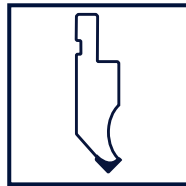


### Pressbrake Tooling

#### Goose Neck Top Tool



EURO 1010/A/85/0.8  
EURO 1010/A/85/0.8/105  
40527  
40528

#### 4-Way Vee Die Bottom Tool



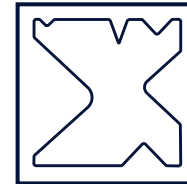
EURO 2009  
1061  
1062  
1071  
1081

#### 5-Way Vee Die Bottom Tool



40529  
40530  
40531

#### 6-Way Vee Die Bottom Tool



AB6 3-4  
AB6 5-6  
AB6 7-8  
AB6 9-10  
AB6 11-12  
AB6 16

MODEL	GOOSE NECK TOP TOOL REFERENCE	TOP TOOL OVERALL HEIGHT	BOTTOM TOOL REFERENCE	BOTTOM TOOL NO. OF VEE'S	BOTTOM TOOL VEE SIZES	BOTTOM TOOL OVERALL SIZE
		mm			mm	mm
<b>PBS CNC Range</b>						
1250/40 - 4100/160	1010/A/85/0.8	96.5	2009	4	16, 22, 35, 50	60 x 60
3100/200 - 4100/240	1010/A/85/0.8/105	135	2009	4	16, 22, 35, 50	60 x 60
3700/300, 4100/300	1010/A/85/0.8/105	135	AB6 11-12	6	12, 15, 26, 50, 80, 125	145 x 145
3100/300	1010/A/85/0.8/105	135	AB6 16	6	20, 25, 40, 80, 100, 170	200 x 200
<b>PBXS CNC Range</b>						
1250/40 - 6100/160	1010/A/85/0.8	96.5	2009	4	16, 22, 35, 50	60 x 60
3100/120 - 6100/240	1010/A/85/0.8/105	135	2009	4	16, 22, 35, 50	60 x 60
3100/160, 3700/200, 4100/200, 6100/300	1010/A/85/0.8/105	135	AB6 7-8	6	10, 12, 20, 30, 50, 80	100 x 100
3100/200, 3100/240, 3700/240, 4100/240, 6100/380	1010/A/85/0.8/105	135	AB6 9-10	6	2, 15, 26, 40, 60, 100	125 x 125
3700/300, 4100/300, 6100/440, 6100/500	1010/A/85/0.8/105	135	AB6 11-12	6	12, 15, 26, 50, 80, 125	145 x 145
3100/300, 4100/440, 6100/600	1010/A/85/0.8/105	135	AB6 16	6	20, 25, 40, 80, 100, 170	200 x 200
<b>PBE NC Range</b>						
1250/30	1010/A/85/0.8	96.5	40531	5	6, 10, 12, 15, 30	60 x 60
<b>PB NC Range</b>						
1250/40, 2100/40, 2600/60, 3100/90	1010/A/85/0.8	96.5	AB6 3-4	6	8, 10, 15, 20, 26, 40	70 x 70
2600/90, 3100/120, 3700/160, 4100/160	1010/A/85/0.8	96.5	AB6 5-6	6	10, 12, 16, 26, 40, 60	90 x 90
3100/160	1010/A/85/0.8	96.5	AB6 7-8	6	10, 12, 20, 30, 50, 80	100 x 100
4100/200	1010/A/85/0.8/105	135	AB6 7-8	6	10, 12, 20, 30, 50, 80	100 x 100
3100/200, 3700/200, 3700/240, 4100/240	1010/A/85/0.8/105	135	AB6 9-10	6	12, 15, 26, 40, 60, 100	125 x 125
3100/240, 4100/300	1010/A/85/0.8/105	135	AB6 11-12	6	12, 15, 26, 50, 80, 125	145 x 145
3100/300	1010/A/85/0.8/105	135	AB6 16	6	20, 25, 40, 80, 100, 170	200 x 200
<b>PBH Range</b>						
1020/100, 1020/150	40527	190	40529	5	10, 20, 30, 40, 65	95 x 95
1520/100, 1520/150	40528	190	40530	5	10, 20, 30, 40, 65	95 x 95

# Advanced Tooling

The following pages detail the various types and technical drawings of the standard range of pressbrake tooling available from Selmach Machinery.

**Goose neck top tools** are particularly useful for double bend 'U' shape brackets to avoid the leg from the first bend colliding with the top tool.

The **35 degree tools** are designed for over bending requirements as well as for the first stage bending for safe edge tooling.

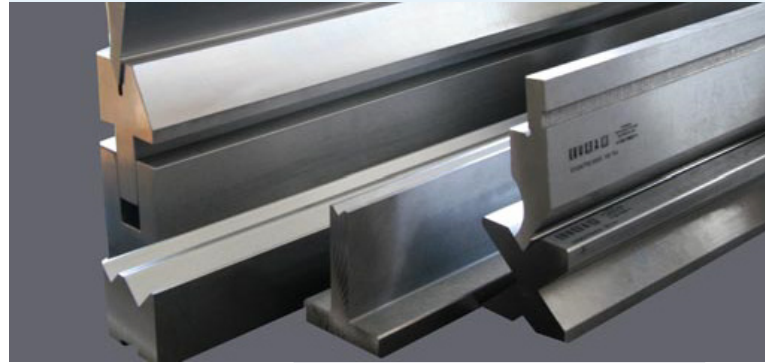
**Segmented tooling** allows for return bending and is necessary for box making after the corners have first been notched.

The **bull nose tooling** is ideal for bending thicker materials as the tonnes per meter rating is very high.

The chart below indicates the tonnage required for various bending operations and includes a quick calculation formula.

# Machine Features

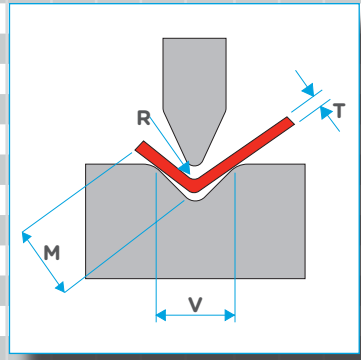
- Standard Euro style top & bottom tools
- Hemming tools for producing safe edges
- Joggle tools for small return bends
- Radius tools
- 835mm and 415mm sections
- Segmented top tools with horns for box folding
- Segmented bottom tools
- Bespoke tooling service
- Intermediates and security clamps



## TONNAGE CALCULATOR

T = Steel thickness (mm) R = Internal radius of bend (mm) M = Minimum return bend (mm) V = Bottom die Vee width (mm) L = Bending length (mm)

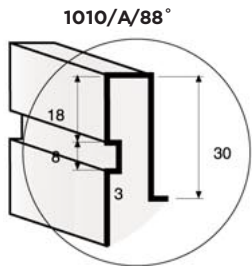
T mm	0.7	0.8	1	1.3	1.6	2	2.7	3	3.3	4	5	5.5	6.5	7	8	10	11	13	16	19	21	23	24.5	26	28	32	41	48	R (mm)	
	2.8	3.5	4	6	7	9	11	13	14	17	22	24	28	31	35	42	90	56	70	80	90	100	105	110	130	140	170	200	M (mm)	
	4	5	6	8	10	12	15	18	20	25	30	35	40	45	50	60	70	80	100	120	130	140	150	160	180	200	250	300	V (mm)	
0.5	4	3	2	2																									Ton/m	
0.6	5	4	3.5	3	2																									Ton/m
0.8		8	7	5	4	2																								Ton/m
1.0			10	8	6	5	4																							Ton/m
1.2				10	8	6	5	4																						Ton/m
1.5					13	12	9	7	7																					Ton/m
1.8						16	13	11	10	8																				Ton/m
2.0							16	14	12	10	8																			Ton/m
2.5								21	20	15	12	11																		Ton/m
3.0									27	22	18	15	13																	Ton/m
3.5										29	24	21	18	13																Ton/m
4.0											32	27	24	21	19															Ton/m
4.5												35	30	27	24	20														Ton/m
5.0													37	33	30	25	21													Ton/m
6.0														48	43	36	31	27												Ton/m
7.0															58	49	42	37	29											Ton/m
8.0																64	55	48	42	32										Ton/m
10																	85	75	60	50	46									Ton/m
12																		107	86	72	66	61								Ton/m
13																			101	84	76	72	67							Ton/m
14																				98	90	84	78	73						Ton/m
15																					103	96	90	84	75					Ton/m
16																						109	102	95	85	76				Ton/m
18																							129	120	107	97	77			Ton/m
20																								149	132	119	95	80		Ton/m
25																									207	186	149	124		Ton/m
30																										268	215	179		Ton/m



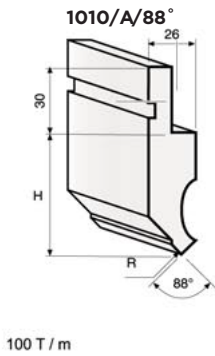
**Tonnage Calculator**

$$\text{Tonnes} = \frac{1.42 \times S \times T^2 \times L}{1000 \times V}$$

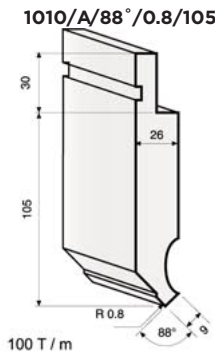
S= Tensile Strength (kg/mm<sup>2</sup>)  
 Mild Steel = 45  
 Stainless Steel = 60  
 Aluminium = 30



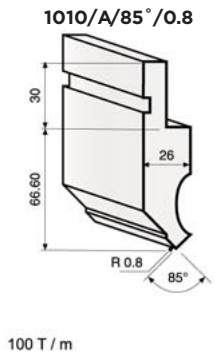
R = 0.2 mm / H = 66.90  
 R = 0.8 mm / H = 66.60  
 R = 1.5 mm / H = 65.90  
 R = 2.3 mm / H = 65.60  
 R = 3 mm / H = 65.25



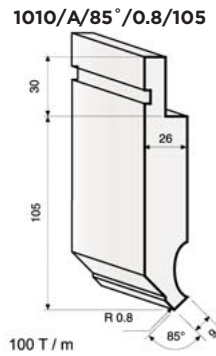
100 T / m



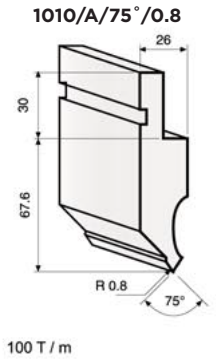
100 T / m



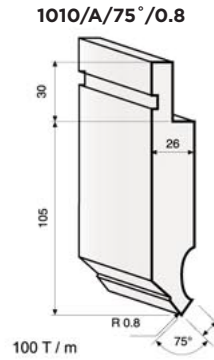
100 T / m



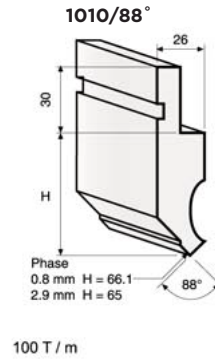
100 T / m



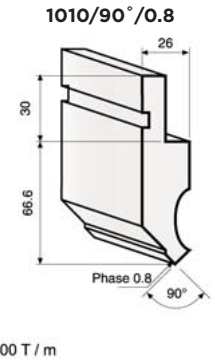
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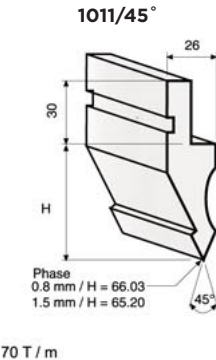
100 T / m



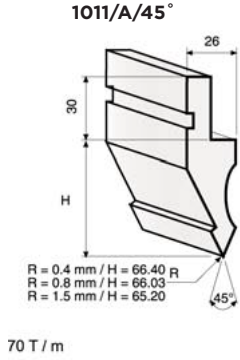
100 T / m



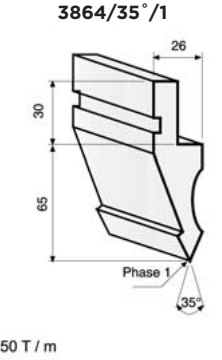
100 T / m



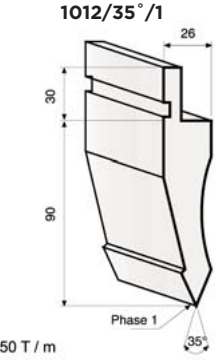
70 T / m



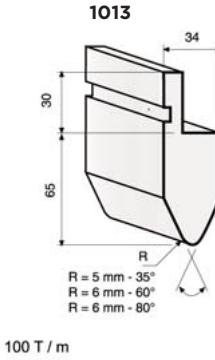
70 T / m



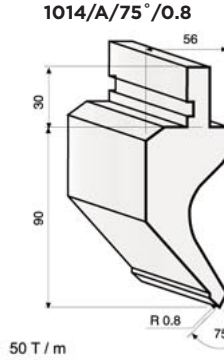
50 T / m



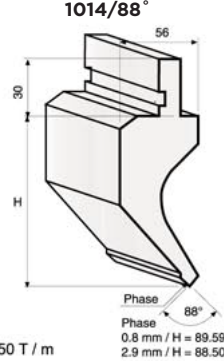
50 T / m



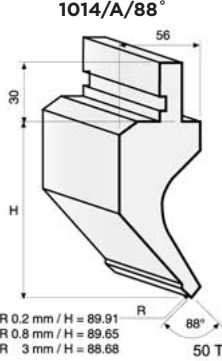
100 T / m



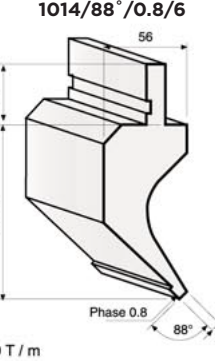
50 T / m



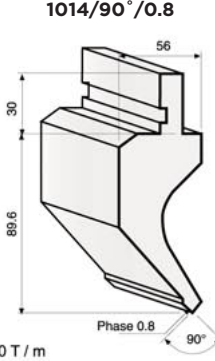
50 T / m



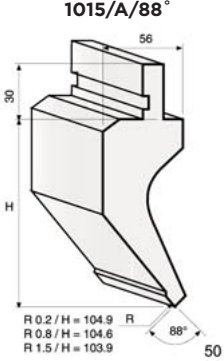
50 T / m



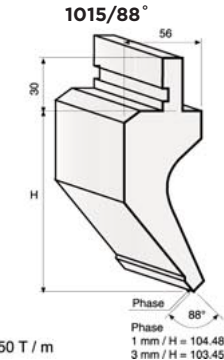
50 T / m



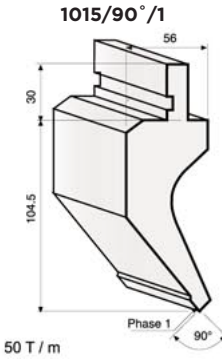
50 T / m



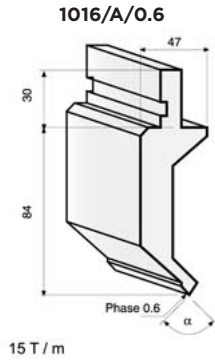
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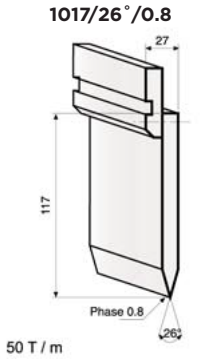
50 T / m



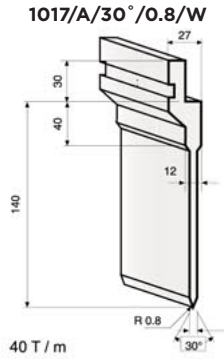
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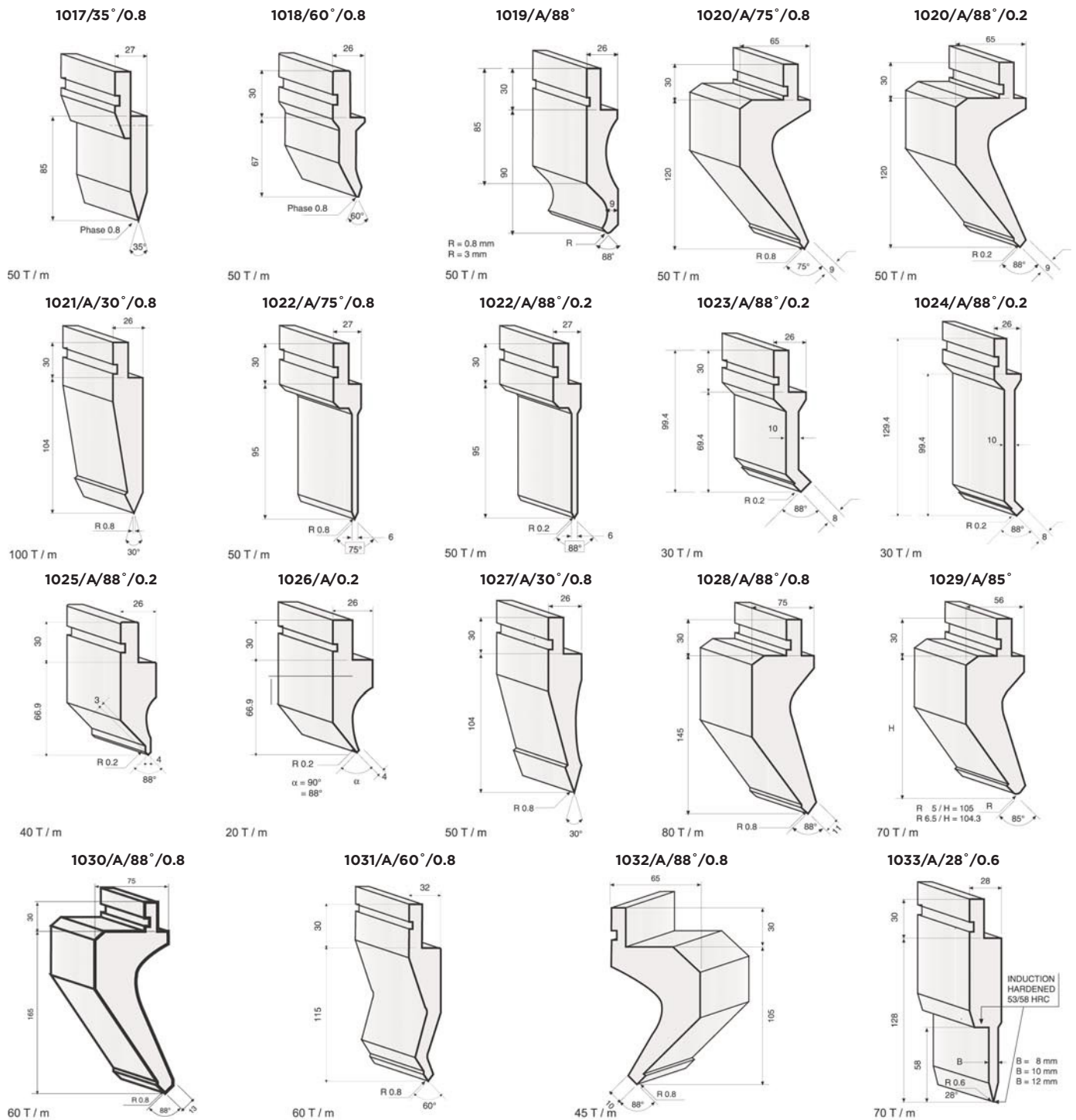
15 T / m



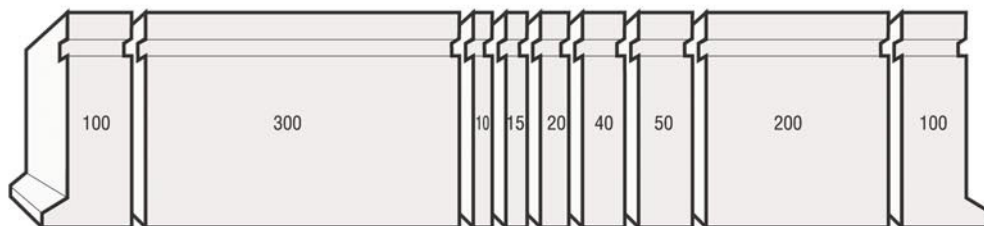
50 T / m



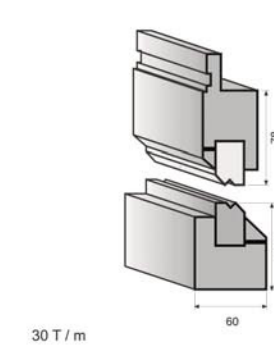
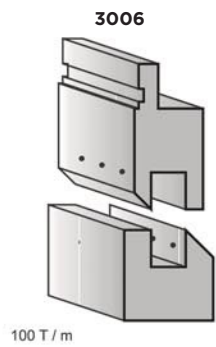
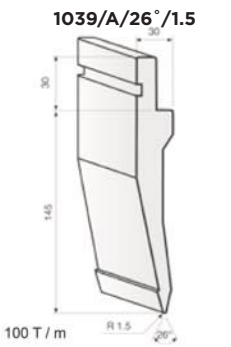
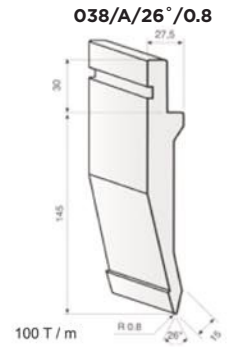
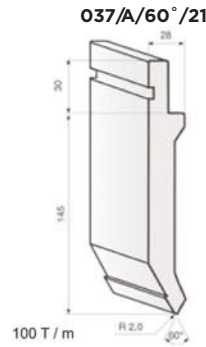
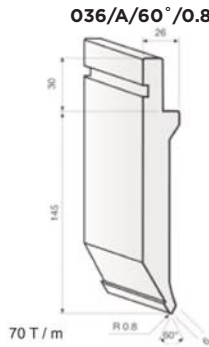
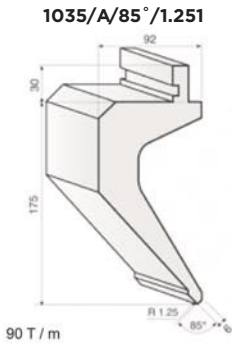
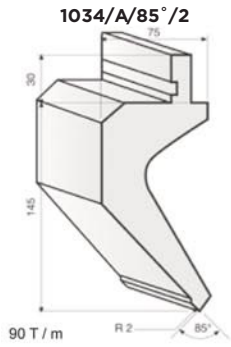
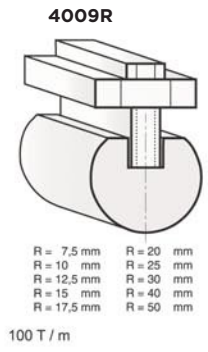
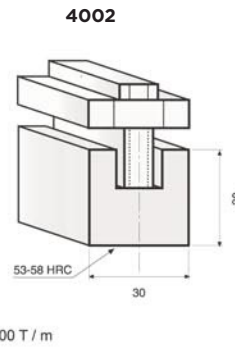
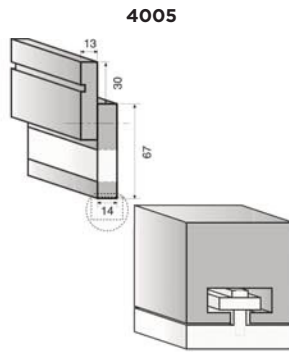
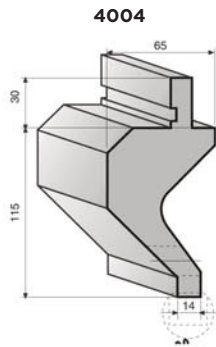
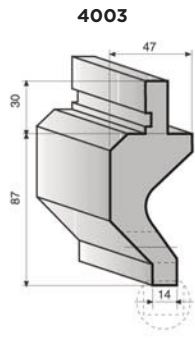
40 T / m



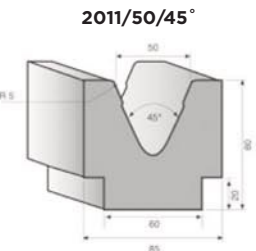
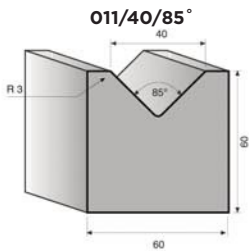
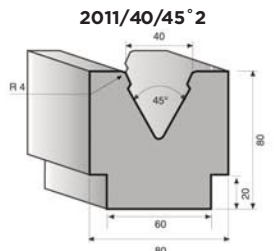
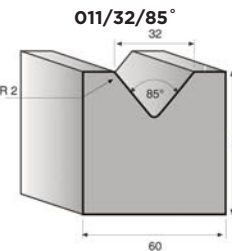
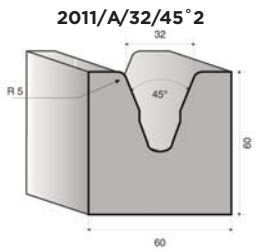
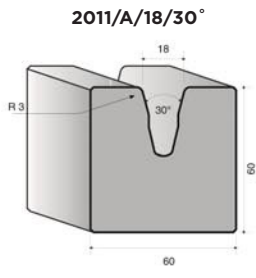
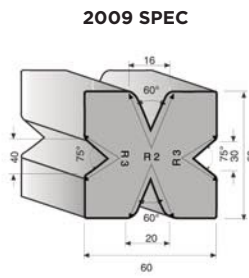
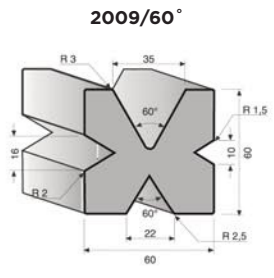
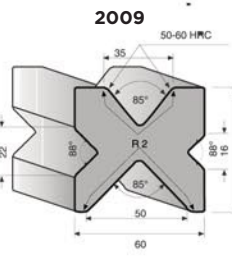
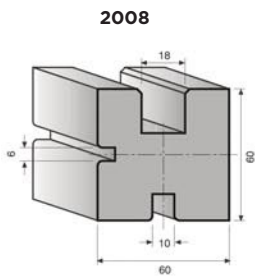
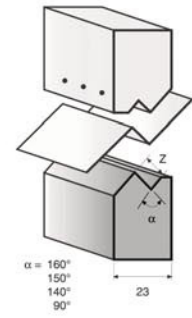
**SECTIONS**



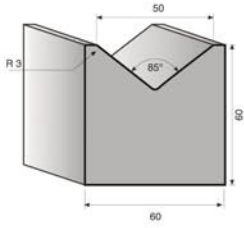




3007	Z (mm)	3007	Z (mm)
160j	1,0	90j	5,0
160j	1,5	90j	5,5
150j	2,0	90j	6,0
140j	2,5	90j	6,5
90j	3,0	90j	7,0
90j	3,5	90j	7,5
90j	4,0	90j	8,0
90j	4,5		

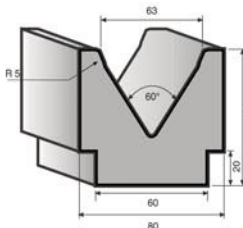


2011/50/85°



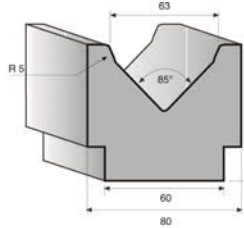
100 T / m

2011/63/60° 2



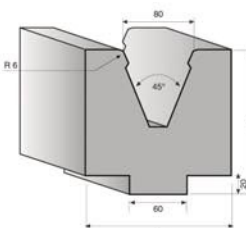
100 T / m

011/A/63/85°



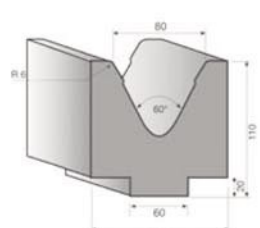
100 T / m

2011/80/45° 2



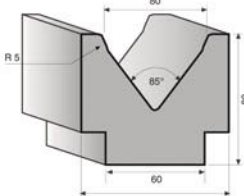
100 T / m

011/80/60°



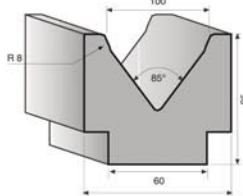
100 T / m

2011/80/85° 2



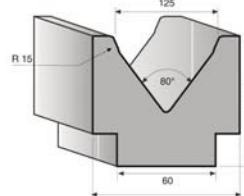
100 T / m

011/100/85° 2



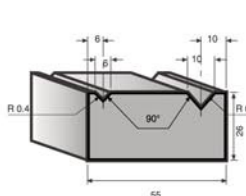
100 T / m

011/125/80° 2



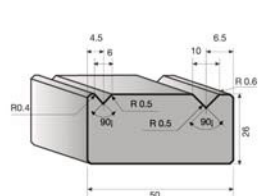
100 T / m

012/90/88°



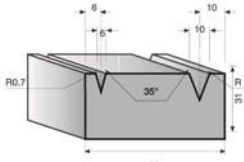
100 T / m

2012/60°



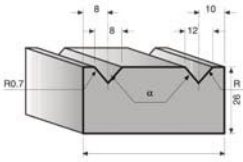
80 T / m

2012/35°



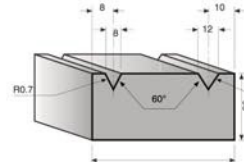
30 T / m

2013/90/88°



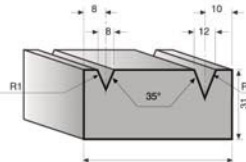
100 T / m

2013/60°



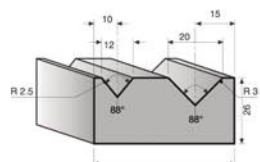
80 T / m

2013/35°



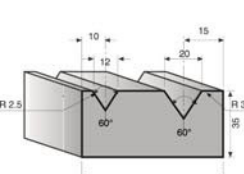
30 T / m

2014/88°



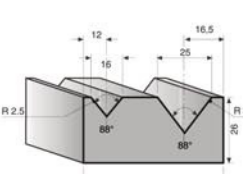
100 T / m

2014/60°



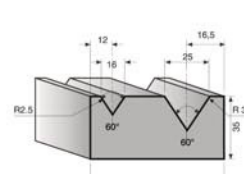
80 T / m

2015/88°



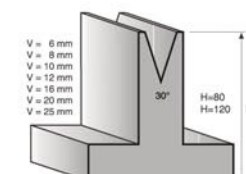
100 T / m

2015/60°



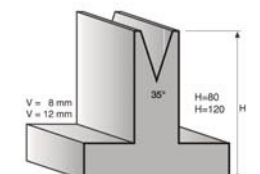
80 T / m

2030/30°



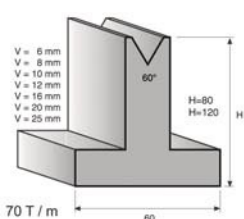
30 T / m

2035/35°



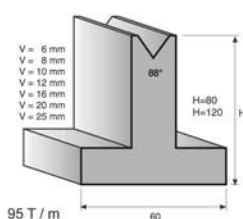
30 T / m

2060/60°



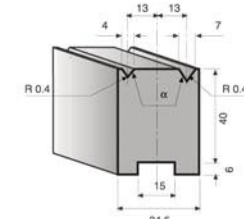
70 T / m

2088/88°



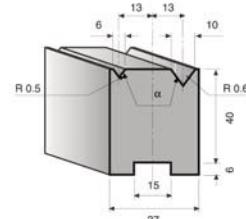
95 T / m

2019



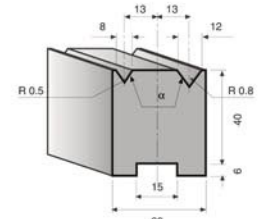
alpha = 88° - 90°

2020



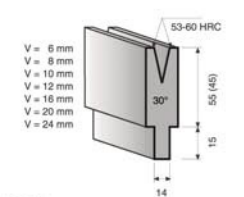
alpha = 88° - 90°

2021



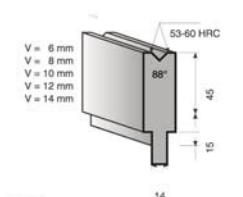
alpha = 88° - 90°

2130/A/30°



30 T / m

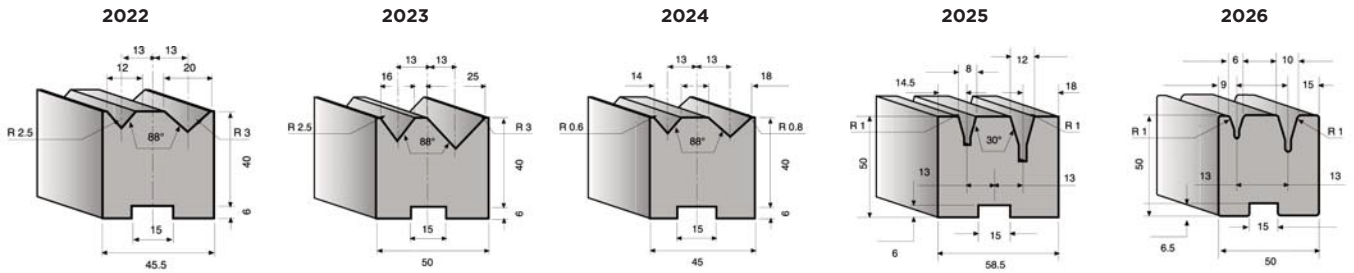
2188/A/88°



95 T / m

SECTIONS



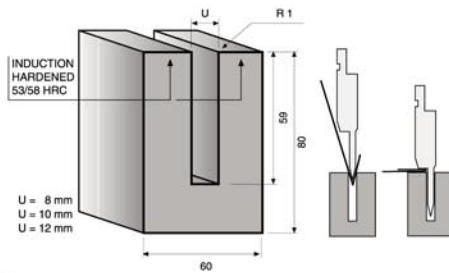


100 T / m  
**BENDING CHART<sup>°</sup>**  
**Acc.R.45 Kg/mm<sup>2</sup>**

S mm	A mm	Ton/M	2xS	Ton/M
0,6	3	9	1,2	2,3
0,8	3	12	1,6	3,2
1	3,5	15	2	4,0
1,25	3,5	17	2,5	5,0
1,5	4,6	22	3	6,3
2	5,5	30	4	8,0
2,5	6,5	55	5	9,0
3	8	70	6	10,0

100 T / m

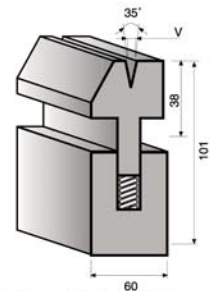
30 T / m  
**3000**



50 T / m

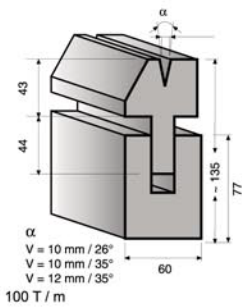
30 T / m

**3001/35°/B**



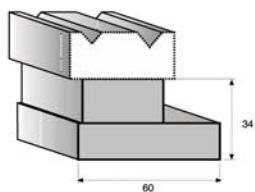
60 T / m V = 6 mm V = 8 mm

**3001**



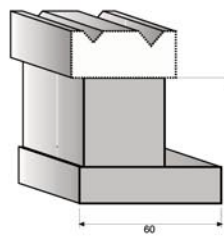
100 T / m

**4006**



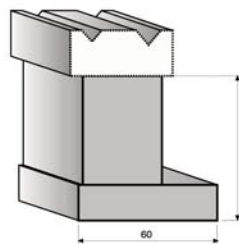
100 T / m

**4007**



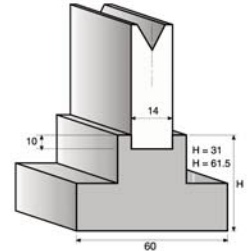
100 T / m

**4008**



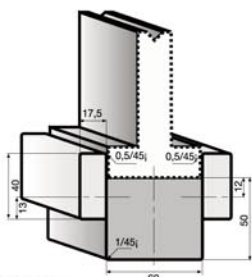
100 T / m

**4017**



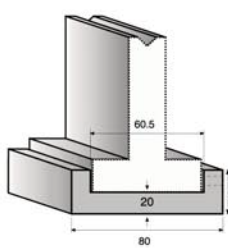
100 T / m

**4018**



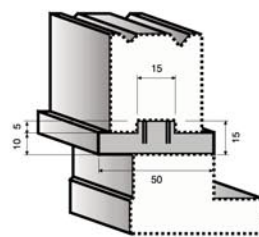
100 T / m

**4016**



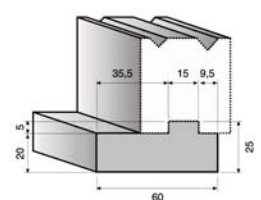
100 T / m

**4010**



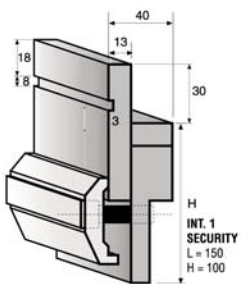
100 T / m

**4011**



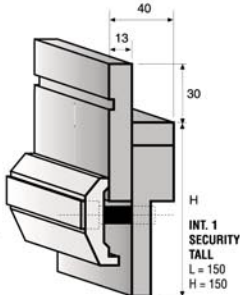
100 T / m

**Int1 Security**



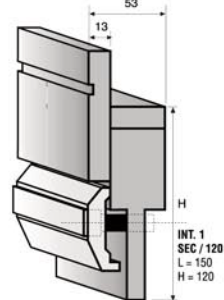
INT. 1 SECURITY  
 L = 150  
 H = 100

**Int1 Security Tall**



INT. 1 SECURITY TALL  
 L = 150  
 H = 150

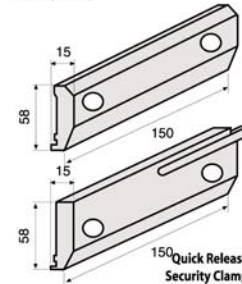
**nt1 Security 120**



INT. 1 SEC / 120  
 L = 150  
 H = 120

**Security Clamps**

**Security Clamp**



150 Quick Release Security Clamp