

Precision Ground

**PRESS BRAKE
TOOLING**

American Style

American Style PRESS BRAKE TOOLING

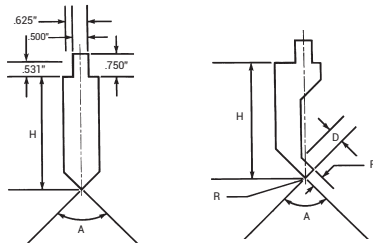
FAB SUPPLY'S precision ground American style press brake tooling is designed to meet the exacting needs of today's high precision metal fabricator.

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

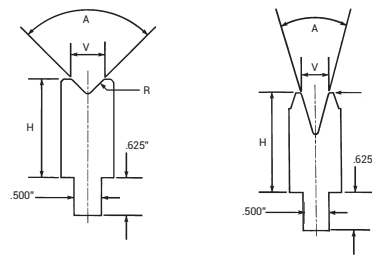
The critical tolerances of all tools are precision ground to within +/- 0.0008 in. In addition, to ensure long lasting accuracy, this high quality tool steel is induction hardened to 50-56 HRC on all working surfaces. Available sectionalized as well as in standard lengths of 36 and 18 inches, this tooling allows for a variety of fast, easy, one-man machine setups.

Precision tooling is a key element of optimal press brake performance, increases accuracy and efficiency and is the key to success.

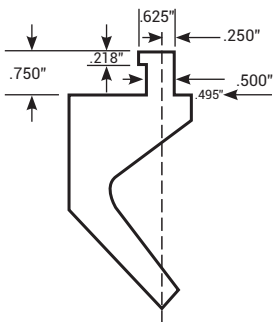
PUNCH DIMENSIONS



DIE DIMENSIONS



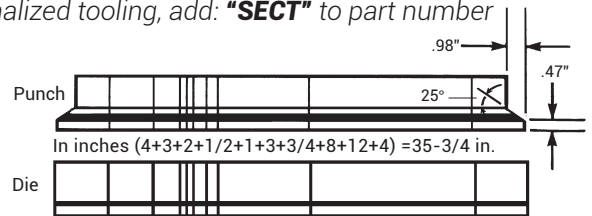
SAFETY TANG



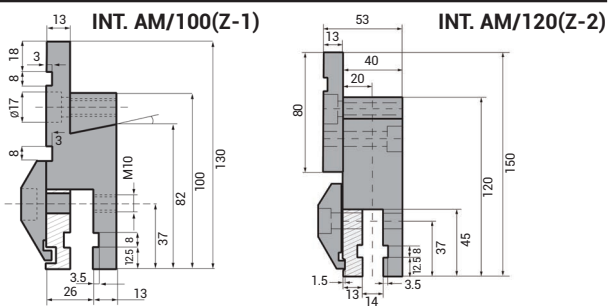
Safety Tangs are standard on all precision ground punches.

SECTIONALIZED TOOLING

Fab Supply's precision ground punches and dies are available sectionalized for convenience and efficiency. Ten matched pieces complete one set of tooling, as shown. When ordering sectionalized tooling, add: **"SECT"** to part number

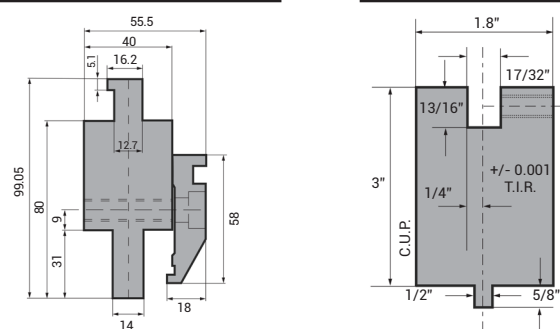


UNIVERSAL TOOL HOLDERS



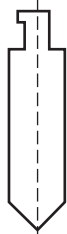

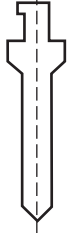





Enables your European press brake to accept American and European style tooling.







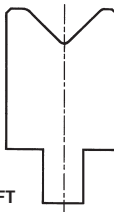
AMERICAN TO EURO PUNCH HOLDER PRECISION GROUND DIE HOLDER



85°/88°/90° PUNCHES




88° AND 90° LOWER DIES

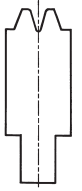
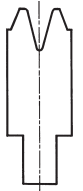



	EP1 H = 3.779 A = 90° R = .010		EP2-90 H = 3.779 A = 90° R = .060
44 T/FT		44 T/FT	EP2-88 H = 3.779 A = 88° R = .060
	EP1A-90 H = 3.779 A = 90° R = .010		EGPA-90 H = 3.779 A = 90° D = .437 F = .250 R = .015
44 T/FT		15 T/FT	EP1A-88 H = 3.779 A = 88° R = .010
	EGPB-90 H = 3.779 A = 90° D = .551 F = .375 R = .015		EGPC-90 H = 3.779 A = 90° D = .630 F = .500 R = .030
22 T/FT		26 T/FT	EGPB-88 H = 3.779 A = 88° D = .551 F = .375 R = .015
	EGP7A-90 H = 3.779 A = 90° D = 1.812 F = .433 R = .030		EGPC-85 H = 3.779 A = 85° D = .630 F = .500 R = .030
15 T/FT		26 T/FT	EGP7A-88 H = 3.779 A = 88° D = 1.812 F = .433 R = .030

	ELD90-1/4 H = 1.937 A = 90° V = .250 R = .030		ELD90-3/8 H = 1.937 A = 90° V = .375 R = .045
30 T/FT		30 T/FT	ELD88-3/8 H = 1.937 A = 88° V = .375 R = .045
	ELD90-1/2 H = 1.937 A = 90° V = .500 R = .060		ELD90-5/8 H = 1.937 A = 90° V = .625 R = .075
30 T/FT		30 T/FT	ELD88-5/8 H = 1.937 A = 88° V = .625 R = .075
	ELD90-3/4 H = 1.937 A = 90° V = .750 R = .150		ELD90-7/8 H = 1.937 A = 90° V = .875 R = .150
30 T/FT		33 T/FT	ELD88-3/4 H = 1.937 A = 88° V = .750 R = .150
			ELD88-7/8 H = 1.937 A = 88° V = .875 R = .150
			ELD90-1 H = 1.937 A = 90° V = 1.000 R = .150
		33 T/FT	ELD88-1 H = 1.937 A = 88° V = 1.000 R = .150

ACUTE PUNCHES

ACUTE LOWER DIES

	EP28 H = 3.779 A = 28° R = .030		EP30 H = 3.779 A = 30° R = .060
26 T/FT		36 T/FT	
			EGP28 H = 5.125 A = 28° R = .030
		13 T/FT	

	ELD30-1/4 H = 1.937 A = 30° V = .250 R = .045		ELD30-3/8 H = 1.937 A = 30° V = .375 R = .045		ELD30-1/2 H = 1.937 A = 30° V = .500 R = .045
17 T/FT		17 T/FT		17 T/FT	
			ELD30-5/8 H = 1.937 A = 30° V = .625 R = .060		ELD34-7/8 H = 1.937 A = 34° V = .875 R = .090
		17 T/FT		17 T/FT	

Precision PRESS BRAKE TOOLING

AIR BENDING FORCE CHART - INCHES

The figures shown in bold print signify die openings equal to eight times the material thickness. These are recommended for average applications and will yield an inside radius equal to approximately 15% of the die opening. Required bending tonnage varies directly with the tensile strength of the material. Conversion factors for materials other than mild steel are available.

TONNAGES REQUIRED FOR AIR BENDING MILD STEEL (with tensile strength of 60,000 lbs. psi). For wider or narrower openings in same stock, refer to the numbers left or right of the recommended tonnage.

V	4mm	6mm	7mm	8mm	10mm	12mm	14mm	16mm	18mm	20mm	25mm	32mm	40mm	50mm	63mm	80mm	100mm	125mm	160mm	200mm	250mm
V(in)	0.157	0.236	0.276	0.315	0.394	0.472	0.551	0.630	0.709	0.787	0.984	1.260	1.575	1.969	2.480	3.150	3.937	4.921	6.299	7.874	9.843
MF	0.110	0.165	0.193	0.220	0.276	0.331	0.397	0.454	0.510	0.567	0.709	0.945	1.181	1.476	1.860	2.362	2.953	3.789	4.850	6.063	7.579
IR	0.026	0.039	0.046	0.052	0.066	0.079	0.092	0.105	0.118	0.131	0.164	0.210	0.262	0.328	0.413	0.525	0.656	0.820	1.050	1.312	1.640
GA.	DEC.	Tons required per linear foot using air bend dies with these "V" die openings																			
20	.036	5.3	3.7	3.1	2.6	2.1	1.8														
18	.048		6.7	5.9	4.7	3.8	2.8	2.5	1.9												
16	.060				7.6	6.1	5.1	4.1	3.6	3.2	2.8										
14	.075					11.1	8.1	6.9	5.6	4.9	4.2	3.0									
12	.105						15.1	13.1	11.1	9.3	7.5	5.4	4.1								
11	.120							15.9	13.1	9.9	7.2	5.1	3.9								
10	.135									11.9	9.1	6.3	4.8	3.1							
3/16	.188										24.1	14.9	10.9	7.6	5.8						
1/4	.250											30.1	20.1	13.9	10.6	8.6					
5/16	.313												36.1	25.1	18.1	12.9	10.1				
3/8	.375													37.9	28.1	19.9	14.9	11.1			
1/2	.500														52.1	39.1	29.9	21.9	16.1		
5/8	.625															70.1	52.1	38.1	27.1	19.9	15.1
3/4	.750																92.0	68.0	53.0	36.3	27.0
1	1.0																		112.0	76.0	56.0

SAFETY WARNING

The press brake dies shown in this catalog should be used in strict compliance with all local, state and federal safety standards, as well as those outlined in the American National Standards Institute Bulletin A.N.S.I. #B11-3.

Press brake dies are never intended to be used in equipment without a means provided for preventing any and all body parts from entering or remaining in the die space at any time.

It is the user's responsibility to make certain that point of operation protection is effective and that all applicable safety requirements are met.

