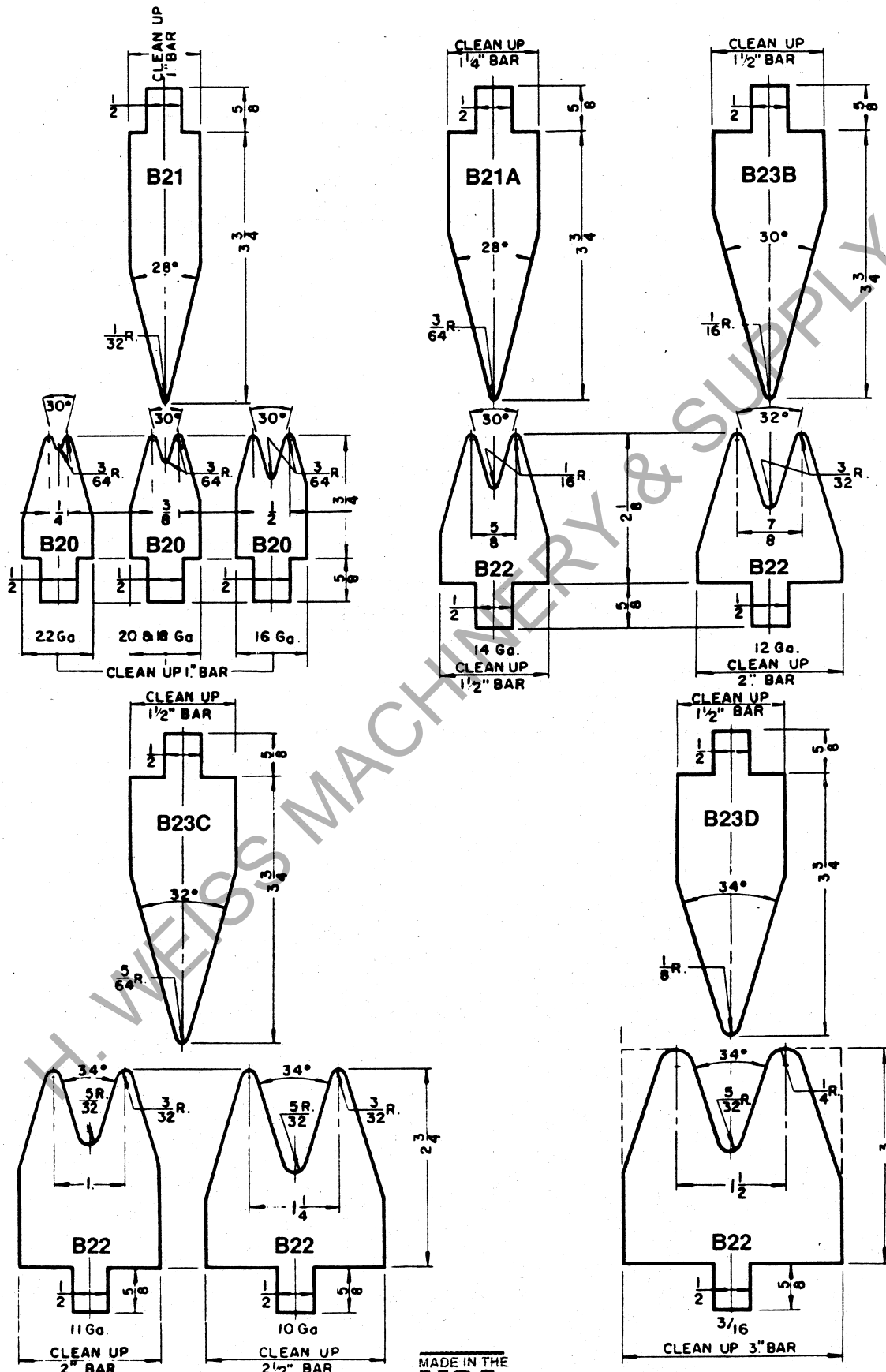


30° DEGREE FORMING PUNCHES AND DIES



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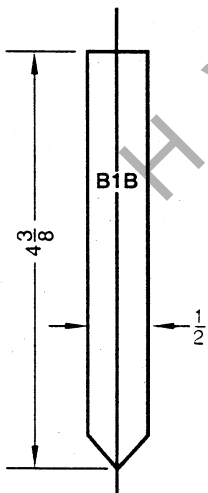
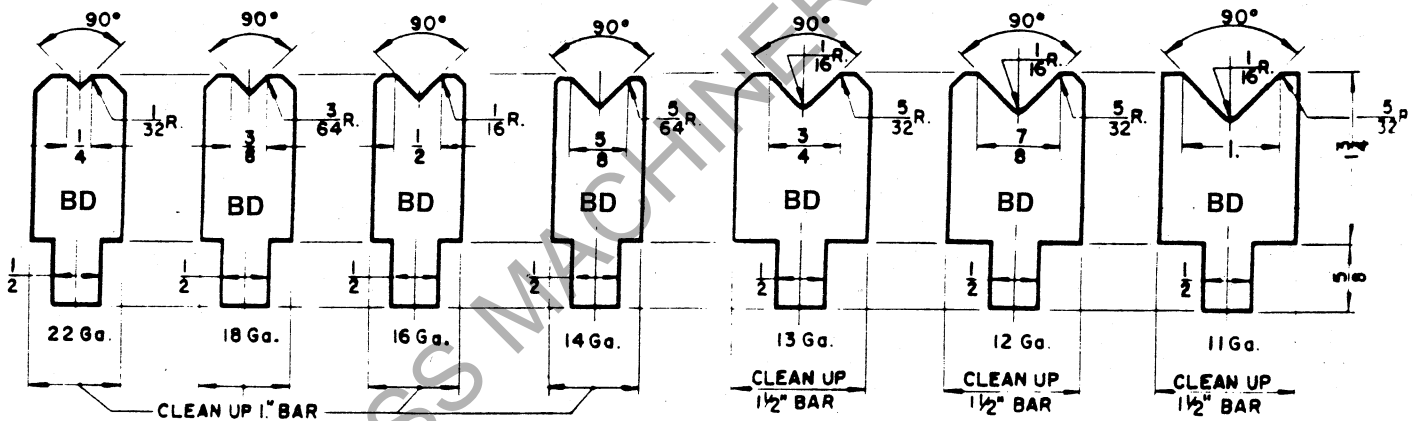
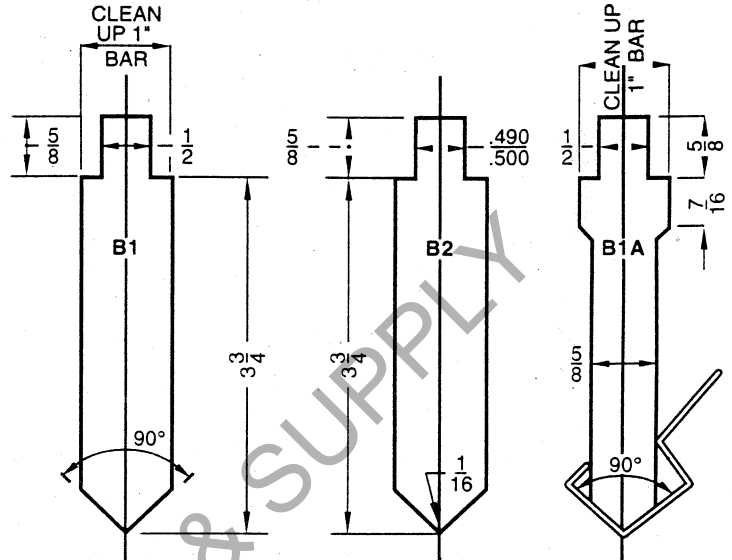
90° DEGREE FORMING PUNCHES AND DIES

STANDARD AND HOOK TONGUES OR SAFETY TANGS

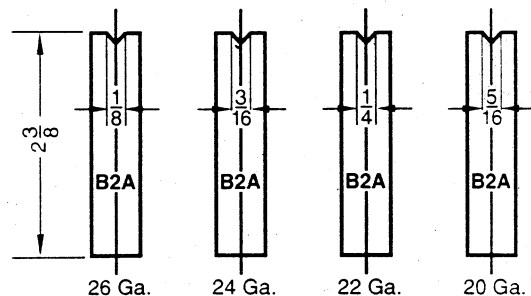
The dimensions shown on the accompanying illustrations are generally considered Standard. Some die users believe the Standard Tongue is preferable, others feel that the Hook Tongue or Safety Tang is safer to use. This may be especially true if the punch is to be used in sections, where weight or dimensions of punch are great, or where stripping pressure would create an extreme downward pull as in the case of a Channel Forming Die. We offer both, however Standard with tolerances as shown will be furnished unless specifications are to the contrary.

All combinations of these general purpose press brake dies are available from stock. Below are illustrated the general purpose dies recommended for forming 26 gauge to 11 gauge mild steel. Open angle air forming can be performed with these dies by limiting punch penetration into dies with the press brake ram adjustment mechanism.

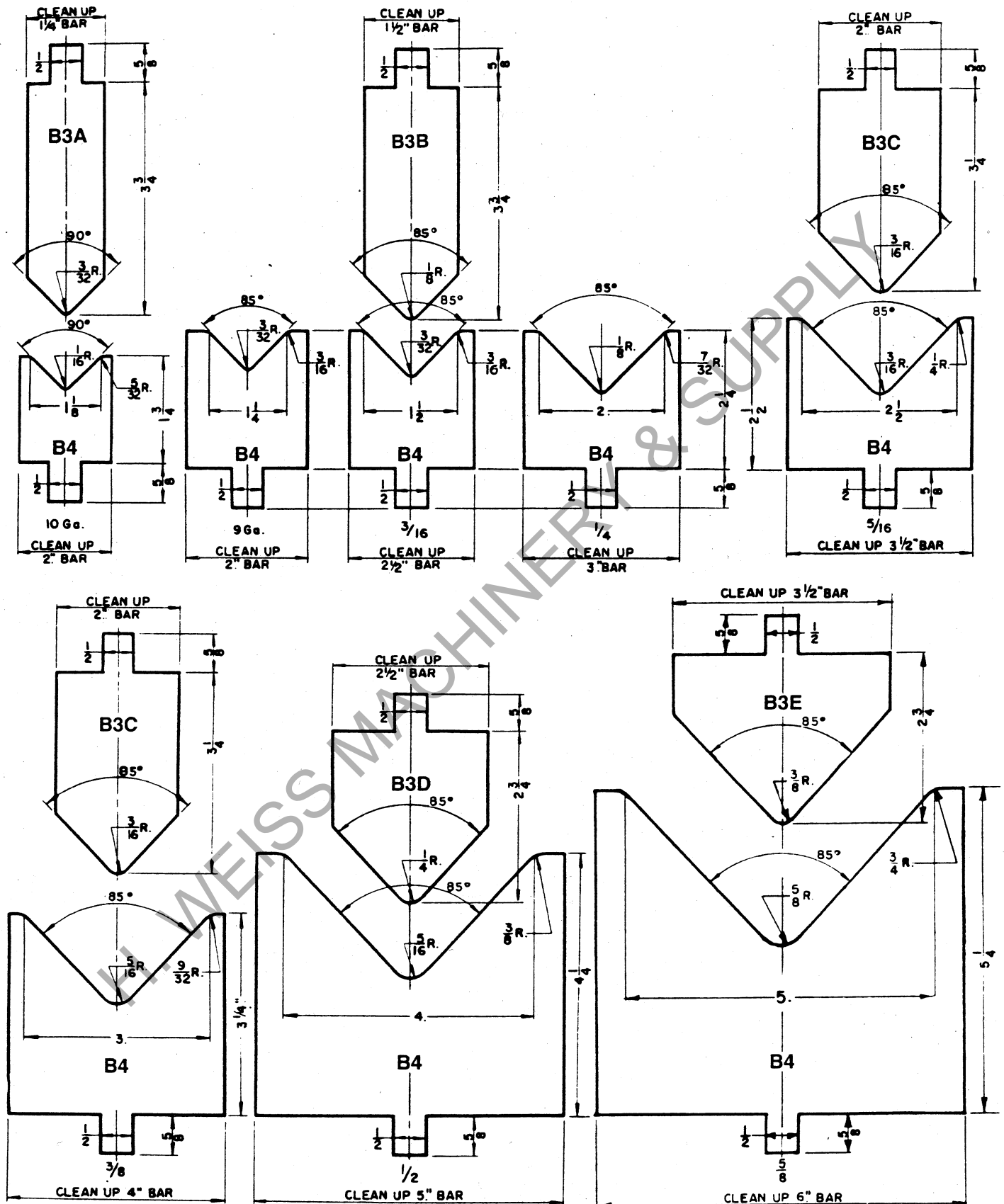
Punch **B1A** has sides relieved to permit closer back gauging and longer return flanges than number **B1** punch.



Number **B1B** punch and **B2A** die are not recommended for high production or where punch is cut into sections, but it is an economical die set for light sheet metal forming.

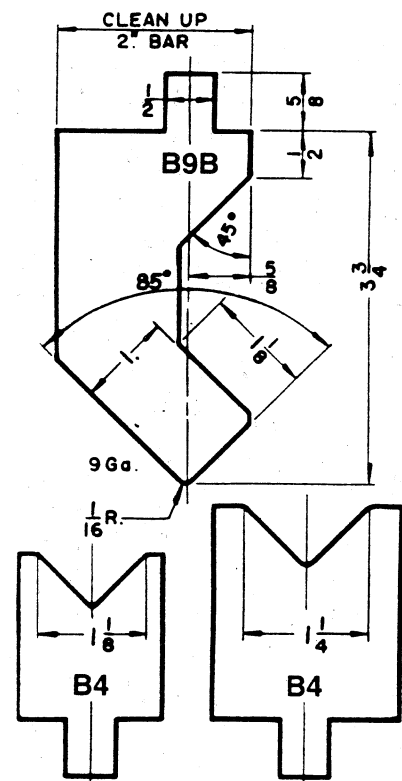
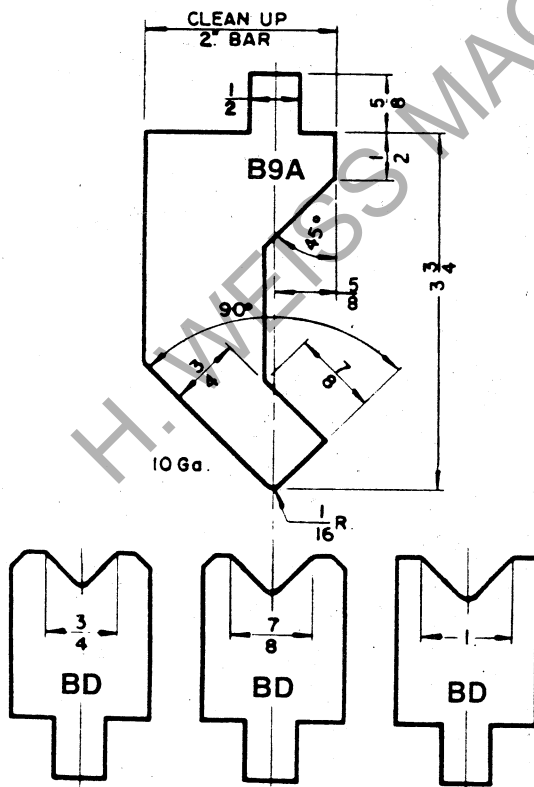
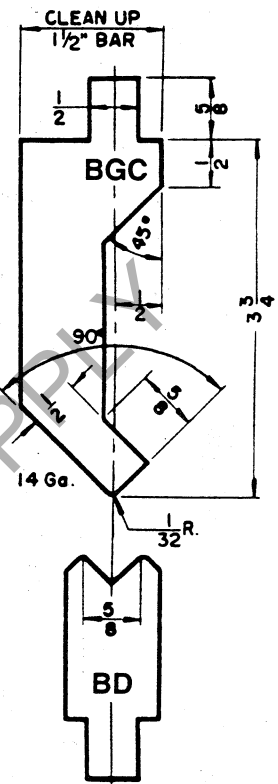
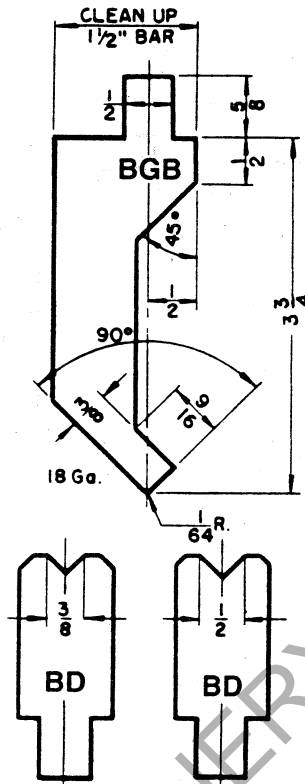
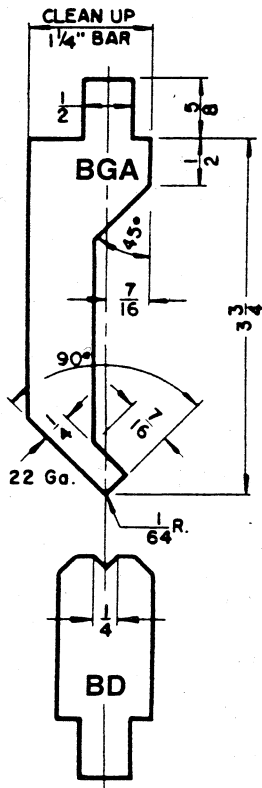


90° DEGREE FORMING PUNCHES AND DIES

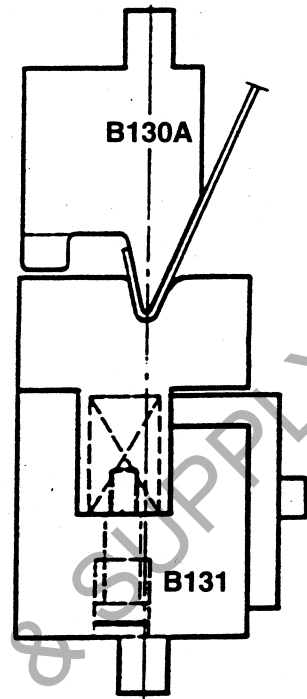
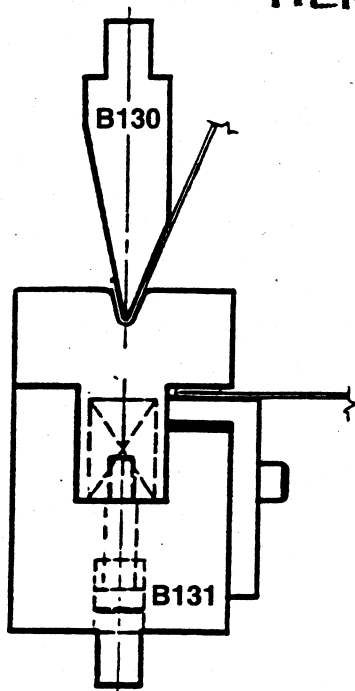


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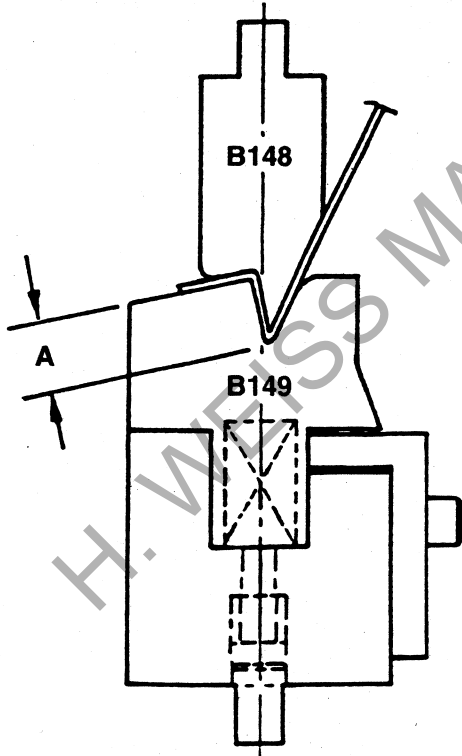
GOOSENECK PUNCHES



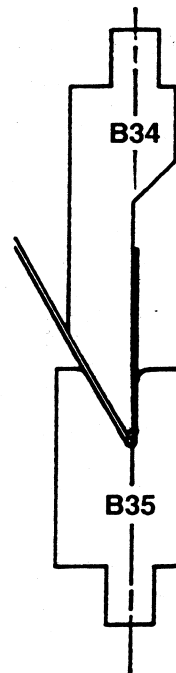
HEMMING DIES



Number **B130** and **B131** are a three high hemming die set recommended for 18 gauge and lighter mild steel. Shimming under adjustment angle on lower section will produce an open or closed hem. Number **B130A** is shown with equalizing back heel for higher production and heavier material.



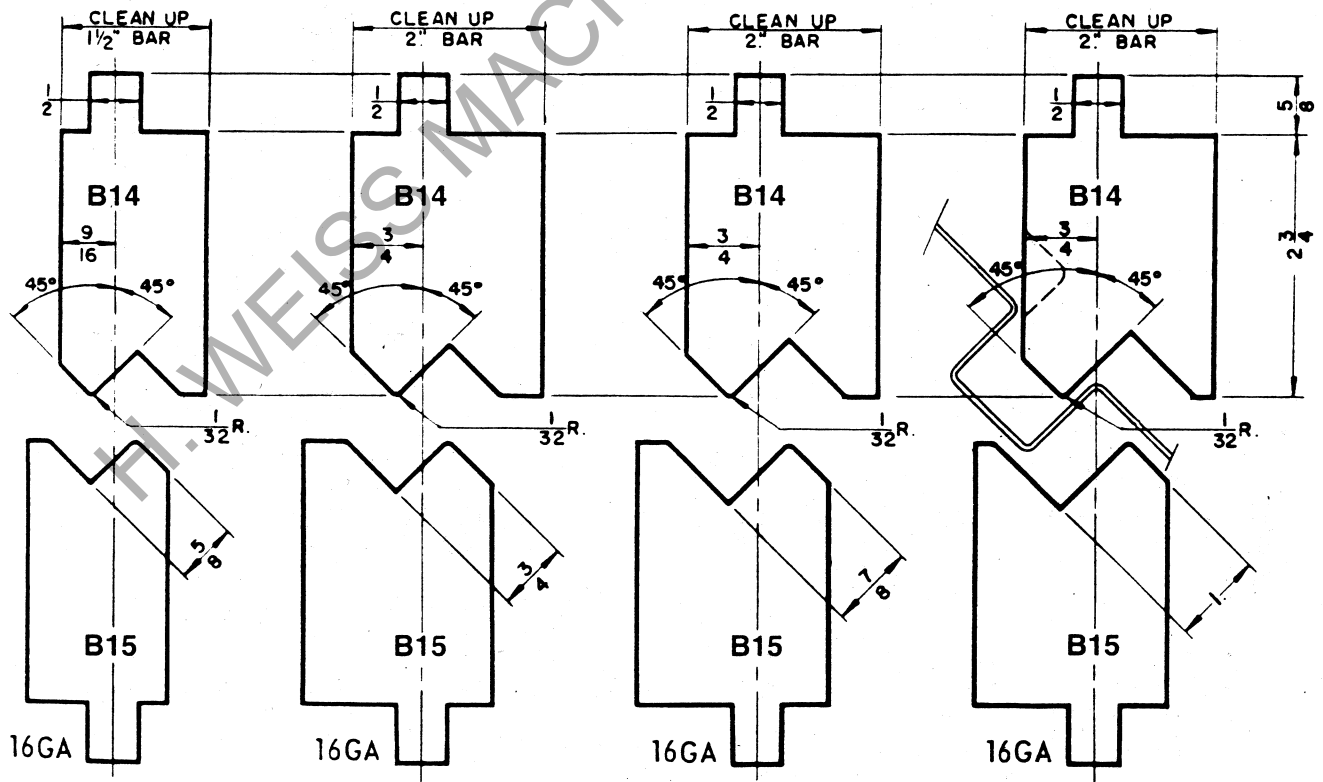
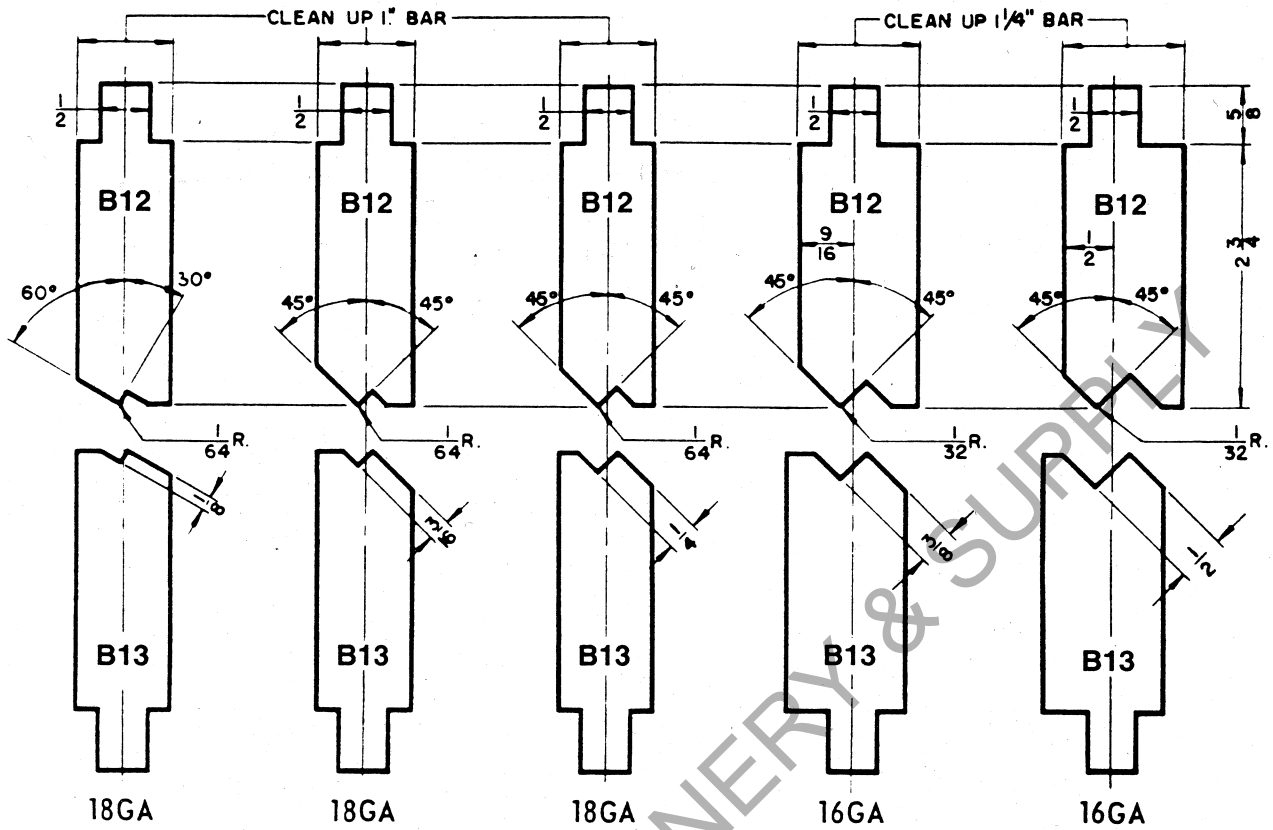
Dies **B148** and **B149** are used to form a Standing Seam in Two Operations. The Top Station forms an acute angle offset, which is subsequently closed at the lower level.



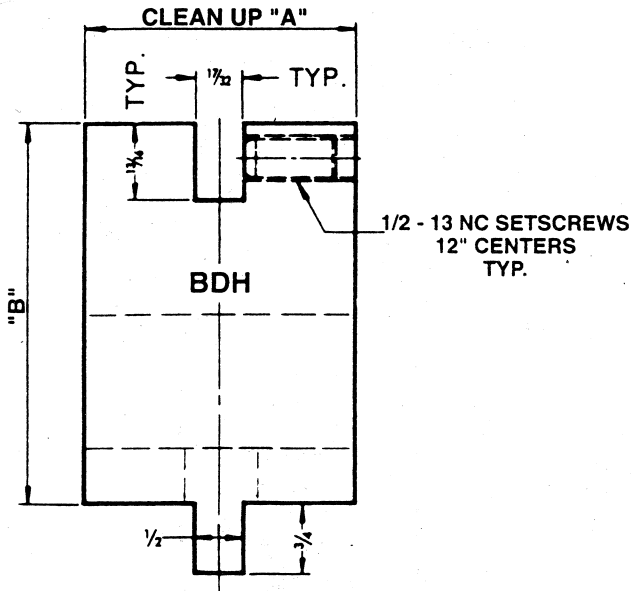
Dies **B34** and **B35** offer an inexpensive alternative for Hemming 18 gauge and lighter material. This set will require two strokes to bend and close the Hem.



OFFSET DIES



DIE HOLDERS AND FILLER BLOCKS



CONVENTIONAL DIE HOLDERS

No.	A	B
BDH-A	2"	1-1/2"
BDH-B	2"	2"
BDH-C	2"	3"
BDH-D	2"	4"
BDH-E	2"	5"
BDH-F	3"	1-1/2"
BDH-G	3"	2"
BDH-H	3"	3"
BDH-I	3"	4"

No.	A	B
BDH-J	3"	5"
BDH-K	4"	2"
BDH-L	4"	3"
BDH-M	4"	4"
BDH-N	4"	5"
BDH-O	5"	2"
BDH-P	5"	3"
BDH-Q	5"	4"
BDH-R	5"	5"

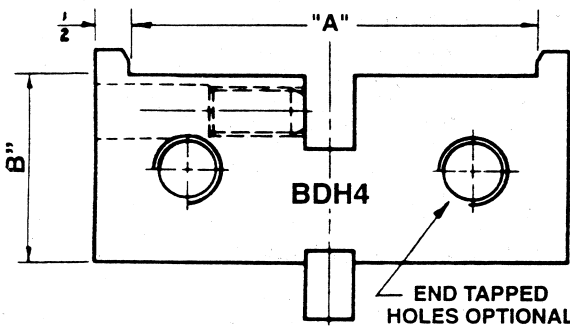
All Die holders can be furnished in any length up to 24 ft. in mild steel or prehardened Brake Die Steel.

THREE AND FOUR WAY COMBINATION DIE HOLDERS

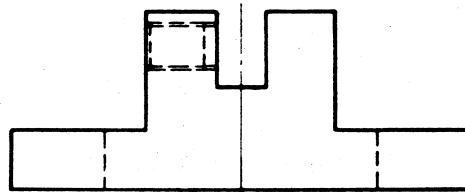
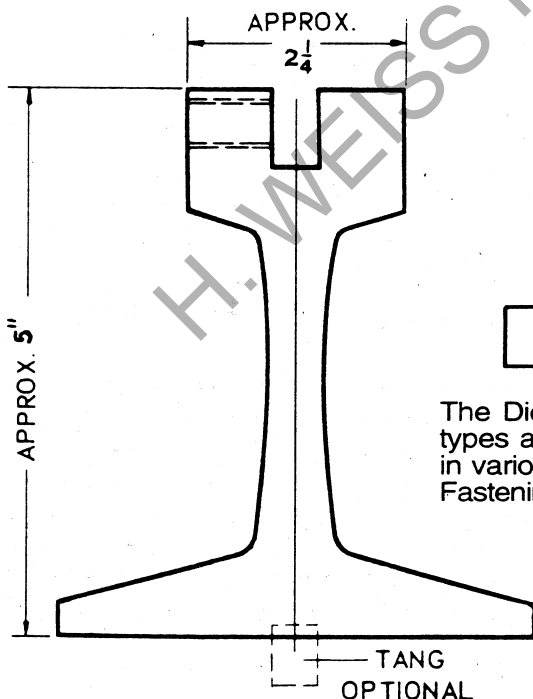
No.	A	B
BDH4A	2-1/4"	3-1/4"
BDH4B	2-1/4"	4-3/4"
BDH4C	2-3/4"	3-1/4"
BDH4D	2-3/4"	4-3/4"
BDH4E	3-1/4"	3-1/4"
BDH4F	3-1/4"	4-3/4"
BDH4G	3-3/4"	3-1/4"
BDH4H	3-3/4"	4-3/4"
BDH4I	4-1/4"	3-1/4"
BDH4J	4-1/4"	4-3/4"

No.	A	B
BDH4K	4-3/4"	3-1/4"
BDH4L	4-3/4"	4-3/4"
BDH4M	5-1/4"	3-1/4"
BDH4N	5-1/4"	4-3/4"
BDH4O	5-3/4"	3-1/4"
BDH4P	5-3/4"	4-3/4"
BDH4Q	6-3/4"	3-1/4"
BDH4R	7-3/4"	3-1/4"
BDH4S	10"	3-1/4"
BDH4T	12"	3-1/4"

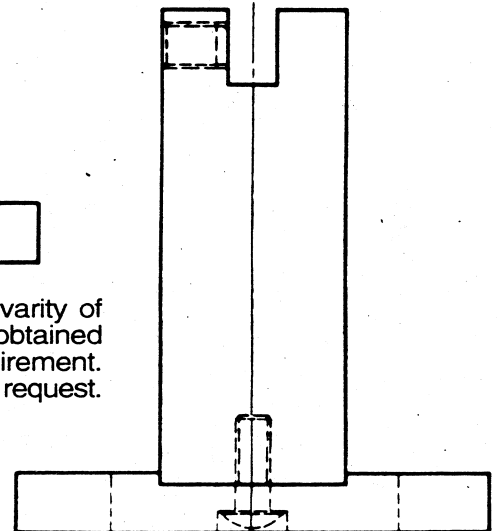
Any Die holder 4" high or over can be furnished with half moon burnouts for mounting.



MISCELLANEOUS DIE HOLDERS



The Die holders shown illustrate the variety of types available. These items can be obtained in various sizes to suit any press requirement. Fastening means will be provided upon request.



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