

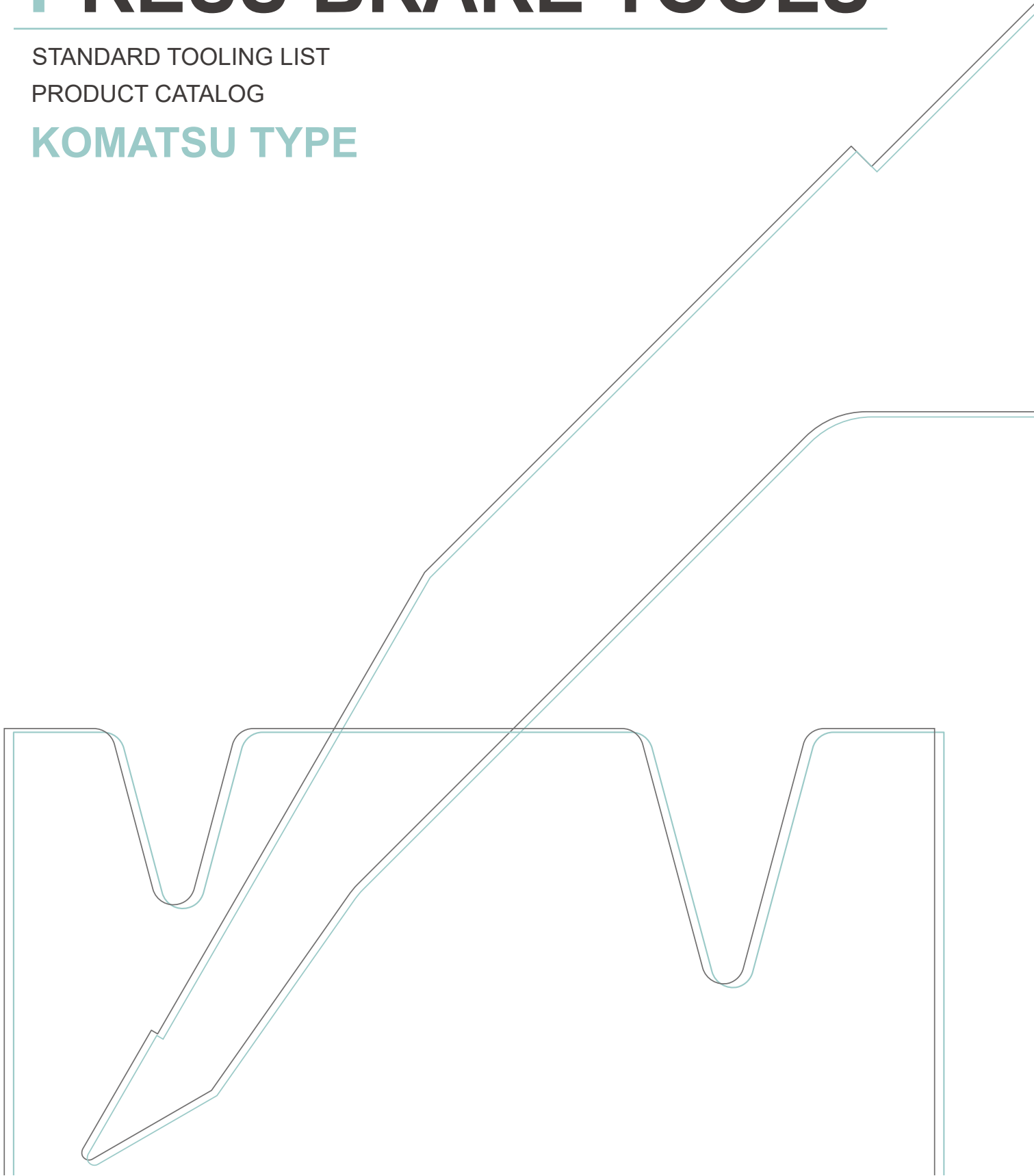
# PRESS BRAKE TOOLS

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STANDARD TOOLING LIST

PRODUCT CATALOG

**KOMATSU TYPE**



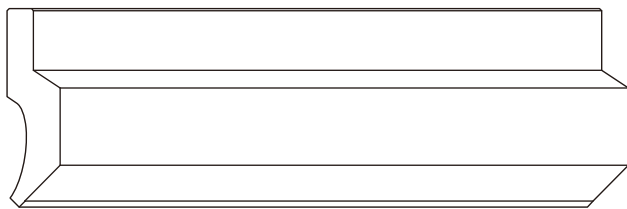
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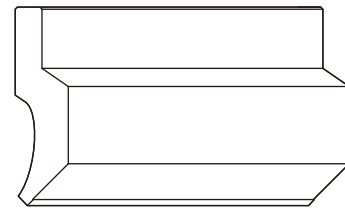
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# INFORMATION

## ■ TOOL LENGTH

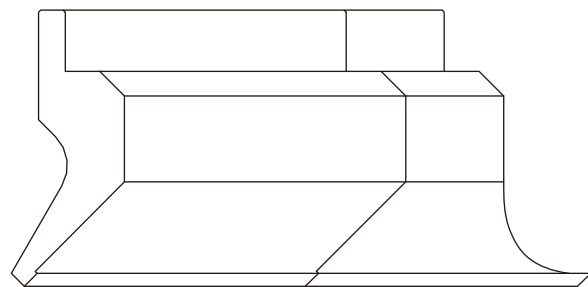
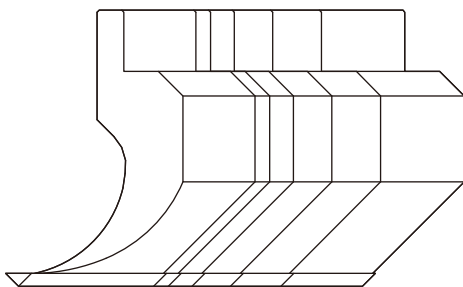


Type L 835 mm



Type S 415 mm

## ■ SECTIONING



## ■ SECTIONING (PUNCH)

SECTIONING KLP (Total 800mm) 10 ▪ 15 ▪ 20 ▪ 30 ▪ 50 ▪ 75 ▪ 100 ▪ 300 ▪ 100 (Right) ▪ 100 (Left)

SECTIONING KSP (Total 385mm) 10 ▪ 15 ▪ 20 ▪ 40 ▪ 50 ▪ 75 ▪ 175

\*Pressure allowance (tonnage) of one piece design tool and sectional tool is different.

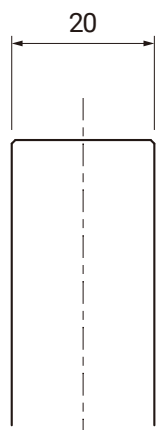
## ■ SECTIONING (DIE)

SECTIONING KLD (Total 800mm) 10 ▪ 15 ▪ 20 ▪ 40 ▪ 50 ▪ 100 ▪ 200 ▪ 365

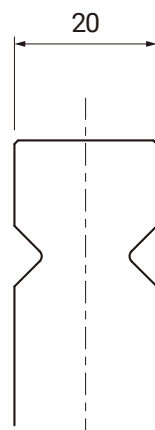
SECTIONING KSD (Total 385mm) 10 ▪ 15 ▪ 20 ▪ 40 ▪ 50 ▪ 75 ▪ 175

\*There is no sectional tool set on screw fix type die.

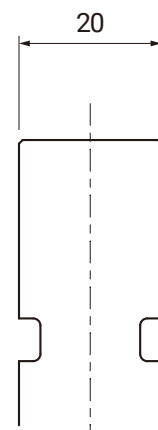
## ■ CLAMP TYPE



STANDARD TYPE



I CLAMP TYPE



FALL PREVENTION TYPE

# GOOSENECK PUNCH

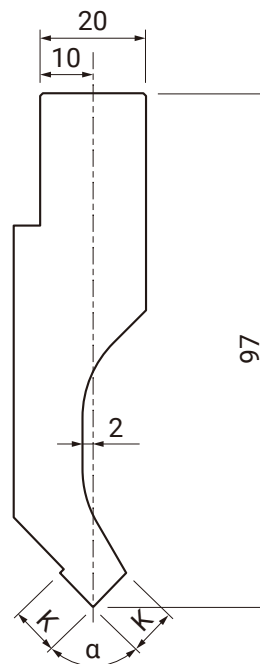
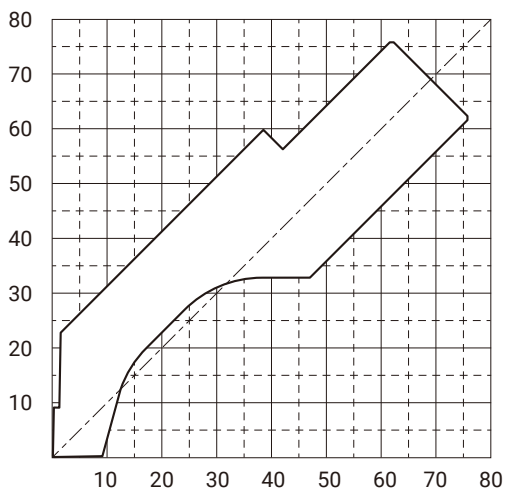
Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

Type	H (mm)	$\alpha$ Angle	R (mm)	K (mm)	Max (ton/m)	Product No.
	GOOSENECK PUNCH	97	88	0.2	9	
90			6		50	GN028T
			9		70	GN02C
6			50		GN02CT	
115		88	9		70	GN108A
			6		50	GN108T
		90	9		70	GN10C
			6		50	GN10CT
130		88	9		70	GN208A
			6		50	GN208T
		90	9		70	GN20C
			6		50	GN20CT

■ GN0



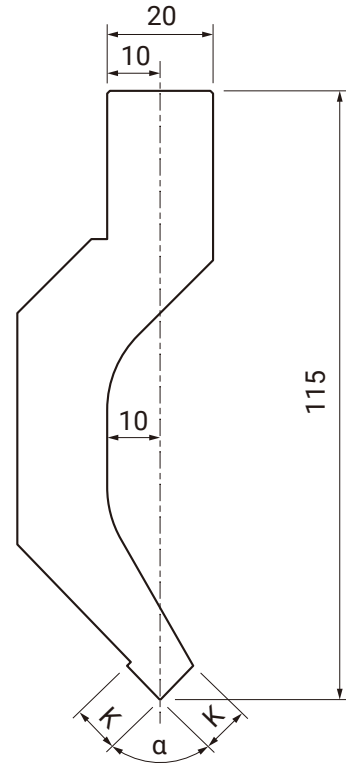
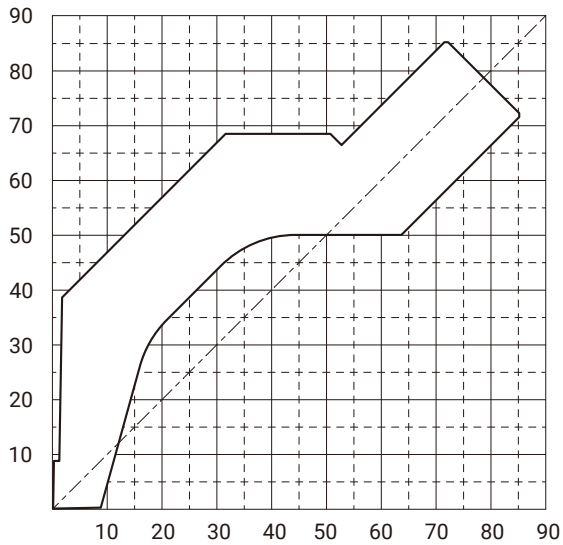
# GOOSENECK PUNCH

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

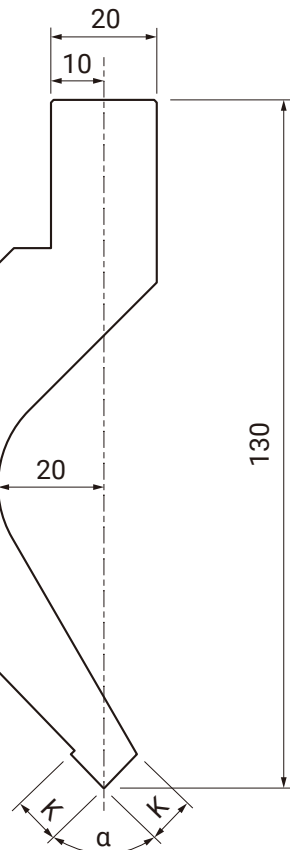
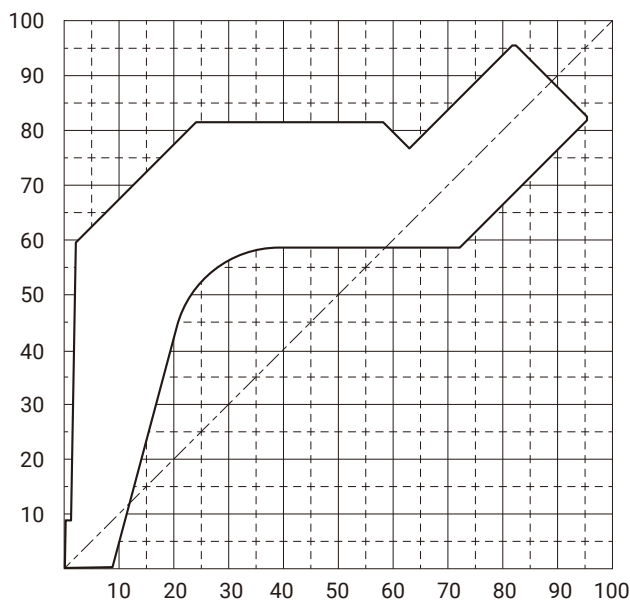
L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

## ■ GN1



## ■ GN2



# GOOSENECK 30° / 45°

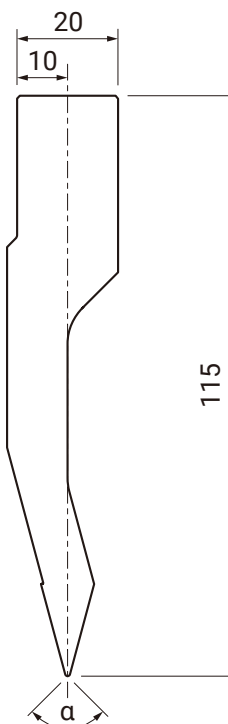
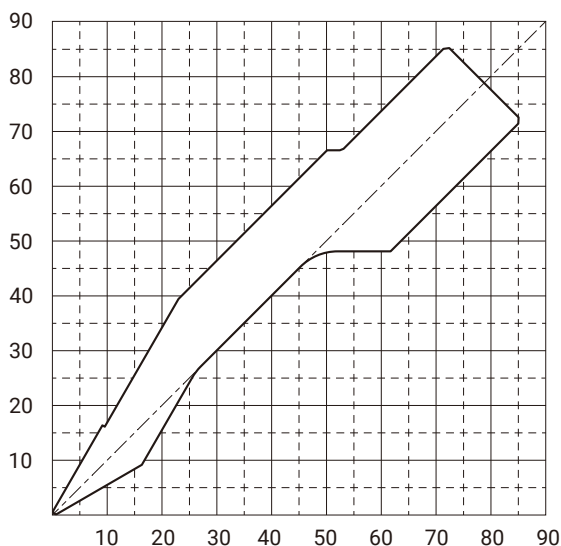
Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

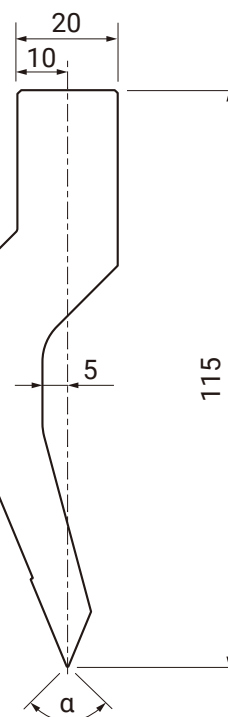
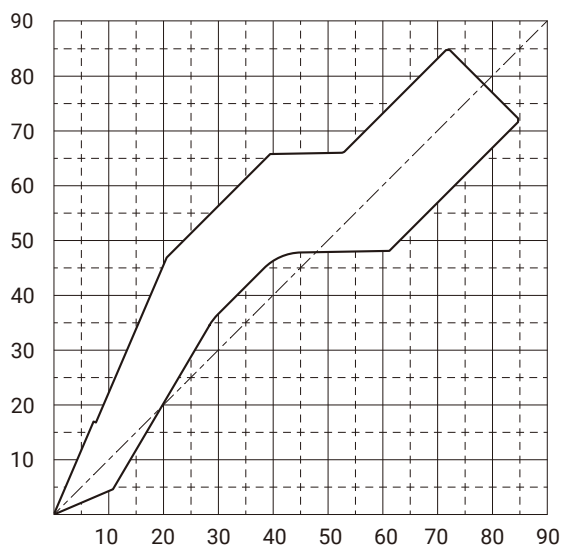
Sectioning KLP: 800mm KSP: 385mm

Type	H (mm)	$\alpha$ Angle	R (mm)	Max (ton/m)	Product No.	Shape
	GOOSENECK PUNCH	115	30	0.5		
45			0.2	GNS045P		
						GNS545P

■ i



■ ii



# STRAIGHT PUNCH

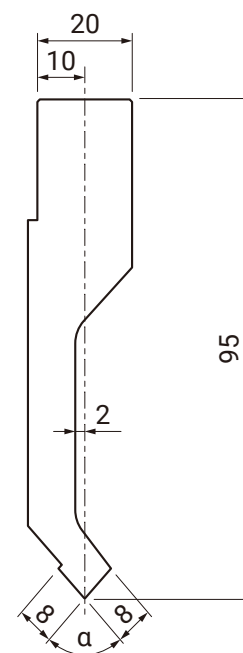
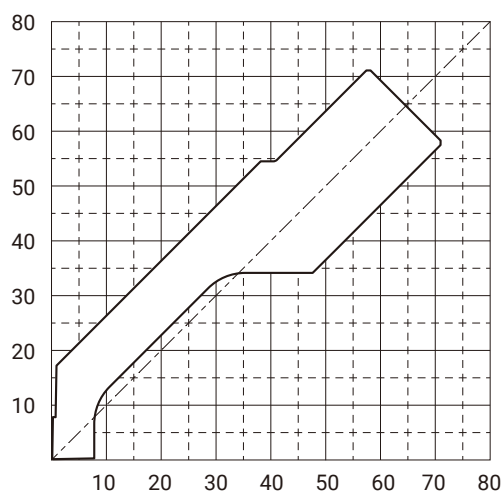
Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

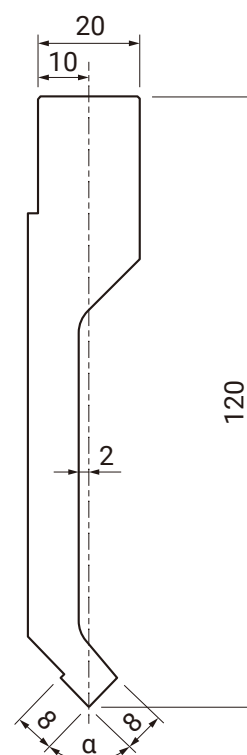
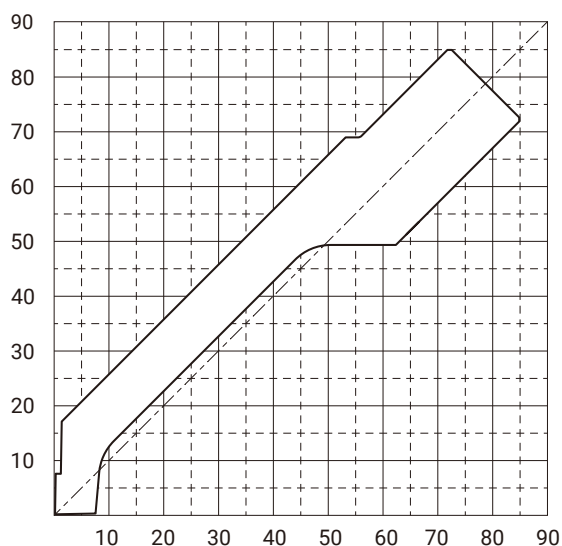
Sectioning KLP: 800mm KSP: 385mm

Type	H (mm)	$\alpha$ Angle	R (mm)	Max (ton/m)	Product No.
	STRAIGHT PUNCH	95	88	0.2	
90			STE05CP		
120		88	STEH058AP		
		90	STEH05CP		

■ STE



■ STEH



# STRAIGHT PUNCH

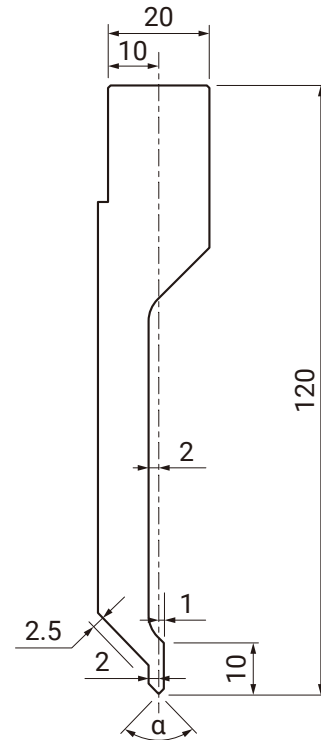
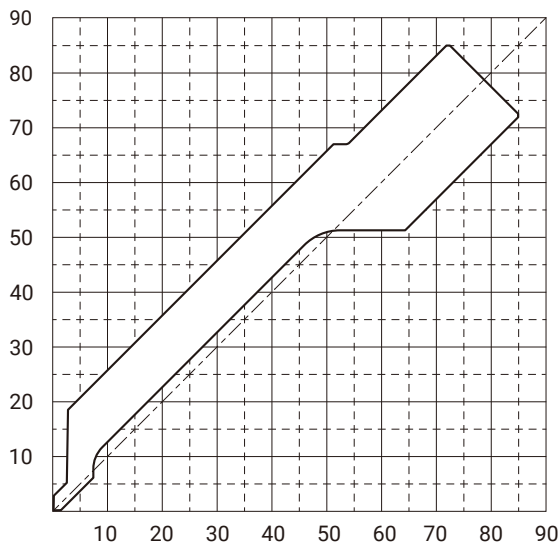
Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

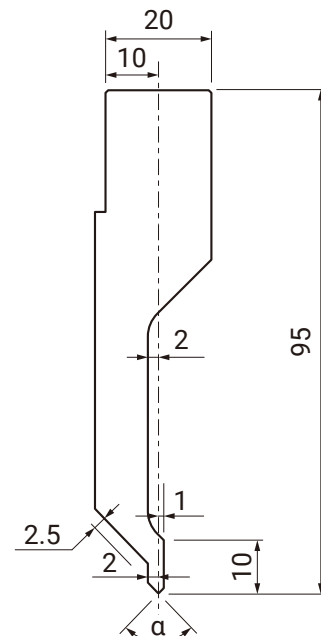
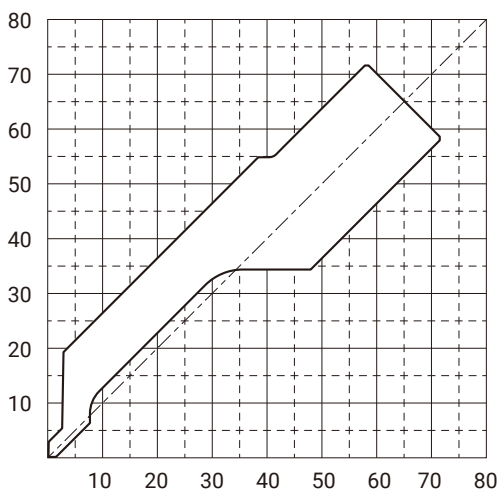
Type	H	$\alpha$	R	Max	Product No.
	(mm)	Angle	(mm)	(ton/m)	
STRAIGHT PUNCH	120	88	0.2	20	STSH058AP

\*Pressure allowance (tonnage) of both L and R horn tool is 8ton/m.



Type	H	$\alpha$	R	Max	Product No.
	(mm)	Angle	(mm)	(ton/m)	
STRAIGHT PUNCH	95	88	0.2	20	STS058AP

\*Pressure allowance (tonnage) of both L and R horn tool is 8ton/m





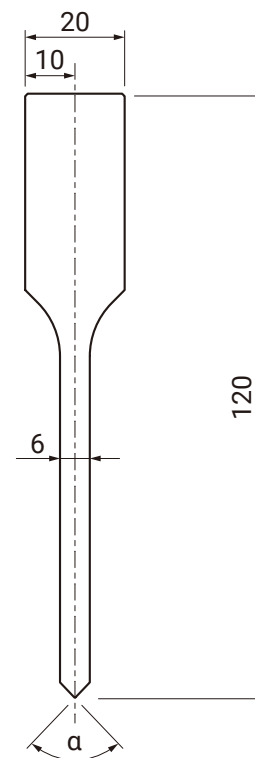
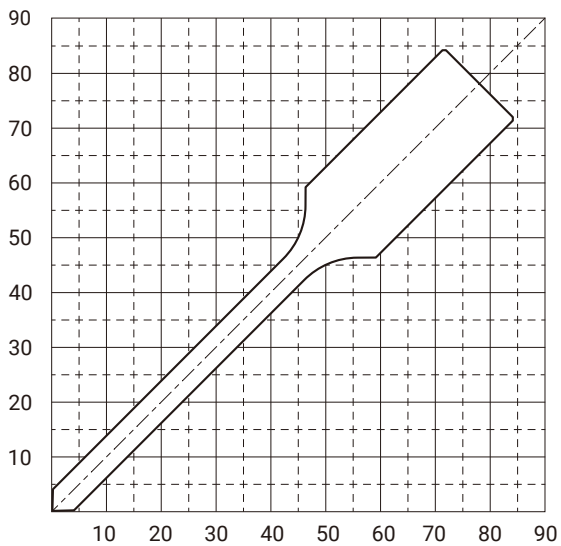
# STRAIGHT PUNCH

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

L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

Type	H	$\alpha$	R	Max	Product No.
	(mm)	Angle	(mm)	(ton/m)	
STRAIGHT PUNCH	120	88	0.2	20	STK068A
		90			STK06C



# STRAIGHT PUNCH

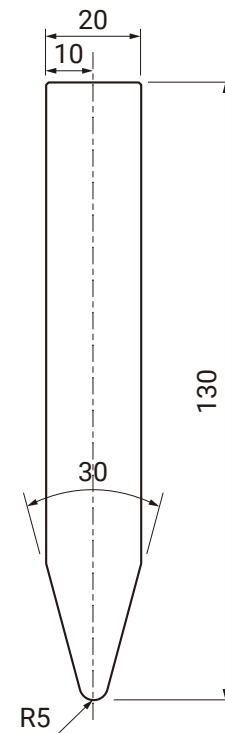
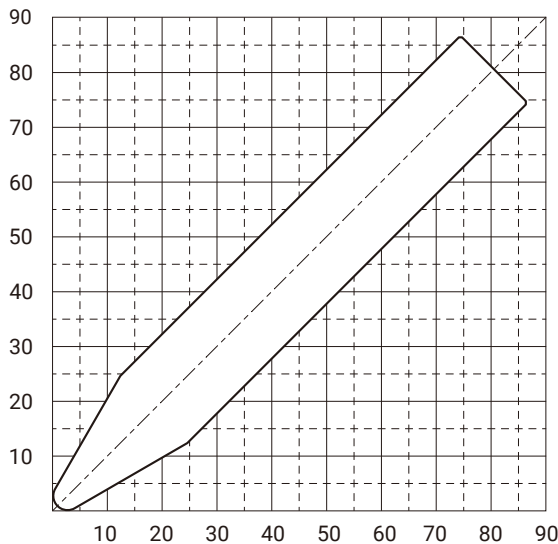
Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

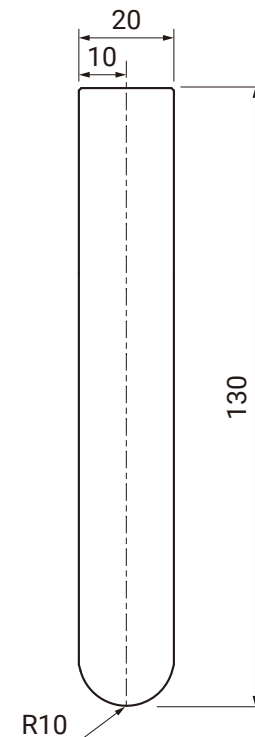
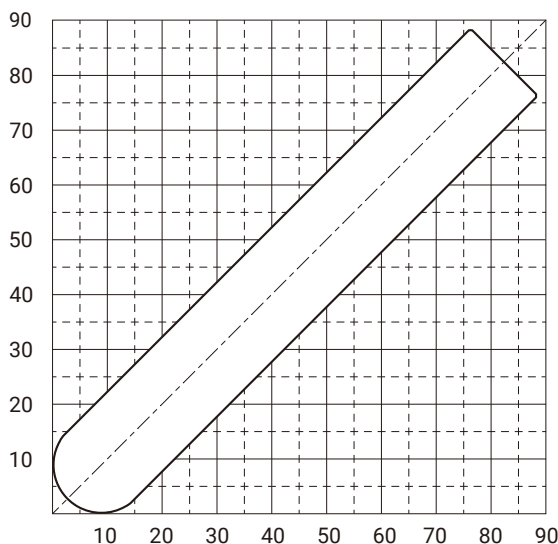
Sectioning KLP: 800mm KSP: 385mm

Type	H (mm)	α Angle	R (mm)	Max (ton/m)	Product No.
	STRAIGHT PUNCH	130	30	5.0	
		-	10.0		STR10A

## ■ STR05A



## ■ STR10A



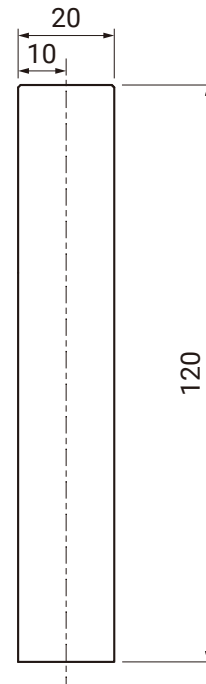
# OTHERS

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

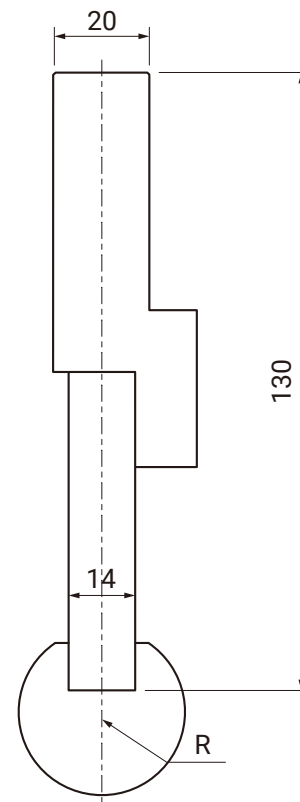
L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

Type	H	Max	Product No.
	(mm)	(ton/m)	
STRAIGHT PUNCH	120	100	STF20



Type	Parts Name	R	Product No.
		(mm)	
RADIUS PUNCH	Holder	-	Punch Holder
	Punch Tip	15	R15
		20	R20
		25	R25
		30	R30
		35	R35
40	R40		

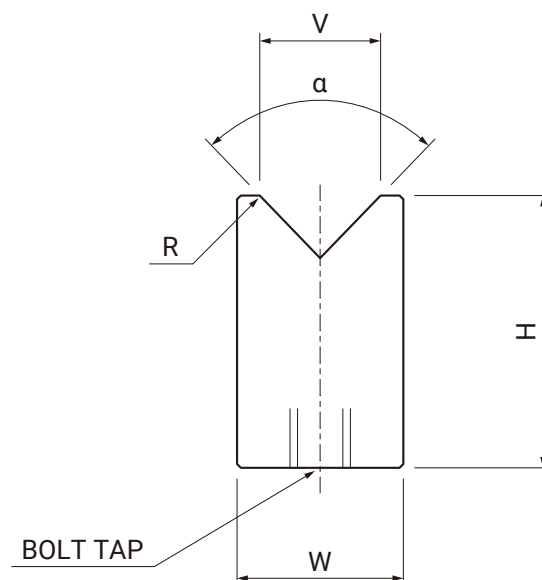


# 1V DIE 88° 90°

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

L: 835mm S: 415mm

Type	V	$\alpha$	R	W	H	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)	
1V DIE	4	88	1.0	14	30	70	1V048A
	6						1V068A
	8						1V088A
	10		1.5	16	1V108A		
	12			18	1V128A		
	16			22	36		1V168A
1V DIE	4	90	1.0	14	30	70	1V04C
	6						1V06C
	8						1V08C
	10		1.5	16	1V10C		
	12			18	1V12C		
	16			22	36		1V16C



# 1V SEPARATE DIE 88° 90°

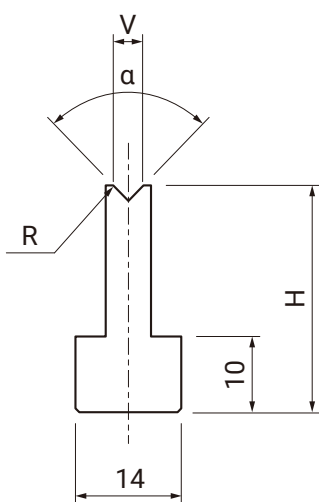
Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

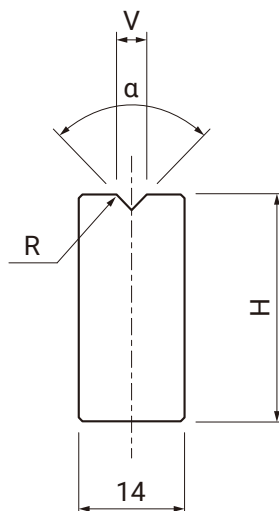
Sectioning KLD: 800mm KSD: 385mm

Type	V	$\alpha$	R	W	H	Max	Product No.	Shape	
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)			
1V SEPARATE DIE	4	88	0.2	-	30	30	1V04FAB	i	
	6		0.5			35			1V06FAB
	8		1.0			45			
1V SEPARATE DIE	4	88	1.0	-	30	70	1V048AB	ii	
	6						1V068AB		
	8						1V088AB		
	10		1.5				16	1V108AB	iii
	12							1V128AB	
	14							1V148AB	
	16							1V168AB	
1V SEPARATE DIE	4	90	0.2	-	30	30	1V04FCB	i	
	6		0.5			35			1V06FCB
	8		1.0			45			
1V SEPARATE DIE	4	90	1.0	-	30	70	1V04CB	ii	
	6						1V06CB		
	8						1V08CB		
	10		1.5				16	1V10CB	iii
	12							1V12CB	
	14							1V14CB	
	16							1V16CB	

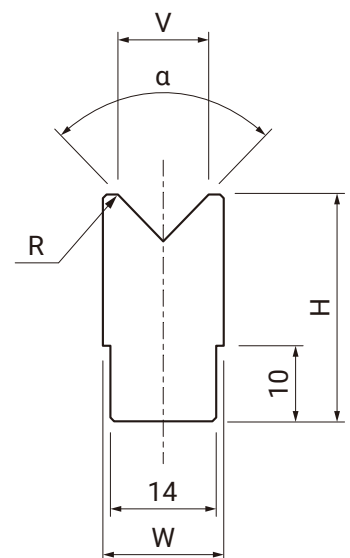
■ i



■ ii



■ iii



# 1V DIE 85°

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

L: 835mm S: 415mm

Type	V	α	R	W	H	Max	Product No.	Shape
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)		
1V DIE	32	85	4.0	49	46	70	1V325DB	i
	36			51			1V365DB	
	40		54	1V405DB				

1V DIE	25	85	3.0	60	60	100	1 V 2 5	ii
	32		4.0				1 V 3 2	
	40		5.0				1 V 4 0	
	50			1 V 5 0				
	63		80	1 V 6 3			iii	

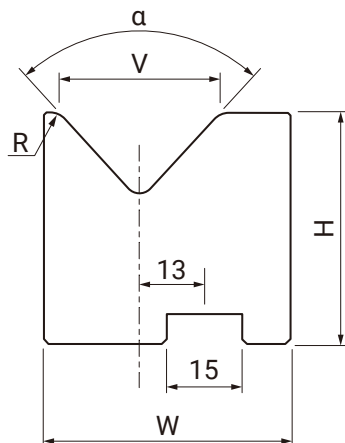
Material: **S50C (Induction hardening)**

Hardness: **HRC52-55**

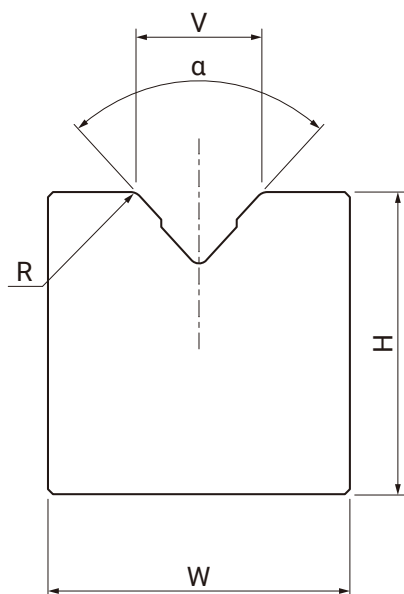
L: 835mm S: 415mm

Type	V	α	R	W	H	Max	Product No.	Shape
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)		
1V DIE	80	85	8.0	95	95	100	1 V 8 0	iii
	100		10.0	125	100		1 V 1 0 0	

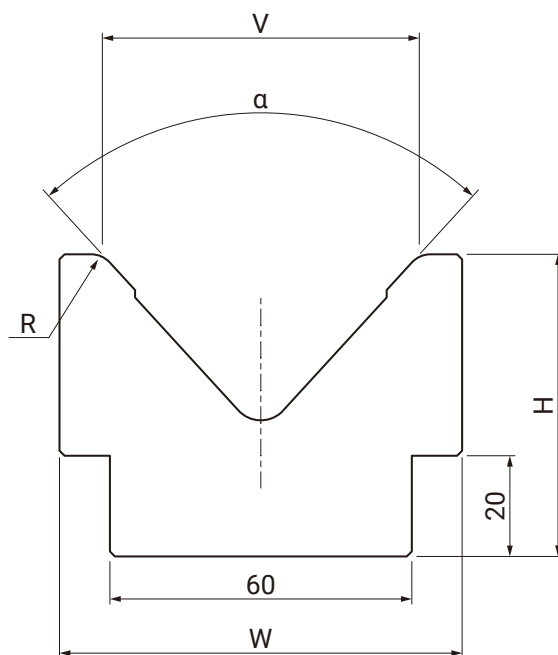
■ i



■ ii



■ iii



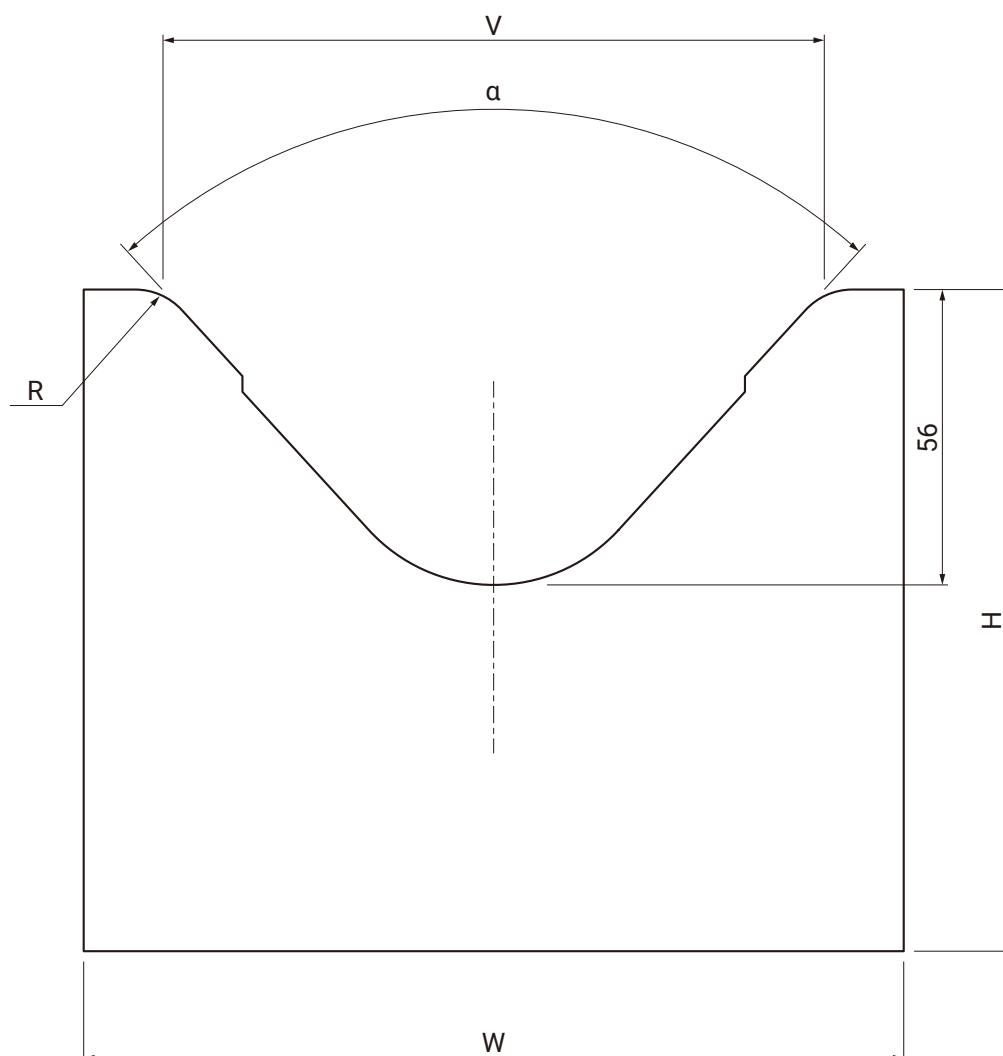
# 1V DIE 85°

Material: **S50C (Induction hardening)**

Hardness: **HRC52-55**

L: 835mm S: 415mm

Type	V	$\alpha$	R	W	H	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)	
1V DIE	125	85	12.0	155	125	150	1 V 1 2 5

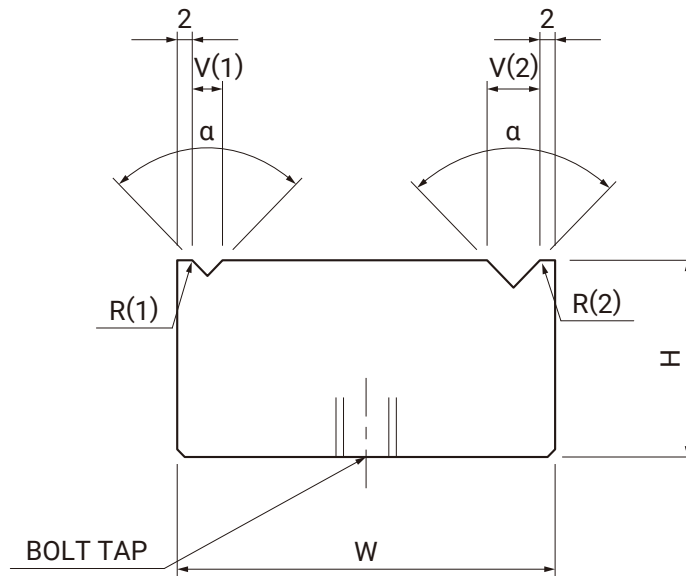


# 2V DIE 88° 90°

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

L: 835mm S: 415mm

Type	V(1)	V(2)	$\alpha$	R(1)	R(2)	W	H	Max	Product No.
	(mm)	(mm)	Angle	(mm)	(mm)	(mm)	(mm)	(ton/m)	
2V DIE	4	7	88	1.0	1.0	50	26	70	2V04078A
	6	10		1.0	1.5				2V06108A
	8	12		1.5	1.5				2V08128A
	12	20		1.5	3.0				2V12208A
	16	25		1.5	3.0				2V16258A
2V DIE	4	7	90	1.0	1.0	50	26	70	2V0407C
	6	10		1.0	1.5				2V0610C
	8	12		1.5	1.5				2V0812C
	12	20		1.5	3.0				2V1220C
	16	25		1.5	3.0				2V1625C





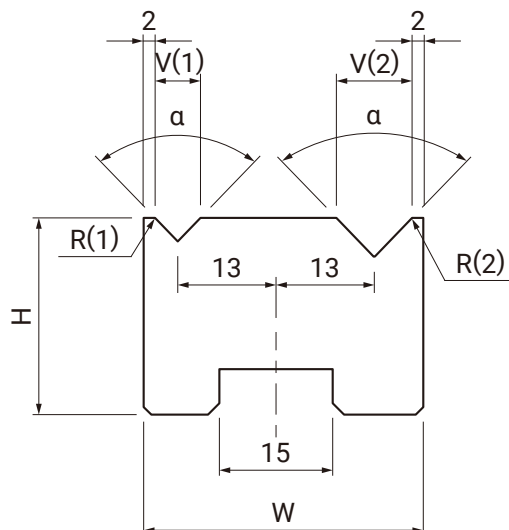
# SELF CENTERING 2V DIE 88° 90°

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

L: 835mm S: 415mm

Sectioning KLD: 800mm KSD: 385mm

Type	V(1)	V(2)	$\alpha$	R(1)	R(2)	W	H	Max (ton/m)	Product No.
	(mm)	(mm)	Angle	(mm)	(mm)	(mm)	(mm)		
SELF CENTERING 2V DIE	6	10	88	1.0	1.5	37	26	70	2V06108AB2
							36		2V06108AB3
							46		2V06108AB4
	8	12		26	2V08128AB2				
				36	2V08128AB3				
				46	2V08128AB4				
	10	16	26	2V10168AB2					
			36	2V10168AB3					
			46	2V10168AB4					
	12	20	1.5	1.5	45.5	26	2V12208AB2		
						36	2V12208AB3		
						46	2V12208AB4		
	14	18	45	26	2V14188AB2				
				36	2V14188AB3				
				46	2V14188AB4				
	16	25	1.5	3.0	50	36	2V16258AB3		
46						2V16258AB4			
SELF CENTERING 2V DIE	6	10	90	1.0	1.5	37	26	2V0610CB2	
							36	2V0610CB3	
							46	2V0610CB4	
	8	12		26	2V0812CB2				
				36	2V0812CB3				
				46	2V0812CB4				
	10	16	1.5	1.5	42	26	2V1016CB2		
						36	2V1016CB3		
						46	2V1016CB4		



# 1V SHARP ANGLE DIE

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

L: 835mm S: 415mm

Type	V	α	R	W	H	Max	Product No.	Shape
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)		
1V SHARP ANGLE DIE	6	30	1.0	14	30	30	1V0630P	i
	8			16	36		1V0830P	
	10		1.5	20	46		1V1030P	
	12			24			1V1230P	
	16	40	1.5	60	60	45	1VA16	vi
	25		3.0		70	30	1VA25	

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

L: 835mm S: 415mm

Sectioning KLD: 800mm KSD: 385mm

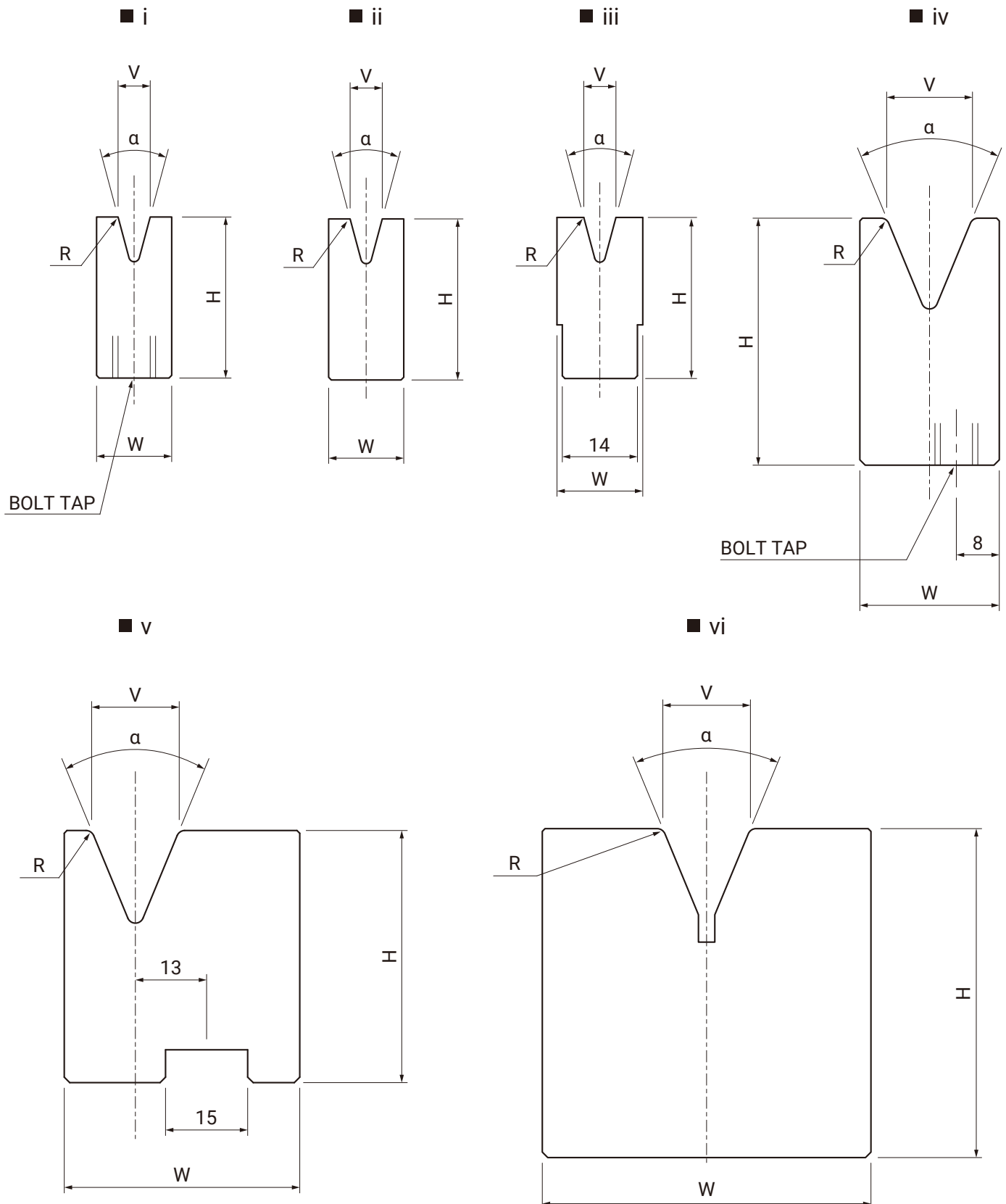
Type	V	α	R	W	H	Max	Product No.	Shape
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)		
1V SHARP ANGLE DIE	6	30	1.0	14	30	30	1V0630PB	ii
	8			16	36		1V0830PB	iii
	10		2.0	20	46		1V1030PB	
	12			24			20	1V1230PB
	16	45	1.5	43	46	35	1V1645P	iv
	20			46		30	1V2045P	
1V SHARP ANGLE DIE	16	45	1.5	60	60	35	1V1645PB	v
	20				70	30	1V2045PB	
	32		4.0	26	46	40	1V3245PB	
	40						5.0	

# 1V SHARP ANGLE DIE

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

L: 835mm S: 415mm

Sectioning KLD: 800mm KSD: 385mm

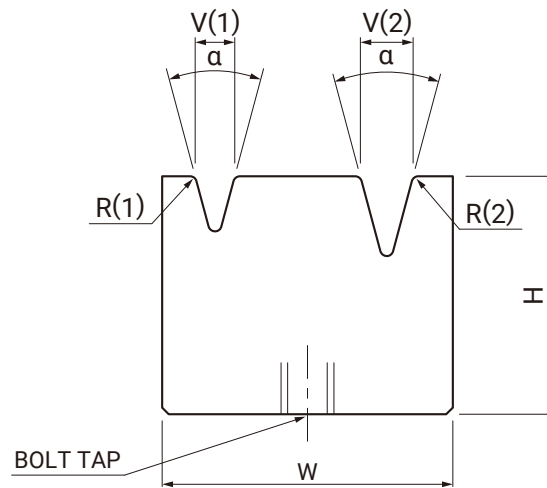


# 2V SHARP ANGLE DIE

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

L: 835mm S: 415mm

Type	V(1)	V(2)	$\alpha$	R(1)	R(2)	W	H	Max (ton/m)	Product No.
	(mm)	(mm)	Angle	(mm)	(mm)	(mm)	(mm)		
2V DIE	6	8	30	1.0	1.0	44	36	30	2V0608P-2
	10	12		1.5	1.5	50	46		2V1012P-2
	16	20	45			55			2V1620P

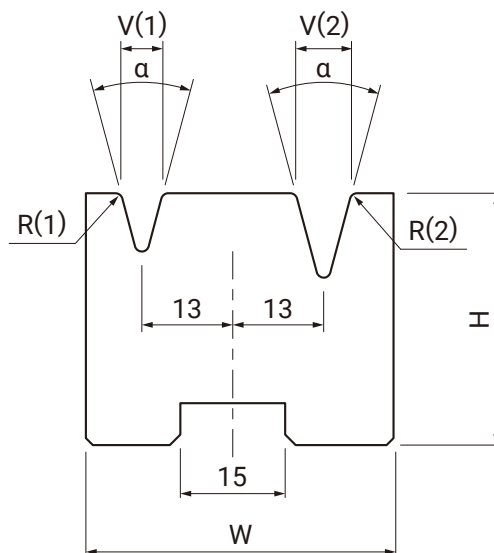


Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

Sectioning KLD: 800mm KSD: 385mm

Type	V(1)	V(2)	$\alpha$	R(1)	R(2)	W	H	Max (ton/m)	Product No.
	(mm)	(mm)	Angle	(mm)	(mm)	(mm)	(mm)		
SELF CENTERING 2V DIE	6	8	30	1.0	1.0	44	36	30	2V0608PB-2
	10	12		1.5	1.5	50	46		2V1012PB-2
	16	20	45			55			2V1620PB

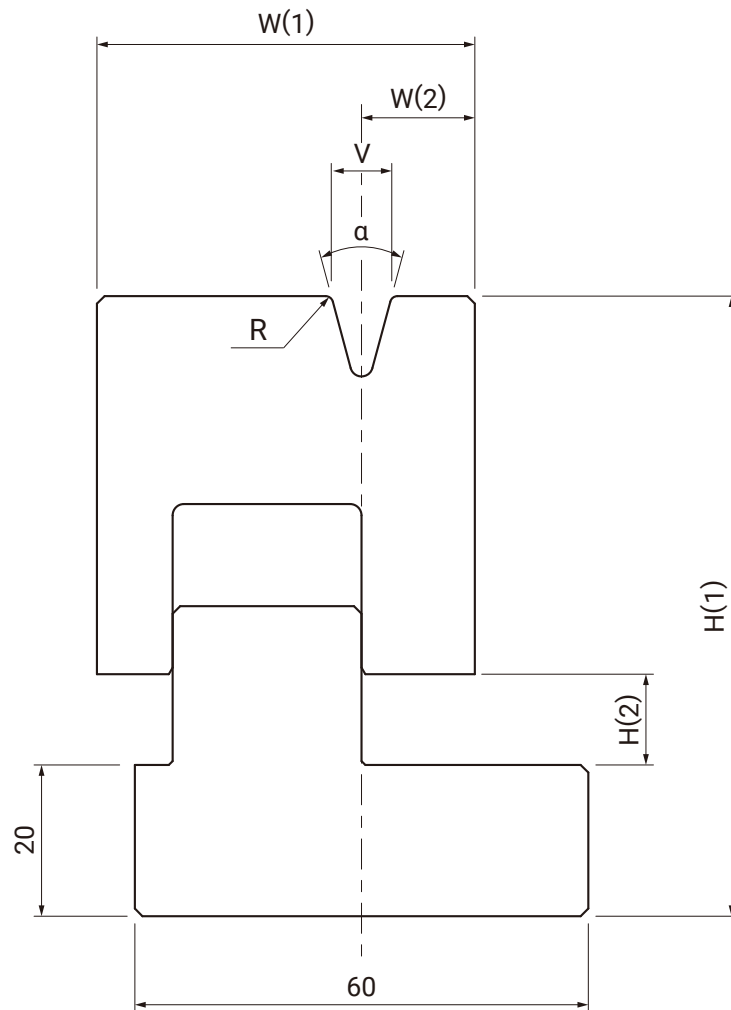


# HEMMING DIE

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

L: 835mm S: 415mm

Type	V (mm)	$\alpha$ Angle	R (mm)	W(1) (mm)	W(2) (mm)	H(1) (mm)	H(2) (mm)	Max (ton/m)	Product No.	
	HEMMING DIE	8	30	1.0	50	15	82	12		1st process
25										
2nd process										
12		2.0		60	20	105	15	1st process	HM1V12S	
								25		
								2nd process		
							80			



# GOOSENECK PUNCH FOR STAINLESS AND ALUMINUM (84°)

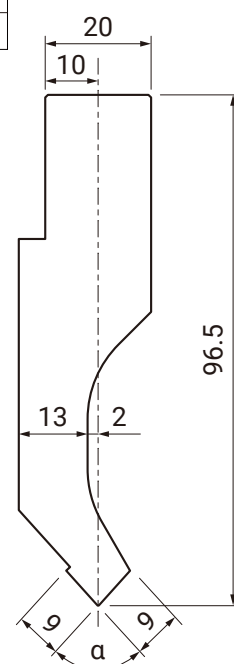
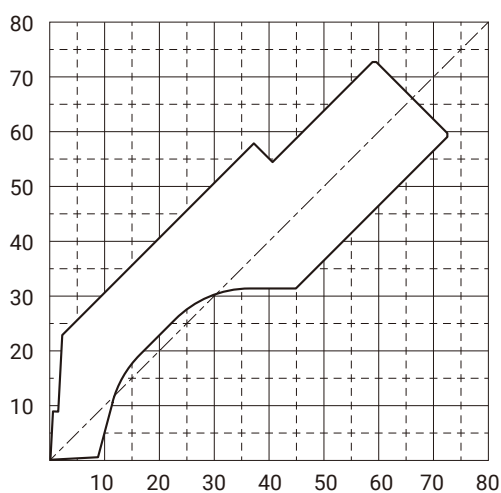
Material: **SCM440** Hardness: **HRC47 ± 3**

L: 835mm S: 415mm

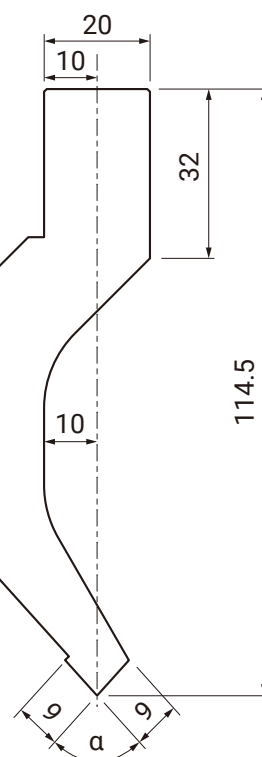
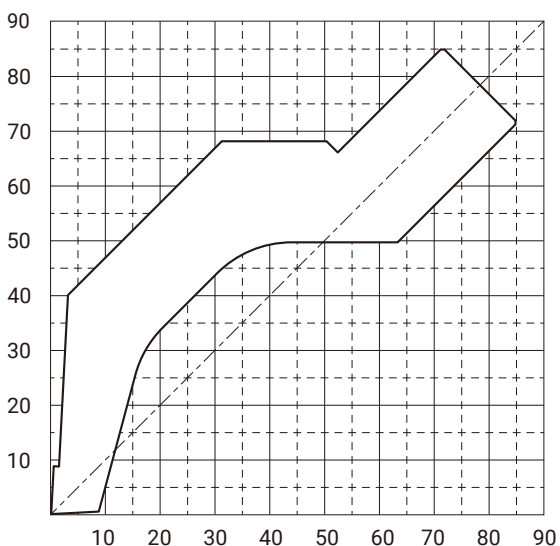
Sectioning KLP: 800mm KSP: 385mm

Type	H	$\alpha$	R	Max	Product No.
	(mm)	Angle	(mm)	(ton/m)	
GOOSENECK PUNCH	96.5	84	0.2	70	GN0284A
	114.5				GN1084A
	129.5				GN2084A
	96.5	84	0.2	45	GN0284T
	114.5				GN1084T
	129.5				GN2084T

## ■ GN0284A



## ■ GN1084A



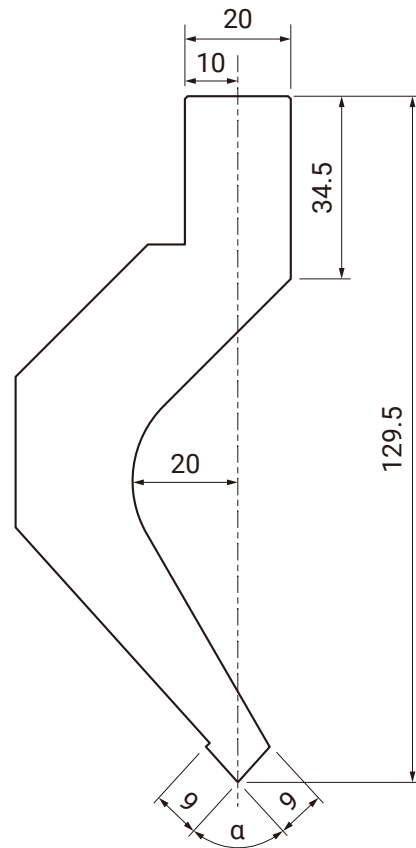
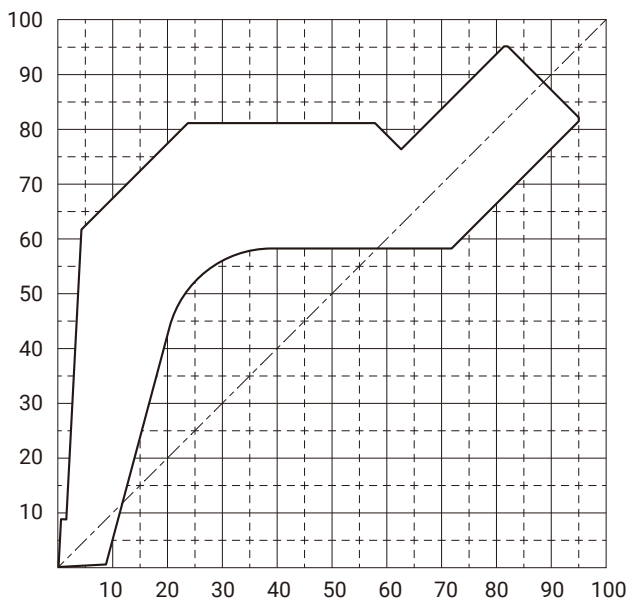
# GOOSENECK PUNCH FOR STAINLESS AND ALUMINUM (84°)

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

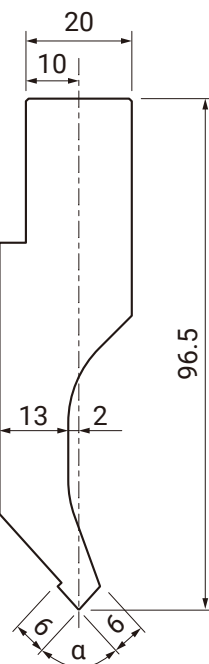
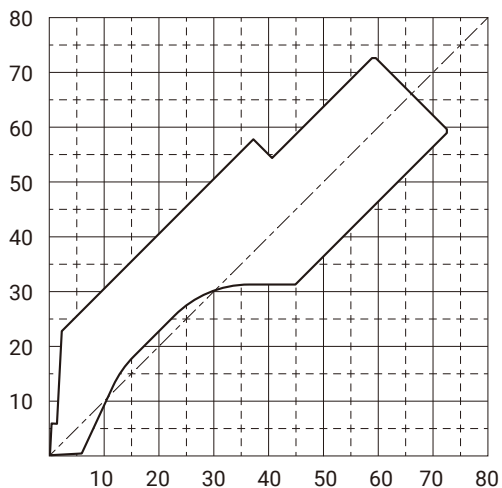
L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

■ GN2084A



■ GN0284T



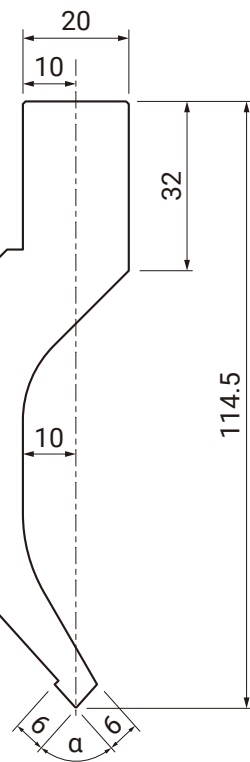
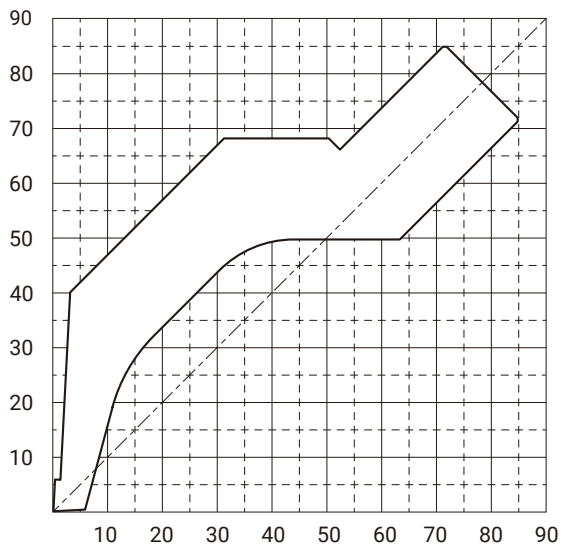
# GOOSENECK PUNCH FOR STAINLESS AND ALUMINUM(84°)

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

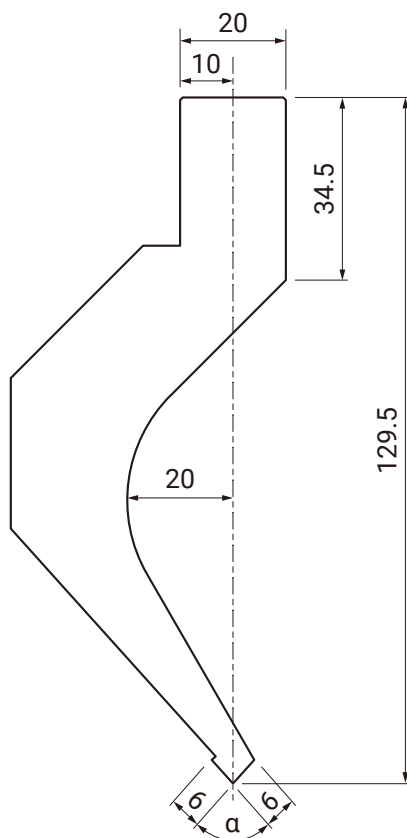
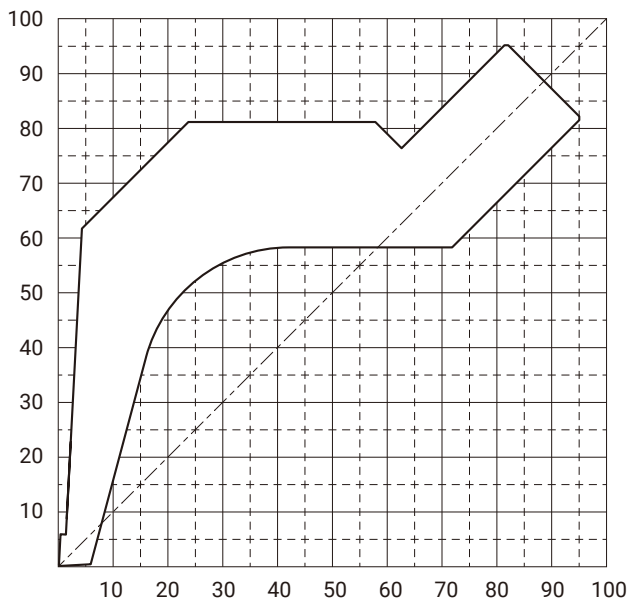
L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

## ■ GN1084T



## ■ GN2084T





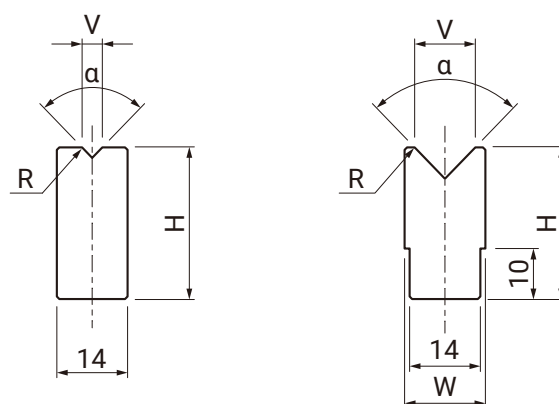
# DIE FOR STAINLESS AND ALUMINUM(84°)

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

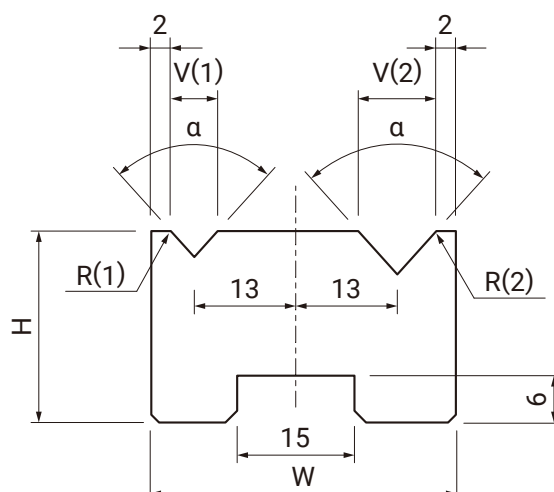
L: 835mm S: 415mm

Sectioning KLP: 800mm KSP: 385mm

Type	V	α	R	W	H	Max	Product No.
	(mm)	Angle	(mm)	(mm)	(mm)	(ton/m)	
1V DIE	6	84	2.0	14	36	60	1V0684AB
	8		3.0				1V0884AB
	10			3.5			1V1084AB
	12		1V1284AB				



Type	V(1)	V(2)	α	R(1)	R(2)	W	H	Max	Product No.
	(mm)	(mm)	Angle	(mm)	(mm)	(mm)	(mm)	(ton/m)	
SELF CENTERING 2V DIE	6	10	84	2.0	3.0	39	24.5	70	2V061084AB2
	8	14		2.0	3.5		34.5		2V081484AB2
	12	16		3.5	3.5		44.5		2V121684AB2
	6	10	84	2.0	3.0	42	24.5	70	2V061084AB3
	8	14		2.0	3.5		34.5		2V081484AB3
	12	16		3.5	3.5		44.5		2V121684AB3
	6	10	84	2.0	3.0	45	24.5	70	2V061084AB4
	8	14		2.0	3.5		34.5		2V081484AB4
	12	16		3.5	3.5		44.5		2V121684AB4



# BEND CHART

t : Material thickness

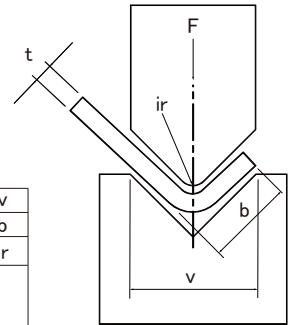
F : Pressure per 1m (kN/m)

b : Minimum length of flange

(Tensile Strength 450~500N/mm<sup>2</sup>)

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
(mm)	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
0.5	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
0.6	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
(mm)	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
0.5	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
0.6	60	50																				
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)



## PRODUCT CATALOG

### KOMATSU TYPE

#### CONIC HIGH PERFORMANCE TOOLING

- AMADA TYPE TOOLING
- TRUMPF TYPE TOOLING
- MURATA TYPE TOOLING
- KOMATSU TYPE TOOLING
- TOYOKOKI TYPE TOOLING
- NISSHINBO TYPE TOOLING

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Dealer