

R2

Compatibility

Punches Rolleri Type R2 are **compatible** with press brakes:

- LVD
- Safan
- Trumpf
- press brake machines with System NSCL (New Standard Clamping)
- Darley

With the use of adapters Rolleri R2 type punches can be mounted in other press brake models.

PUNCHES ROLLERI TYPE R2

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Compatibility

Punches Rolleri Type R2 are:

- **compatible** with press brakes: LVD, Trumpf, Darley, Safan or on press brakes with System NSCL (New Standard Clamping)
- also applicable on all other press brakes **with adapters** (see page 228)

Our Advantages – Your Convenience

- own production facilities (no reseller or dealer)
- every single tool is traceable thanks to a unique **serial number** stamped after the first quality control
- precision grinding (tolerance of +/-0.01 mm)
- guaranteed tool reproduction
- exact parallelism
- precise, consistent working height
- tang retrofitting and modifications possible (see pages 264-265)
- very large stock availability

Material

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

Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRc	54 - 60 HRc
C45	560-710 N/mm ²	12 - 15.5 HRc	54 - 60 HRc

- Specifications for the maximum press force kN/m are indicated as such, **1 t = 10 kN**.

Tang

All punches Rolleri Type R2 can be equipped with three different clamping systems.

1. **QuickLock** ↑↓
2. **Safety Pins** ↔
3. **ROL-System** ↑↓

ATTENTION:

QuickLock

By default, all tools are delivered with the QuickLock system, provided that these weigh less than 12.5 kg. This applies to most sectioned tools and to some standard length tools.

If you prefer the QuickLock-System on tools that weigh more than 12.5 kg, it is possible to section the tool for a small surcharge.

Safety Pins

All tools that weigh more than 12.5 kg, are delivered by default with safety pins. This applies to all standard tool lengths and some segmented tools.

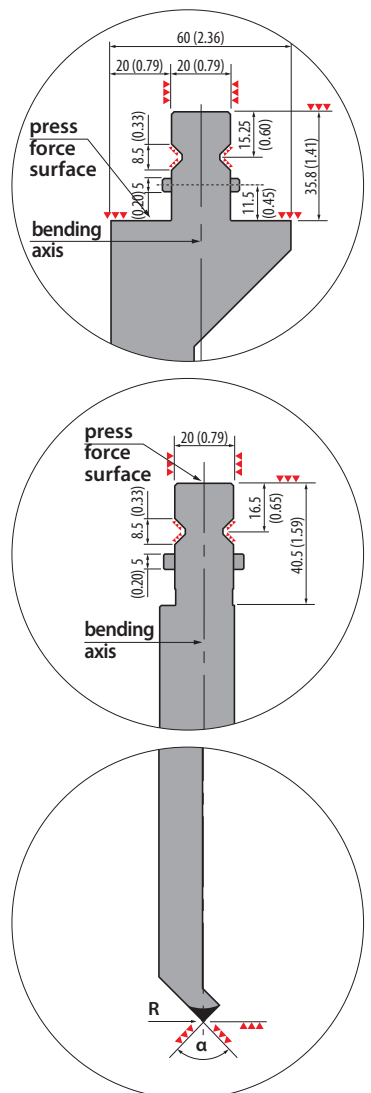
ROL1-System

Alternatively, you have the option of using tools with spring-loaded balls. Also here the max. weight is 12.5 kg per tool.

If you have any questions, please call to be assisted by one of our representatives!

Rolleri punches are either head-bearing or shoulder-bearing.

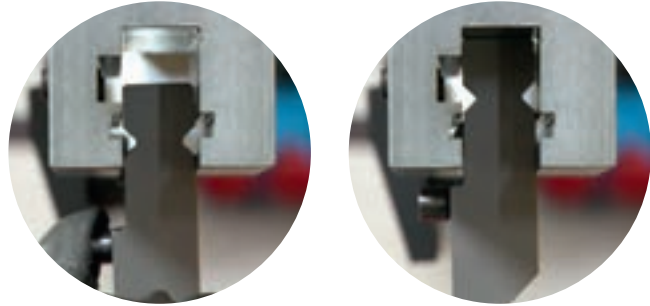
Indications of precision ground surfaces:



■ Clamping Systems

QuickLock (Standard)

- vertical tool change
- easy handling
- substantial improvement in time consumption and related costs
- applicable on tools < 12.5 kg
- applicable on tools > 12.5 kg through special sectioning



QuickLock



3
R2



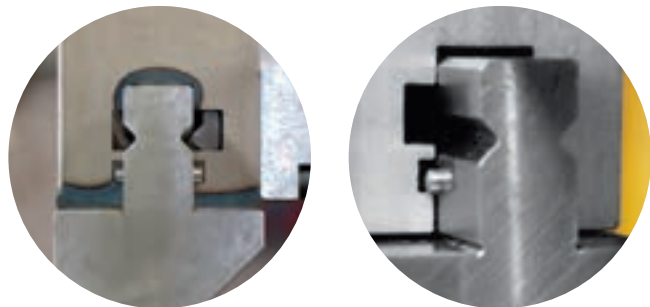
Rolleri Videos

QuickLock System:
[www.rolleritools.com/
videos/quicklock](http://www.rolleritools.com/videos/quicklock)



Safety Pins (Standard)

- horizontal tool change



ROL1-System

- vertical tool change through spring-loaded ball bearings, which are mounted in the punch
- increased longevity
- easy handling
- to be used in hardened clamping systems only
- applicable on tools < 12.5 kg



Article on stock



Please ask for delivery time!

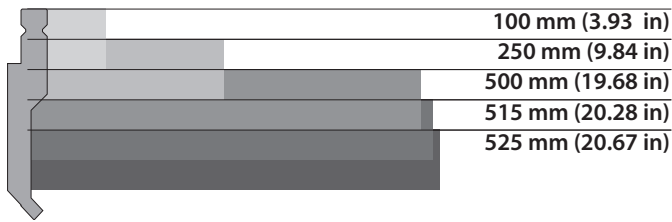
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



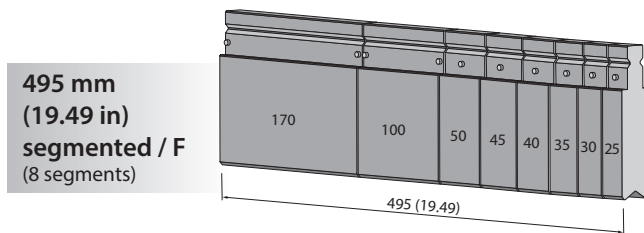
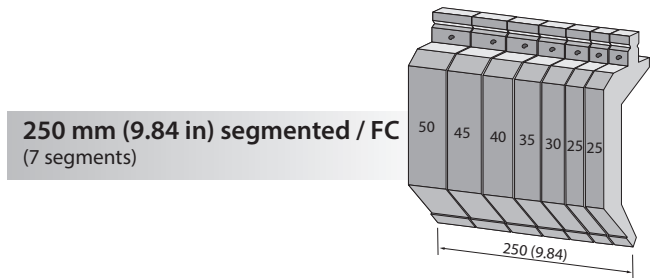
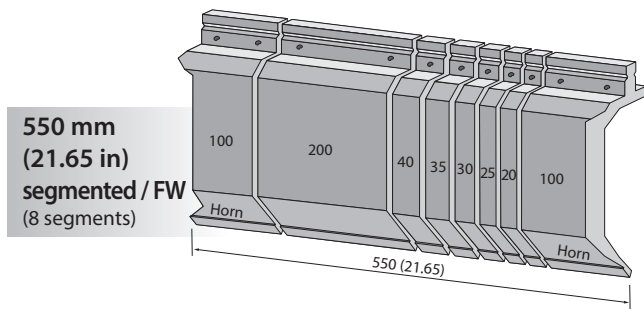
Articles on stock – Please note that delivery time depends on your location.

Tool Lengths and Sectioning

Standard



More lengths and sectionings are possible upon request.



Segmented tools are delivered in complete sets. More lengths and sectionings are possible upon request.

Sectioning FA

1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94) Horn l.	100 (3.94) Horn r.	100 (3.94)
1250 (49.21)	2	1	1	1	1	1	1	1	8
2050 (80.71)	2	1	1	1	1	1	1	1	16
2550 (100.39)	2	1	1	1	1	1	1	1	21
3050 (120.08)	2	1	1	1	1	1	1	1	26
4050 (159.45)	2	1	1	1	1	1	1	1	36

available on request

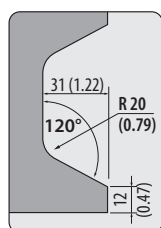
Sectioning FB

1250 (49.21) / 2050 (80.71) / 2550 (100.39) / 3050 (120.08) / 4050 (159.45) mm (in)

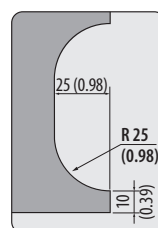
Length in mm (in)	25 (0.98)	30 (1.18)	35 (1.38)	40 (1.57)	45 (1.77)	50 (1.97)	100 (3.94) Horn l.	100 (3.94) Horn r.	100 (3.94)	200 (7.87)	300 (11.81)
1250 (49.21)	2	1	1	1	1	1	1	1	1	2	1
2050 (80.71)	2	1	1	1	1	1	1	1	1	3	3
2550 (100.39)	2	1	1	1	1	1	1	1	1	4	4
3050 (120.08)	2	1	1	1	1	1	1	1	1	5	5
4050 (159.45)	2	1	1	1	1	1	1	1	1	7	7

available on request

Horn Types



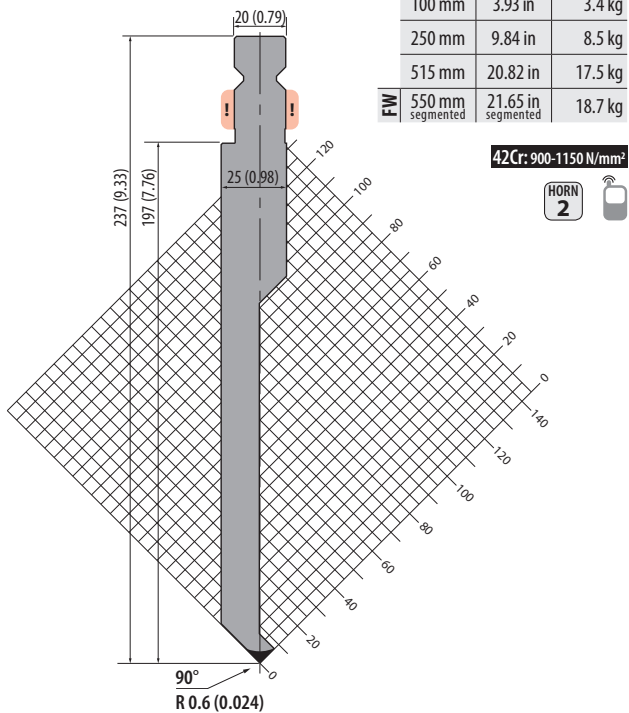
HORN 1 Horn 1
Standard for all segmented Punches Roller Type R2



HORN 2 Horn 2
for all segmented Punches Roller Type R2 of Length 550 mm (21.65 in)

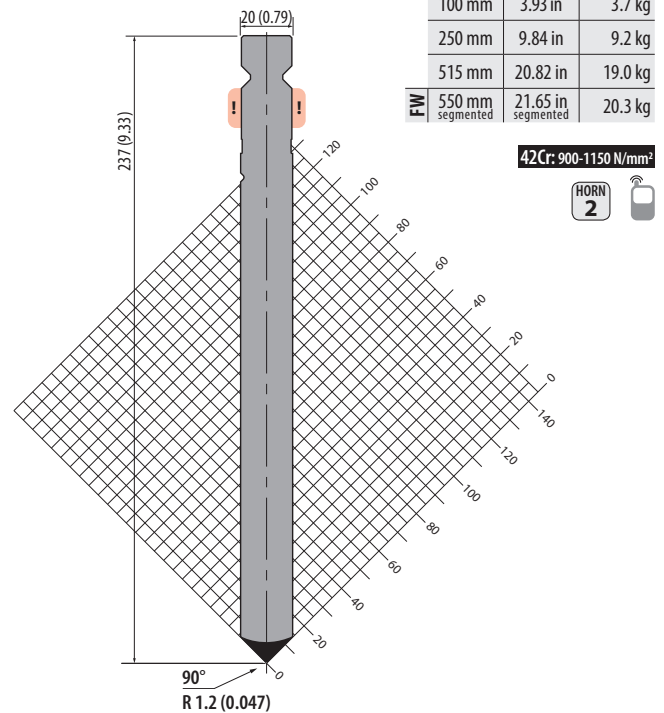
TPR237.90.R06

600 kN/m max.



TPR237.90.R12

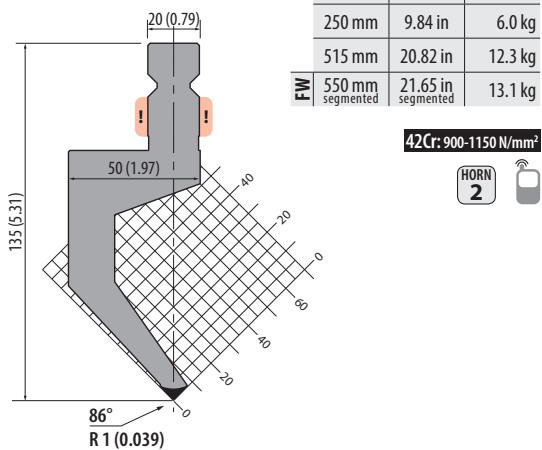
1000 kN/m max.



86° Punches

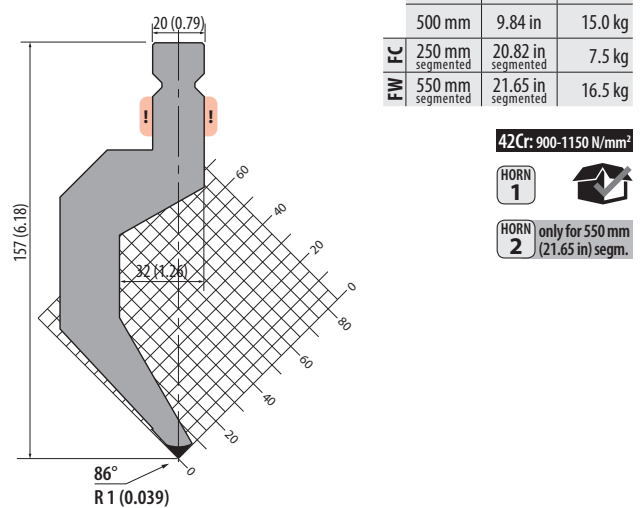
TPR135.86.R1

650 kN/m max.



TPR157.86.R1

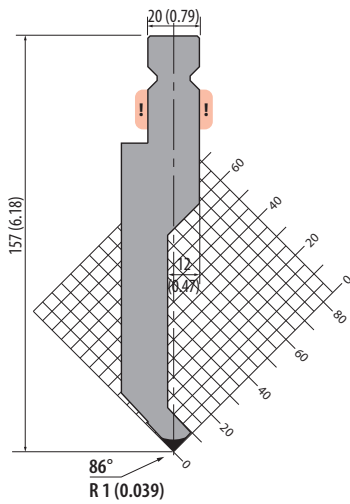
800 kN/m max.



Please choose the clamping system!
Standard equipment:
< 12.5 kg QuickLock
> 12.5 kg safety pins
Also available: ROL1-System see pages 86-87 for more information.

TPR157.86.R1-A

800 kN/m max.



	100 mm	3.93 in	2.5 kg
	500 mm	9.84 in	12.5 kg
FW	250 mm segmented	20.82 in segmented	6.3 kg
FC	550 mm segmented	21.65 in segmented	13.8 kg

42Cr: 900-1150 N/mm²

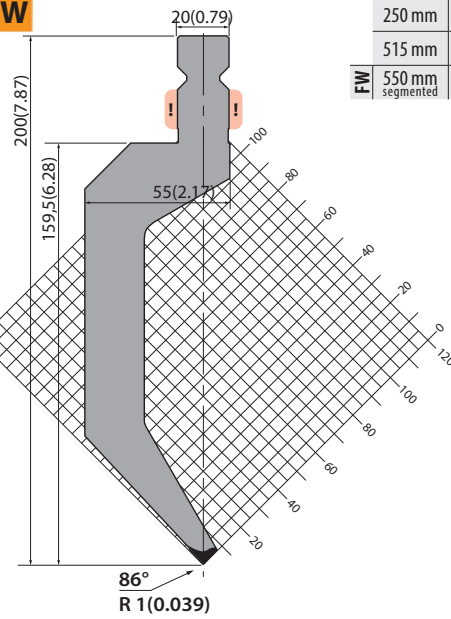


HORN 2 only for 550 mm (21.65 in) segm.

TPR200.86.R1

500 kN/m max.

NEW



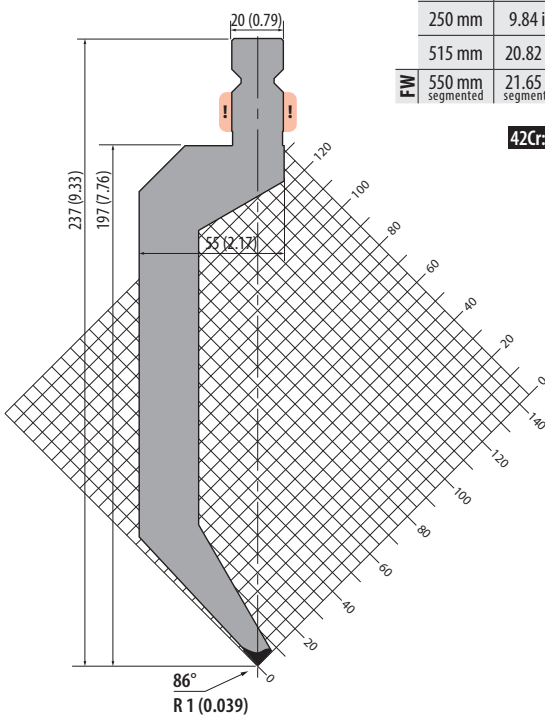
	100 mm	3.93 in	3.7 kg
	250 mm	9.84 in	9.2 kg
	515 mm	20.82 in	19.1 kg
FW	550 mm segmented	21.65 in segmented	20.4 kg

42Cr: 900-1150 N/mm²



TPR237.86.R1

500 kN/m max.



	100 mm	3.93 in	4.5 kg
	250 mm	9.84 in	11.2 kg
	515 mm	20.82 in	23.0 kg
FW	550 mm segmented	21.65 in segmented	24.6 kg

42Cr: 900-1150 N/mm²



Please choose the clamping system!
Standard equipment:
 < 12.5 kg QuickLock
 > 12.5 kg safety pins
 Also available: ROL1-System see pages 86-87 for more information.



TPR256.86.R1

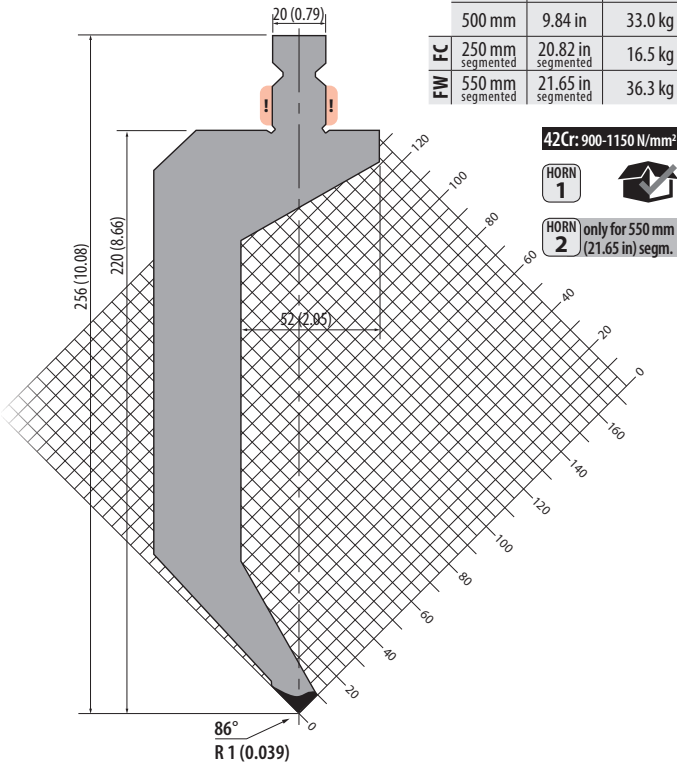
800 kN/m max.

	100 mm	3.93 in	6.6 kg
	500 mm	9.84 in	33.0 kg
FW FC	250 mm segmented	20.82 in segmented	16.5 kg
	550 mm segmented	21.65 in segmented	36.3 kg

42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.



TPR256.86.R1-A

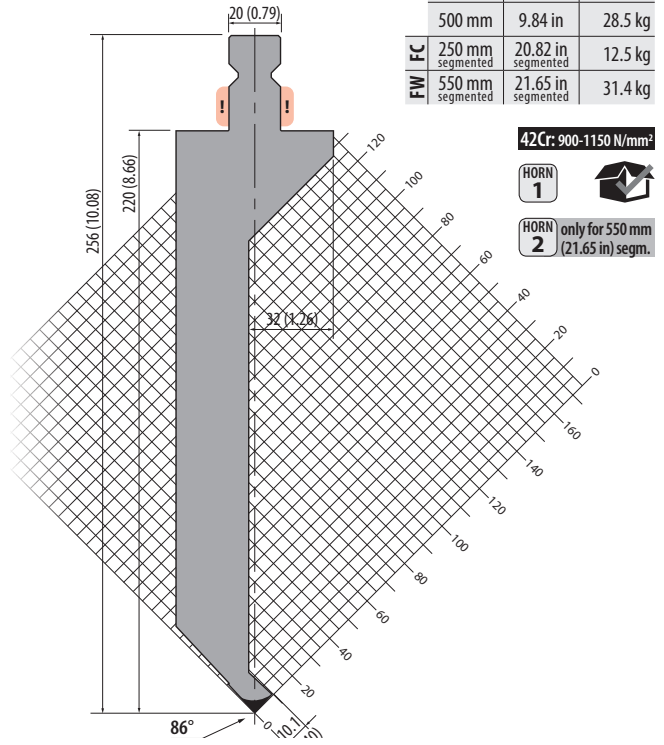
800 kN/m max.

	100 mm	3.93 in	4.7 kg
	500 mm	9.84 in	28.5 kg
FW FC	250 mm segmented	20.82 in segmented	12.5 kg
	550 mm segmented	21.65 in segmented	31.4 kg

42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.



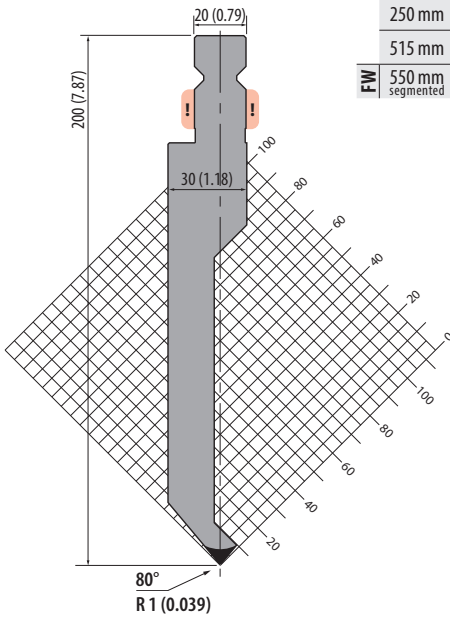
80° Punches

TPR200.80.R1

800 kN/m max.

	100 mm	3.93 in	3.7 kg
	250 mm	9.84 in	9.2 kg
	515 mm	20.82 in	19.0 kg
FW	550 mm segmented	21.65 in segmented	20.3 kg

42Cr: 900-1150 N/mm²

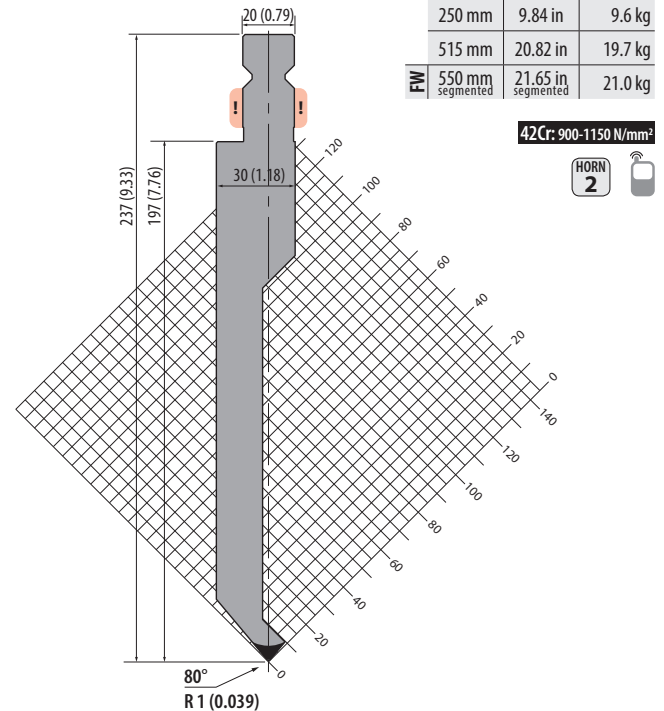


TPR237.80.R1

800 kN/m max.

	100 mm	3.93 in	3.8 kg
	250 mm	9.84 in	9.6 kg
	515 mm	20.82 in	19.7 kg
FW	550 mm segmented	21.65 in segmented	21.0 kg

42Cr: 900-1150 N/mm²



Article on stock



Please ask for delivery time!

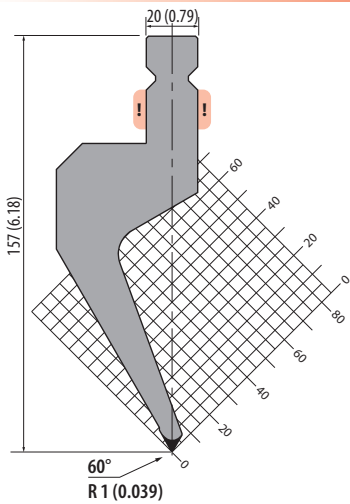
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

TPR157.60.R1

700 kN/m max.



	100 mm	3.93 in	3.0 kg
	500 mm	9.84 in	15.0 kg
FW	250 mm segmented	20.82 in segmented	7.5 kg
FC	550 mm segmented	21.65 in segmented	16.5 kg

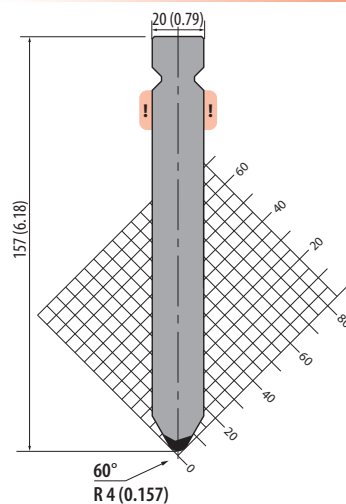
42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.

TPR157.60.R4

1300 kN/m max.



	100 mm	3.93 in	2.4 kg
	500 mm	9.84 in	12.0 kg
FW	250 mm segmented	20.82 in segmented	6.0 kg
FC	550 mm segmented	21.65 in segmented	13.2 kg

42Cr: 900-1150 N/mm²

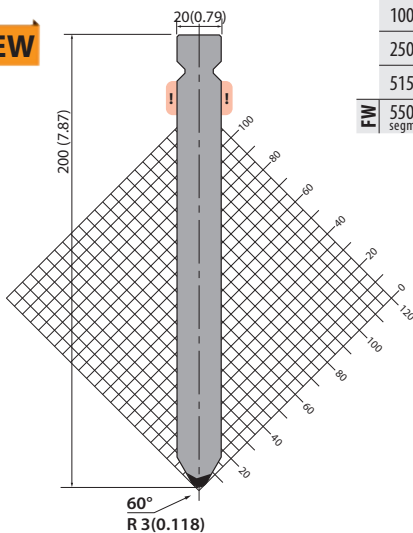


HORN 2 only for 550 mm (21.65 in) segm.

TPR200.60.R3

1300 kN/m max.

NEW



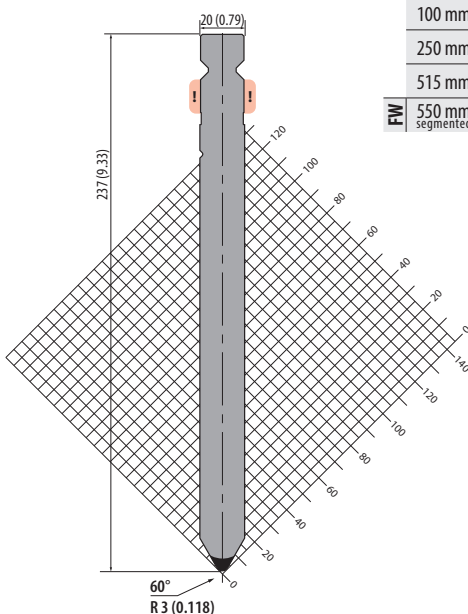
	100 mm	3.93 in	3.0 kg
	250 mm	9.84 in	7.6 kg
	515 mm	20.82 in	15.6 kg
FW	550 mm segmented	21.65 in segmented	16.7 kg

42Cr: 900-1150 N/mm²



TPR237.60.R3

1300 kN/m max.



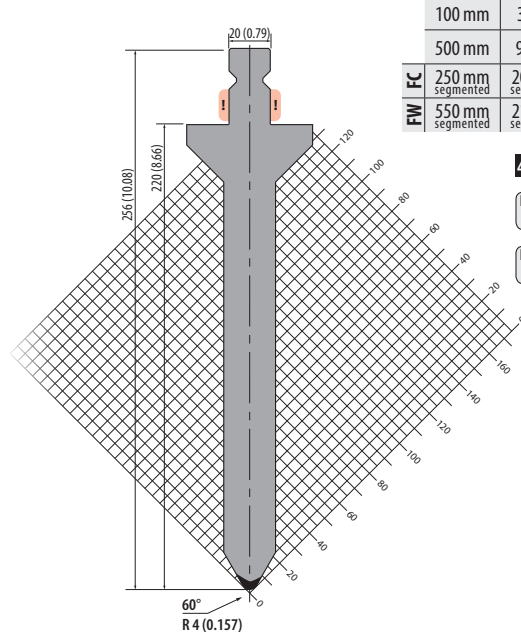
	100 mm	3.93 in	3.6 kg
	250 mm	9.84 in	9.1 kg
	515 mm	20.82 in	18.8 kg
FW	550 mm segmented	21.65 in segmented	20.1 kg

42Cr: 900-1150 N/mm²



TPR256.60.R4

1300 kN/m max.



	100 mm	3.93 in	5.2 kg
	500 mm	9.84 in	26.1 kg
FW	250 mm segmented	20.82 in segmented	13.5 kg
FC	550 mm segmented	21.65 in segmented	28.7 kg

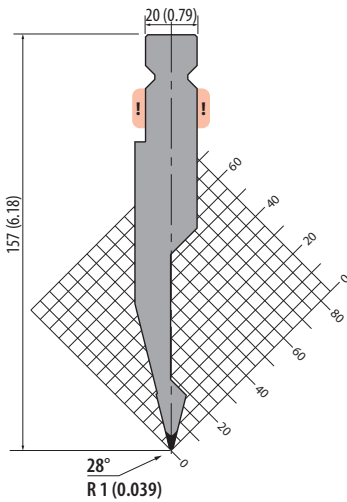
42Cr: 900-1150 N/mm²



HORN 2 only for 550 mm (21.65 in) segm.

TPR157.28.R1

600 kN/m max.



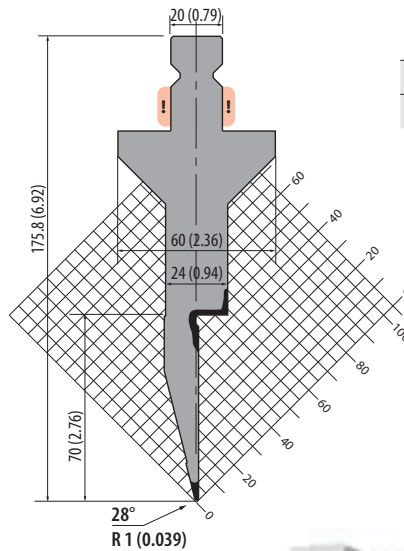
	100 mm	3.93 in	2.0 kg
	500 mm	9.84 in	10.0 kg
FW FC	250 mm segmented	20.82 in segmented	5.0 kg
	550 mm segmented	21.65 in segmented	11.0 kg

42Cr: 900-1150 N/mm²

- HORN 1**
- HORN 2** only for 550 mm (21.65 in) segm.

TPR176.28.R1

400 kN/m max.



	100 mm	3.93 in	3.0 kg
	500 mm	9.84 in	15.0 kg
FW FC	250 mm segmented	20.82 in segmented	7.5 kg
	550 mm segmented	21.65 in segmented	16.5 kg

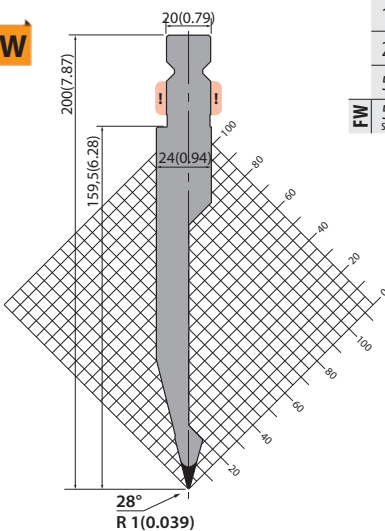
42Cr: 900-1150 N/mm²

- HORN 1**
- HORN 2** only for 550 mm (21.65 in) segm.

TPR200.28.R1

600 kN/m max.

NEW



	100 mm	3.93 in	2.4 kg
	250 mm	9.84 in	6.1 kg
	515 mm	20.82 in	12.6 kg
FW	550 mm segmented	21.65 in segmented	13.5 kg

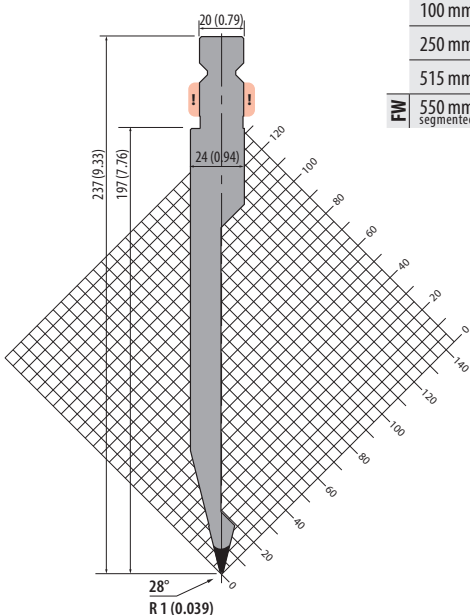
42Cr: 900-1150 N/mm²

- HORN 2**



TPR237.28.R1

600 kN/m max.



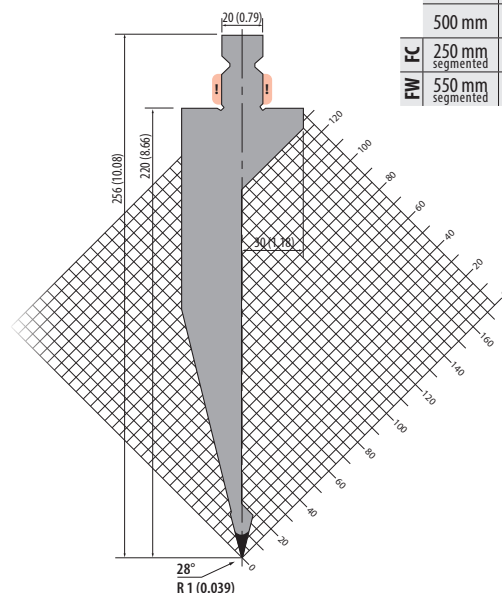
	100 mm	3.93 in	2.9 kg
	250 mm	9.84 in	7.3 kg
	515 mm	20.82 in	15.0 kg
FW	550 mm segmented	21.65 in segmented	16.0 kg

42Cr: 900-1150 N/mm²

- HORN 2**

TPR256.28.R1

600 kN/m max.



	100 mm	3.93 in	5.0 kg
	500 mm	9.84 in	25.0 kg
FW FC	250 mm segmented	20.82 in segmented	5.0 kg
	550 mm segmented	21.65 in segmented	27.5 kg

42Cr: 900-1150 N/mm²

- HORN 1**
- HORN 2** only for 550 mm (21.65 in) segm.



Article on stock



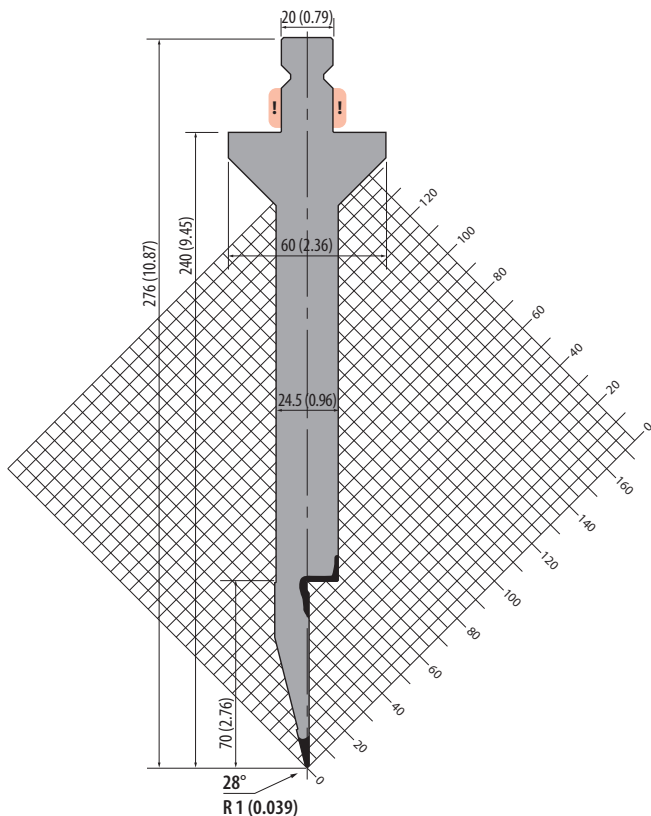
Please ask for delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that delivery time depends on your location.

TPR276.28.R1



400 kN/m max.

	100 mm	3.93 in	4.8 kg
	500 mm	9.84 in	24.0 kg
FW FC	250 mm segmented	20.82 in segmented	12.0 kg
	550 mm segmented	21.65 in segmented	26.4 kg

42Cr: 900-1150 N/mm²

HORN 1



HORN 2 only for 550 mm (21.65 in) segm.

Please choose the clamping system!
Standard equipment:
 < 12.5 kg QuickLock
 > 12.5 kg safety pins
 Also available: ROL1-System see pages 86-87 for more information.



Take advantage of the wide range of Rolleri R1 Type punches by using an adapter. See pages 226-231

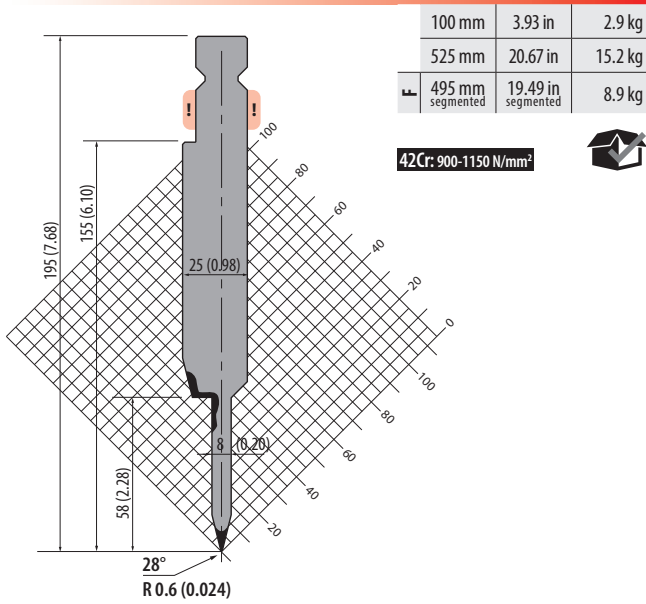


Rolleri Videos

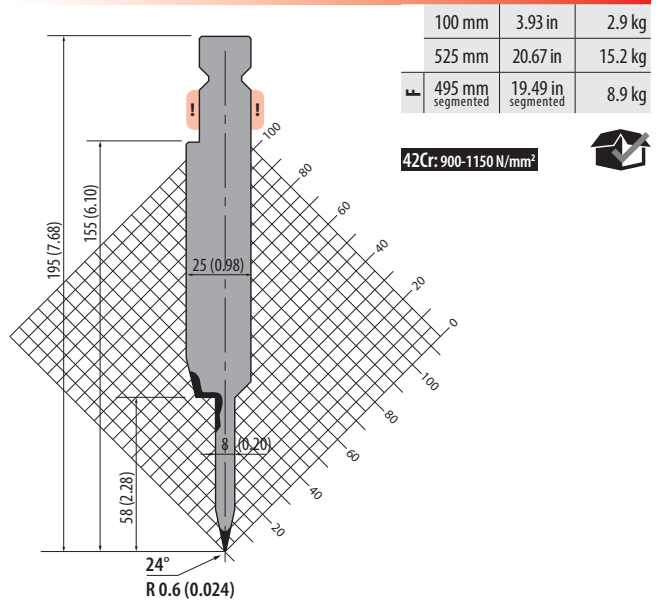
find updated and helpful videos at:
www.rolleritools.com/videos/overview



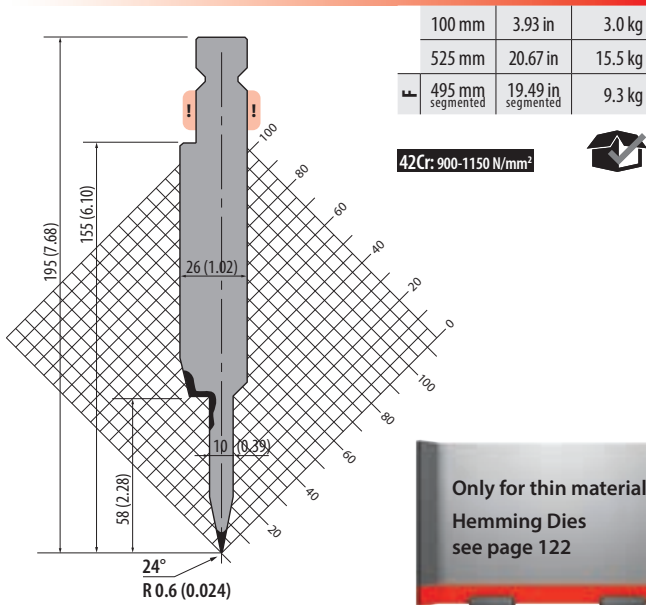
TPR.SP.195.28.8



TPR.SP.195.24.8

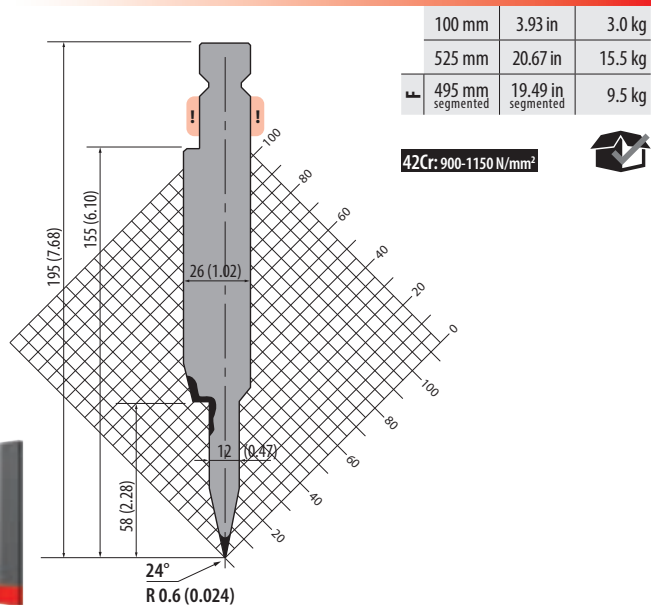


TPR.SP.195.24.10

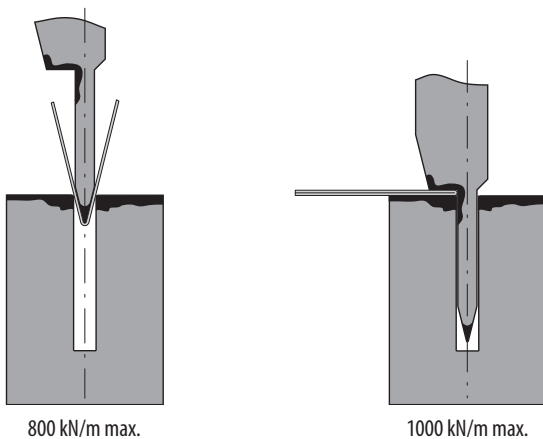


Only for thin material!
Hemming Dies
see page 122

TPR.SP.195.24.12



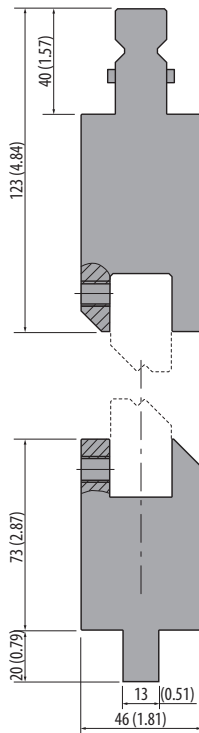
Example of application



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	kN/mm ²	mm	in	mm	in	kN/mm ²	kN/mm ²
				t/m	t/m					t/m	t/m
0.6	0.02	3.0	0.12	9	15	0.6	0.02	1.2	0.05	23	35
0.8	0.03	3.0	0.12	12	20	0.8	0.03	1.6	0.06	32	50
1.0	0.04	3.5	0.14	15	25	1.0	0.04	1.0	0.04	40	60
1.25	0.05	3.5	0.14	17	26	1.25	0.05	2.5	0.10	50	80

TPZ

1000 kN/m max.



835 mm	32.87 in	46.0 kg
415 mm	16.34 in	23.0 kg

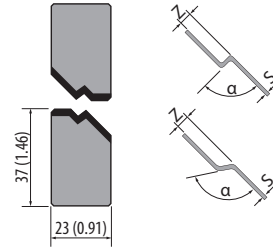
C45: 560-710 N/mm²



Joggle Tool Inserts 160° / 150° / 140° / 90°

1000 kN/m max.

C45: 560-710 N/mm²



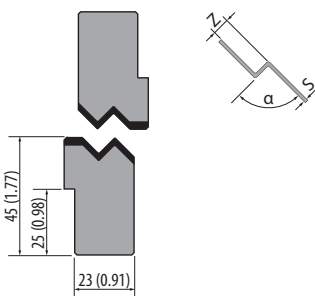
Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 1.0	1.0	0.04	160°	1.2	0.05	11.0 kg	5.5 kg
CEZ 1.5	1.5	0.06	160°	1.5	0.06	11.0 kg	5.5 kg
CEZ 2.0	2.0	0.08	150°	1.4	0.06	11.0 kg	5.5 kg
CEZ 2.5	2.5	0.10	140°	1.3	0.05	11.0 kg	5.5 kg
CEZ 1.0/90	1.0	0.04	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 1.5/90	1.5	0.06	90°	0.3	0.01	11.0 kg	5.5 kg
CEZ 2.0/90	2.0	0.08	90°	0.4	0.02	11.0 kg	5.5 kg
CEZ 2.5/90	2.5	0.10	90°	0.5	0.02	11.0 kg	5.5 kg
CEZ 3.0	3.0	0.12	90°	1.0	0.04	10.3 kg	5.1 kg
CEZ 3.5	3.5	0.14	90°	1.0	0.04	10.0 kg	5.0 kg
CEZ 4.0	4.0	0.16	90°	1.2	0.05	10.0 kg	5.0 kg
CEZ 4.5	4.5	0.18	90°	1.2	0.05	10.0 kg	5.0 kg
CEZ 5.0	5.0	0.20	90°	1.3	0.05	10.0 kg	5.0 kg
CEZ 5.5	5.5	0.22	90°	1.4	0.06	10.0 kg	5.0 kg
CEZ 6.0	6.0	0.24	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 6.5	6.5	0.26	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 7.0	7.0	0.28	90°	1.5	0.06	10.0 kg	5.0 kg
CEZ 7.5	7.5	0.30	90°	1.6	0.06	10.0 kg	5.0 kg
CEZ 8.0	8.0	0.31	90°	1.6	0.06	10.0 kg	5.0 kg

* Fe Rmax = 42 Kg/mm²

Please choose the clamping system!
Standard equipment:
< 12.5 kg QuickLock
> 12.5 kg safety pins
Also available: ROL1-System see
pages 86-87 for more information.

Joggle Tool Inserts 90°

1000 kN/m max.



C45: 560-710 N/mm²



Articles on stock – Please
note that delivery
time varies
according to
your location.



Model	Z mm	Z in	α	S* mm	S* inch	Weight	Weight
CEZ 9.0	9	0.35	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 10.0	10	0.39	90°	1.8	0.07	13.5 kg	6.5 kg
CEZ 11.0	11	0.43	90°	2	0.08	13.5 kg	6.5 kg
CEZ 12.0	12	0.47	90°	2	0.08	13.5 kg	6.5 kg
CEZ 13.0	13	0.51	90°	2	0.08	13.5 kg	6.5 kg
CEZ 14.0	14	0.55	90°	2	0.08	13.5 kg	6.5 kg
CEZ 15.0	15	0.59	90°	2.3	0.09	13.5 kg	6.5 kg

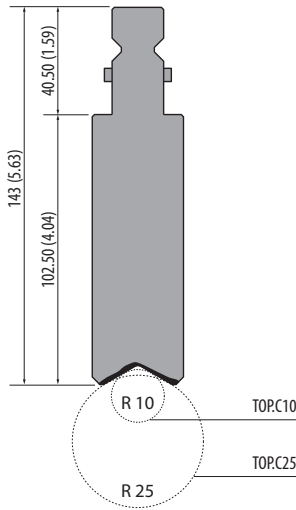
* Fe Rmax = 42 Kg/mm²

* Fe Rmax = 42 Kg/mm²



TPR143.10

1000 kN/m max.



	525 mm	20.67 in	18.0 kg
F	495 mm segmented	19.49 in segmented	17.0 kg

For Radius tools with R10-R25 (TOP.C10-TOP.C25) see below

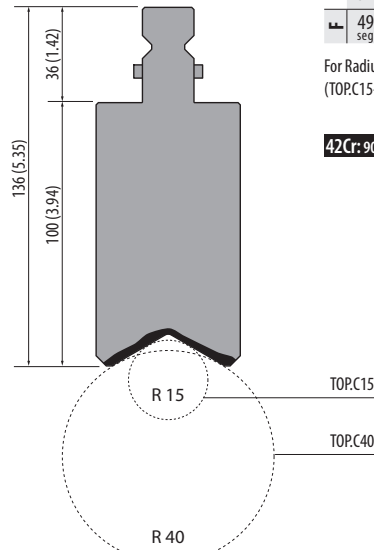
42Cr: 900-1150 N/mm²



Do you prefer the QuickLock or ROL1-System? Send us an email or give us a call!

TPR136.15

1000 kN/m max.



	525 mm	20.67 in	25.0 kg
F	495 mm segmented	19.49 in segmented	23.7 kg

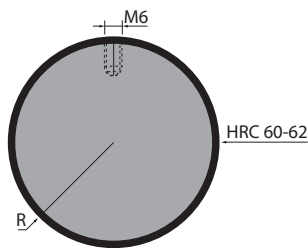
For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm²



Radius punches: R10-40

1000 kN/m max.



Material C53
induction hardened
60-62 HRC

Rolleri radius tools are on stock in sectioned version too! Take advantage of our tool availability!



C53: 610-760 N/mm²

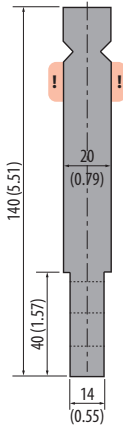
Model	R mm	R in	Weight	Weight
TOP.C10	10	0.39	1.3 kg	2.7 kg
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C22.5	22.5	0.88	6.6 kg	7.5 kg
TOP.C25	25	0.98	8.1 kg	11.3 kg
TOP.C27.5	27.5	1.08	9.8 kg	15.1 kg
TOP.C30	30	1.18	11.7 kg	11.3 kg
TOP.C32.5	32.5	1.28	13.7 kg	12.9 kg
TOP.C35	35	1.38	16.0 kg	15.1 kg
TOP.C37.5	37.5	1.47	18.2 kg	17.2 kg
TOP.C40	40	1.57	20.7 kg	19.5 kg

525 mm / 20.67 in
495 mm / 16.34 in segmented



TPR140-14

800 kN/m max.



830 mm	32.68 in	17.0 kg
412 mm	16.22 in	9.0 kg

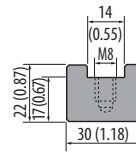
For Radius tools with R8-R50 (C13.08-C70.50) and hemming tool (E 30.22) see below

C45: 560-710 N/mm²



E30.22

800 kN/m max.



835 mm	32.87 in	3.5 kg
415 mm	16.34 in	1.7 kg

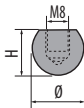
Hemming tool

C45: 560-710 N/mm²



Radius Tool: Ø 16-20 mm (0.63-0.79 in)

800 kN/m max.



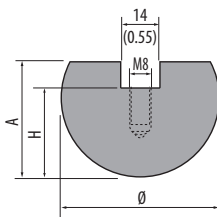
C45: 560-710 N/mm²



Model	Ø mm	Ø in	H mm	H in	Weight	Weight
C13.08	16	0.63	13	0.51	2.00 kg	1.00 kg
C13.09	18	0.71	16	0.63	2.00 kg	1.00 kg
C16.10	20	0.79	16	0.63	2.00 kg	1.00 kg

Radius Tool: Ø 25-100 mm (0.98-3.94)

800 kN/m max.



C45: 560-710 N/mm²



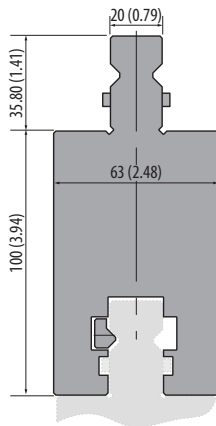
Model	Ø (mm)	H (mm)	A (mm)	Weight	Weight
C17.12	25	17	22	2.5 kg	1.2 kg
C20.15	30	20	27	3.7 kg	1.8 kg
C22.17	35	22	32	5.0 kg	2.4 kg
C24.20	40	24	34	7.0 kg	3.5 kg
C25.22	45	25	35	7.5 kg	3.8 kg
C29.25	50	29	39	10.0 kg	4.7 kg
C34.27	55	34	44	12.4 kg	6.2 kg
C34.30	60	34	44	13.5 kg	6.7 kg
C37.32	65	37	47	15.9 kg	7.9 kg
C45.35	70	45	55	20.3 kg	10.0 kg
C42.37	75	42	52	20.5 kg	10.3 kg
C45.40	80	45	55	23.0 kg	11.5 kg
C60.45	90	60	70	34.0 kg	17.0 kg
C70.50	100	70	80	43.5 kg	21.7 kg

AD21

1500 kN/m max.

150 mm	5.91 in	7.0 kg
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C42Cr: 900-1150 N/mm²



3
R2

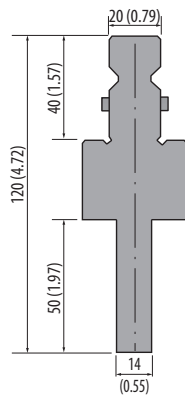
Punch Adapters

AD11

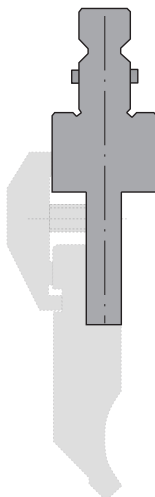
1000 kN/m max.

150 mm	5.91 in	3.0 kg
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C45: 560-710 N/mm²



Example of application



For more Adpaters
see pages 226-231



Article
on stock



Please ask for
delivery time!

1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



Articles on stock – Please note that
delivery time depends on your location.