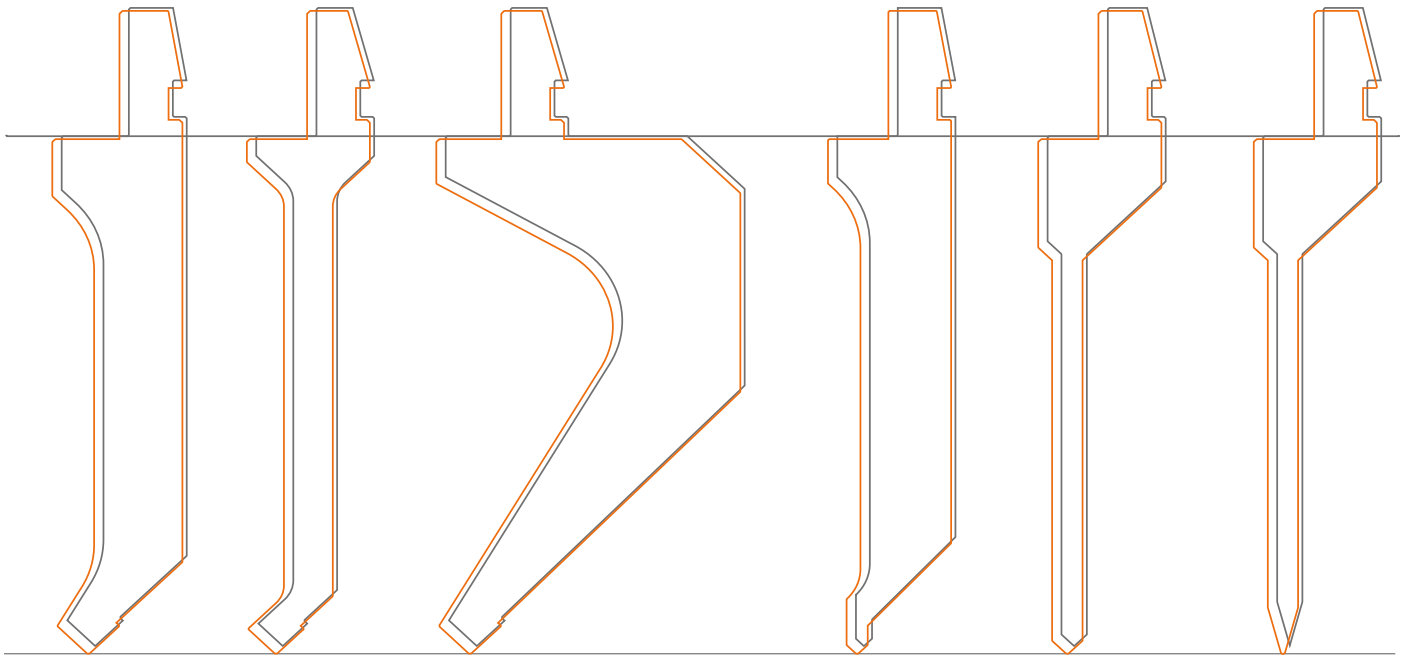


PRESS BRAKE TOOLS

SPECIAL BEND TOOLING

PRODUCT CATALOG

AMADA TYPE



High Quality & Technology For  The Future

CONIC

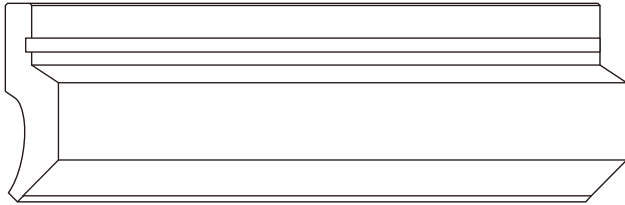
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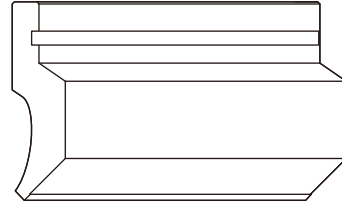
*Mentioned tonnage in the table is for standard type.

INFORMATION

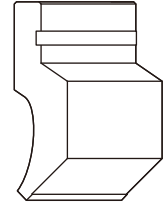
■ TOOL LENGTH



Type L 835 mm

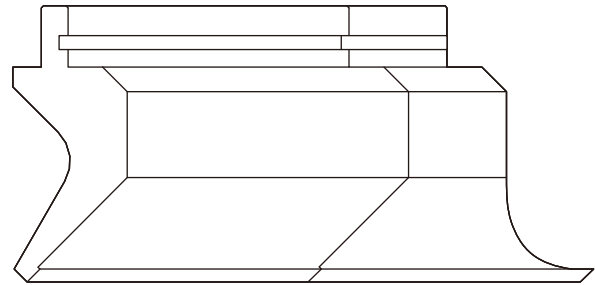
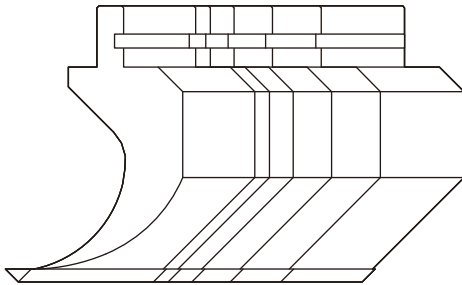


Type M 510 mm



Type SS 200 mm

■ SECTIONING



■ SECTIONING (PUNCH)

SECTIONING A (Total 370mm) 10 ▪ 10 ▪ 15 ▪ 20 ▪ 25 ▪ 40 ▪ 50 ▪ 100 ▪ 100

SECTIONING B (Total 800mm) 10 ▪ 15 ▪ 20 ▪ 40 ▪ 50 ▪ 100 ▪ 100 ▪ 165 ▪ 300

EARS 200mm 100 (Right) ▪ 100 (Left)

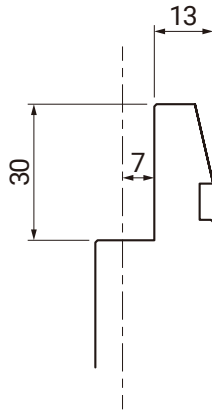
■ SECTIONING (DIE)

SECTIONING A (Total 370mm) 10 ▪ 10 ▪ 15 ▪ 20 ▪ 25 ▪ 40 ▪ 50 ▪ 100 ▪ 100

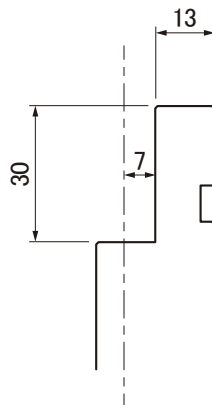
SECTIONING B (Total 800mm) 10 ▪ 15 ▪ 20 ▪ 40 ▪ 50 ▪ 100 ▪ 100 ▪ 165 ▪ 300

CLAMP TYPE

■ OT-TYPE (One Touch)

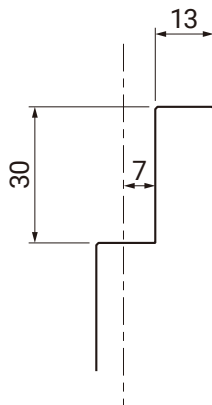


■ A9-TYPE (Safety Groove)



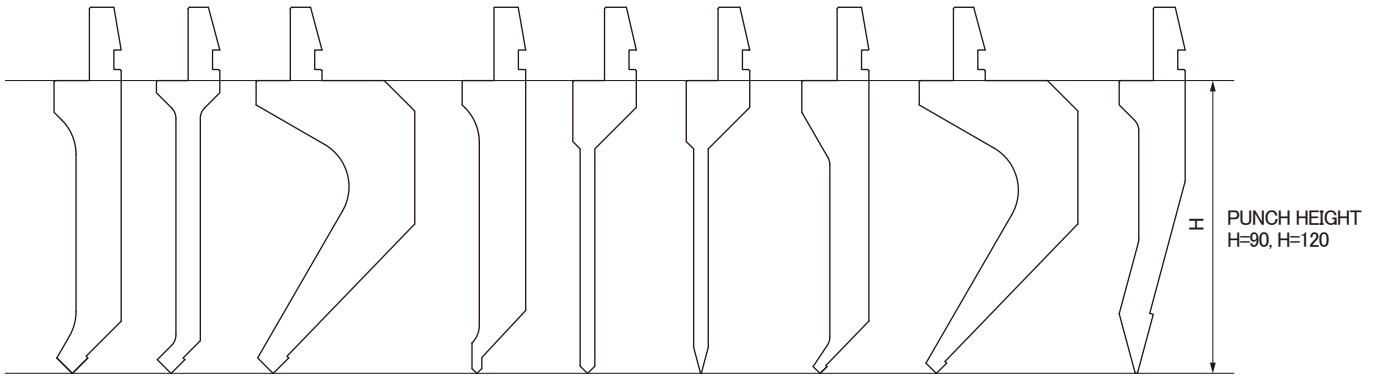
■ STANDARD-TYPE

Recommend other type



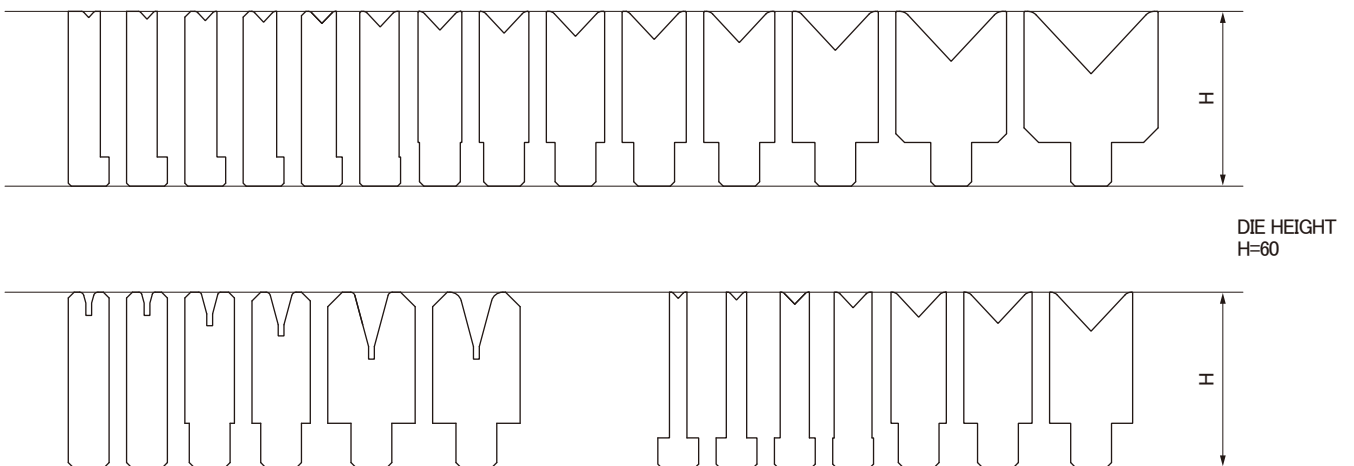
UNIFIED HEIGHT SYSTEM

■ PUNCH



*H=90 does not include Burring Punch

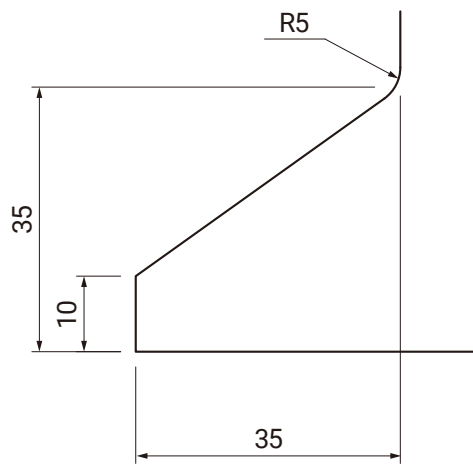
■ DIE



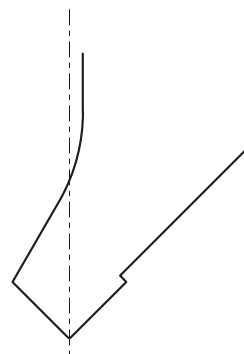
STANDARD PUNCH 1

Material: **SCM440** Hardness: **HRC47 ± 3**
 L: 835mm M: 510mm SS: 200mm
 Sectioning A: 370mm B: 800mm Ears: 200mm

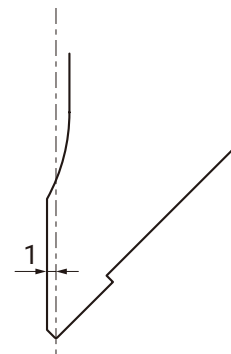
Type	H	α	R	k	Max	Product No.	
	(mm)	Angle	(mm)	(mm)	(ton/m)		
STANDARD PUNCH 1	90	86	0.2	9	100	ST9-09-8602	
			0.6			ST9-09-8606	
			1.5			ST9-09-8615	
			2.3			ST9-09-8623	
			3.0			ST9-09-8630	
		88	0.2			ST9-09-8802	
			0.6			ST9-09-8806	
			3.0			ST9-09-8830	
			90			0.2	ST9-09-9002
			120			86	0.2
	0.6	ST9-12-8606					
	1.5	ST9-12-8615					
	2.3	ST9-12-8623					
	3.0	ST9-12-8630					
	88	0.2		ST9-12-8802			
		0.6		ST9-12-8806			
		3.0		ST9-12-8830			
		90		0.2	ST9-12-9002		
		STANDARD PUNCH 1 T-TYPE		120	86	0.2	9
	0.6		STT-12-8606				
88	0.2		STT-12-8802				
	0.6		STT-12-8806				



45ton/m
T-TYPE 40ton/m



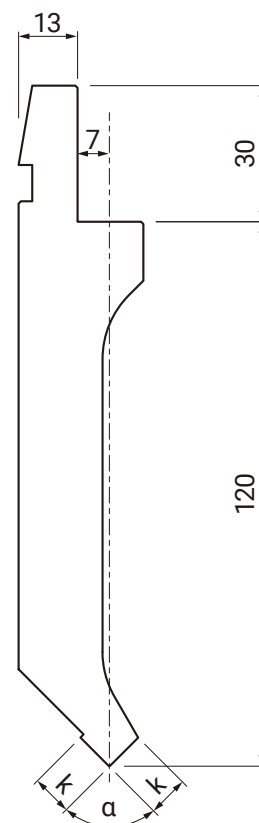
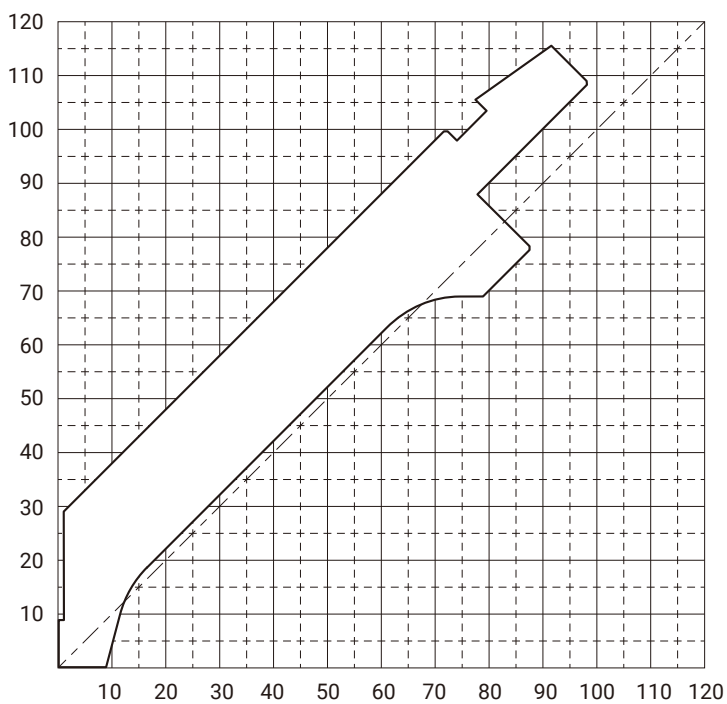
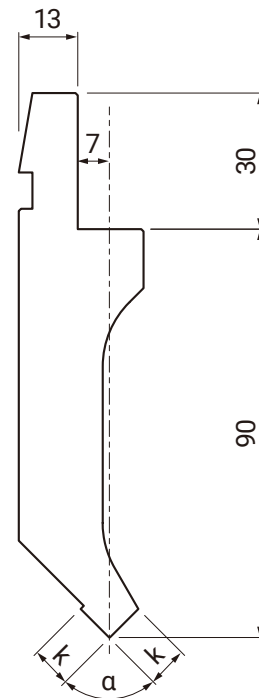
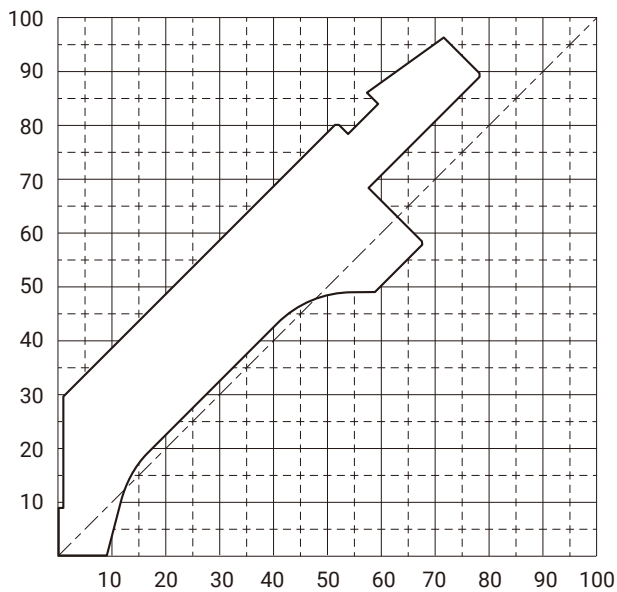
STANDARD PUNCH 1



STANDARD PUNCH 1 T-TYPE

STANDARD PUNCH 1

Material: **SCM440** Hardness: **HRC47 ± 3**
 L: 835mm M: 510mm SS: 200mm
 Sectioning A: 370mm B: 800mm Ears: 200mm



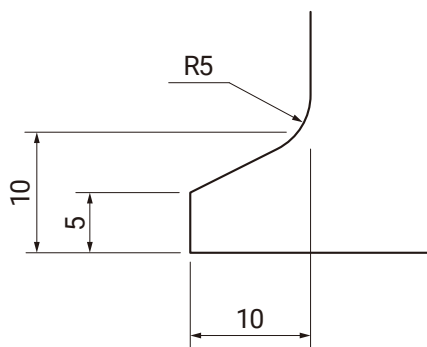
STANDARD PUNCH 2

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

Type	H	α	R	k	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD PUNCH 2	90	86	0.2	4	20	ST4-09-8602
			0.6			ST4-09-8606
		88	0.2			ST4-09-8802
			0.6			ST4-09-8806
		90	0.2			ST4-09-9002
		120	86			0.2
	0.6			ST4-12-8606		
	88		0.2	ST4-12-8802		
			0.6	ST4-12-8806		
	90		0.2	ST4-12-9002		



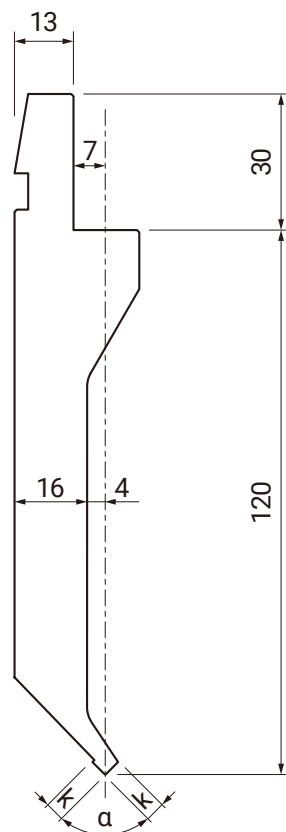
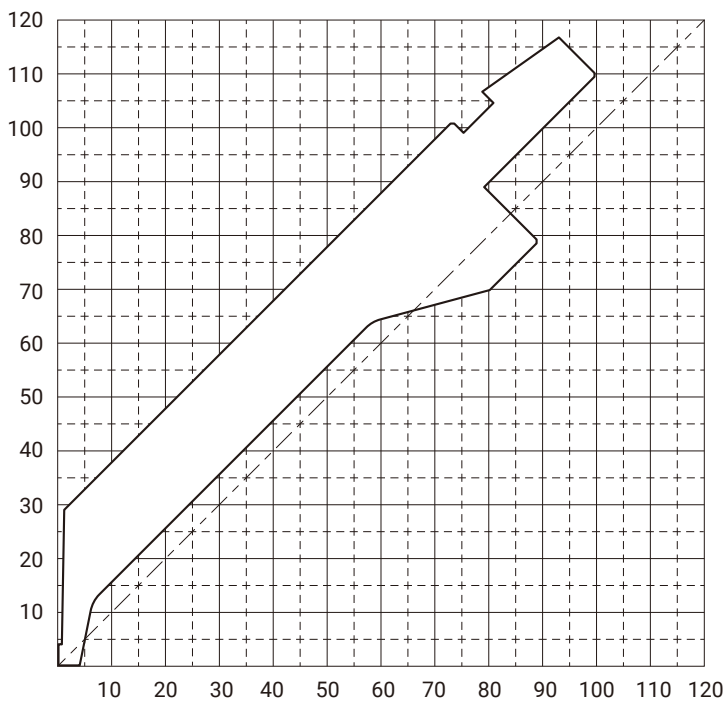
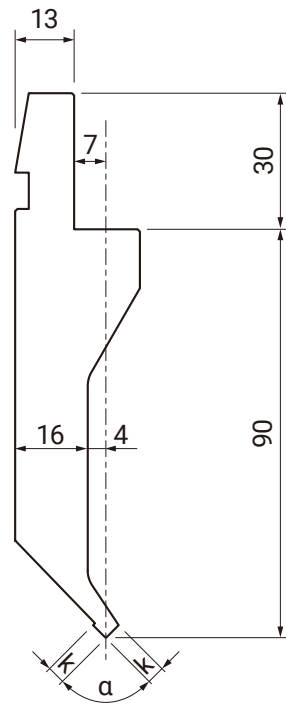
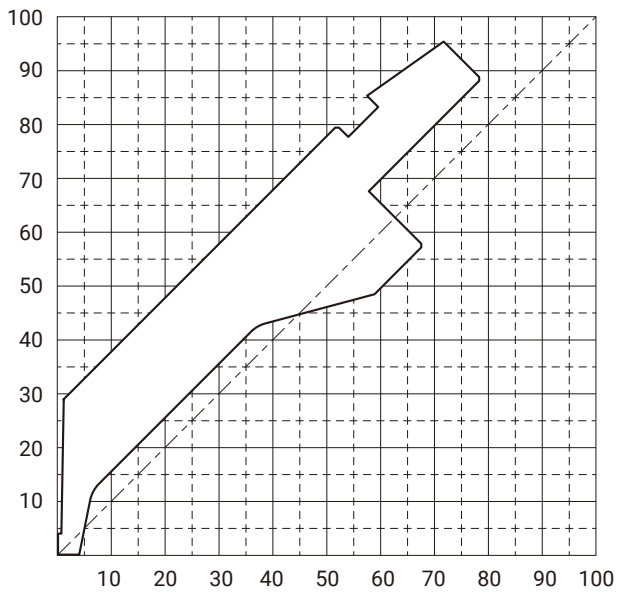
10ton/m

STANDARD PUNCH 2

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



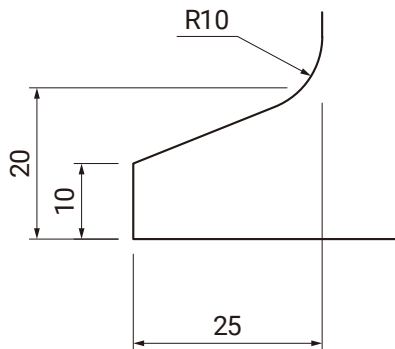
SASH PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**

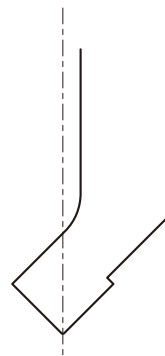
L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

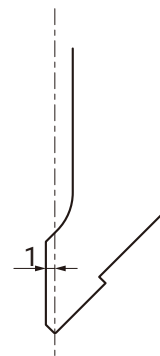
Type	H (mm)	α Angle	R (mm)	k (mm)	Max (ton/m)	Product No.				
	SASH PUNCH	90	86	0.2	8		30	SS8-09-8602		
0.6				SS8-09-8606						
3.0				SS8-09-8630						
88			0.2	SS8-09-8802						
			0.6	SS8-09-8806						
			3.0	SS8-09-8830						
90			0.2	SS8-09-9002						
120			86	0.2		8		30	SS8-12-8602	
				0.6					SS8-12-8606	
		3.0		SS8-12-8630						
		88	0.2	SS8-12-8802						
			0.6	SS8-12-8806						
			3.0	SS8-12-8830						
		90	0.2	SS8-12-9002						
		SASH PUNCH T-TYPE	120	86	0.2		8		25	SST-12-8602
					0.6					SST-12-8606
88				0.2	SST-12-8802					
				0.6	SST-12-8806					



15ton/m
T-Type 10ton/m



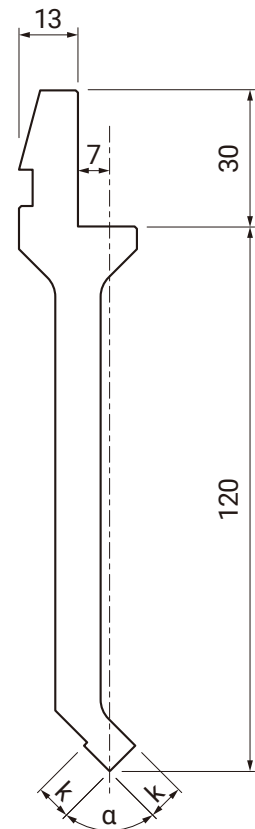
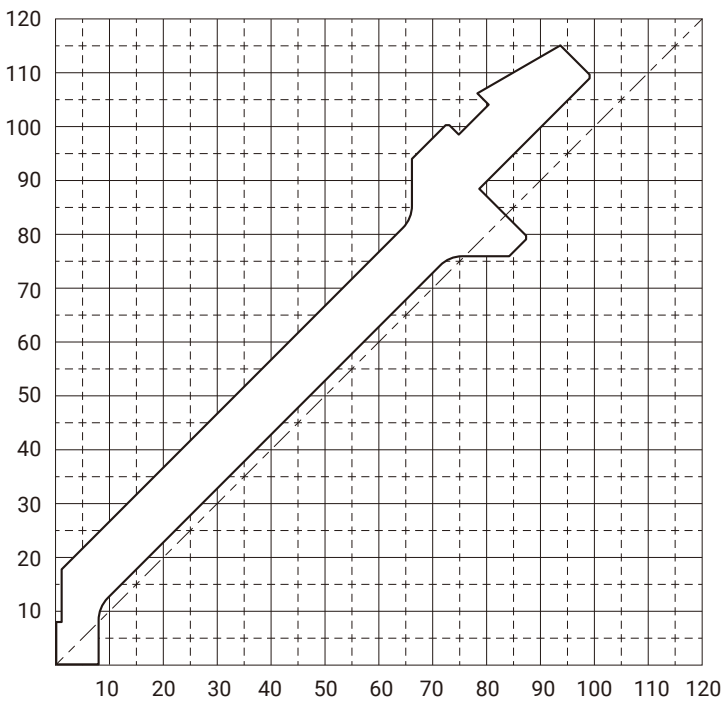
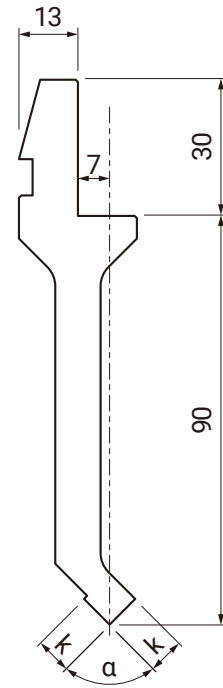
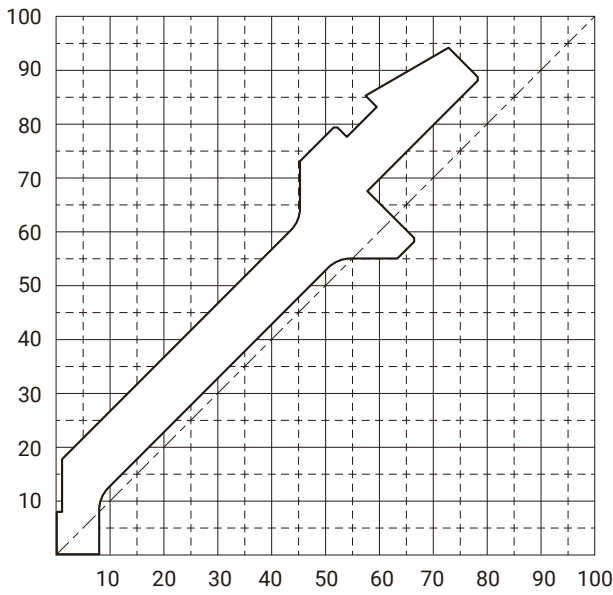
SASH
PUNCH



SASH
PUNCH
T-TYPE

SASH PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**
 L: 835mm M: 510mm SS: 200mm
 Sectioning A: 370mm B: 800mm Ears: 200mm



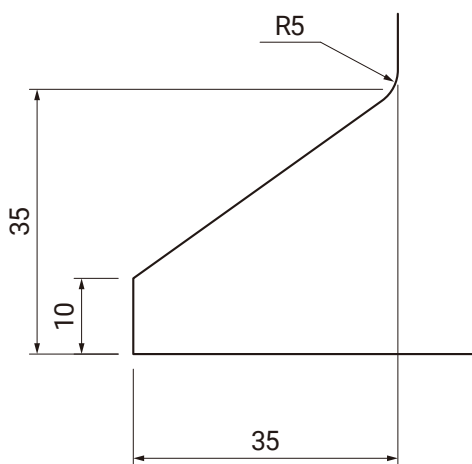
GOOSENECK PUNCH 1

Material: **SCM440** Hardness: **HRC47 ± 3**

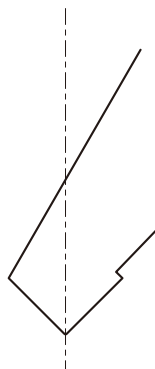
L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

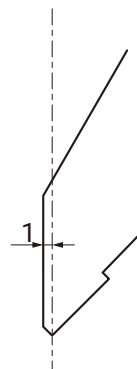
Type	H (mm)	α Angle	R (mm)	k (mm)	Max (ton/m)	Product No.				
	GOOSENECK PUNCH 1	90	86	0.2	9		50	GN9-09-8602		
0.6				GN9-09-8606						
3.0				GN9-09-8630						
88			0.2	GN9-09-8802						
			0.6	GN9-09-8806						
			0.2	GN9-09-9002						
120		86	86	0.2	9	50	GN9-12-8602			
				0.6			GN9-12-8606			
				1.5			GN9-12-8615			
				2.3			GN9-12-8623			
				3.0			GN9-12-8630			
				0.2			GN9-12-8802			
		88	0.6	GN9-12-8806						
			3.0	GN9-12-8830						
			0.2	GN9-12-9002						
		GOOSENECK PUNCH 1 T-TYPE	120	86			0.2	9	35	GNT-12-8602
							0.6			GNT-12-8606
							0.2			GNT-12-8802
88	0.6			GNT-12-8806						
	0.2			GNT-12-8802						
	0.6			GNT-12-8806						



45ton/m
T-TYPE 15ton/m



GOOSENECK
PUNCH 1



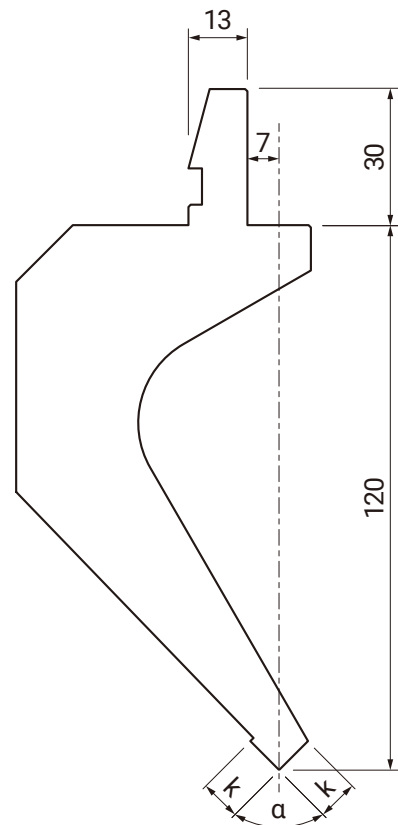
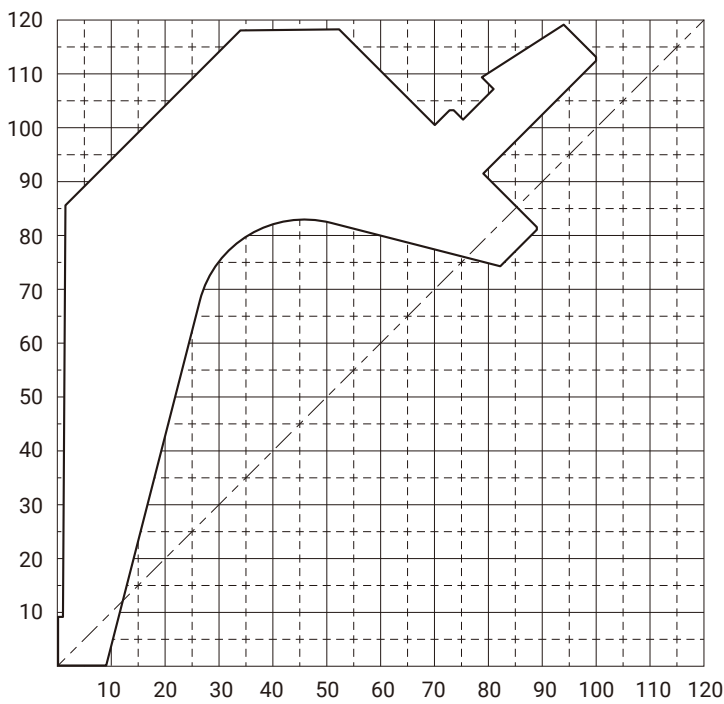
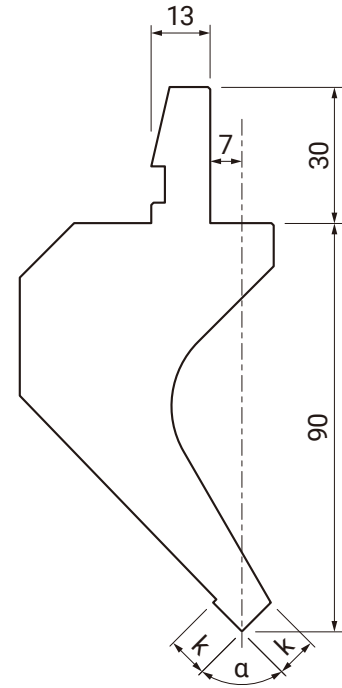
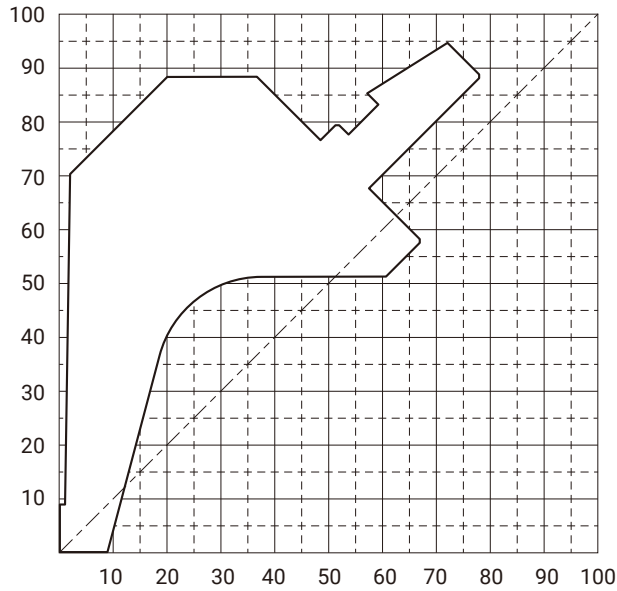
GOOSENECK
PUNCH 1
T-TYPE

GOOSENECK PUNCH 1

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



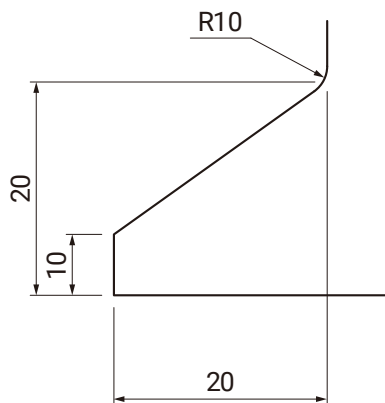
GOOSENECK PUNCH 2

Material: **SCM440** Hardness: **HRC47 ± 3**

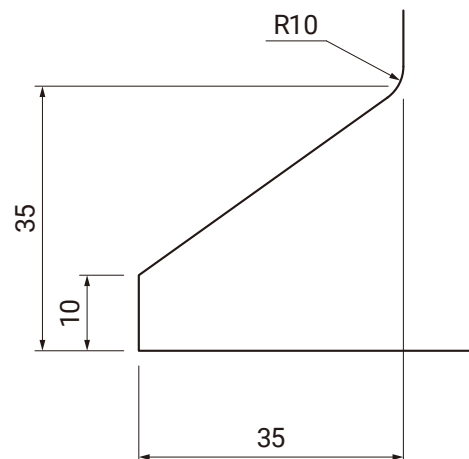
L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

Type	H (mm)	α Angle	R (mm)	k (mm)	Max (ton/m)	Product No.
	GOOSENECK PUNCH 2	90	86	0.2	6	
0.6				GN6-09-8606		
3.0				GN6-09-8630		
88			0.2	GN6-09-8802		
			0.6	GN6-09-8806		
			90	0.2		GN6-09-9002
120		86	0.2	6	35	GN6-12-8602
			0.6			GN6-12-8606
			3.0			GN6-12-8630
			88			0.2
		0.6				GN6-12-8806
		90	0.2			GN6-12-9002



30ton/m
H90



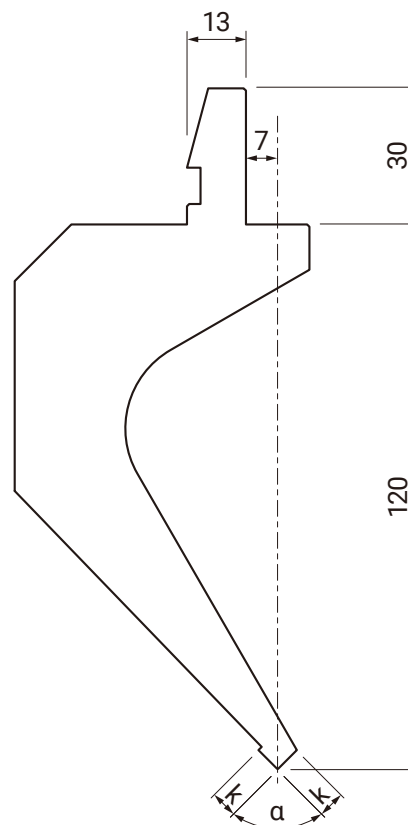
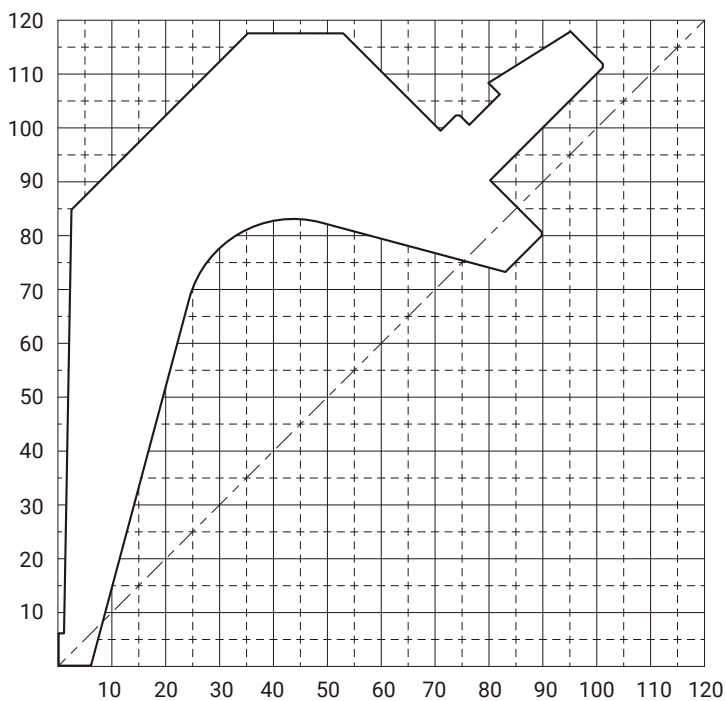
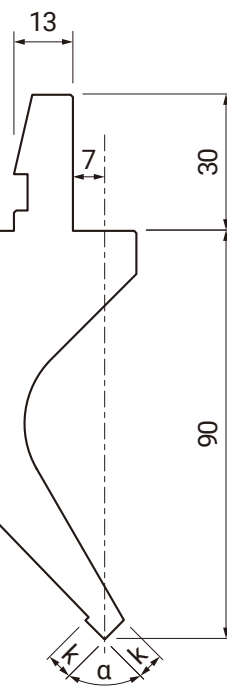
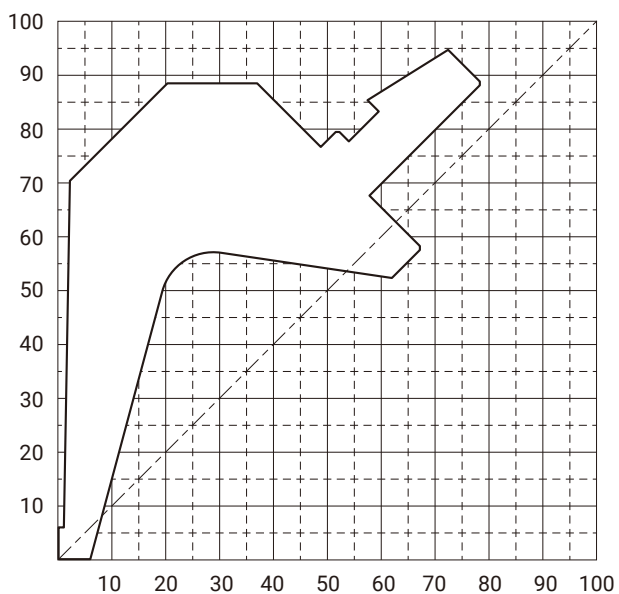
15ton/m
H120

GOOSENECK PUNCH 2

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



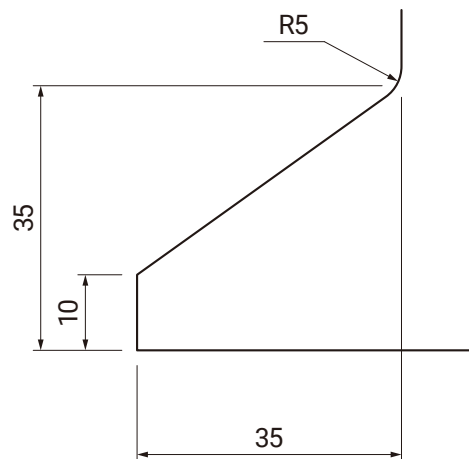
BURRING PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

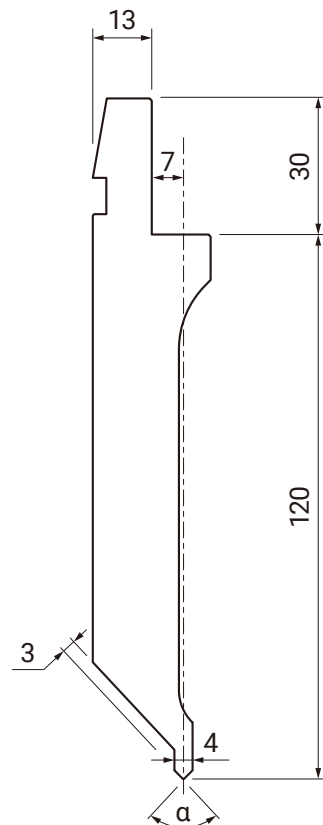
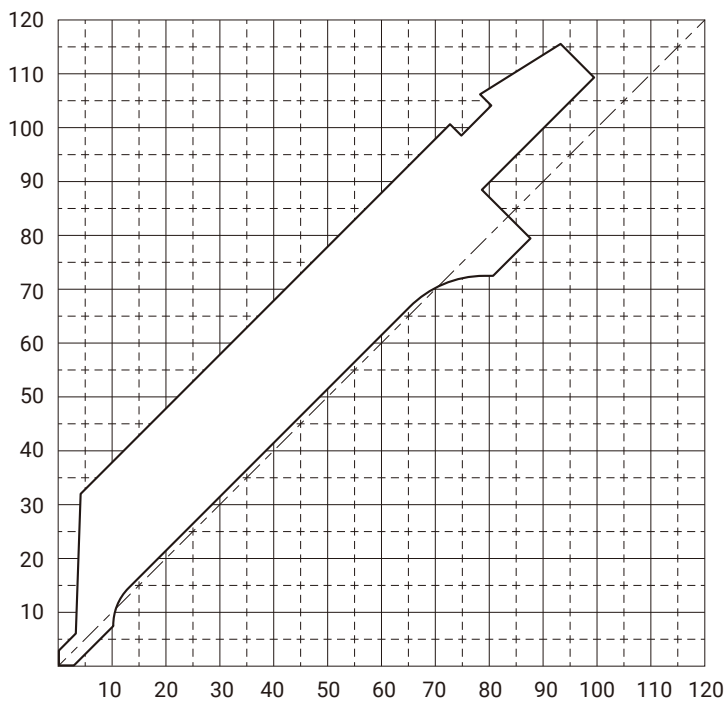
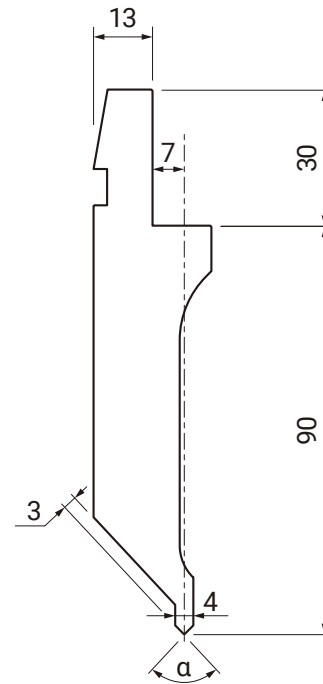
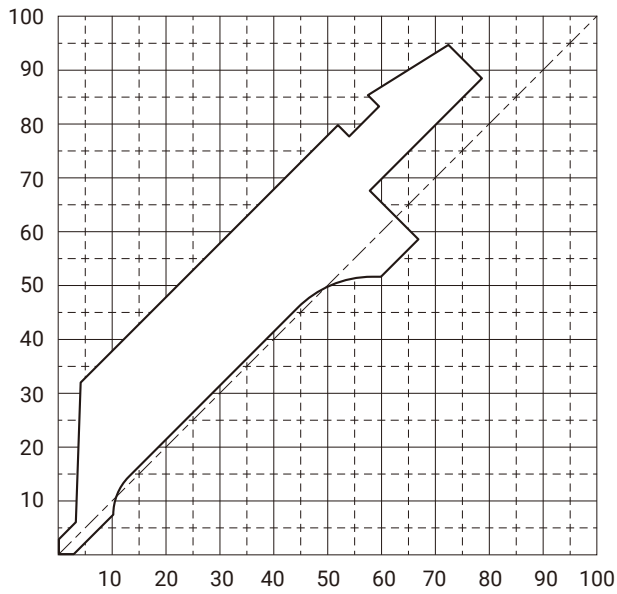
Type	H	α	R	Max	Product No.
	(mm)	Angle	(mm)	(ton/m)	
BURRING PUNCH	90	86	0.2	40	BR4-09-8602
			0.6		BR4-09-8606
		90	0.2		BR4-09-9002
	120	86	0.2		BR4-12-8602
			0.6		BR4-12-8606
		90	0.2		BR4-12-9002



20ton/m

BURRING PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**
 L: 835mm M: 510mm SS: 200mm
 Sectioning A: 370mm B: 800mm Ears: 200mm



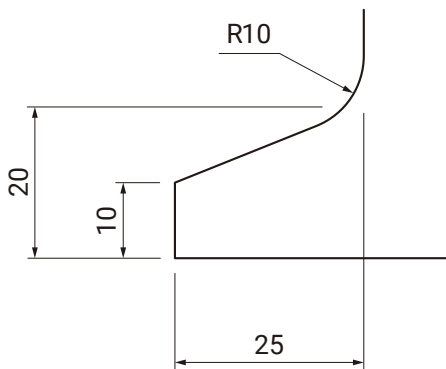
STRAIGHT PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**

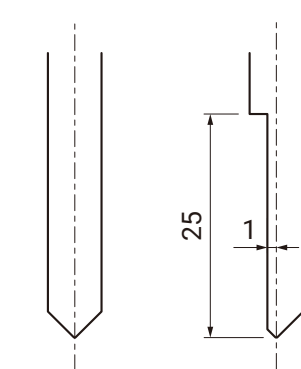
L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

Type	H	α	R	Max	Product No.			
	(mm)	Angle	(mm)	(ton/m)				
STRAIGHT PUNCH	90	86	0.2	50	SRG-09-8602			
			0.6		SRG-09-8606			
			3.0		SRG-09-8630			
		88	0.2		SRG-09-8802			
			0.6		SRG-09-8806			
			3.0		SRG-09-8830			
		90	0.2		SRG-09-9002			
		120	86		0.2	50	SRG-12-8602	
					0.6		SRG-12-8606	
	3.0			SRG-12-8630				
	88		0.2	SRG-12-8802				
			0.6	SRG-12-8806				
			3.0	SRG-12-8830				
	90		0.2	SRG-12-9002				
	STRAIGHT PUNCH T-TYPE		120	86	0.2		40	SRT-12-8602
					0.6			SRT-12-8606
		88		0.2	SRT-12-8802			
				0.6	SRT-12-8806			

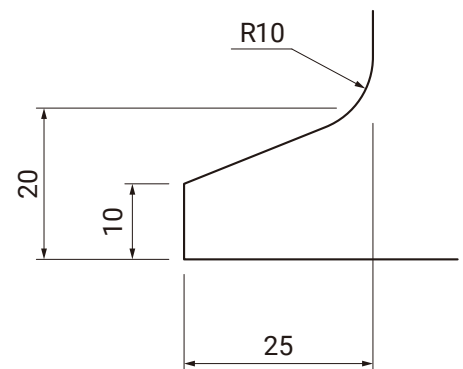


12ton/m
STRAIGHT



STRAIGHT
PUNCH

STRAIGHT
PUNCH
T-TYPE



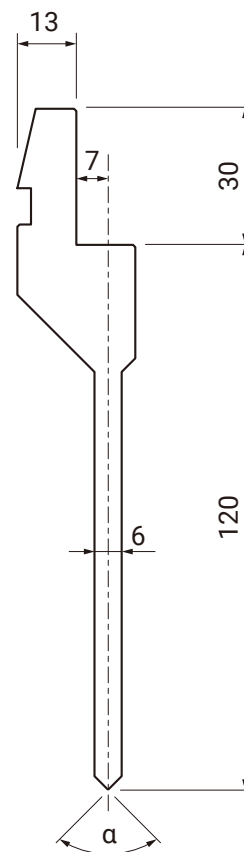
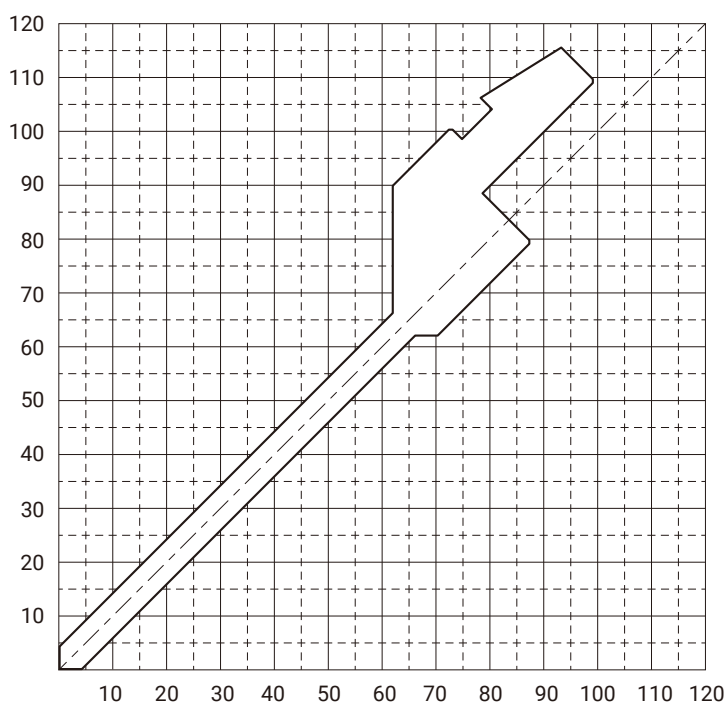
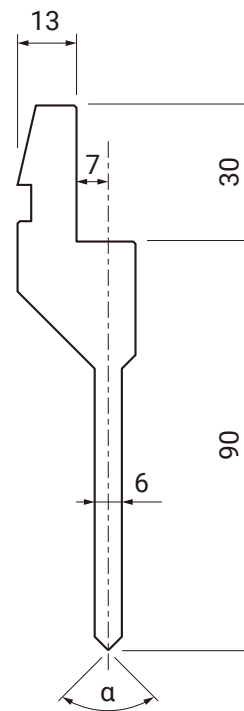
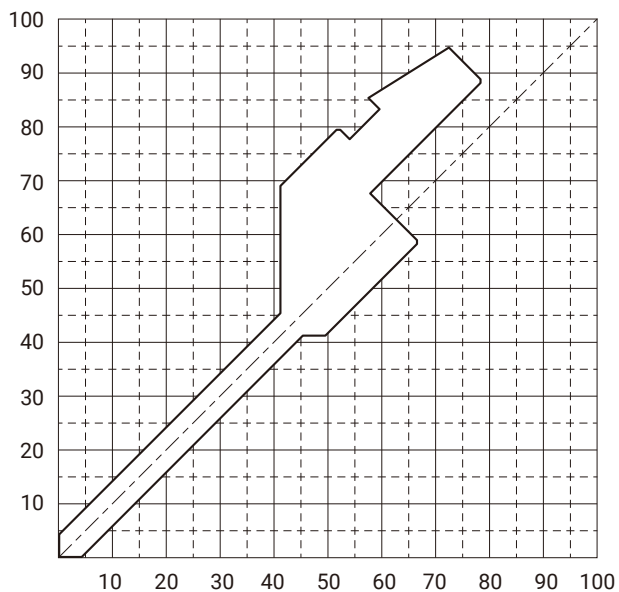
10ton/m
STRAIGHT
T-TYPE

STRAIGHT PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



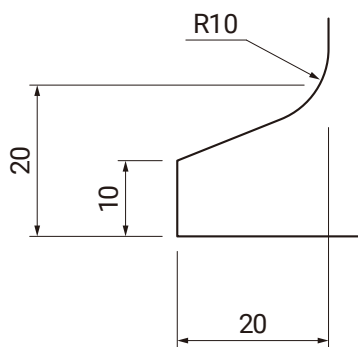
ACUTE PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm

Type	H	α	R	Max	Product No.
	(mm)	Angle	(mm)	(ton/m)	
ACUTE PUNCH	90	30	0.2	50	ACT-09-3002
			0.5		ACT-09-3005
			0.6		ACT-09-3006
	120	30	0.2	50	ACT-12-3002
			0.5		ACT-12-3005
			0.6		ACT-12-3006



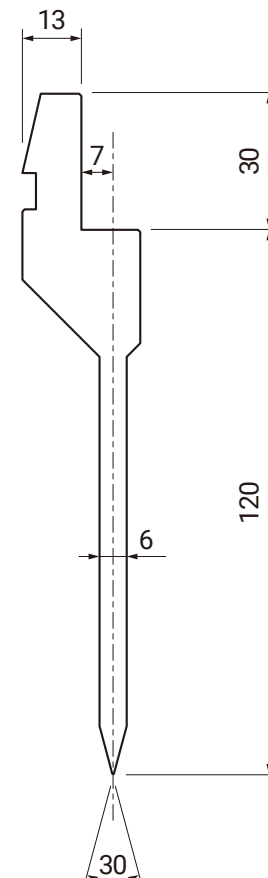
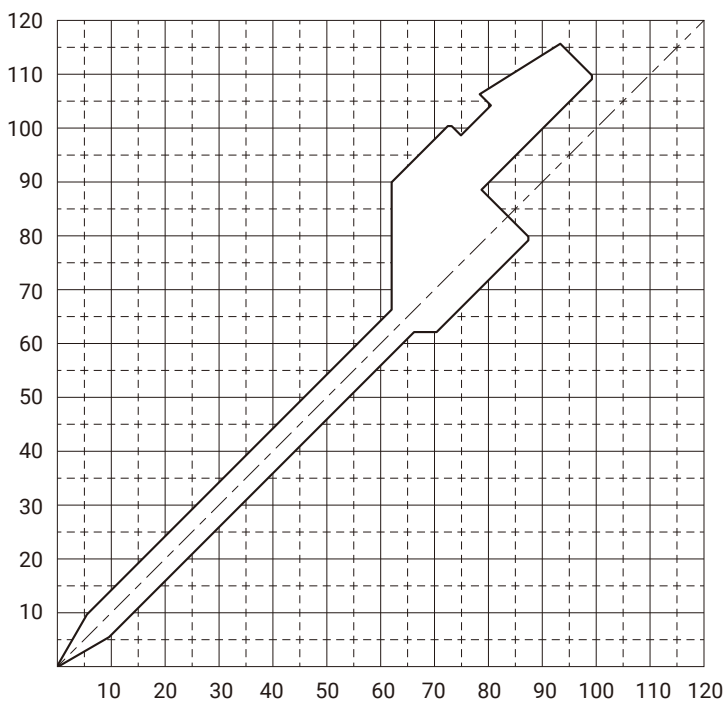
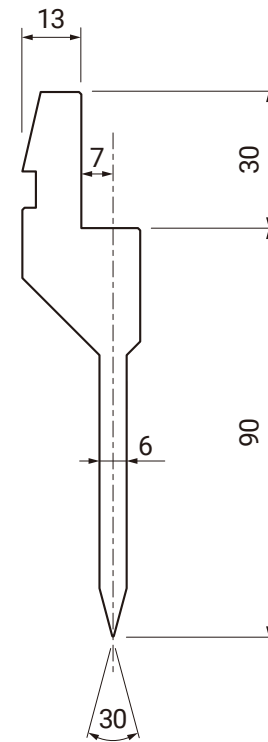
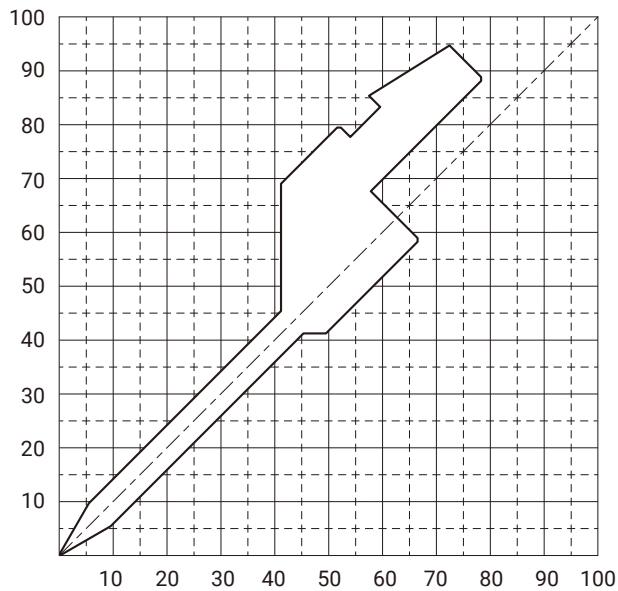
11ton/m

ACUTE PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm Ears: 200mm



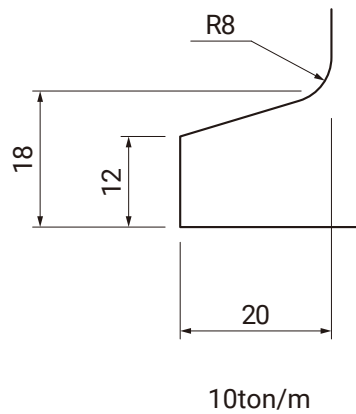
HEMMING PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

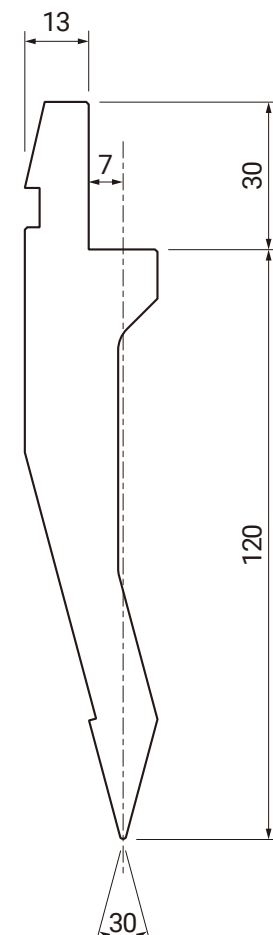
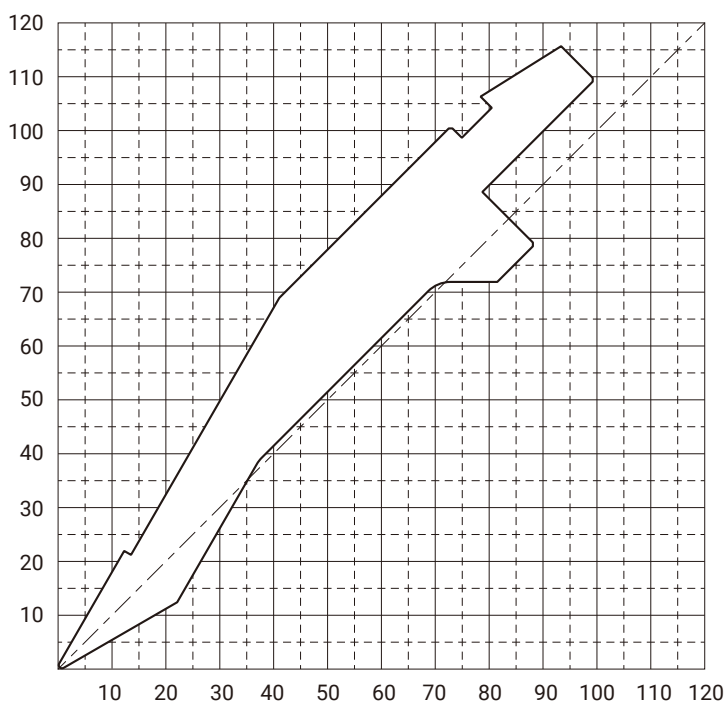
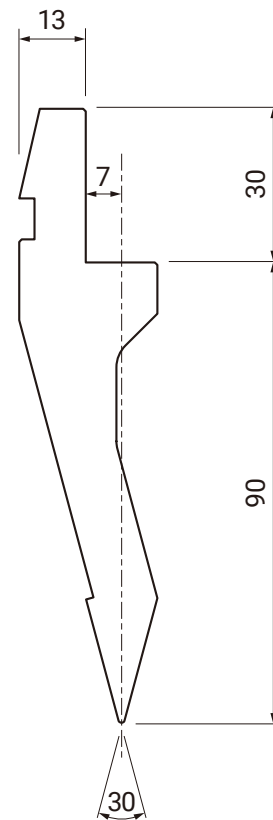
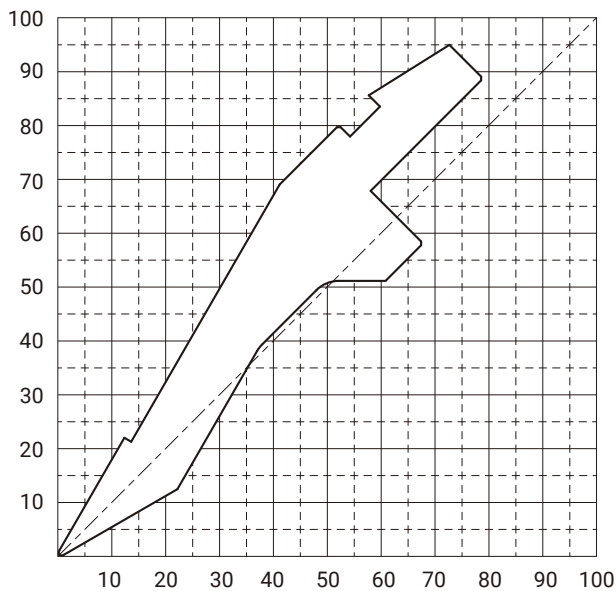
Sectioning A: 370mm B: 800mm Ears: 200mm

Type	H	α	R	Max	Product No.
	(mm)	Angle	(mm)	(ton/m)	
HEMMING PUNCH	90	30	0.6	40	HMG-09-3006
			0.65		HMG-09-3065
	120	30	0.6	40	HMG-12-3006
			0.65		HMG-12-3065



HEMMING PUNCH

Material: **SCM440** Hardness: **HRC47 ± 3**
 L: 835mm M: 510mm SS: 200mm
 Sectioning A: 370mm B: 800mm Ears: 200mm



86° DIE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm

Series	V	α	R	B	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD DIE	4	86	1.0	10.0	50	V004-86-S
	5			10.5		V005-86-S
	6		1.5	11.0	60	V006-86-S
	7			11.5	65	V007-86-S
	8			12.0	70	V008-86-S
	10		2.0	13.5	90	V010-86-S
	12		2.5	15.0		V012-86-S
	14			17.0	100	V014-86-S
	16			20.0		V016-86-S
	18			22.0		V018-86-S
	20		3.0	24.4	100	V020-86-S
	25			29.5		V025-86-S
R-TYPE DIE	4	86	1.5	10.0	50	V004-86-R
	5			10.5		V005-86-R
	10		2.5	13.5	90	V010-86-R
	16		3.5	20.0	100	V016-86-R
	18			22.0		V018-86-R
	20		4.0	24.4		V020-86-R
	25			29.5	V025-86-R	
T-TYPE DIE	4	86	1.0	6.0	50	V004-86-T
	5			7.0		V005-86-T
	6		1.5	8.0	60	V006-86-T
	8			10.0	70	V008-86-T
	10		2.0	13.0	90	V010-86-T
	16		2.5	19.0	100	V016-86-T
	18			21.0		V018-86-T
	20		3.0	23.4		V020-86-T
	25			28.5	V025-86-T	

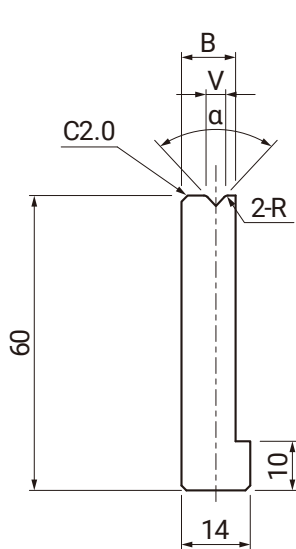
*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

*It does not have special relief on the bottom V for standard.

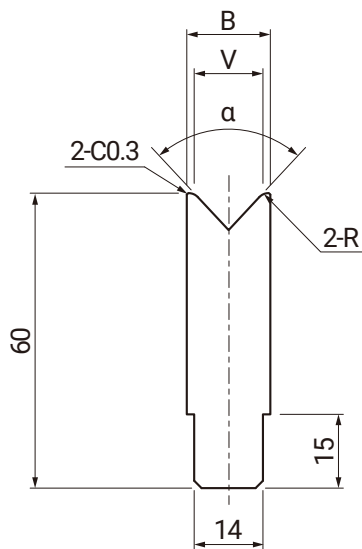
Please contact us if you require.

86° DIE

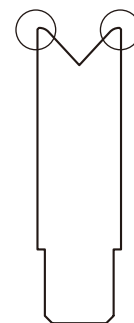
■ STANDARD



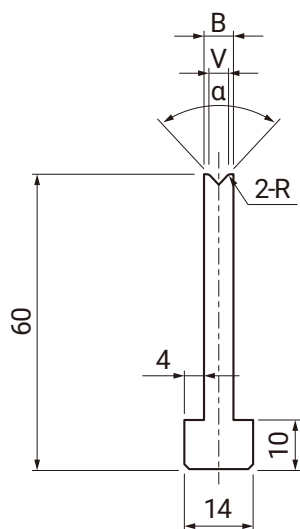
■ R-TYPE



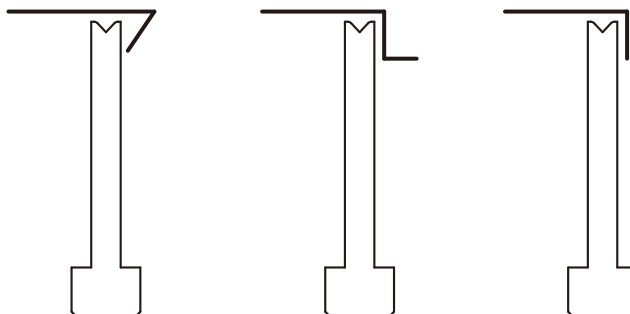
For anti-scratch



■ T-TYPE



For support short flange bending



88° DIE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

Sectioning A: 370mm B: 800mm

Series	V	α	R	B	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD DIE	4	88	1.0	10.0	50	V004-88-S
	5			10.5		V005-88-S
	6		1.5	11.0	60	V006-88-S
	8			12.0	70	V008-88-S
	10		2.0	13.5	90	V010-88-S
	12		2.5	15.0		V012-88-S
	14			17.0	100	V014-88-S
	16			20.0		V016-88-S
	18			22.0		V018-88-S
	20		3.0	24.4	100	V020-88-S
	25			29.5		V025-88-S
R-TYPE DIE	4	88	1.5	10.0	50	V004-88-R
	5			10.5		V005-88-R
	10		2.5	13.5	90	V010-88-R
	16		3.5	20.0	100	V016-88-R
	18			22.0		V018-88-R
	20		4.0	24.4		V020-88-R
	25			29.5	V025-88-R	
T-TYPE DIE	4	88	1.0	6.0	50	V004-88-T
	5			7.0		V005-88-T
	6		1.5	8.0	60	V006-88-T
	8			10.0	70	V008-88-T
	10		2.0	13.0	90	V010-88-T
	16		2.5	19.0	100	V016-88-T
	18			21.0		V018-88-T
	20		3.0	23.4		V020-88-T
	25			28.5	V025-88-T	

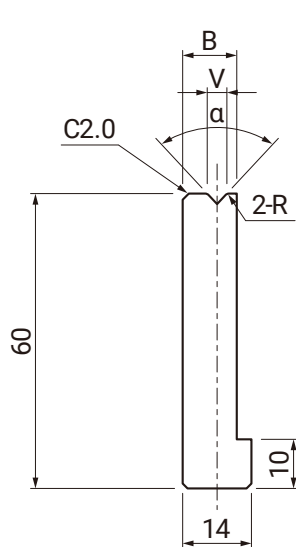
*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

*It does not have special relief on the bottom V for standard.

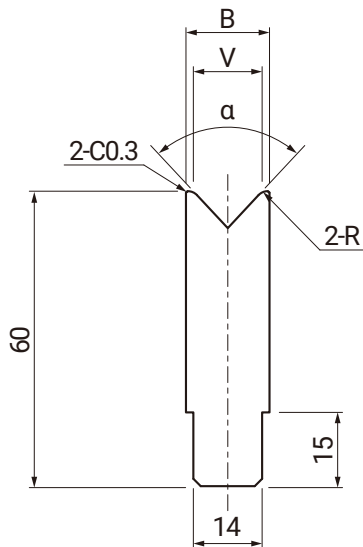
Please contact us if you require.

88° DIE

■ STANDARD



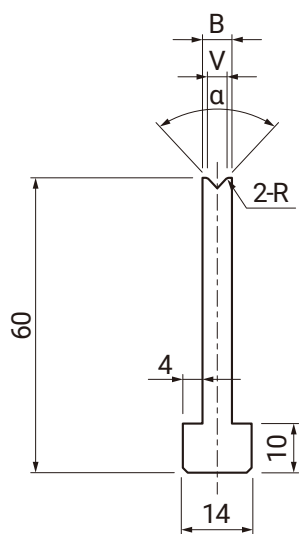
■ R-TYPE



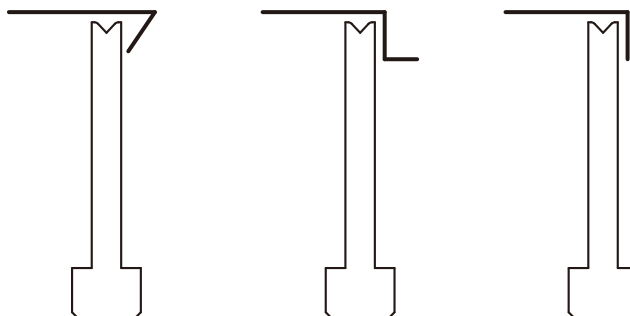
For anti-scrach



■ T-TYPE



For support short flange bending



90° DIE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

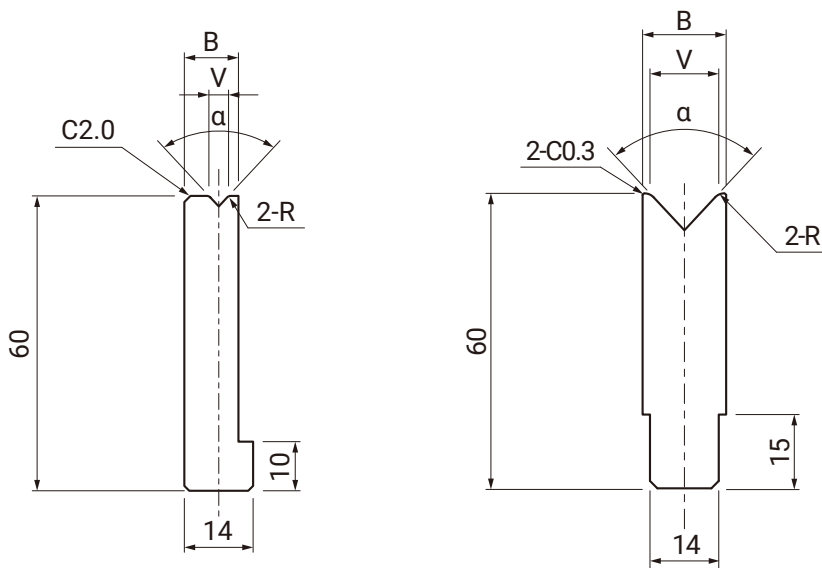
Sectioning A: 370mm B: 800mm

Series	V	α	R	B	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(ton/m)	
STANDARD DIE	4	90	1.0	10.0	50	V004-90-S
	5			10.5		V005-90-S
	6		1.5	11.0	60	V006-90-S
	7			12.0	65	V007-90-S
	8		2.0	13.5	70	V008-90-S
	10		2.5	15.0	90	V010-90-S
	12			17.0	100	V012-90-S

*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

*It does not have special relief on the bottom V for standard.

Please contact us if you require.



STANDARD

30° DIE

Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm M: 510mm SS: 200mm

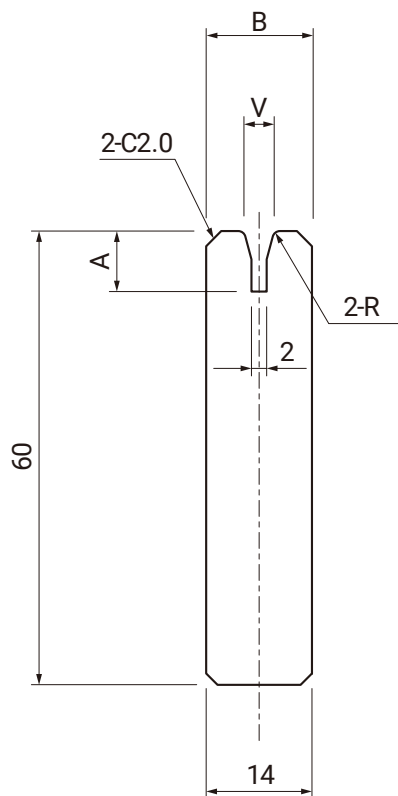
Sectioning A: 370mm B: 800mm

Series	V	α	R	A	B	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)	
STANDARD DIE	4	30	1.0	8.0	14.0	16	V004-30-S
	6			11.5	17.0	18	V006-30-S
	8		1.5	15.0	20.0	20	V008-30-S
	10		2.0	20.0	25.0	26	V010-30-S
	12		2.5	23.0	30.0	30	V012-30-S
R-TYPE DIE	4	30	1.5	8.0	14.0	16	V004-30-R
	6		2.0	11.5	17.0	18	V006-30-R
	8		2.5	15.0	20.0	20	V008-30-R
	10		3.0	20.0	25.0	26	V010-30-R
	12		4.0	23.0	30.0	30	V012-30-R

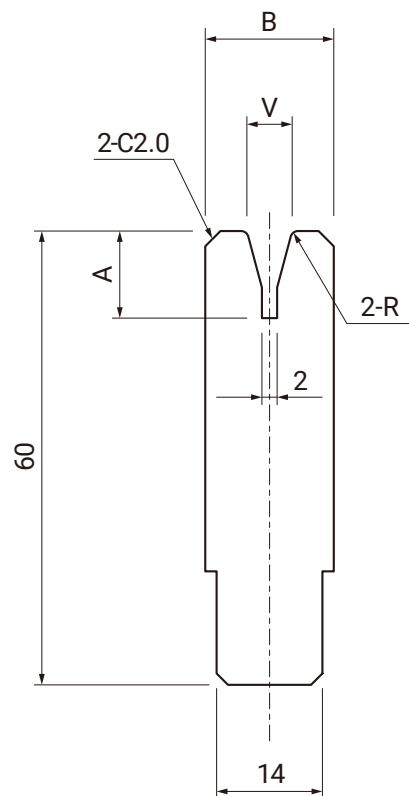
*There are chamfer on the shoulder for standard. If you don't need, we provide a reasonable price.

*Special relief on the bottom V is standard.

Please contact us if you require.



STANDARD



R-TYPE

BEND CHART

t : Material thickness

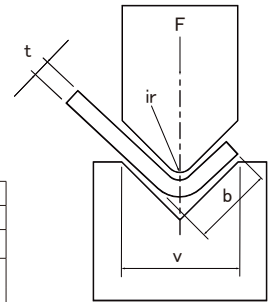
F : Pressure per 1m (kN/m)

b : Minimum length of flange

(Tensile Strength 450~500N/mm²)

ir : Radius of punch tip

v : Width of die



For mild steel

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	v
	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b
(mm)	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir
0.5	40	30																				
0.6	60	40	40	40																		
0.8		70	70	50	40																	
1		110	100	80	70	60																
1.2			140	120	110	80	70	60														
1.4				150	130	110	100	90	80													
1.5				200	170	150	130	110	100	90												
1.6					170	150	130	110	100	90												
2						220	190	170	150	130	110											
2.3							250	230	190	170	150	120										
2.6								280	250	220	180	140										
3									340	300	240	190	150									
3.2										340	270	220	170	140								
3.5											330	260	200	160	130							
4											430	340	270	210	170							
4.5												440	340	270	210							
5												520	420	330	260	210						
6													600	480	380	300	240					
7														520	410	330	260					
9															670	540	430					
10															850	670	530	420				
12																960	780	600	550			
16																	1360	1070	860			
19																		1500	1250	1000		
20																		1700	1350	1080		
22																			1600	1300		
25																			2100	1700		
30																					2400	

F (kN)

For stainless

t	4	6	7	8	10	12	14	16	18	20	25	32	40	50	63	80	100	125	160	200	250	v
	2.8	4	5	5.5	7	8.5	10	11	13.5	14	17.5	22	28	35	45	55	71	89	113	140	175	b
(mm)	0.7	1	1.1	1.3	1.6	2	2.3	2.6	3	3.3	4	5	6.5	8	10	13	16	20	26	33	41	ir
0.5	60	50																				
0.6	90	60	60	60																		
0.7	120	80	80	60	60																	
0.8		110	110	80	70																	
0.9		130	120	100	90	70																
1		170	150	120	110	90																
1.2			210	180	150	120	110	90														
1.5				290	230	200	170	150	130	120												
2					330	290	260	230	200	170												
2.5						390	350	300	250	190												
3							510	450	360	290	230											
4								650	510	410	320	260										
5									780	630	500	390	320									
6										900	720	570	450	360								
8												1020	810	650	510							
10													1290	1010	800	630						
12														1440	1170	900	830					
15															1800	1410	1140					
20																2500	2080	1670				
25																	3150	2550				
30																		3600				

F (kN)

AMADA TYPE

CONIC HIGH PERFORMANCE TOOLING

- AMADA TYPE TOOLING
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- MURATA TYPE TOOLING
- KOMATSU TYPE TOOLING
- TOYOKOKI TYPE TOOLING
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