch Button Assembly - 24mm   | Punch Button Assembly - 30mm  |
|  |  |  |
| Description   | Description  |   |
| Punch Button Assembly - 35mm  | Punch Button Assembly - 45mm   |   |
|  |  |   |

# System division - Punches



550 mm sect



## Version B

| Set  | 100L | 250X | 100 | 200 | 300 | 500 | 100R |
|------|------|------|-----|-----|-----|-----|------|
| 1050 | 1    | 1    | 1   | 1   | 1   | 0   | 1    |
| 1250 | 1    | 1    | 1   | 2   | 1   | 0   | 1    |
| 2050 | 1    | 1    | 1   | 1   | 1   | 2   | 1    |
| 2550 | 1    | 1    | 1   | 1   | 1   | 3   | 1    |
| 3050 | 1    | 1    | 1   | 1   | 1   | 4   | 1    |
| 4050 | 1    | 1    | 1   | 1   | 1   | 6   | 1    |

Division version for tool sets with a weight of up to 50kg/m

| Set  | 100L | 250X | 100 | 200 | 300 | 500 | 100R |
|------|------|------|-----|-----|-----|-----|------|
| 1050 | 1    | 1    | 1   | 1   | 1   | 0   | 1    |
| 1250 | 1    | 1    | 1   | 2   | 1   | 0   | 1    |
| 2050 | 1    | 1    | 1   | 3   | 3   | 0   | 1    |
| 2550 | 1    | 1    | 1   | 4   | 4   | 0   | 1    |
| 3050 | 1    | 1    | 1   | 5   | 5   | 0   | 1    |
| 4050 | 1    | 1    | 1   | 7   | 7   | 0   | 1    |

Division version for tool sets with a weight of more than 50kg/m

## Version A

| Set   | 100L | 250X | 100 | 100R |
|-------|------|------|-----|------|
| 1050A | 1    | 1    | 6   | 1    |
| 1250A | 1    | 1    | 8   | 1    |
| 2050A | 1    | 1    | 16  | 1    |

### Benefit version B

- High flexibility
- Fewer tool change-overs
- Short tool set-up time
- Version most often selected and recommended
- Low purchase cost

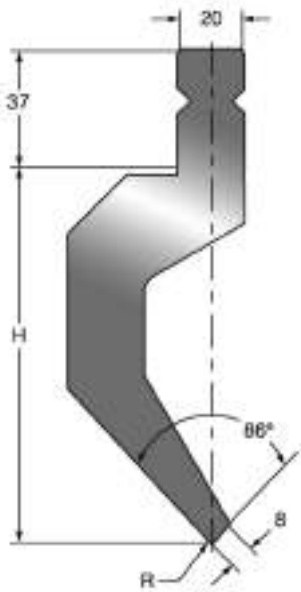
### Benefit version A

- Maximum flexibility
- Weight of the individual part pieces very low
- Maximum tool set-up time
- All tools can be loaded vertically and horizontally

### SYSTEM DIVISION VERSION B/A

The combination of a punch block A-division and a die block in B-division will not cause any problems

# Punches - Swan Neck



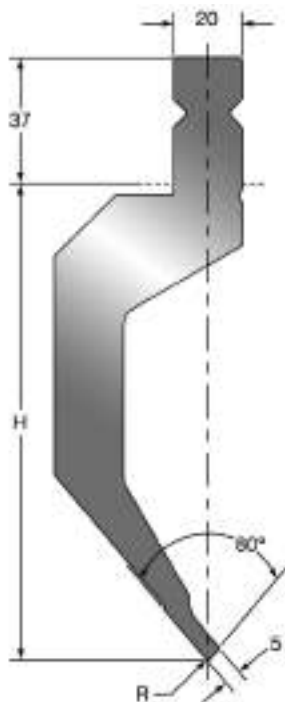
|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW200</b>    |
| <b>Trumpf Profile</b>     | <b>OW200/K</b>   |
| Radius                    | R1               |
| Angle                     | 86°              |
| Height                    | 120              |
| <b>Maximum Loading:</b>   | <b>800 kN/m</b>  |
| <b>Weight:</b>            | <b>29.1 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        |                    |
| Length 2050        | <b>Single</b>      |
| Length 1250        | <b>Description</b> |
| Length 1050        | 500                |
|                    | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |       |      |      |       |       |       |  |        |
|--------------------------|-------|-------|------|------|-------|-------|-------|--|--------|
| R0.5                     | R1.6  | R2    | R2.3 | R2.5 | R3    | R3.2  | R4    |  | Radius |
| 86°                      | 86°   | 86°   | 86°  | 86°  | 86°   | 86°   | 86°   |  | Angle  |
| 119.8                    | 119.2 | 119.2 | 119  | 119  | 118.7 | 118.6 | 118.3 |  | Height |

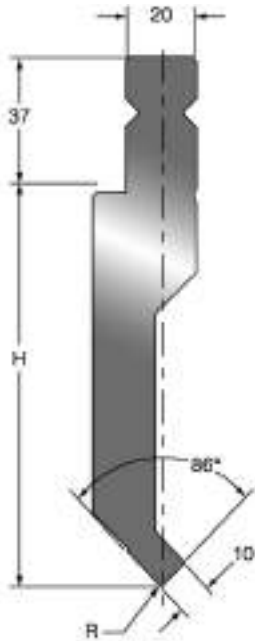
# Punches - Thin Tip



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW280</b>    |
| <b>Trumpf Profile</b>     | <b>OW280/K</b>   |
| Radius                    | R0.5             |
| Angle                     | 80°              |
| Height                    | 140              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>30.9 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        |                    |
| Length 2050        | <b>Single</b>      |
| Length 1250        | <b>Description</b> |
| Length 1050        | 500                |
|                    | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

# Punches - Goose Neck



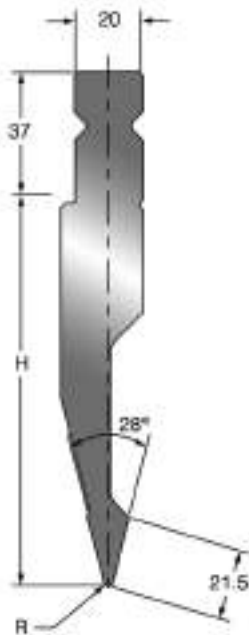
|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW201</b>    |
| <b>Trumpf Profile</b>     | <b>OW201/K</b>   |
| Radius                    | R1               |
| Angle                     | 86°              |
| Height                    | 120              |
| <b>Maximum Loading:</b>   | <b>800 kN/m</b>  |
| <b>Weight:</b>            | <b>24.3 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        |                    |
| Length 2050        | <b>Single</b>      |
| Length 1250        | <b>Description</b> |
| Length 1050        | 500                |
|                    | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |       |      |      |       |       |       |        |  |
|--------------------------|-------|-------|------|------|-------|-------|-------|--------|--|
| R0.5                     | R1.6  | R2    | R2.3 | R2.5 | R3    | R3.2  | R4    | Radius |  |
| 86°                      | 86°   | 86°   | 86°  | 86°  | 86°   | 86°   | 86°   | Angle  |  |
| 119.8                    | 119.4 | 119.2 | 119  | 119  | 118.8 | 118.6 | 118.2 | Height |  |

# Punches - Pointed with Recess



|                                   |                  |
|-----------------------------------|------------------|
| <b>Toolspress Profile</b>         | <b>TOW202</b>    |
| <b>Trumpf Profile</b>             | <b>OW202/K</b>   |
| Radius                            | R1               |
| Angle                             | 28°              |
| Height                            | 120              |
| <b>Max. Loading (Bending):</b>    | <b>600 kN/m</b>  |
| <b>Max. Loading (Flattening):</b> | <b>800 kN/m</b>  |
| <b>Weight:</b>                    | <b>19.5 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        |                    |
| Length 2050        | <b>Single</b>      |
| Length 1250        | <b>Description</b> |
| Length 1050        | 500                |
|                    | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |     |       |       |       |       |       |        |  |
|--------------------------|-------|-----|-------|-------|-------|-------|-------|--------|--|
| R0.5                     | R1.6  | R2  | R2.3  | R2.5  | R3    | R3.2  | R4    | Radius |  |
| 28°                      | 28°   | 28° | 28°   | 28°   | 28°   | 28°   | 28°   | Angle  |  |
| 119.8                    | 117.2 | 116 | 115.1 | 114.4 | 112.8 | 112.7 | 109.8 | Height |  |



# Punches - Pointed/Bottoming



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW203</b>    |
| <b>Trumpf Profile</b>     | <b>OW203/K</b>   |
| Radius                    | R4               |
| Angle                     | 60°              |
| Height                    | 120              |
| <b>Maximum Loading:</b>   | <b>1300 kN/m</b> |
| <b>Weight:</b>            | <b>23.3 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |       |       |       |       |       |        |
|--------------------------|-------|-------|-------|-------|-------|-------|--------|
| R2                       | R2.5  | R3    | R4.7  | R5    | R6    | R6.35 | Radius |
| 60°                      | 60°   | 60°   | 60°   | 60°   | 60°   | 60°   | Angle  |
| 119.8                    | 119.8 | 119.8 | 119.1 | 118.8 | 117.6 | 117.2 | Height |

# Punches - Pointed with Flattened Spot



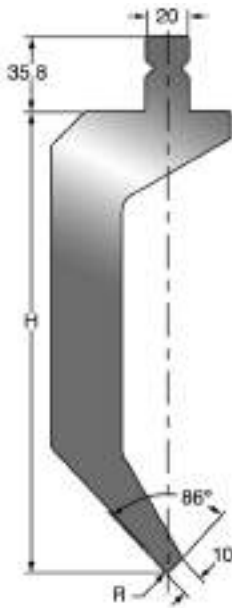
|                                   |                  |
|-----------------------------------|------------------|
| <b>Toolspress Profile</b>         | <b>TOW210</b>    |
| <b>Trumpf Profile</b>             | <b>OW210</b>     |
| Radius                            | R1               |
| Angle                             | 28°              |
| Height                            | 140              |
| <b>Max. Loading (Bending):</b>    | <b>400 kN/m</b>  |
| <b>Max. Loading (Flattening):</b> | <b>1300 kN/m</b> |
| <b>Weight:</b>                    | <b>28.9 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |        |
|--------------------------|--------|
| R0.5                     | Radius |
| 28°                      | Angle  |
| 139.8                    | Height |

# Punches - Swan Neck



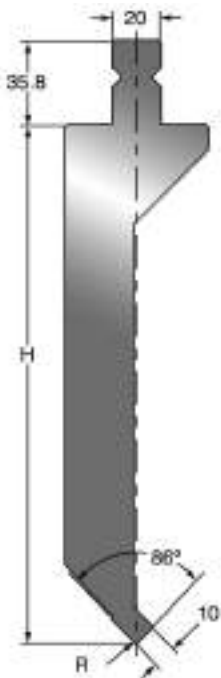
|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW200S</b>   |
| <b>Trumpf Profile</b>     | <b>OW200/S</b>   |
| Radius                    | R1               |
| Angle                     | 86°              |
| Height                    | 220              |
| <b>Maximum Loading:</b>   | <b>800 kN/m</b>  |
| <b>Weight:</b>            | <b>66,3 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 300                |
| Length 1050        | 200                |
| <b>Version A</b>   | Horn right         |
| <b>Description</b> | Horn Left          |
| Length 2050        | 100                |
| Length 1250        | 50                 |
| Length 1050        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |       |      |       |       |       |       |       |        |
|--------------------------|-------|-------|------|-------|-------|-------|-------|-------|--------|
| R0.5                     | R1.6  | R2    | R2.3 | R2.5  | R3    | R3.2  | R4    | R6    | Radius |
| 86°                      | 86°   | 86°   | 86°  | 86°   | 86°   | 86°   | 86°   | 86°   | Angle  |
| 219.8                    | 219.2 | 219.2 | 219  | 218.7 | 218.5 | 218.5 | 218.3 | 217.5 | Height |

# Punches - Goose Neck



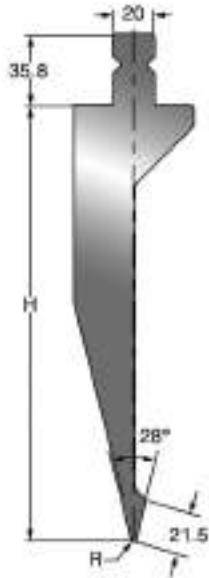
|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW201S</b>   |
| <b>Trumpf Profile</b>     | <b>OW201/S</b>   |
| Radius                    | R1               |
| Angle                     | 86°              |
| Height                    | 220              |
| <b>Maximum Loading:</b>   | <b>800 kN/m</b>  |
| <b>Weight:</b>            | <b>57.0 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 300                |
| Length 1050        | 200                |
| <b>Version A</b>   | Horn right         |
| <b>Description</b> | Horn Left          |
| Length 2050        | 100                |
| Length 1250        | 50                 |
| Length 1050        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |       |      |       |       |       |       |        |       |
|--------------------------|-------|-------|------|-------|-------|-------|-------|--------|-------|
| R0.5                     | R1.6  | R2    | R2.3 | R2.5  | R3    | R3.2  | R4    | Radius |       |
| 86°                      | 86°   | 86°   | 86°  | 86°   | 86°   | 86°   | 86°   | 86°    | Angle |
| 219.8                    | 219.4 | 219.2 | 219  | 218.7 | 218.8 | 218.6 | 218.3 | Height |       |

## Punches - Pointed with Recess



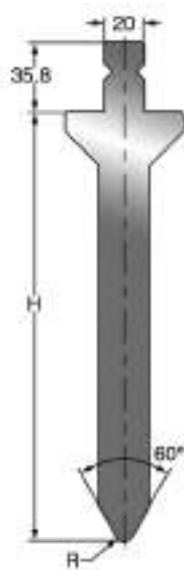
|                                   |                  |
|-----------------------------------|------------------|
| <b>Toolspress Profile</b>         | <b>TOW202S</b>   |
| <b>Trumpf Profile</b>             | <b>OW202/S</b>   |
| Radius                            | R1               |
| Angle                             | 28°              |
| Height                            | 220              |
| <b>Max. Loading (Bending):</b>    | <b>600 kN/m</b>  |
| <b>Max. Loading (Flattening):</b> | <b>800 kN/m</b>  |
| <b>Weight:</b>                    | <b>49.6 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |     |       |      |       |       |       |        |  |
|--------------------------|-------|-----|-------|------|-------|-------|-------|--------|--|
| R0.5                     | R1.6  | R2  | R2.3  | R2.5 | R3    | R3.2  | R4    | Radius |  |
| 28°                      | 28°   | 28° | 28°   | 28°  | 28°   | 28°   | 28°   | Angle  |  |
| 219.8                    | 217.8 | 216 | 215.6 | 214  | 212.8 | 212.7 | 209.8 | Height |  |

## Punches - Pointed/Bottoming



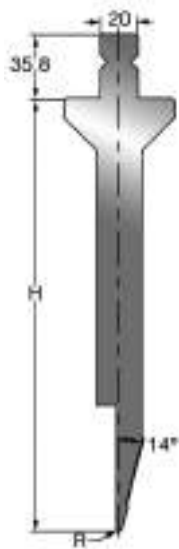
|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW203S</b>   |
| <b>Trumpf Profile</b>     | <b>OW203/S</b>   |
| Radius                    | R4               |
| Angle                     | 60°              |
| Height                    | 220              |
| <b>Maximum Loading:</b>   | <b>1300 kN/m</b> |
| <b>Weight:</b>            | <b>52.1 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 300                |
| Length 1050        | 200                |
| <b>Version A</b>   | Horn right         |
| <b>Description</b> | Horn Left          |
| Length 2050        | 100                |
| Length 1250        | 50                 |
| Length 1050        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

| Modified Punch Tip Radii |       |       |      |       |       |       |     |     |        |
|--------------------------|-------|-------|------|-------|-------|-------|-----|-----|--------|
| R2                       | R2.5  | R3    | R4.7 | R5    | R6    | R6.35 | R8  | R10 | Radius |
| 60°                      | 60°   | 60°   | 60°  | 60°   | 60°   | 60°   | 60° | 60° | Angle  |
| 219.8                    | 219.8 | 219.8 | 219  | 218.6 | 217.6 | 217.2 | 220 | 220 | Height |

# Punches - Pointed with Flattening Spot



|                                   |                  |
|-----------------------------------|------------------|
| <b>Toolspress Profile</b>         | <b>TOW210S</b>   |
| <b>Trumpf Profile</b>             | <b>OW210/S</b>   |
| Radius                            | R1               |
| Angle                             | 28°              |
| Height                            | 240              |
| <b>Max. Loading (Bending):</b>    | <b>400 kN/m</b>  |
| <b>Max. Loading (Flattening):</b> | <b>1300 kN/m</b> |
| <b>Weight:</b>                    | <b>47.7 kg/m</b> |

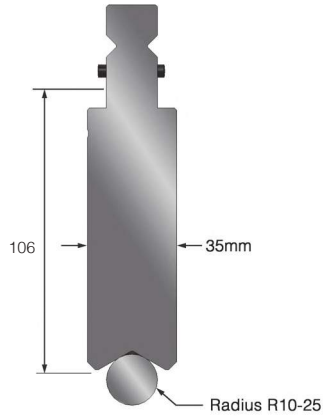
| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | 250                  |
| Length 3050        | 550                  |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 500                  |
| Length 1050        | 300                  |
| <b>Version A</b>   | 200                  |
| <b>Description</b> | Horn right           |
| Length 2050        | Horn Left            |
| Length 1250        | 100                  |
| Length 1050        | 50                   |
|                    | 45                   |
|                    | 40                   |
|                    | 35                   |
|                    | 30                   |
|                    | 25                   |

| <b>Modified Punch Tip Radii</b> |        |
|---------------------------------|--------|
| R0.5                            | Radius |
| 28°                             | Angle  |
| 239.8                           | Height |

Dimensions in mm

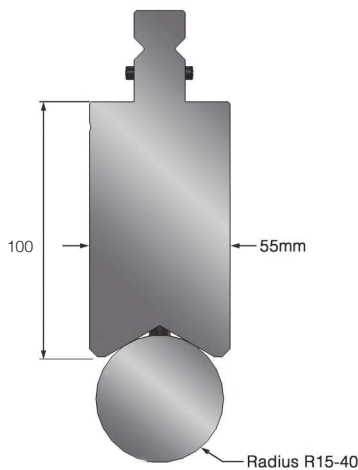
# Radius Punches

- Hardened Holders and Inserts
- Standard Radius Sizes up to 40mm
- Insert Holder made in 42CrMo4 hardened and ground
- Insert Radius made in C50 hardened and ground



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW308</b>    |
| <b>Trumpf Profile</b>     | <b>OW308/K</b>   |
| Radius                    | 10-25            |
| Height                    | 106              |
| <b>Maximum Loading:</b>   | <b>1300 kN/m</b> |
| <b>Weight:</b>            | <b>33.3 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        |                    |
| Length 2050        | <b>Single</b>      |
| Length 1250        | <b>Description</b> |
| Length 1050        | 500                |
|                    | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>TOW308S</b>   |
| <b>Trumpf Profile</b>     | <b>OW308/S</b>   |
| Radius                    | 15-40            |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b> |
| <b>Weight:</b>            | <b>46.5 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | 250                |
| Length 3050        | 550                |
| Length 2550        |                    |
| Length 2050        | <b>Single</b>      |
| Length 1250        | <b>Description</b> |
| Length 1050        | 500                |
|                    | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | Horn right         |
| Length 2050        | Horn Left          |
| Length 1250        | 100                |
| Length 1050        | 50                 |
|                    | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

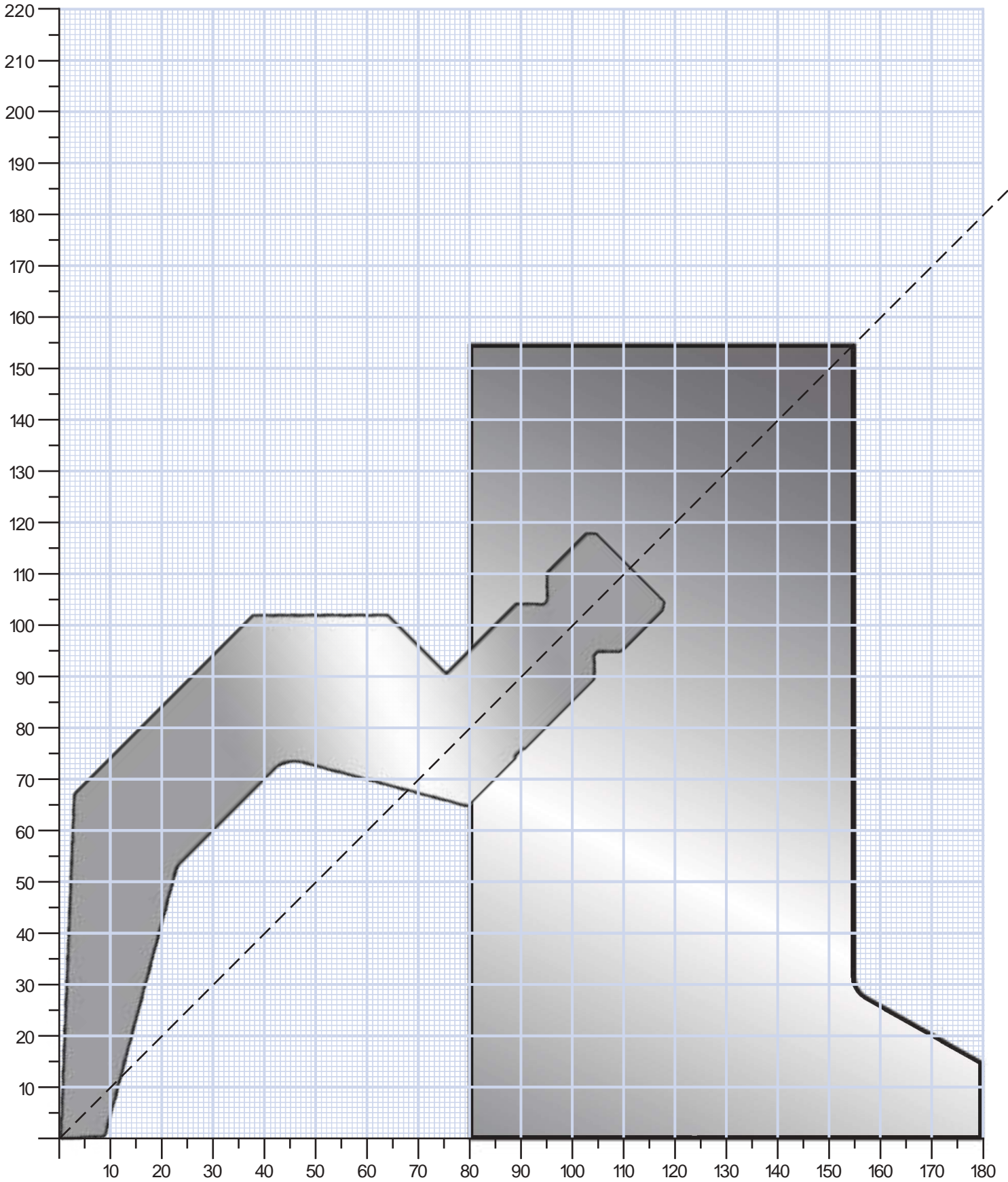
## Standard Radius insert

|    |    |    |    |    |    |    |
|----|----|----|----|----|----|----|
| 10 | 15 | 20 | 25 | 30 | 35 | 40 |
|----|----|----|----|----|----|----|

Other Radius inserts available on request

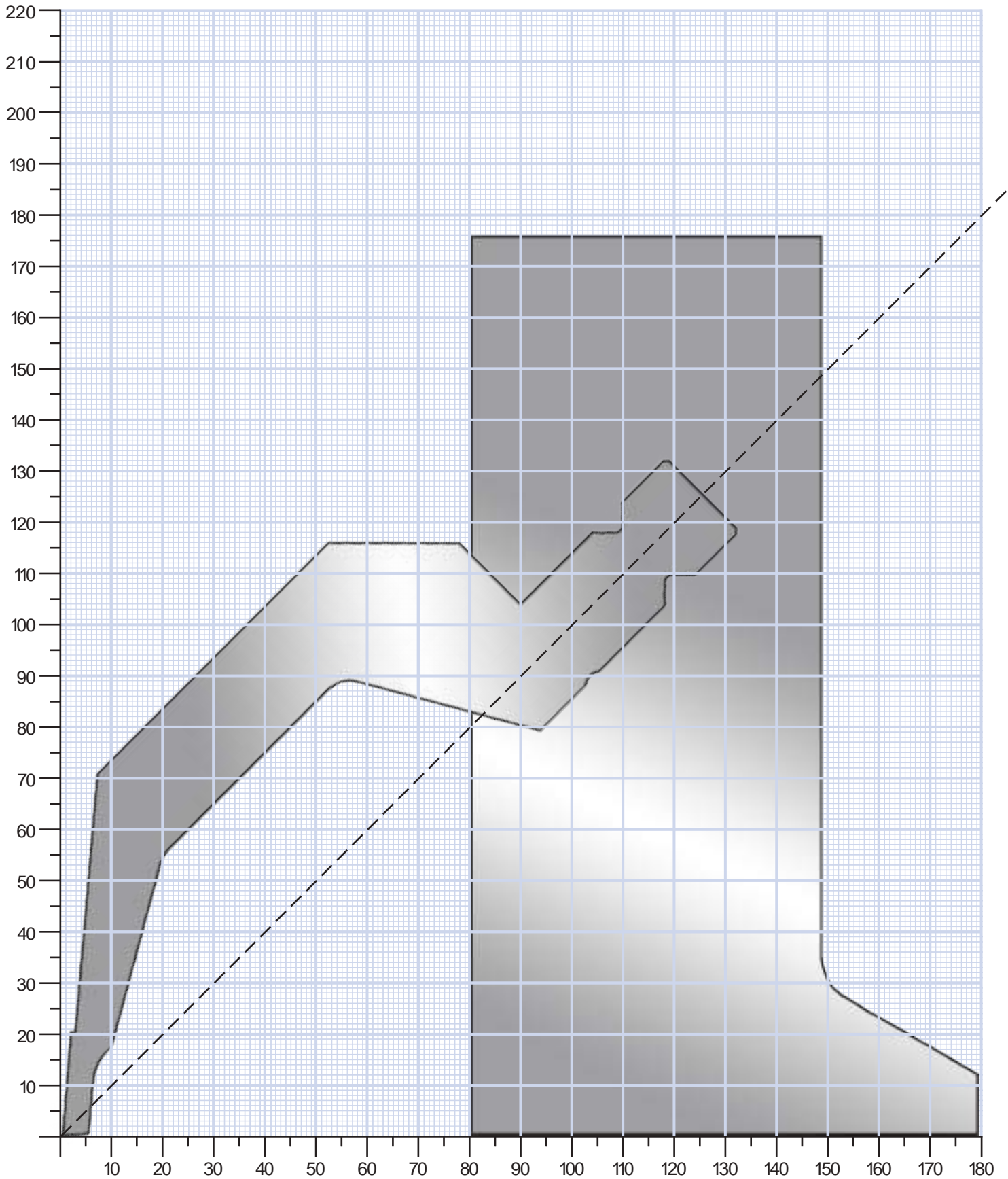
# Bend Limit Graph

TOW200 Swan-Neck Punch



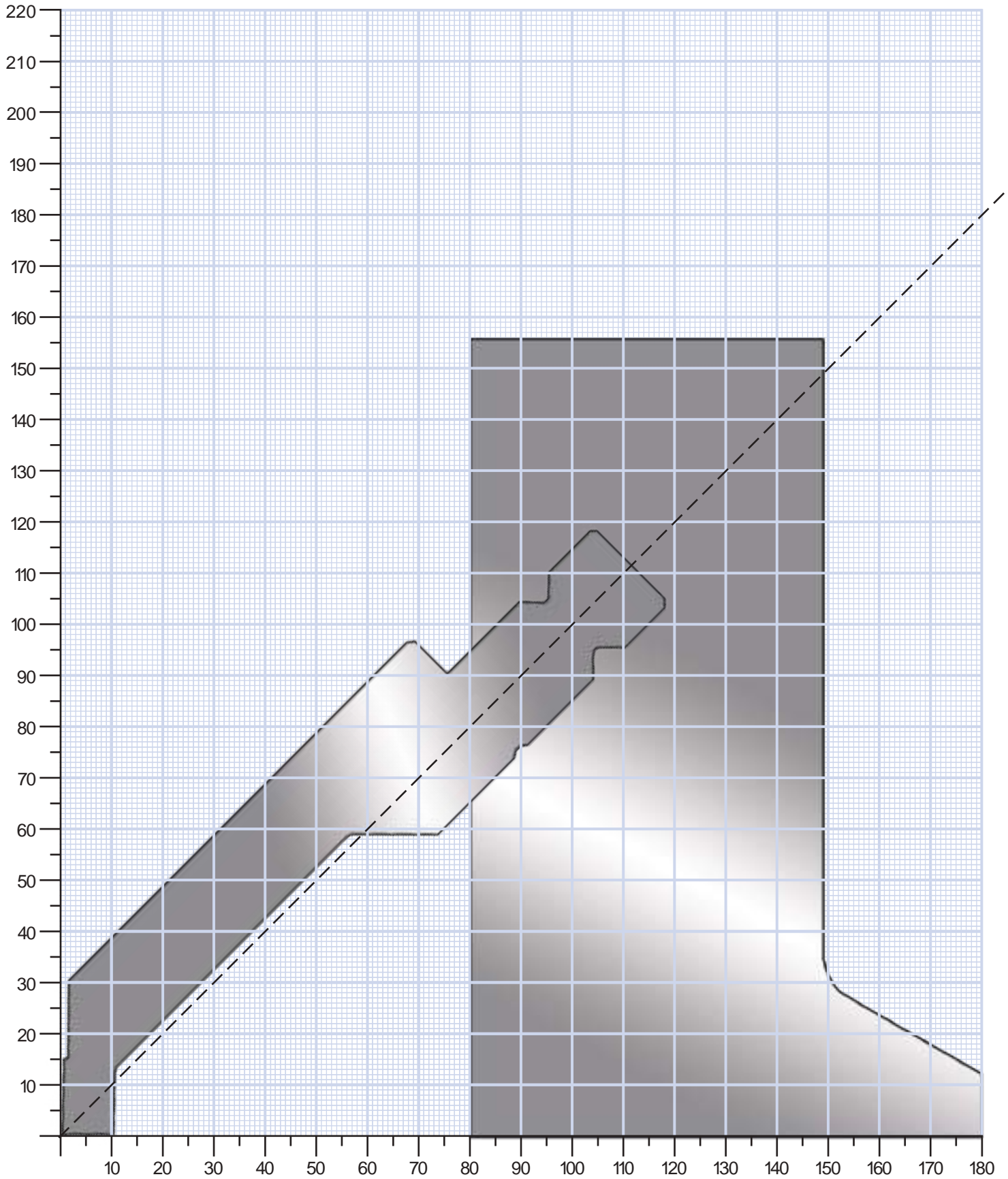
# Bend Limit Graph

TOW280 Thin Tip Punch



# Bend Limit Graph

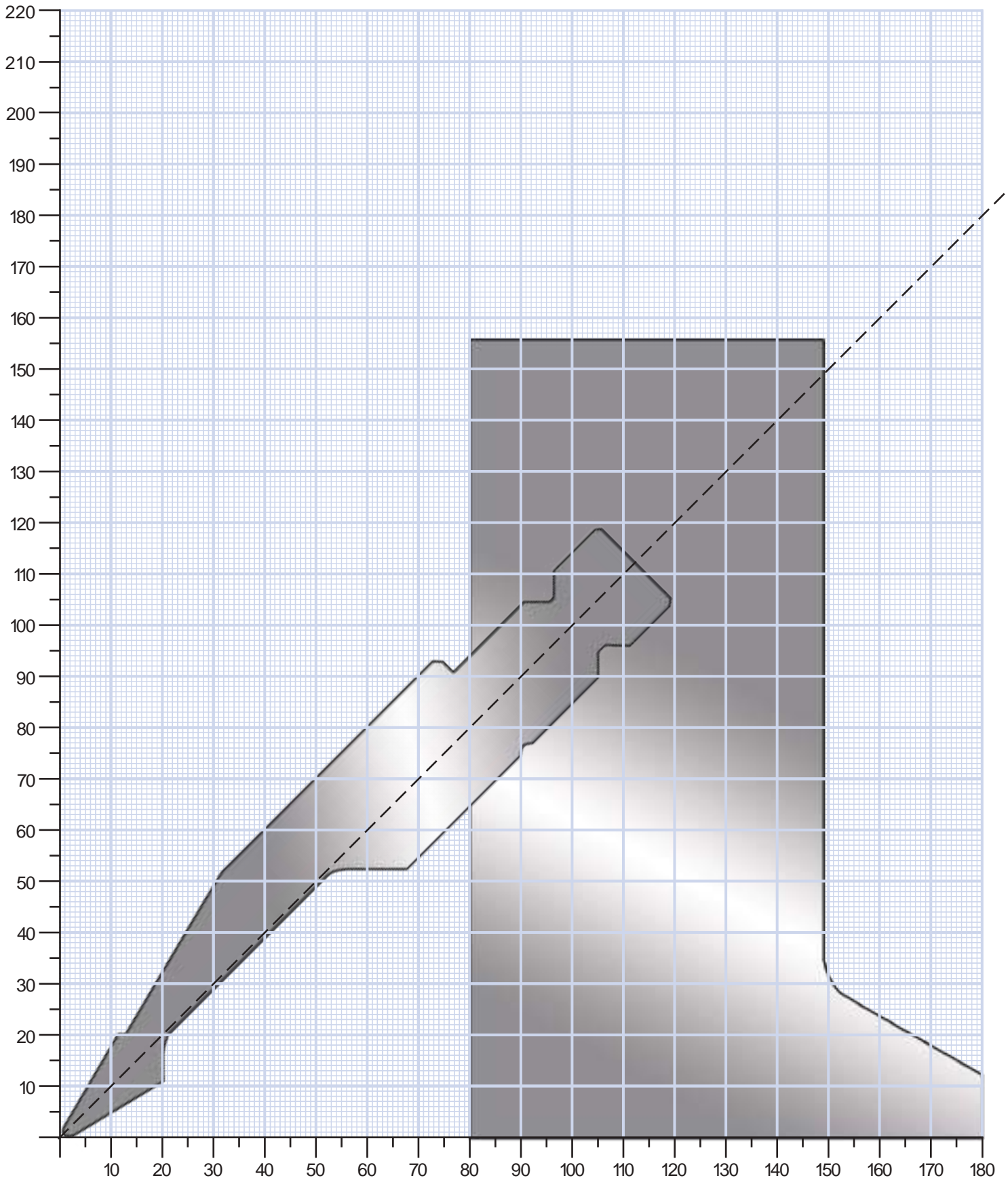
TOW201 Goose-Neck Punch





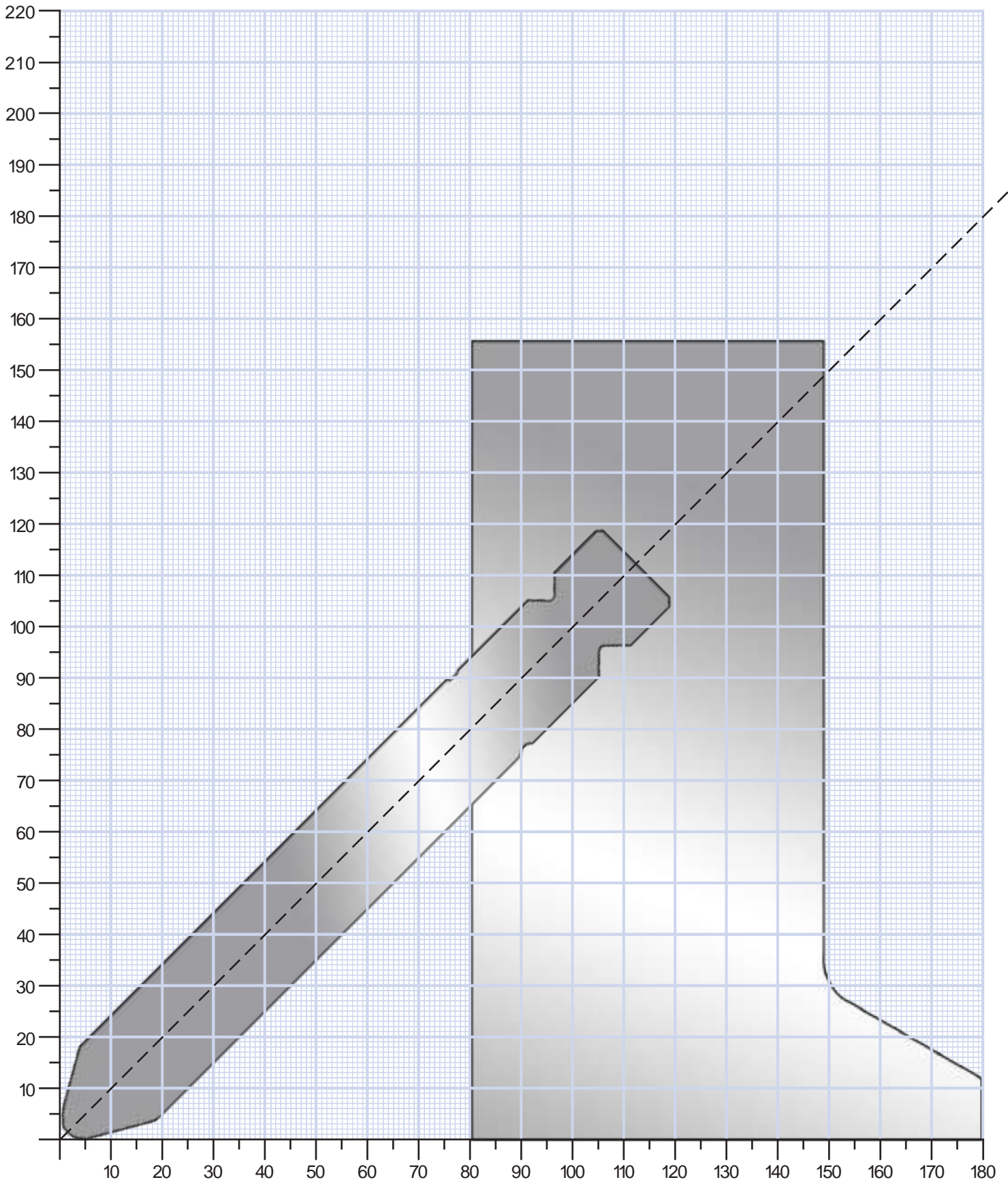
# Bend Limit Graph

TOW202 Pointed with Recess Punch



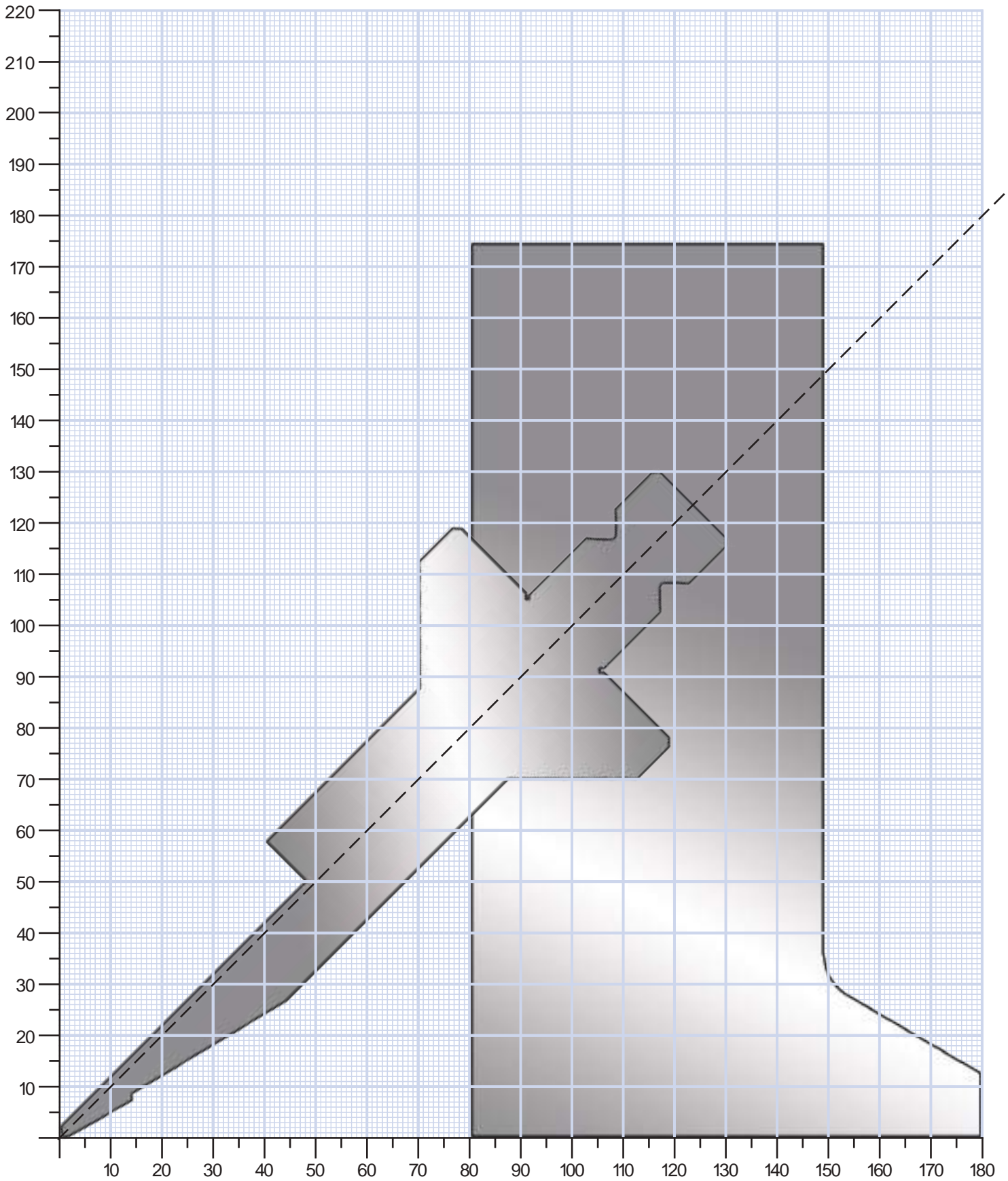
# Bend Limit Graph

TOW203 Pointed/Bottoming Punch



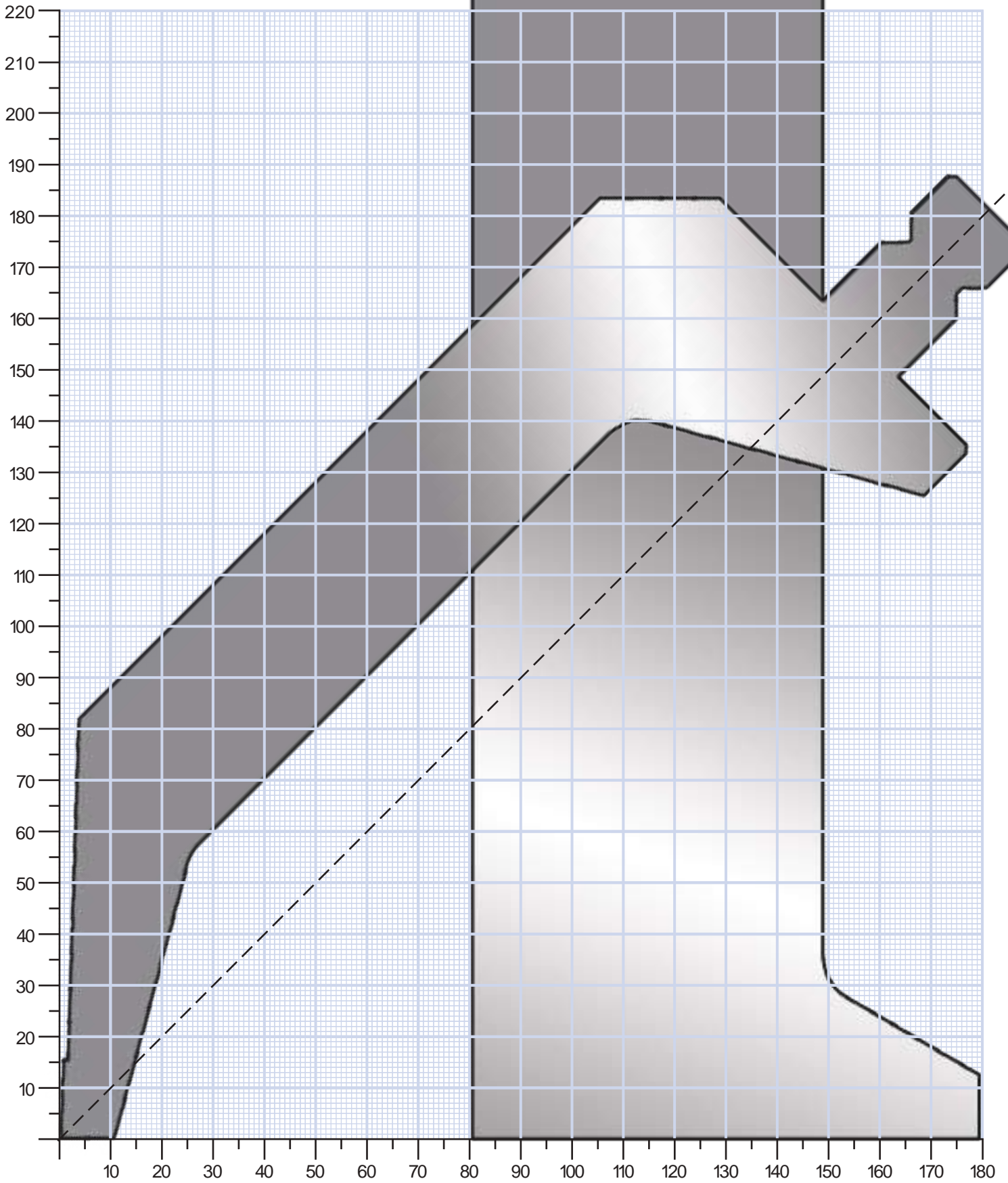
# Bend Limit Graph

TOW210 Pointed with Flattened Spot Punch



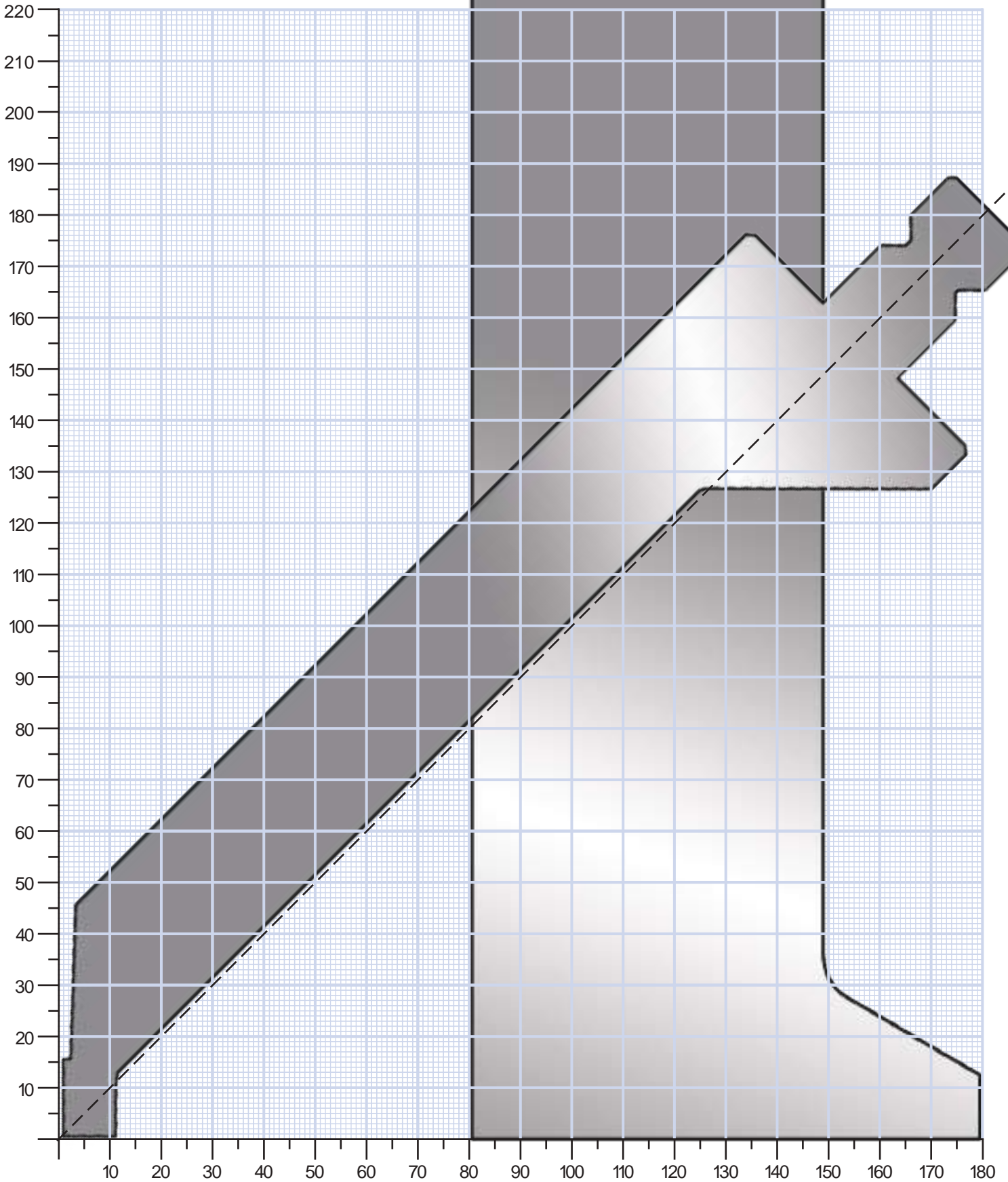
# Bend Limit Graph

TOW200S Swan-Neck Punch



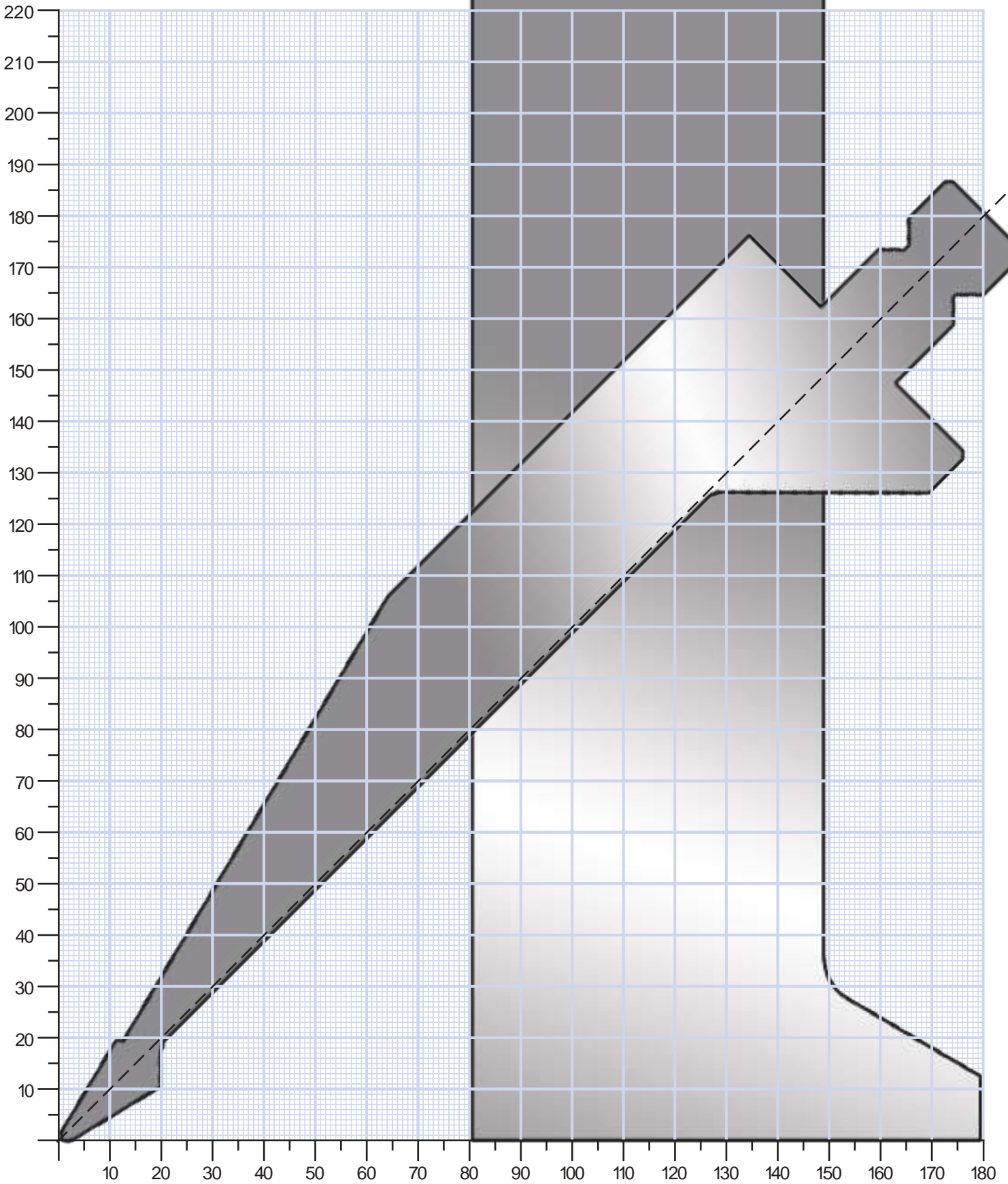
# Bend Limit Graph

TOW201S Goose-Neck Punch



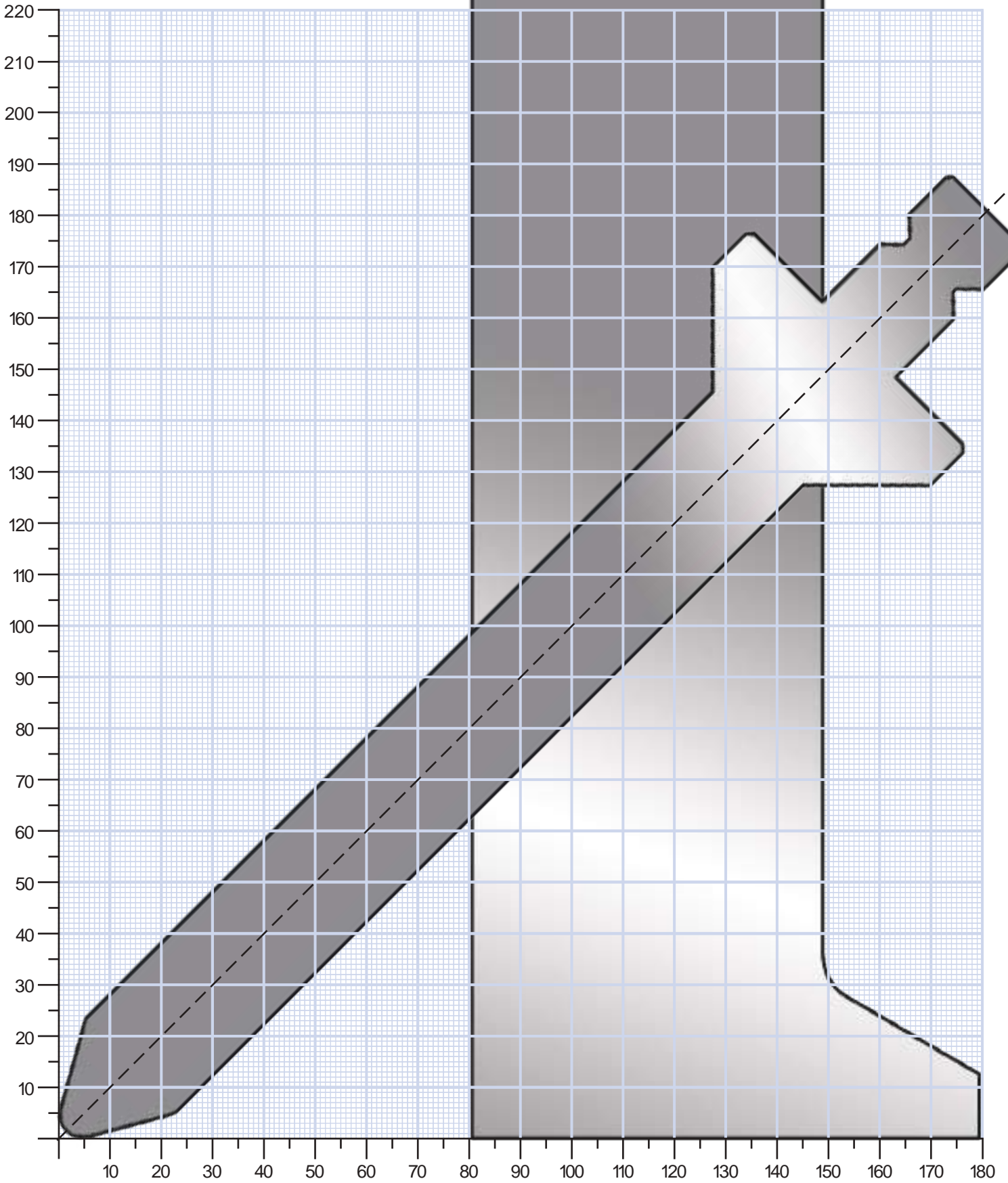
# Bend Limit Graph

TOW202S Pointed with Recess Punch



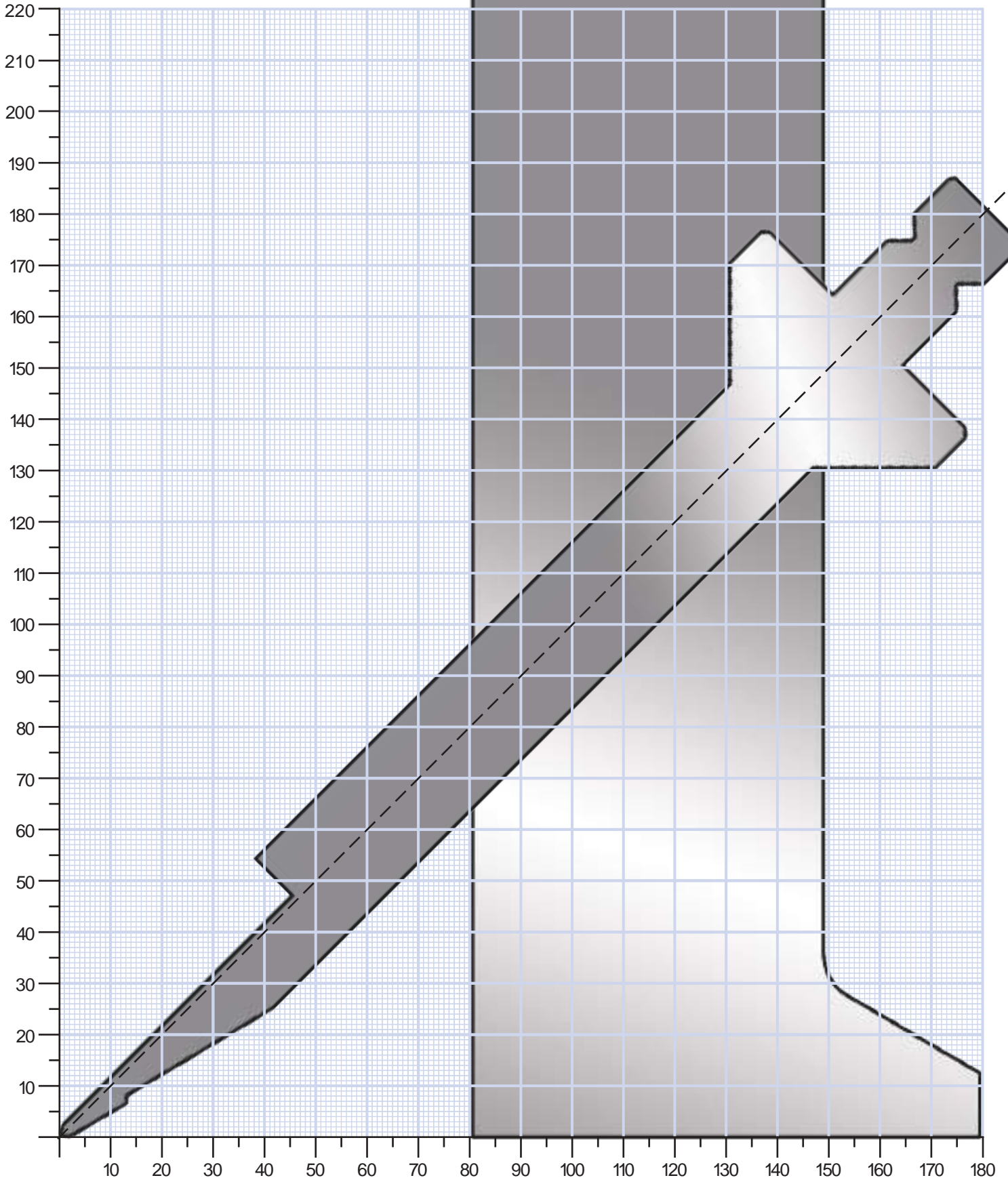
# Bend Limit Graph

TOW203S Pointed/Bottoming Punch



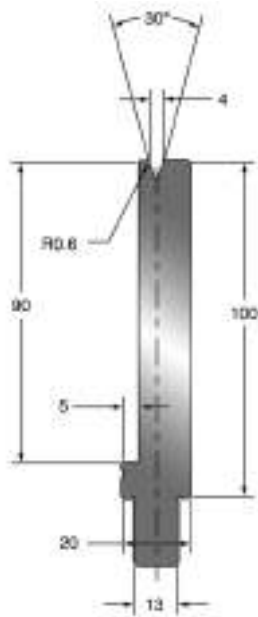
# Bend Limit Graph

TOW210S Pointed with Flattened Spot





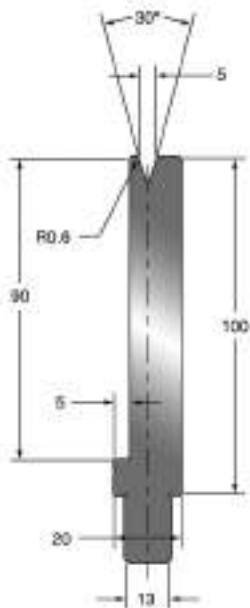
# Die V-Opening = 4mm & 5mm



|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T04S.30°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S-W4/30°</b> |
| V-Opening                 | 4                  |
| Angle                     | 30°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>150 kN/m</b>    |
| <b>Weight:</b>            | <b>14.0 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

## Bolt Holes Standard



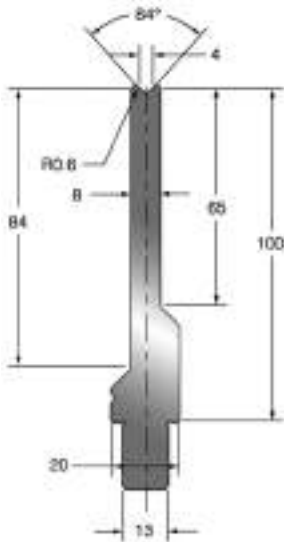
|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T05S.30°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S-W5/30°</b> |
| V-Opening                 | 5                  |
| Angle                     | 30°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>150 kN/m</b>    |
| <b>Weight:</b>            | <b>13.9 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

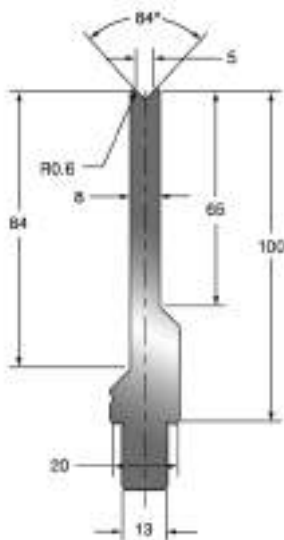
## Bolt Holes Standard

# Die V-Opening = 4mm & 5mm



|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T04S.84°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S-W4/84°</b> |
| V-Opening                 | 4                  |
| Angle                     | 84°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>250 kN/m</b>    |
| <b>Weight:</b>            | <b>10.3 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

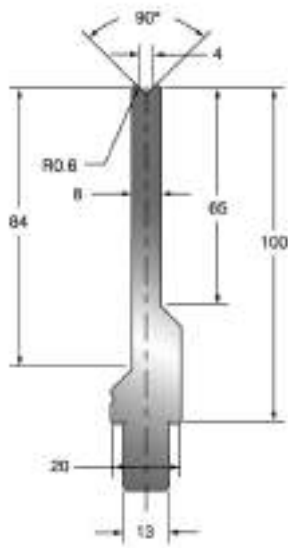


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T05S.84°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S-W5/84°</b> |
| V-Opening                 | 5                  |
| Angle                     | 84°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>250 kN/m</b>    |
| <b>Weight:</b>            | <b>10.2 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

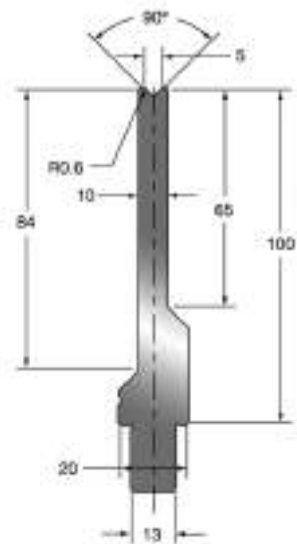
Dimensions in mm

# Die V-Opening = 4mm & 5mm



|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T04S.90°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S-W4/90°</b> |
| V-Opening                 | 4                  |
| Angle                     | 90°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>250 kN/m</b>    |
| <b>Weight:</b>            | <b>10.8 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

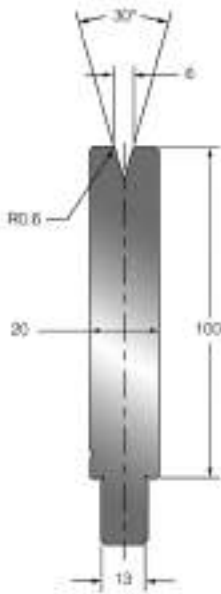


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T05S.90°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S-W5/90°</b> |
| V-Opening                 | 5                  |
| Angle                     | 90°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>390 kN/m</b>    |
| <b>Weight:</b>            | <b>11.9 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

# Die V-Opening = 6mm

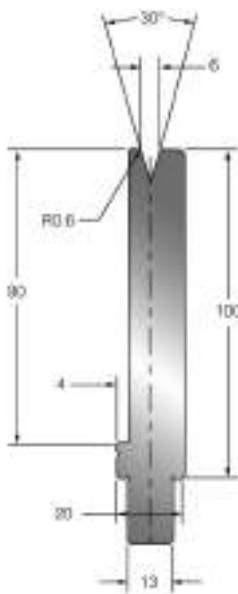


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T06.30°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV001 30°</b> |
| V-Opening                 | 6                |
| Angle                     | 30°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>17.3 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T06.30° also available with H=150

## Bolt Holes Standard



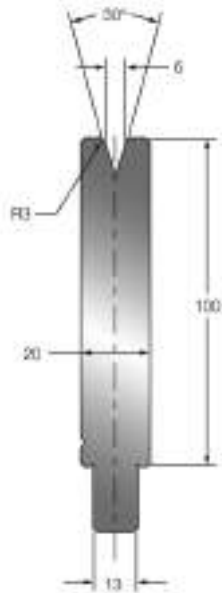
|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T06S.30°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV001/S 30°</b> |
| V-Opening                 | 6                  |
| Angle                     | 30°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>170 kN/m</b>    |
| <b>Weight:</b>            | <b>14.5 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

## Bolt Holes Standard

# Die V-Opening = 6mm



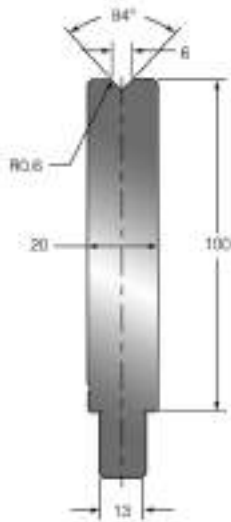
|                           |                     |
|---------------------------|---------------------|
| <b>Toolspress Profile</b> | <b>T06.30° R3</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV001 R3 30°</b> |
| V-Opening                 | 6                   |
| Angle                     | 30°                 |
| Height                    | 100                 |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>     |
| <b>Weight:</b>            | <b>17.2 kg/m</b>    |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

**Bolt Holes Standard**

Dimensions in mm

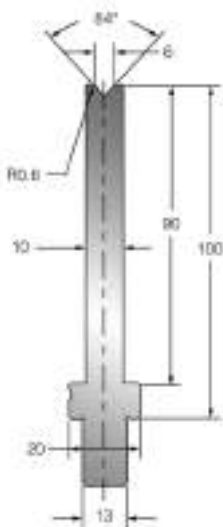
# Die V-Opening = 6mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T06.84°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV W6 84°</b> |
| V-Opening                 | 6                |
| Angle                     | 84°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>17.6 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T06.84° also available with H=150

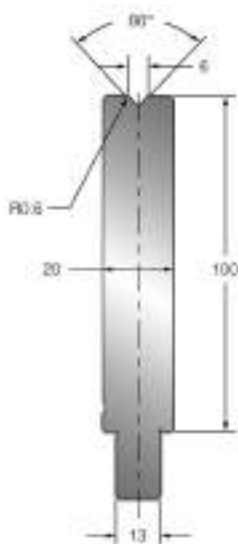


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T06S.84°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S W6 84°</b> |
| V-Opening                 | 6                  |
| Angle                     | 84°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>250 kN/m</b>    |
| <b>Weight:</b>            | <b>10.6 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

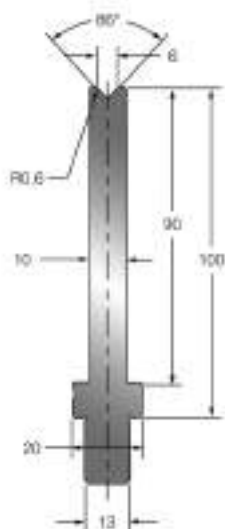
Dimensions in mm

# Die V-Opening = 6mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T06.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV020 86°</b> |
| V-Opening                 | 6                |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>17.6 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

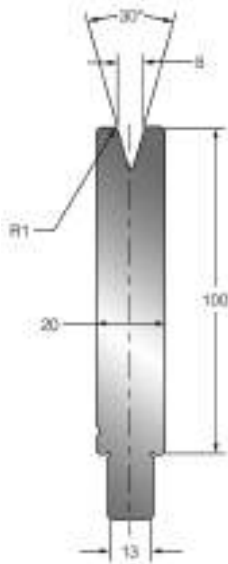


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T06S.86°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV020/S 86°</b> |
| V-Opening                 | 6                  |
| Angle                     | 86°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>240 kN/m</b>    |
| <b>Weight:</b>            | <b>10.6 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

# Die V-Opening = 8mm

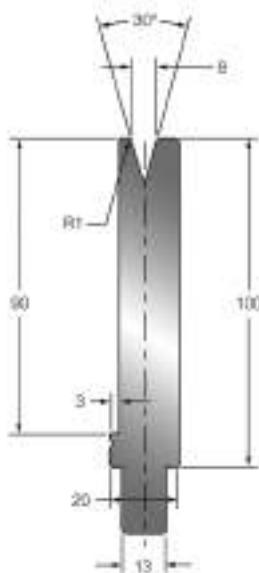


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T08.30°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV002 30°</b> |
| V-Opening                 | 8                |
| Angle                     | 30°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>17.1 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T08.30° also available with H=150

## Bolt Holes Standard



|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T08S.30°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV002/S 30°</b> |
| V-Opening                 | 8                  |
| Angle                     | 30°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>200 kN/m</b>    |
| <b>Weight:</b>            | <b>15.1 kg/m</b>   |

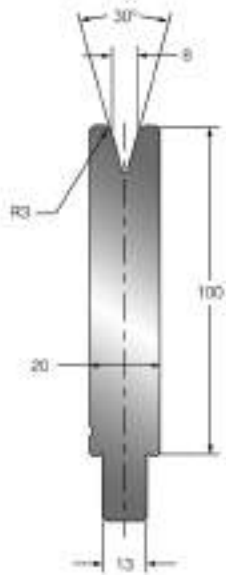
| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

## Bolt Holes Standard



# Die V-Opening = 8mm



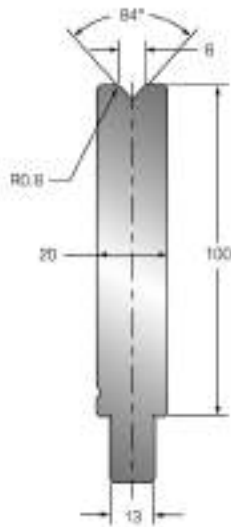
|                           |                     |
|---------------------------|---------------------|
| <b>Toolspress Profile</b> | <b>T08.30° R3</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV002 R3 30°</b> |
| V-Opening                 | 8                   |
| Angle                     | 30°                 |
| Height                    | 100                 |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>     |
| <b>Weight:</b>            | <b>17.0 kg/m</b>    |

| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | Length 250           |
| Length 3050        | Length 550           |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 500                  |
| Length 1050        | 300                  |
| <b>Version A</b>   | 200                  |
| <b>Description</b> | 100                  |
| Length 2050        | 50                   |
| Length 1250        | 45                   |
| Length 1050        | 40                   |
|                    | 35                   |
|                    | 30                   |
|                    | 25                   |

## Bolt Holes Standard

Dimensions in mm

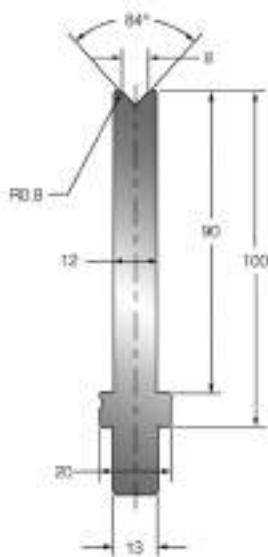
# Die V-Opening = 8mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T08.84°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV W8/84°</b> |
| V-Opening                 | 8                |
| Angle                     | 84°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>17.5 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T08.84° also available with H=150

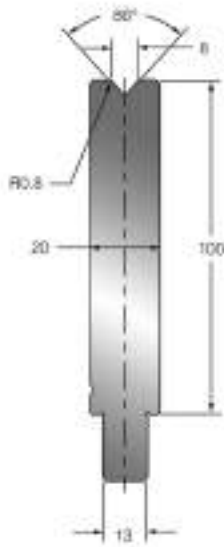


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T08S.84°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV/S W8/84°</b> |
| V-Opening                 | 8                  |
| Angle                     | 84°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>350 kN/m</b>    |
| <b>Weight:</b>            | <b>11.9 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

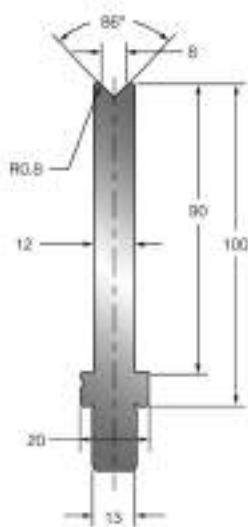
Dimensions in mm

# Die V-Opening = 8mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T08.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV021 86°</b> |
| V-Opening                 | 8                |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>17.6 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

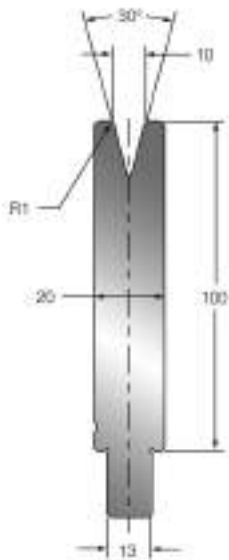


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T08S.86°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV021/S 86°</b> |
| V-Opening                 | 8                  |
| Angle                     | 86°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>310 kN/m</b>    |
| <b>Weight:</b>            | <b>11.9 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

# Die V-Opening = 10mm

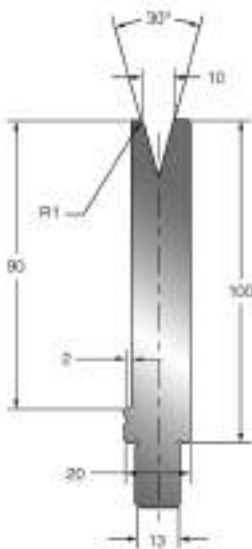


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T10.30°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV003 30°</b> |
| V-Opening                 | 10               |
| Angle                     | 30°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>16.9 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T10.30° also available with H=150

## Bolt Holes Standard



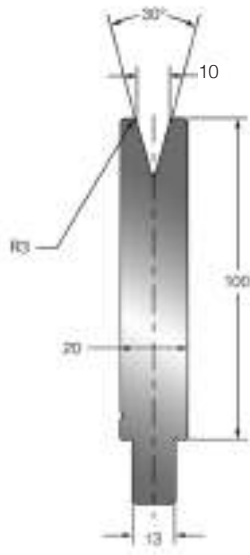
|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T10S.30°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV003/S 30°</b> |
| V-Opening                 | 10                 |
| Angle                     | 30°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>200 kN/m</b>    |
| <b>Weight:</b>            | <b>15.5 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

## Bolt Holes Standard

# Die V-Opening = 10mm



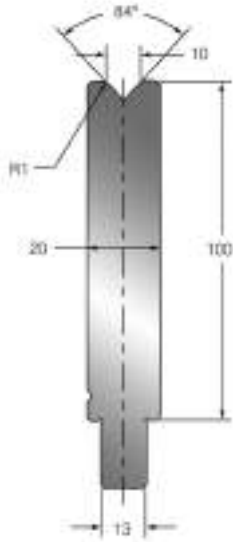
|                           |                     |
|---------------------------|---------------------|
| <b>Toolspress Profile</b> | <b>T10.30° R3</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV003 R3 30°</b> |
| V-Opening                 | 10                  |
| Angle                     | 30°                 |
| Height                    | 100                 |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>     |
| <b>Weight:</b>            | <b>16.7 kg/m</b>    |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

## Bolt Holes Standard

Dimensions in mm

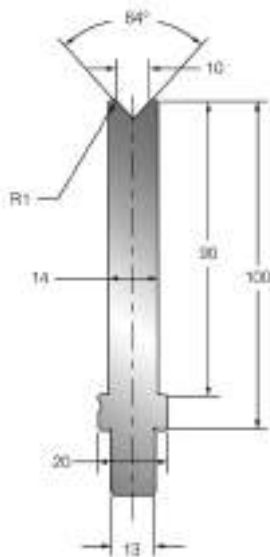
# Die V-Opening = 10mm



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T10.84°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W10/84°</b> |
| V-Opening                 | 10                |
| Angle                     | 84°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>500 kN/m</b>   |
| <b>Weight:</b>            | <b>17.5 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T10.84° also available with H=150

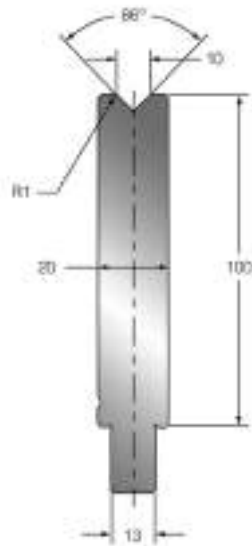


|                           |                     |
|---------------------------|---------------------|
| <b>Toolspress Profile</b> | <b>T10S.84°</b>     |
| <b>Trumpf Cat. No.</b>    | <b>EV/S W10/84°</b> |
| V-Opening                 | 10                  |
| Angle                     | 84°                 |
| Height                    | 100                 |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>     |
| <b>Weight:</b>            | <b>13.3 kg/m</b>    |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

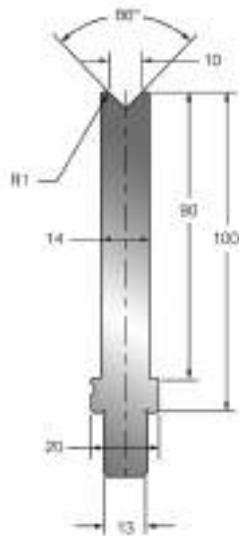
# Die V-Opening = 10mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T10.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV022 86°</b> |
| V-Opening                 | 10               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>500 kN/m</b>  |
| <b>Weight:</b>            | <b>17.5 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T10.86° also available with H=150

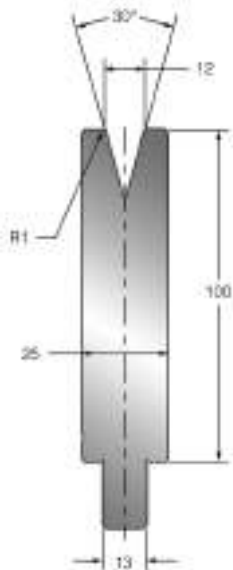


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T10S.86°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV022/S 86°</b> |
| V-Opening                 | 10                 |
| Angle                     | 86°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>380 kN/m</b>    |
| <b>Weight:</b>            | <b>13.3 kg/m</b>   |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

# Die V-Opening = 12mm

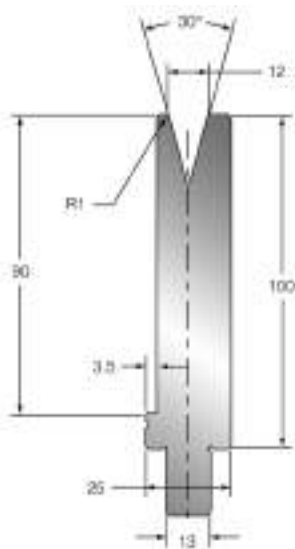


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T12.30°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV004 30°</b> |
| V-Opening                 | 12               |
| Angle                     | 30°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>  |
| <b>Weight:</b>            | <b>20.5 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T12.30° also available with H=150

## Bolt Holes Standard



|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T12S.30°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV004/S 30°</b> |
| V-Opening                 | 12                 |
| Angle                     | 30°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>250 kN/m</b>    |
| <b>Weight:</b>            | <b>18.0 kg/m</b>   |

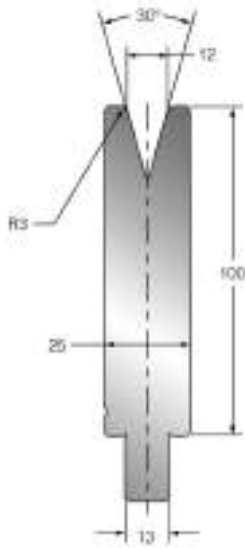
| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

## Bolt Holes Standard



# Die V-Opening = 12mm



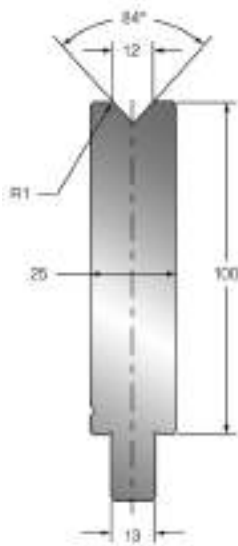
|                           |                     |
|---------------------------|---------------------|
| <b>Toolspress Profile</b> | <b>T12.30° R3</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV004 R3 30°</b> |
| V-Opening                 | 12                  |
| Angle                     | 30°                 |
| Height                    | 100                 |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>     |
| <b>Weight:</b>            | <b>20.3 kg/m</b>    |

| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | Length 250           |
| Length 3050        | Length 550           |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 500                  |
| Length 1050        | 300                  |
| <b>Version A</b>   | 200                  |
| <b>Description</b> | 100                  |
| Length 2050        | 50                   |
| Length 1250        | 45                   |
| Length 1050        | 40                   |
|                    | 35                   |
|                    | 30                   |
|                    | 25                   |

## Bolt Holes Standard

Dimensions in mm

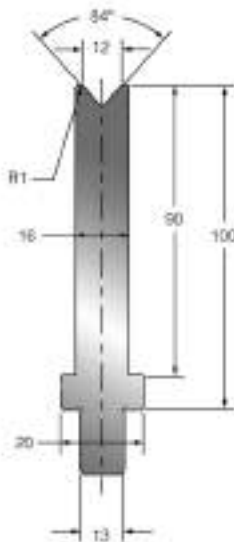
# Die V-Opening = 12mm



| Toolspress Profile      | T12.84°           |
|-------------------------|-------------------|
| <b>Trumpf Cat. No.</b>  | <b>EV W12/84°</b> |
| V-Opening               | 12                |
| Angle                   | 84°               |
| Height                  | 100               |
| <b>Maximum Loading:</b> | <b>500 kN/m</b>   |
| <b>Weight:</b>          | <b>21.4 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T12.84° also available with H=150

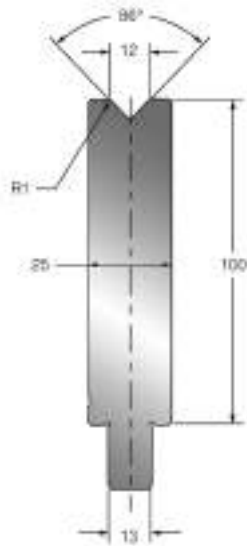


| Toolspress Profile      | T12S.84°            |
|-------------------------|---------------------|
| <b>Trumpf Cat. No.</b>  | <b>EV/S W12/84°</b> |
| V-Opening               | 12                  |
| Angle                   | 84°                 |
| Height                  | 100                 |
| <b>Maximum Loading:</b> | <b>400 kN/m</b>     |
| <b>Weight:</b>          | <b>14.9 kg/m</b>    |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

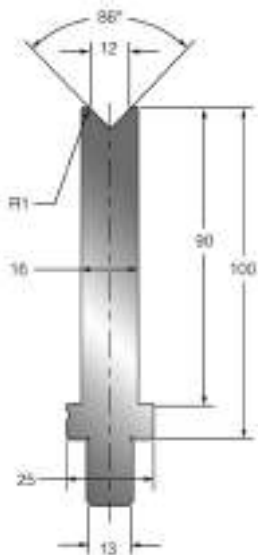
Dimensions in mm

# Die V-Opening = 12mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T12.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV023 86°</b> |
| V-Opening                 | 12               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>500 kN/m</b>  |
| <b>Weight:</b>            | <b>21.4 kg/m</b> |

| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | Length 250           |
| Length 3050        | Length 550           |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 500                  |
| Length 1050        | 300                  |
| <b>Version A</b>   | 200                  |
| <b>Description</b> | 100                  |
| Length 2050        | 50                   |
| Length 1250        | 45                   |
|                    | 40                   |
|                    | 35                   |
|                    | 30                   |
|                    | 25                   |

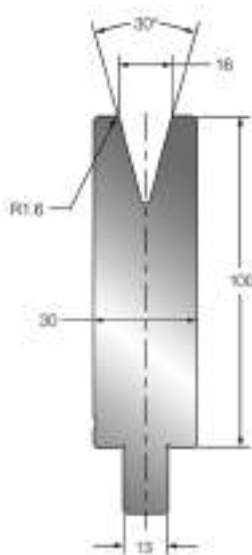


|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T12S.86°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV023/S 86°</b> |
| V-Opening                 | 12                 |
| Angle                     | 86°                |
| Height                    | 100                |
| <b>Maximum Loading:</b>   | <b>400 kN/m</b>    |
| <b>Weight:</b>            | <b>14.9 kg/m</b>   |

| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | Length 250           |
| Length 3050        | Length 550           |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 500                  |
| Length 1050        | 300                  |
| <b>Version A</b>   | 200                  |
| <b>Description</b> | 100                  |
| Length 2050        | 50                   |
| Length 1250        | 45                   |
|                    | 40                   |
|                    | 35                   |
|                    | 30                   |
|                    | 25                   |

Dimensions in mm

# Die V-Opening = 16mm

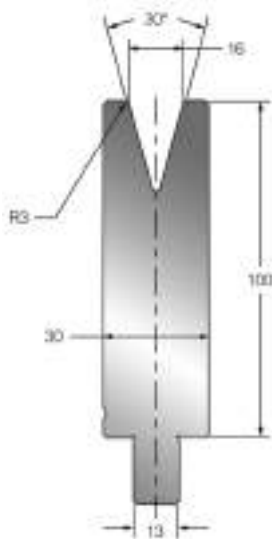


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T16.30°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV005 30°</b> |
| V-Opening                 | 16               |
| Angle                     | 30°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>500 kN/m</b>  |
| <b>Weight:</b>            | <b>23.4 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T16.30° also available with H=150

## Bolt Holes Standard



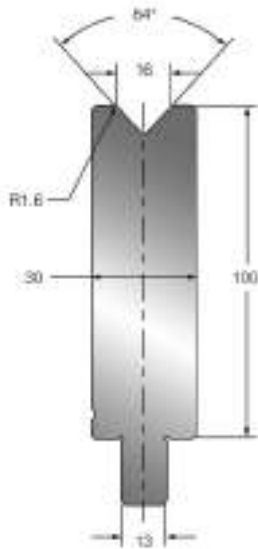
|                           |                     |
|---------------------------|---------------------|
| <b>Toolspress Profile</b> | <b>T16.30° R3</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV005 R3 30°</b> |
| V-Opening                 | 16                  |
| Angle                     | 30°                 |
| Height                    | 100                 |
| <b>Maximum Loading:</b>   | <b>500 kN/m</b>     |
| <b>Weight:</b>            | <b>23.3 kg/m</b>    |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

## Bolt Holes Standard

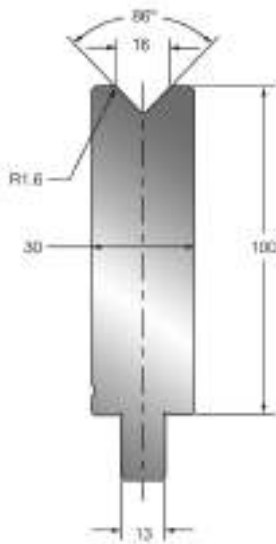
# Die V-Opening = 16mm



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T16.84°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W16/84°</b> |
| V-Opening                 | 16                |
| Angle                     | 84°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>700 kN/m</b>   |
| <b>Weight:</b>            | <b>25.0 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T16.84° also available with H=150

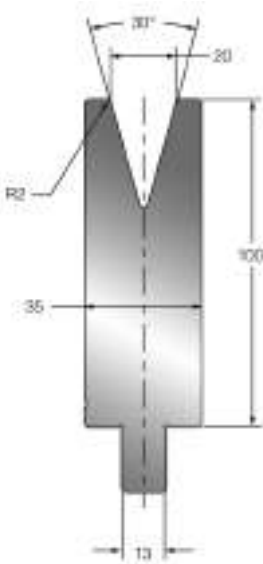


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T16.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV024 86°</b> |
| V-Opening                 | 16               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>700 kN/m</b>  |
| <b>Weight:</b>            | <b>25.0 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

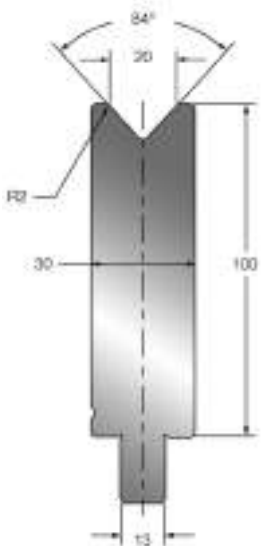
# Die V-Opening = 20mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T20.30°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV006 30°</b> |
| V-Opening                 | 20               |
| Angle                     | 30°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>600 kN/m</b>  |
| <b>Weight:</b>            | <b>26.3 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T20.30° also available with H=150



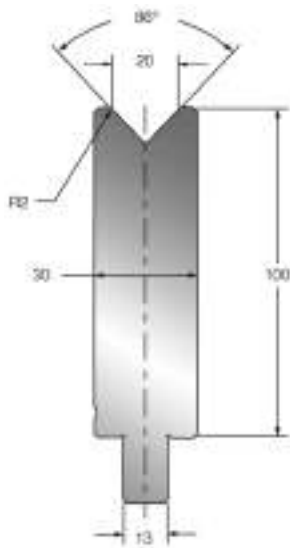
|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T20.84°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W20/84°</b> |
| V-Opening                 | 20                |
| Angle                     | 84°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>700 kN/m</b>   |
| <b>Weight:</b>            | <b>24.6 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T20.84° also available with H=150

Dimensions in mm

# Die V-Opening = 20mm



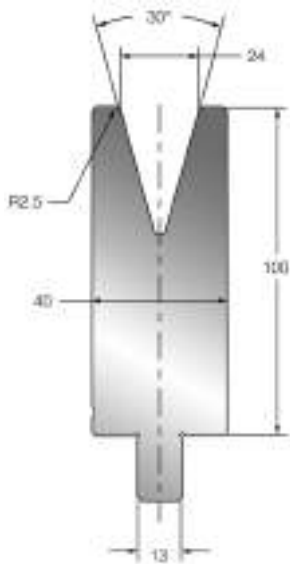
|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T20.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV025 86°</b> |
| V-Opening                 | 20               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>700 kN/m</b>  |
| <b>Weight:</b>            | <b>24.6 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T20.86° also available with H=150

Dimensions in mm

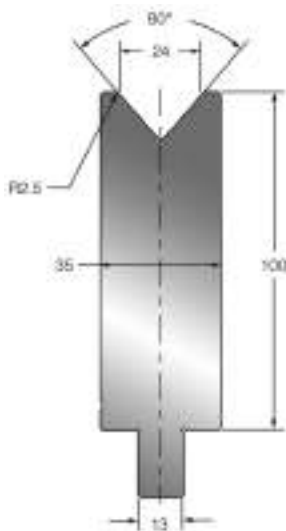
# Die V-Opening = 24mm



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T24.30°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV007 30°</b> |
| V-Opening                 | 24               |
| Angle                     | 30°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>650 kN/m</b>  |
| <b>Weight:</b>            | <b>29.5 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T24.30° also available with H=150



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T24.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W24/80°</b> |
| V-Opening                 | 24                |
| Angle                     | 80°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>700 kN/m</b>   |
| <b>Weight:</b>            | <b>28.1 kg/m</b>  |

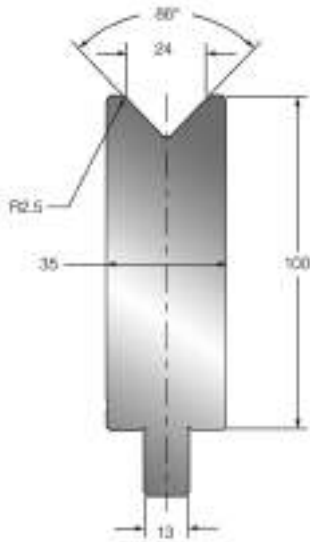
| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T24.80° also available with H=150

Dimensions in mm



# Die V-Opening = 24mm

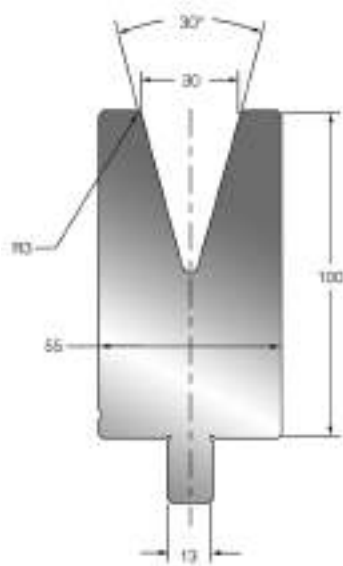


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T24.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV026 86°</b> |
| V-Opening                 | 24               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>700 kN/m</b>  |
| <b>Weight:</b>            | <b>28.2 kg/m</b> |

| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | Length 250           |
| Length 3050        | Length 550           |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 500                  |
| Length 1050        | 300                  |
| <b>Version A</b>   | 200                  |
| <b>Description</b> | 100                  |
| Length 2050        | 50                   |
| Length 1250        | 45                   |
|                    | 40                   |
|                    | 35                   |
|                    | 30                   |
|                    | 25                   |

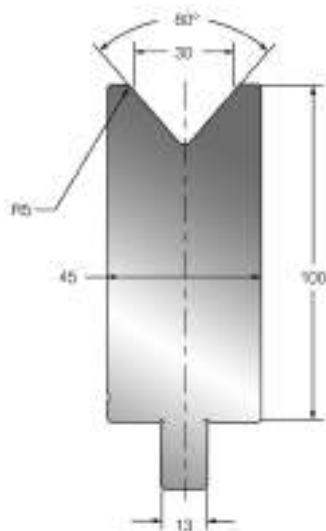
Dimensions in mm

# Die V-Opening = 30mm



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T30.30°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W30/30°</b> |
| V-Opening                 | 30                |
| Angle                     | 30°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>900 kN/m</b>   |
| <b>Weight:</b>            | <b>37.8 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |



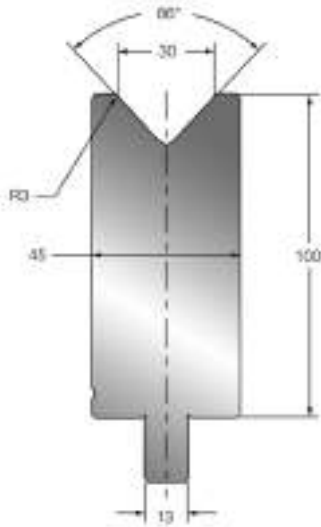
|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T30.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W30/80°</b> |
| V-Opening                 | 30                |
| Angle                     | 80°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>900 kN/m</b>   |
| <b>Weight:</b>            | <b>34.8 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T30.80° also available with H=150

Dimensions in mm

# Die V-Opening = 30mm

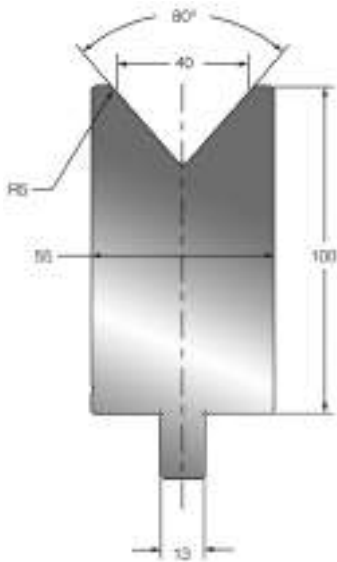


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T30.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV027 86°</b> |
| V-Opening                 | 30               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>750 kN/m</b>  |
| <b>Weight:</b>            | <b>34.7 kg/m</b> |

| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | Length 250           |
| Length 3050        | Length 550           |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 500                  |
| Length 1050        | 300                  |
| <b>Version A</b>   | 200                  |
| <b>Description</b> | 100                  |
| Length 2050        | 50                   |
| Length 1250        | 45                   |
|                    | 40                   |
|                    | 35                   |
|                    | 30                   |
|                    | 25                   |

Dimensions in mm

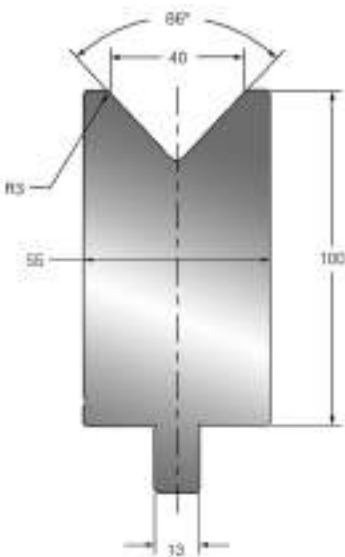
# Die V-Opening = 40mm



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T40.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W40/80°</b> |
| V-Opening                 | 40                |
| Angle                     | 80°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>1200 kN/m</b>  |
| <b>Weight:</b>            | <b>40.8 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T40.80° also available with H=150

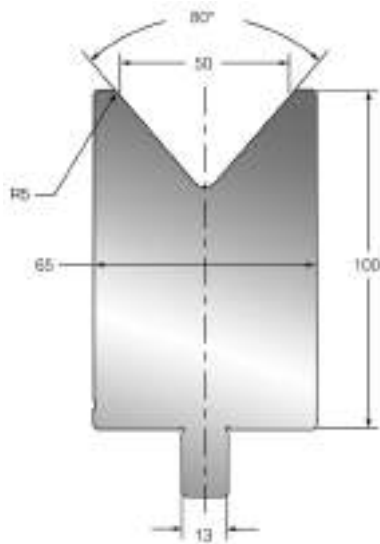


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T40.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV028 86°</b> |
| V-Opening                 | 40               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>1200 kN/m</b> |
| <b>Weight:</b>            | <b>41.6 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

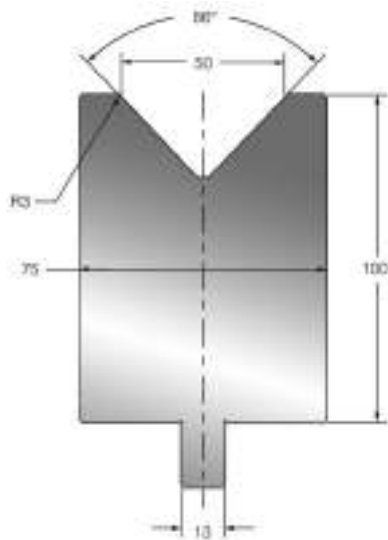
# Die V-Opening = 50mm



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T50.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W50/80°</b> |
| V-Opening                 | 50                |
| Angle                     | 80°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b>  |
| <b>Weight:</b>            | <b>46.4 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Mod. T50.80° also available with H=150

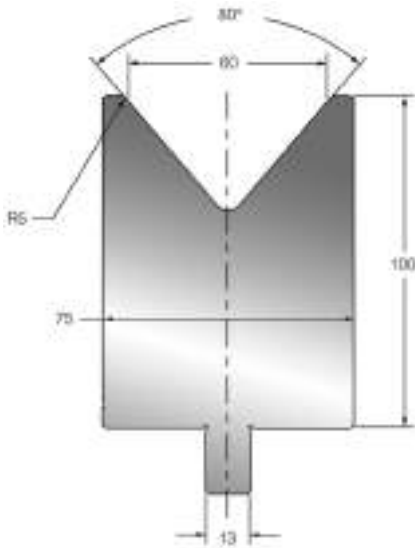


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>T50.86°</b>   |
| <b>Trumpf Cat. No.</b>    | <b>EV029 86°</b> |
| V-Opening                 | 50               |
| Angle                     | 86°              |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b> |
| <b>Weight:</b>            | <b>55.4 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
|                    | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

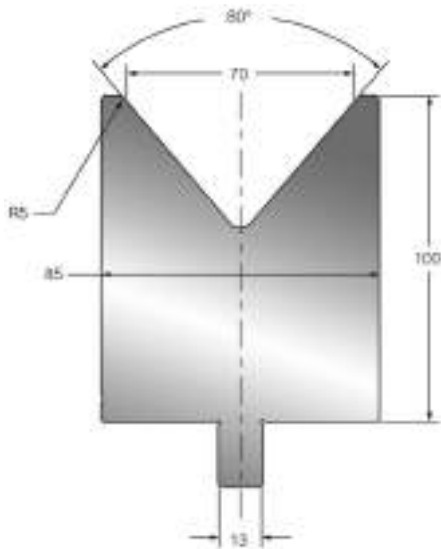
Dimensions in mm

# Die V-Opening = 60mm - 70mm



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T60.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W60/80°</b> |
| V-Opening                 | 60                |
| Angle                     | 80°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b>  |
| <b>Weight:</b>            | <b>51.6 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 300                |
| Length 1050        | 200                |
| <b>Version A</b>   | 100                |
| <b>Description</b> | 50                 |
| Length 2050        | 45                 |
| Length 1250        | 40                 |
| Length 1050        | 35                 |
|                    | 30                 |
|                    | 25                 |

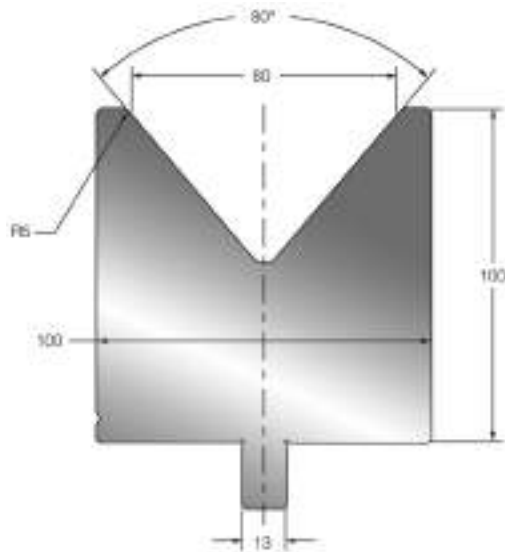


|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T70.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W70/80°</b> |
| V-Opening                 | 70                |
| Angle                     | 80°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b>  |
| <b>Weight:</b>            | <b>56.2 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 300                |
| Length 1050        | 200                |
| <b>Version A</b>   | 100                |
| <b>Description</b> | 50                 |
| Length 2050        | 45                 |
| Length 1250        | 40                 |
| Length 1050        | 35                 |
|                    | 30                 |
|                    | 25                 |

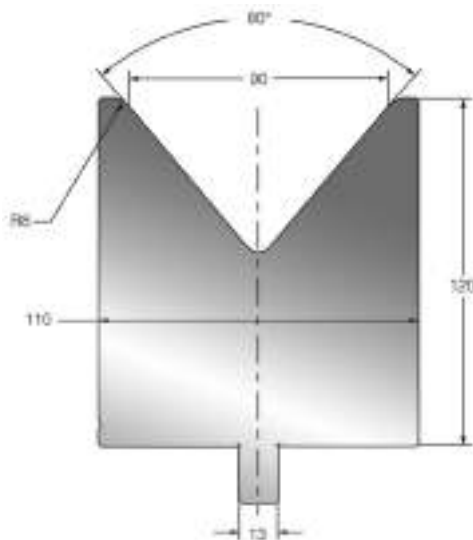
Dimensions in mm

# Die V-Opening = 80mm - 90mm



|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T80.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W80/80°</b> |
| V-Opening                 | 80                |
| Angle                     | 80°               |
| Height                    | 100               |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b>  |
| <b>Weight:</b>            | <b>64.3 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 300                |
| Length 1050        | 200                |
| <b>Version A</b>   | 100                |
| <b>Description</b> | 50                 |
| Length 2050        | 45                 |
| Length 1250        | 40                 |
| Length 1050        | 35                 |
|                    | 30                 |
|                    | 25                 |

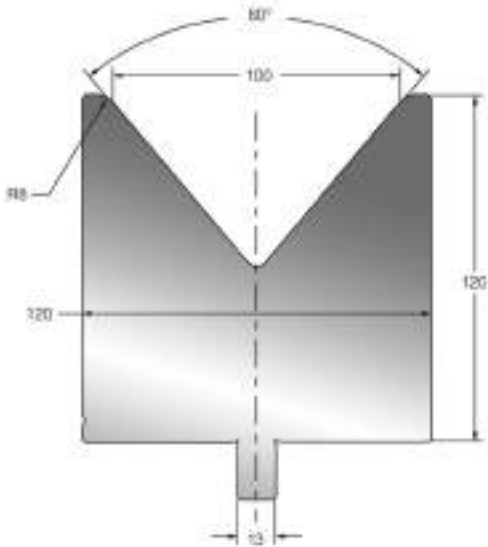


|                           |                   |
|---------------------------|-------------------|
| <b>Toolspress Profile</b> | <b>T90.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W90/80°</b> |
| V-Opening                 | 90                |
| Angle                     | 80°               |
| Height                    | 120               |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b>  |
| <b>Weight:</b>            | <b>84.5 kg/m</b>  |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 200                |
| Length 1050        | 100                |
| <b>Version A</b>   | 50                 |
| <b>Description</b> | 45                 |
| Length 2050        | 40                 |
| Length 1250        | 35                 |
| Length 1050        | 30                 |
|                    | 25                 |

Dimensions in mm

# Die V-Opening = 100mm



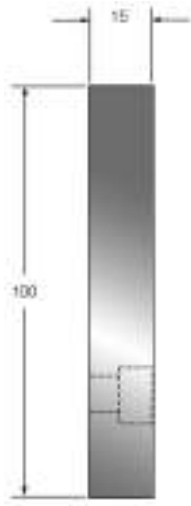
|                           |                    |
|---------------------------|--------------------|
| <b>Toolspress Profile</b> | <b>T100.80°</b>    |
| <b>Trumpf Cat. No.</b>    | <b>EV W100/80°</b> |
| V-Opening                 | 100                |
| Angle                     | 80°                |
| Height                    | 120                |
| <b>Maximum Loading:</b>   | <b>1500 kN/m</b>   |
| <b>Weight:</b>            | <b>89.2 kg/m</b>   |

| <b>Version B</b>   | <b>Sectionalised</b> |
|--------------------|----------------------|
| <b>Description</b> | <b>Description</b>   |
| Length 4050        | Length 250           |
| Length 3050        | Length 550           |
| Length 2550        | <b>Single</b>        |
| Length 2050        | <b>Description</b>   |
| Length 1250        | 200                  |
| Length 1050        | 100                  |
| <b>Version A</b>   | 50                   |
| <b>Description</b> | 45                   |
| Length 2050        | 40                   |
| Length 1250        | 35                   |
| Length 1050        | 30                   |
|                    | 25                   |

Dimensions in mm

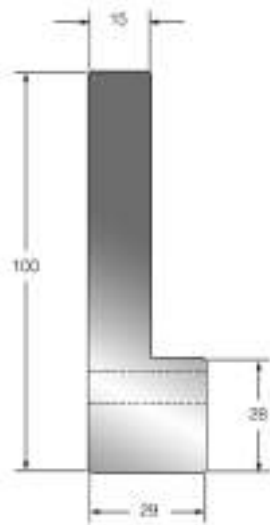


# Hemming



|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>ZDL 100</b>   |
| <b>Trumpf Cat. No.</b>    | <b>ZDL</b>       |
| Height                    | 100              |
| <b>Maximum Loading:</b>   | <b>1300 kN/m</b> |
| <b>Weight:</b>            | <b>11.6 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

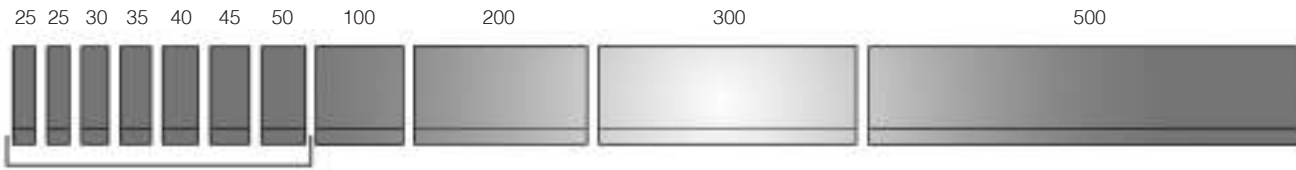


|                           |                  |
|---------------------------|------------------|
| <b>Toolspress Profile</b> | <b>FWZ 100</b>   |
| <b>Trumpf Cat. No.</b>    | <b>FWZ</b>       |
| V-Opening                 | 100              |
| <b>Maximum Loading:</b>   | <b>1200 kN/m</b> |
| <b>Weight:</b>            | <b>14.8 kg/m</b> |

| Version B          | Sectionalised      |
|--------------------|--------------------|
| <b>Description</b> | <b>Description</b> |
| Length 4050        | Length 250         |
| Length 3050        | Length 550         |
| Length 2550        | <b>Single</b>      |
| Length 2050        | <b>Description</b> |
| Length 1250        | 500                |
| Length 1050        | 300                |
| <b>Version A</b>   | 200                |
| <b>Description</b> | 100                |
| Length 2050        | 50                 |
| Length 1250        | 45                 |
| Length 1050        | 40                 |
|                    | 35                 |
|                    | 30                 |
|                    | 25                 |

Dimensions in mm

# System Division - Dies



Basic Division 250mm

## Division version for tool sets with a weight up to 50 kg/m

### System Division Version B

| Set   | 250X | 100 | 200 | 300 | 500 |
|-------|------|-----|-----|-----|-----|
| 550   | 1    | 3   | 0   | 0   | 0   |
| 1050B | 1    | 3   | 1   | 1   | 0   |
| 1250B | 1    | 3   | 2   | 1   | 0   |
| 2050B | 1    | 3   | 1   | 1   | 2   |
| 2550B | 1    | 3   | 1   | 1   | 3   |
| 3050B | 1    | 3   | 1   | 1   | 4   |
| 4050B | 1    | 3   | 1   | 1   | 6   |

## Division version for tool sets with weights starting from 50 kg/m

### For Dies: T60.80°, T70.80° & T80.80° ONLY

| Set   | 250X | 100 | 200 | 300 |
|-------|------|-----|-----|-----|
| 550   | 1    | 3   | 0   | 0   |
| 1050  | 1    | 3   | 1   | 1   |
| 1250B | 1    | 3   | 2   | 1   |
| 2050B | 1    | 3   | 3   | 3   |
| 2550B | 1    | 3   | 4   | 4   |
| 3050B | 1    | 3   | 5   | 5   |
| 4050B | 1    | 3   | 7   | 7   |

## Division version for tool sets with weights of more than 83 kg/m

### For Dies: T90.80° & T100.80° ONLY

| Set   | 250X | 100 | 200 |
|-------|------|-----|-----|
| 550   | 1    | 3   | 0   |
| 1050  | 1    | 2   | 3   |
| 1250B | 1    | 4   | 3   |
| 2050B | 1    | 6   | 6   |
| 2550B | 1    | 7   | 8   |
| 3050B | 1    | 8   | 10  |
| 4050B | 1    | 10  | 14  |

- Benefits:
- High flexibility
  - Short tool set-up time
  - Low purchase cost

- Fewer tool change-overs
- Version most often selected and recommended

25 25 30 35 40 45 50 100



Basic Division 250mm

## System Division Version A

| Set   | 250X | 100 |
|-------|------|-----|
| 550   | 1    | 3   |
| 1050A | 1    | 8   |
| 1250A | 1    | 10  |
| 2050A | 1    | 18  |

- Benefits:
- Maximum flexibility
  - Minimum tool set-up time
  - Weight of the individual part pieces very low

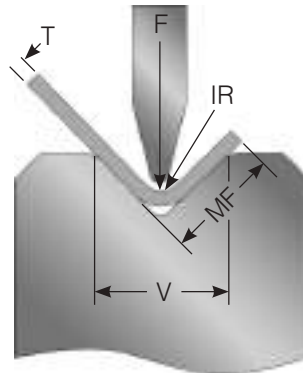
## System Division Version B/A

The combination of a punch block A-division and a die in B-division will not cause any problems.

# Press Force Table

## Required Press Force for 90° Air Bends

T = Material Thickness  
 F = Press Force (kN/m)  
 IR = Inside Radius  
 MF = Minimum Flange  
 V = Die V Opening



### Notes

- \* Optimum Die
- F in kN
- T, MF, V, IR in mm

|                    |     | Material 400 N / mm <sup>2</sup> Mild Steel |     |      |      |      |      |      |      |      |      |      |      |      |      |     |     |       |
|--------------------|-----|---|-----|------|------|------|------|------|------|------|------|------|------|------|------|-----|-----|-------|
| Material Thickness |     | 6   | 8   | 10   | 12   | 16   | 20   | 24   | 30   | 40   | 50   | 60   | 70   | 80   | 90   | 100 | 120 | V     |
|                    |     | 4.5   | 6   | 7.5  | 9    | 12   | 15   | 18   | 22.5 | 30   | 37.5 | 45   | 52.5 | 60   | 67.5 | 75  | 90  | MF    |
|                    |     | 1   | 1.3 | 1.6  | 1.9  | 2.6  | 3.2  | 3.8  | 4.8  | 6.4  | 8    | 9.6  | 11   | 13   | 14   | 16  | 19  | IR    |
| 0.75               | 52* | 39  | 31  | 26   |      |      |      |      |      |      |      |      |      |      |      |     |     |       |
| 1                  | 93  | 70*   | 56  | 47   | 35   |      |      |      |      |      |      |      |      |      |      |     |     |       |
| 1.25               | 145 | 109   | 87* | 73   | 55   | 44   |      |      |      |      |      |      |      |      |      |     |     |       |
| 1.5                | 209 | 157   | 126 | 105* | 79   | 63   |      |      |      |      |      |      |      |      |      |     |     |       |
| 1.75               |     | 214   | 171 | 143* | 107  | 86   | 71   |      |      |      |      |      |      |      |      |     |     |       |
| 2                  |     |   | 223 | 186  | 140* | 112  | 93   |      |      |      |      |      |      |      |      |     |     |       |
| 2.5                |     |   |     | 291  | 218  | 175* | 145  | 116  |      |      |      |      |      |      |      |     |     |       |
| 3                  |     |   |     |      | 314  | 251  | 209* | 168  | 126  |      |      |      |      |      |      |     |     |       |
| 3.5                |     |   |     |      | 428  | 342  | 285  | 228* | 171  | 137  |      |      |      |      |      |     |     |       |
| 4                  |     |   |     |      |      | 447  | 372  | 298* | 223  | 179  | 149  |      |      |      |      |     |     | F / m |
| 4.5                |     |   |     |      |      | 566  | 471  | 377  | 283* | 226  | 189  | 162  |      |      |      |     |     |       |
| 5                  |     |   |     |      |      |      |      | 466  | 349* | 279  | 233  | 200  | 175  |      |      |     |     |       |
| 6                  |     |   |     |      |      |      |      | 670  | 503  | 402* | 335  | 287  | 251  | 223  |      |     |     |       |
| 7                  |     |   |     |      |      |      |      |      | 684  | 547* | 456* | 391  | 342  | 304  | 274  |     |     |       |
| 8                  |     |   |     |      |      |      |      |      |      | 715  | 596* | 511* | 447  | 397  | 358  | 298 |     |       |
| 10                 |     |   |     |      |      |      |      |      |      |      |      | 798* | 698* | 621  | 559  | 466 |     |       |
| 12                 |     |   |     |      |      |      |      |      |      |      |      |      | 1005 | 894* | 804* | 670 |     |       |

|                    |     | Material 700 N / mm <sup>2</sup> Stainless Steel |      |      |      |      |      |      |      |      |      |       |       |       |       |      |     |       |
|--------------------|-----|--|------|------|------|------|------|------|------|------|------|-------|-------|-------|-------|------|-----|-------|
| Material Thickness |     | 6  | 8    | 10   | 12   | 16   | 20   | 24   | 30   | 40   | 50   | 60    | 70    | 80    | 90    | 100  | 120 | V     |
|                    |     | 4.5  | 6    | 7.5  | 9    | 12   | 15   | 18   | 22.5 | 30   | 37.5 | 45    | 52.5  | 60    | 67.5  | 75   | 90  | MF    |
|                    |     | 1  | 1.3  | 1.6  | 1.9  | 2.6  | 3.2  | 3.8  | 4.8  | 6.4  | 8    | 9.6   | 11    | 13    | 14    | 16   | 19  | IR    |
| 0.75               | 87* | 65   | 52   | 44   |      |      |      |      |      |      |      |       |       |       |       |      |     |       |
| 1                  | 155 | 116*   | 93   | 78   | 58   |      |      |      |      |      |      |       |       |       |       |      |     |       |
| 1.25               | 242 | 182  | 145* | 121  | 91   | 73   |      |      |      |      |      |       |       |       |       |      |     |       |
| 1.5                | 349 | 262  | 209  | 175* | 131  | 105  |      |      |      |      |      |       |       |       |       |      |     |       |
| 1.75               |     | 356  | 285  | 238* | 178* | 143  | 119  |      |      |      |      |       |       |       |       |      |     |       |
| 2                  |     |  | 372  | 310  | 233* | 186  | 155  |      |      |      |      |       |       |       |       |      |     |       |
| 2.5                |     |  |      | 485  | 364  | 291* | 242  | 194  |      |      |      |       |       |       |       |      |     |       |
| 3                  |     |  |      |      | 524  | 419  | 349* | 279  | 209  |      |      |       |       |       |       |      |     |       |
| 3.5                |     |  |      |      |      | 570  | 475  | 380* | 285  | 228  |      |       |       |       |       |      |     |       |
| 4                  |     |  |      |      |      |      | 621  | 497* | 372  | 298  | 248  |       |       |       |       |      |     | F / m |
| 4.5                |     |  |      |      |      |      |      | 628  | 471* | 377  | 314  | 269   |       |       |       |      |     |       |
| 5                  |     |  |      |      |      |      |      |      | 582* | 466  | 388  | 333   | 291   |       |       |      |     |       |
| 6                  |     |  |      |      |      |      |      |      | 838  | 670* | 559  | 479   | 419   |       |       |      |     |       |
| 7                  |     |  |      |      |      |      |      |      |      | 912* | 760* | 652   | 570   | 507   |       |      |     |       |
| 8                  |     |  |      |      |      |      |      |      |      | 1192 | 993* | 851*  | 745   | 662   | 596   |      |     |       |
| 10                 |     |  |      |      |      |      |      |      |      |      |      | 1330* | 1164* | 1034  | 931   | 776  |     |       |
| 12                 |     |  |      |      |      |      |      |      |      |      |      |       | 1675  | 1490* | 1340* | 1118 |     |       |

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