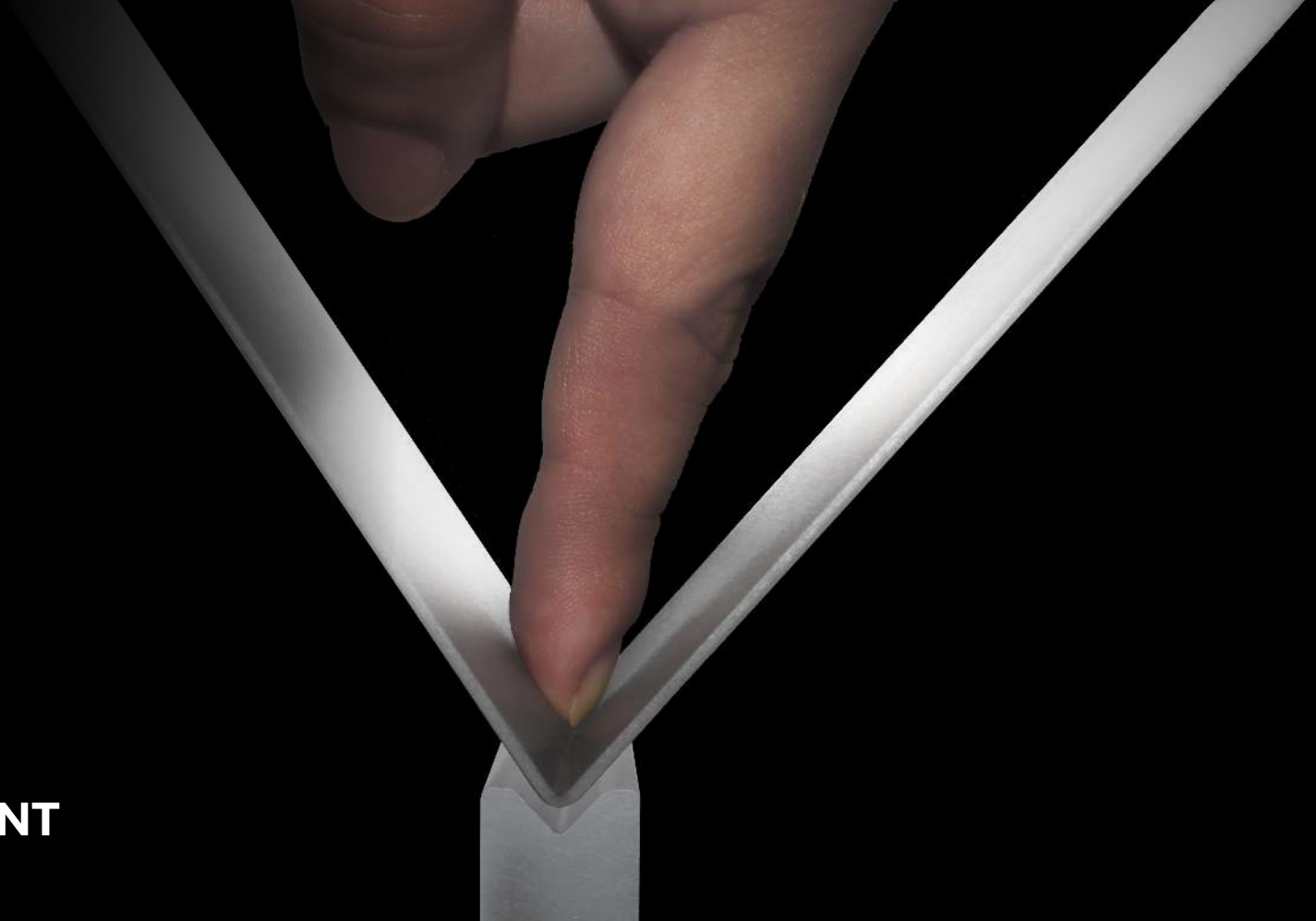




**BENDING SOLUTIONS**  
COMPATIBILITY HÄMMERLE - BYSTRONIC





**OVERVIEW**

4 - 5

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**PUNCHES**

6 - 16



**DIES**

18 - 27

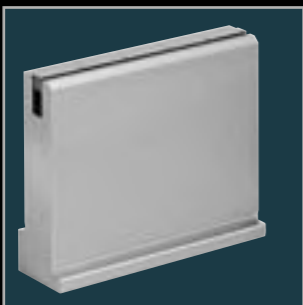
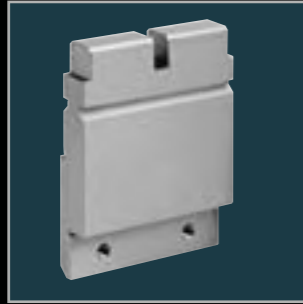
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**ABOUT US**

28 - 35

# R

▶ Hämmerle-  
Bystronic



#### OTHER **ROLLERI** CATALOGUES:

- ▶ CLAMPING SYSTEMS
- ▶ PRESS BRAKE TOOLS
- ▶ PRESS BRAKE TOOLS <sup>®</sup> American
- ▶ PUNCHING TOOLS
- ▶ IRON WORKER
- ▶ LASER CONSUMABLES
- ▶ INDUSTRIAL EQUIPMENT
- ▶ CRIMPING MACHINES





## PUNCHES ROLLERI HÄMMERLE-BYSTRONIC

### EXPLANATION

Tangs	8
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### PUNCHES

H11	8 - 11
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H14	11
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H12	12 - 13
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### PUNCH HOLDERS

H21	14 - 15
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H22	15
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### RADIUS TOOLS

H22	16
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# Punch holders



C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max.

### H21.003.0

	L (mm)	L (inch)	
H21.003.01.01	100	3.94	1.18 kg
H21.003.01.03	200	7.87	2.36 kg
H21.003.02.01	50	1.97	0.59 kg
H21.003.02.02	55	2.17	0.65 kg
H21.003.02.03	60	2.36	0.71 kg
H21.003.02.04	65	2.56	0.77 kg
H21.003.02.05	70	2.76	0.83 kg
H21.003.02.06	75	2.95	0.89 kg
H21.003.02.07	80	3.15	0.94 kg
H21.003.02.08	85	3.35	1.00 kg
H21.003.02.09	90	3.54	1.06 kg
H21.003.02.10	95	3.74	1.12 kg
H21.003.04.01	75 DX	2.95 DX	0.83 kg
H21.003.04.02	85 DX	3.35 DX	0.94 kg
H21.003.04.03	95 DX	3.74 DX	1.06 kg
H21.003.04.04	105 DX	4.13 DX	1.15 kg
H21.003.04.05	115 DX	4.53 DX	1.30 kg
H21.003.04.06	80 SX	3.15 SX	0.89 kg
H21.003.05.01	75 SX	2.95 SX	0.83 kg
H21.003.05.02	85 SX	3.35 SX	0.94 kg
H21.003.05.03	95 SX	3.74 SX	1.06 kg
H21.003.05.04	105 SX	4.13 SX	1.12 kg
H21.003.05.05	115 SX	4.53 SX	1.30 kg
H21.003.05.06	80 DX	3.15 DX	0.89 kg

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max.

### H21.002.0

	L (mm)	L (inch)	
H21.002.01.01	100	3.94	2.44 kg
H21.002.01.03	200	7.87	4.88 kg
H21.002.02.01	50	1.97	1.22 kg
H21.002.02.02	55	2.17	1.34 kg
H21.002.02.03	60	2.36	1.46 kg
H21.002.02.04	65	2.56	1.59 kg
H21.002.02.05	70	2.76	1.71 kg
H21.002.02.06	75	2.95	1.83 kg
H21.002.02.07	80	3.15	1.95 kg
H21.002.02.08	85	3.35	2.07 kg
H21.002.02.09	90	3.54	2.20 kg
H21.002.02.10	95	3.74	2.32 kg
H21.002.04.01	75 DX	2.95 DX	1.71 kg
H21.002.04.02	85 DX	3.35 DX	1.95 kg
H21.002.04.03	95 DX	3.74 DX	2.20 kg
H21.002.04.04	105 DX	4.13 DX	2.40 kg
H21.002.04.05	115 DX	4.53 DX	2.68 kg
H21.002.04.06	80 SX	3.15 SX	1.83 kg
H21.002.05.01	75 SX	2.95 SX	1.70 kg
H21.002.05.02	85 SX	3.35 SX	1.95 kg
H21.002.05.03	95 SX	3.74 SX	2.20 kg
H21.002.05.04	105 SX	4.13 SX	2.40 kg
H21.002.05.05	115 SX	4.53 SX	2.68 kg
H21.002.05.06	80 DX	3.15 DX	1.83 kg

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max.

### H21.004.0

	L (mm)	L (inch)	
H21.004.01.01	100	3.94	1.82 kg
H21.004.01.03	200	7.87	3.64 kg
H21.004.02.01	50	1.97	0.91 kg
H21.004.02.02	55	2.17	1.00 kg
H21.004.02.03	60	2.36	1.09 kg
H21.004.02.04	65	2.56	1.18 kg
H21.004.02.05	70	2.76	1.27 kg
H21.004.02.06	75	2.95	1.37 kg
H21.004.02.07	80	3.15	1.46 kg
H21.004.02.08	85	3.35	1.55 kg
H21.004.02.09	90	3.54	1.64 kg
H21.004.02.10	95	3.74	1.73 kg
H21.004.04.01	75 DX	2.95 DX	1.27 kg
H21.004.04.02	85 DX	3.35 DX	1.46 kg
H21.004.04.03	95 DX	3.74 DX	1.64 kg
H21.004.04.04	105 DX	4.13 DX	1.80 kg
H21.004.04.05	115 DX	4.53 DX	2.00 kg
H21.004.04.06	80 SX	3.15 SX	1.37 kg
H21.004.05.01	75 SX	2.95 SX	1.27 kg
H21.004.05.02	85 SX	3.35 SX	1.46 kg
H21.004.05.03	95 SX	3.74 SX	1.64 kg
H21.004.05.04	105 SX	4.13 SX	1.80 kg
H21.004.05.05	115 SX	4.53 SX	2.00 kg
H21.004.05.06	80 DX	3.15 DX	1.37 kg

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max.

### H21.005.0

	L (mm)	L (inch)	
H21.005.01.01	100	3.94	5.06 kg
H21.005.01.03	200	7.87	10.12 kg
H21.005.02.01	50	1.97	2.53 kg
H21.005.02.02	55	2.17	2.78 kg
H21.005.02.03	60	2.36	3.04 kg
H21.005.02.04	65	2.56	3.29 kg
H21.005.02.05	70	2.76	3.54 kg
H21.005.02.06	75	2.95	3.80 kg
H21.005.02.07	80	3.15	4.05 kg
H21.005.02.08	85	3.35	4.30 kg
H21.005.02.09	90	3.54	4.55 kg
H21.005.02.10	95	3.74	4.81 kg
H21.005.04.01	75 DX	2.95 DX	3.54 kg
H21.005.04.02	85 DX	3.35 DX	4.05 kg
H21.005.04.03	95 DX	3.74 DX	4.55 kg
H21.005.04.04	105 DX	4.13 DX	5.00 kg
H21.005.04.05	115 DX	4.53 DX	5.57 kg
H21.005.04.06	80 SX	3.15 SX	3.80 kg
H21.005.05.01	75 SX	2.95 SX	3.54 kg
H21.005.05.02	85 SX	3.35 SX	4.05 kg
H21.005.05.03	95 SX	3.74 SX	4.55 kg
H21.005.05.04	105 SX	4.13 SX	5.00 kg
H21.005.05.05	115 SX	4.53 SX	5.57 kg
H21.005.05.06	80 DX	3.15 DX	3.80 kg

C45: 560-710 N/mm<sup>2</sup> 1000 kN/m max.

### H21.010.0

	L (mm)	L (inch)	
H21.010.01.01	100	3.94	6.04 kg
H21.010.01.03	200	7.87	12.00 kg
H21.010.02.01	50	1.97	3.00 kg
H21.010.02.02	55	2.17	3.32 kg
H21.010.02.03	60	2.36	3.60 kg
H21.010.02.04	65	2.56	3.93 kg
H21.010.02.05	70	2.76	4.23 kg
H21.010.02.06	75	2.95	4.53 kg
H21.010.02.07	80	3.15	4.83 kg
H21.010.02.08	85	3.35	5.13 kg
H21.010.02.09	90	3.54	5.44 kg
H21.010.02.10	95	3.74	5.74 kg
H21.010.04.01	75 DX	2.95 DX	4.23 kg
H21.010.04.02	85 DX	3.35 DX	4.83 kg
H21.010.04.03	95 DX	3.74 DX	5.44 kg
H21.010.04.04	105 DX	4.13 DX	6.10 kg
H21.010.04.05	115 DX	4.53 DX	6.64 kg
H21.010.04.06	80 SX	3.15 SX	4.53 kg
H21.010.05.01	75 SX	2.95 SX	4.23 kg
H21.010.05.02	85 SX	3.35 SX	4.83 kg
H21.010.05.03	95 SX	3.74 SX	5.44 kg
H21.010.05.04	105 SX	4.13 SX	6.10 kg
H21.010.05.05	115 SX	4.53 SX	6.64 kg
H21.010.05.06	80 DX	3.15 DX	4.53 kg

C45: 560-710 N/mm<sup>2</sup> 600 kN/m max.

### H22.006.0

	L (mm)	L (inch)	
H22.006.01.01	100	3.94	10.3 kg
H22.006.02.01	50	1.97	5.15 kg
H22.006.02.02	55	2.17	5.67 kg
H22.006.02.03	60	2.36	6.18 kg
H22.006.02.04	65	2.56	6.70 kg
H22.006.02.05	70	2.76	7.21 kg
H22.006.02.06	75	2.95	7.73 kg
H22.006.02.07	80	3.15	8.24 kg
H22.006.02.08	85	3.35	8.76 kg
H22.006.02.09	90	3.54	9.27 kg
H22.006.02.10	95	3.74	9.79 kg



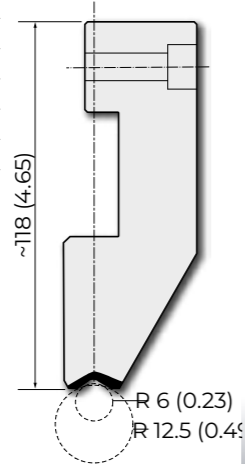
## Radius tools

C45: 560-710 N/mm<sup>2</sup>

1000 kN/m max.

### H22.013.0

	L (mm)	L (inch)	
H22.013.01.01	100	3.94	2.82 kg
H22.013.02.01	50	1.97	1.41 kg
H22.013.02.02	55	2.17	1.55 kg
H22.013.02.03	60	2.36	1.69 kg
H22.013.02.04	65	2.56	1.83 kg
H22.013.02.05	70	2.76	1.97 kg
H22.013.02.06	75	2.95	2.12 kg
H22.013.02.07	80	3.15	2.26 kg
H22.013.02.08	85	3.35	2.40 kg
H22.013.02.09	90	3.54	2.54 kg
H22.013.02.10	95	3.74	2.68 kg

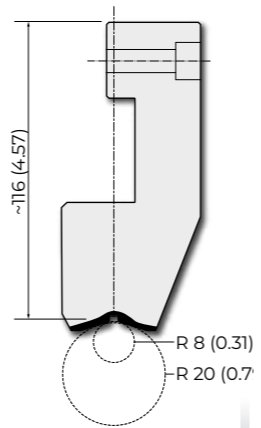


C45: 560-710 N/mm<sup>2</sup>

1000 kN/m max.

### H22.014.0

	L (mm)	L (inch)	
H22.014.01.01	100	3.94	3.06 kg
H22.014.02.01	50	1.97	1.53 kg
H22.014.02.02	55	2.17	1.68 kg
H22.014.02.03	60	2.36	1.83 kg
H22.014.02.04	65	2.56	1.98 kg
H22.014.02.05	70	2.76	2.14 kg
H22.014.02.06	75	2.95	2.29 kg
H22.014.02.07	80	3.15	2.44 kg
H22.014.02.08	85	3.35	2.59 kg
H22.014.02.09	90	3.54	2.75 kg
H22.014.02.10	95	3.74	2.90 kg

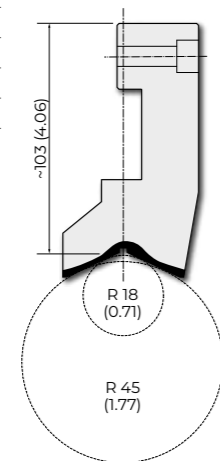


C45: 560-710 N/mm<sup>2</sup>

1000 kN/m max.

### H22.015.0

	L (mm)	L (inch)	
H22.015.01.01	100	3.94	3.28 kg
H22.015.02.01	50	1.97	1.64 kg
H22.015.02.02	55	2.17	1.80 kg
H22.015.02.03	60	2.36	1.97 kg
H22.015.02.04	65	2.56	2.13 kg
H22.015.02.05	70	2.76	2.30 kg
H22.015.02.06	75	2.95	2.46 kg
H22.015.02.07	80	3.15	2.62 kg
H22.015.02.08	85	3.35	2.79 kg
H22.015.02.09	90	3.54	2.95 kg
H22.015.02.10	95	3.74	3.12 kg





## DIES ROLLERI HÄMMERLE-BYSTRONIC

### EXPLANATION

Tangs	20
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### DIES

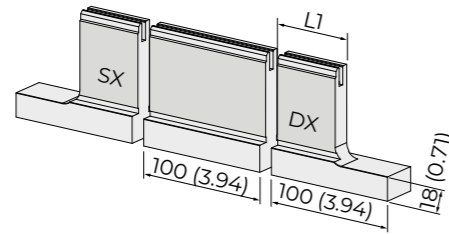
Dies Holder	21
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H41	22
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H31	23 - 27
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STANDARD TANG

H31 - H41



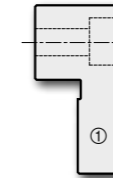
Dies holders



C45: 560-710 N/mm<sup>2</sup>

H61.100.01 / H61.500.01

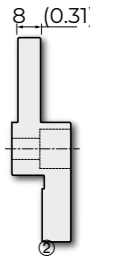
	L (mm)	L (inch)	
H61.100.01	100	3.94	0.63 kg
H61.500.01	500	19.68	3.15 kg



C45: 560-710 N/mm<sup>2</sup>

H61.100.02 / H61.500.02

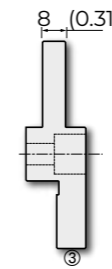
	L (mm)	L (inch)	
H61.100.02	100	3.94	0.70 kg
H61.500.02	500	19.68	3.50 kg



C45: 560-710 N/mm<sup>2</sup>

H61.100.03 / H61.500.03

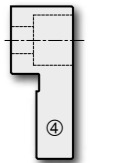
	L (mm)	L (inch)	
H61.100.03	100	3.94	0.70 kg
H61.500.03	500	19.68	3.50 kg



C45: 560-710 N/mm<sup>2</sup>

H61.100.04 / H61.500.04

	L (mm)	L (inch)	
H61.100.04	100	3.94	0.63 kg
H61.500.04	500	19.68	3.15 kg



C45: 560-710 N/mm<sup>2</sup>

H61.100.05 / H61.500.05

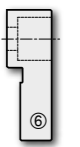
	L (mm)	L (inch)	
H61.100.05	100	3.94	0.30 kg
H61.500.05	500	19.68	1.50 kg



C45: 560-710 N/mm<sup>2</sup>

H61.100.06 / H61.500.06

	L (mm)	L (inch)	
H61.100.06	100	3.94	0.63 kg
H61.500.06	500	19.68	3.15 kg



C45: 560-710 N/mm<sup>2</sup>

H61.100.07

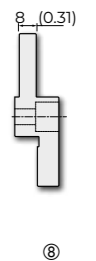
	L (mm)	L (inch)	
H61.100.07	100	3.94	0.65 kg



C45: 560-710 N/mm<sup>2</sup>

H61.100.08 / H61.500.08

	L (mm)	L (inch)	
H61.100.08	100	3.94	0.70 kg
H61.500.08	500	19.68	3.50 kg



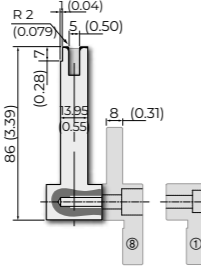






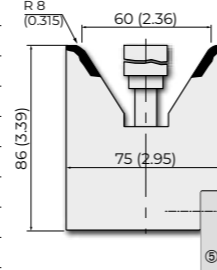
42Cr: 900-1150 N/mm<sup>2</sup> 350 kN/m max.

H31.006.0			
	L (mm)	L (inch)	
H31.006.01.01	100	3.94	1.08 kg
H31.006.02.01	50 SX	1.97 SX	0.81 kg
H31.006.02.02	55 DX	2.17 DX	0.81 kg
H31.006.02.03	60 DX	2.36 DX	0.86 kg
H31.006.02.04	65 DX	2.56 DX	0.86 kg
H31.006.02.05	70 DX	2.76 DX	0.86 kg
H31.006.02.06	75 DX	2.95 DX	0.97 kg
H31.006.02.07	80 DX	3.15 DX	0.97 kg
H31.006.02.08	85 DX	3.35 DX	0.97 kg
H31.006.02.09	90 DX	3.54 DX	1.08 kg
H31.006.02.10	95 DX	3.74 DX	1.08 kg
H31.006.03.01	50 DX	1.97 DX	0.81 kg
H31.006.03.02	55 SX	2.17 SX	0.81 kg
H31.006.03.03	60 SX	2.36 SX	0.86 kg
H31.006.03.04	65 SX	2.56 SX	0.86 kg
H31.006.03.05	70 SX	2.76 SX	0.86 kg
H31.006.03.06	75 SX	2.95 SX	0.97 kg
H31.006.03.07	80 SX	3.15 SX	0.97 kg
H31.006.03.08	85 SX	3.35 SX	0.97 kg
H31.006.03.09	90 SX	3.54 SX	1.08 kg
H31.006.03.10	95 SX	3.74 SX	1.08 kg



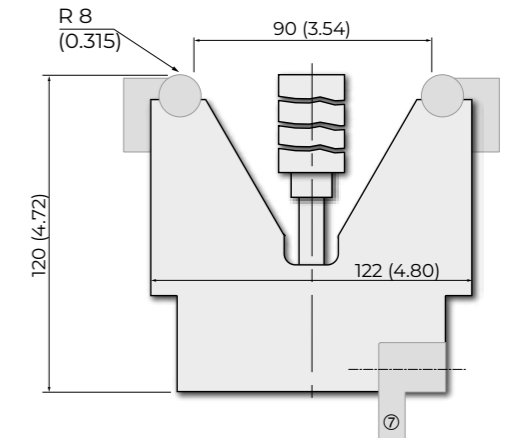
C45: 560-710 N/mm<sup>2</sup> 1500 kN/m max.

H31.060.0			
	L (mm)	L (inch)	
H31.060.01.01	100	3.94	3.76 kg
H31.060.02.01	50 SX	1.97 SX	2.82 kg
H31.060.02.02	55 DX	2.17 DX	2.82 kg
H31.060.02.03	60 DX	2.36 DX	3.01 kg
H31.060.02.04	65 DX	2.56 DX	3.01 kg
H31.060.02.05	70 DX	2.76 DX	3.01 kg
H31.060.02.06	75 DX	2.95 DX	3.38 kg
H31.060.02.07	80 DX	3.15 DX	3.38 kg
H31.060.02.08	85 DX	3.35 DX	3.38 kg
H31.060.02.09	90 DX	3.54 DX	3.76 kg
H31.060.02.10	95 DX	3.74 DX	3.76 kg
H31.060.03.01	50 DX	1.97 DX	2.82 kg
H31.060.03.02	55 SX	2.17 SX	2.82 kg
H31.060.03.03	60 SX	2.36 SX	3.01 kg
H31.060.03.04	65 SX	2.56 SX	3.01 kg
H31.060.03.05	70 SX	2.76 SX	3.01 kg
H31.060.03.06	75 SX	2.95 SX	3.38 kg
H31.060.03.07	80 SX	3.15 SX	3.38 kg
H31.060.03.08	85 SX	3.35 SX	3.38 kg
H31.060.03.09	90 SX	3.54 SX	3.76 kg
H31.060.03.10	95 SX	3.74 SX	3.76 kg



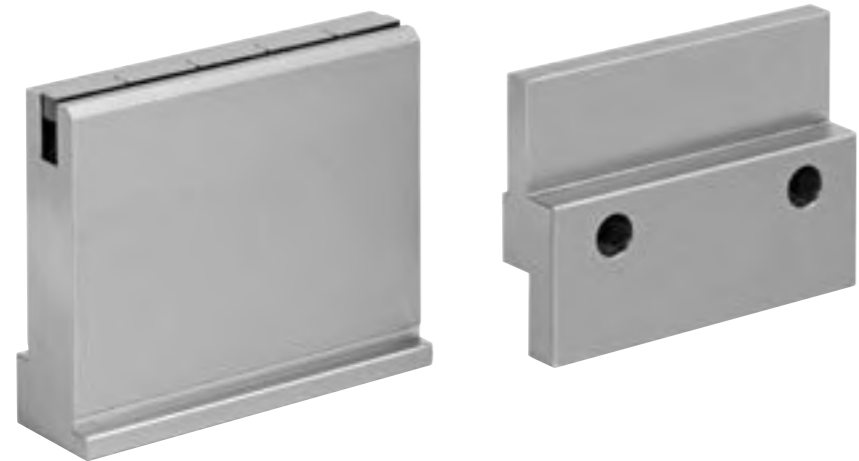
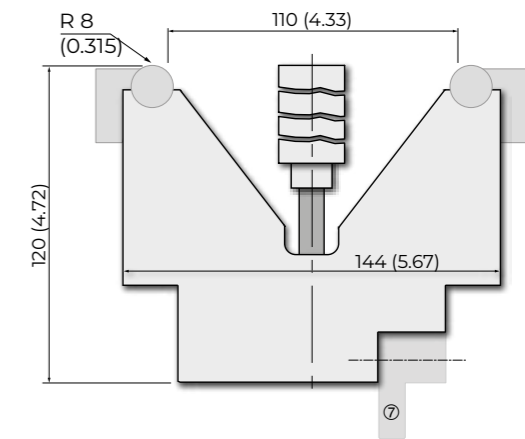
C45: 560-710 N/mm<sup>2</sup> 1500 kN/m max.

H31.090.01.01			
	L (mm)	L (inch)	
H31.090.01.01	100	3.94	8.15 kg



C45: 560-710 N/mm<sup>2</sup> 1500 kN/m max.

H31.110.01.01			
	L (mm)	L (inch)	
H31.110.01.01	100	3.94	8.83 kg





## ABOUT US





## ROLLERI WORLD Today



Since 1987 we have been producing standard and special tooling. The family owned company (Francesco and Marco Rolleri) can nowadays be considered one of the largest press brake tooling manufacturers in Europe. We offer a fast and reliable service through our partners all over Europe.

The reorganization of our sales force, happened in 2012, has guaranteed a widespread presence of our products in every single market. For this reason, our production was enlarged considerably with an additional hall and many new machines in the year 2016.

Rolleri S.p.A. – Head Office **it**  
Rolleri Baltic **ba**  
Rolleri Benelux **bx**  
Rolleri Do Brasil **br**  
Rolleri Trad. Co. China **cn**  
Rolleri Česká Republika **cz**  
Rolleri Iberica **es**  
Rolleri Finland **fi**

Rolleri France **fr**  
Rolleri Deutschland GmbH **de**  
Rolleri Polska **pl**  
Rolleri Slovensko **sk**  
Rolleri Ukraine LLC **ua**  
Rolleri USA **us**  
Rolleri UK **gb**





## OUR PRODUCTION

### Warehouse, Manufacturing and Quality

#### ► Manufacturing

Besides manufacturing many special tools, our research and development team also designs fast clamping systems in order to increase your productivity.

Technicians and engineers develop for you convenient and practical solutions.

We work with highly complex 3D simulation models and we are able to create bending samples of various profiles.



#### ► Quality

Rolleri is ISO 9001:2015 certified.

For us, being your supplier means helping you to find the best and most convenient tool and to develop a large number of bending solutions. Furthermore, we offer training for your bending department employees.

Our quality control department checks and tests every single tool after a complete production cycle. After a careful inspection, every tool is marked with a serial number and a batch number. This process guarantees complete tool traceability.

Rolleri also guarantees accurate reproduction, high-quality material, induction hardening and precision grinding.



## OUR PRODUCTION

### Raw Material and Production

#### ► Raw Material

Raw material is provided by qualified suppliers and chemical composition corresponds to international standards. Therefore, raw material yield and tensile strength are guaranteed.



#### ► Rolleri Tools

Every tool is manufactured in Rolleri's production facilities. This enables us to guarantee high quality, repeatability and parallelism thanks to high precision grinding.

We use induction hardening at 54-60 HRc for all tools to get the best results for your punches and dies.

Each tool is subjected to quality control and then provided with a serial number to guarantee its traceability.





## OUR PRODUCTION Machinery

### Warehouse

With more than 20,000 press brake tools on stock, we hold one of the largest warehouses in Europe. Thanks to this, a large amount of tools is ready to be shipped all around the world.



### CNC-Milling

With our state-of-the-art milling centers we can quickly modify tools with high precision.

Very flexible tilting machine heads can carry out a wide variety of processes. This is where grooves, relieves, and other machining types are carried out.



### CNC-Profile Grinding

Our CNC-Professional grinding machines guarantee high precision (tolerance of +/-0.01 mm), accurate parallelism and repeatability.

Here you can also retrofit induction hardened and core hardened tools. Radius and angle modifications are precisely carried out upon request.



## OUR PRODUCTION Machinery

### Hardening

Tool working areas are exposed to the highest mechanical stress, because press brake force is concentrated on small surfaces. For this reason, press force on tool working areas is very high and it results in high friction between tools and sheet metal to be bent.

In order to have more resistant tools, their surface is hardened. Rollerli uses induction hardening, which penetrates about 3 mm into the tool steel, to guarantee high wear resistance and to offer customers the best solution to competitive prices.



### EDM

By using electro-discharge machines, Rollerli can machine hardened and tough materials. This process is based on the definition of the tool shape with a high precision CAD software and the manufacturing of simple and complicated shapes.

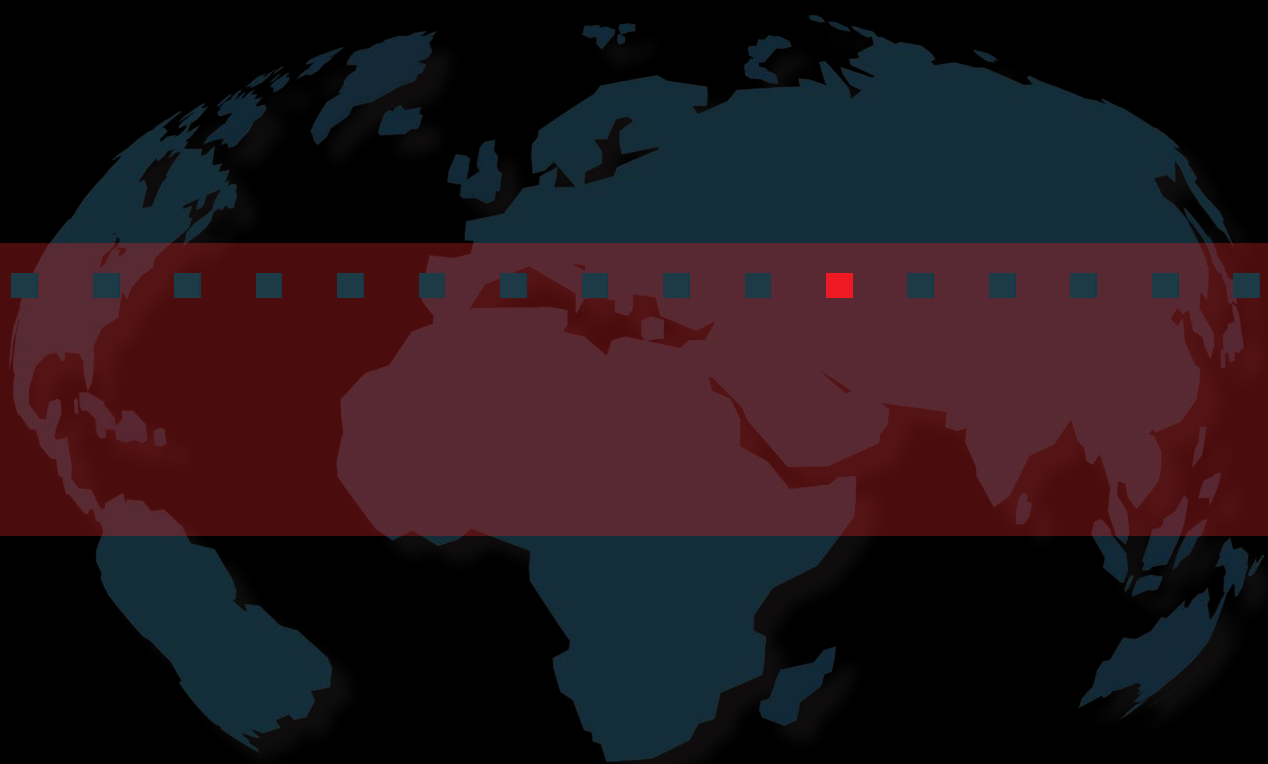


### 3D printer

The introduction of new "Additive" machines with the possibility of constructing any object with materials similar to steel starting from a 3D design. Thanks to this technology it's possible to reduce the production time of very complex tools and to have fast delivery times



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