



R3

Compatibility

Punches Rolleri Type R3 are compatible with press brake machines from:

- Bystronic-Beyeler RFA
- Bystronic-Beyeler RF
- Bystronic-Beyeler R
- Bystronic-Beyeler S

With the use of adapters Rolleri R3 type punches can be mounted in other press brake models.

PUNCHES ROLLERI TYPE R3

Content Explanation	126 - 127
Bystronic-Beyeler RFA punches	128 - 129
Bystronic-Beyeler RF punches	129
Bystronic-Beyeler RFA hemming punches	130
Bystronic-Beyeler R punches	131
Bystronic-Beyeler S punches	132
Punch adapters	133
Joggle Tools	134 - 135
Radius Tools	136 - 137

Compatibility

Punches Roller Type R3 are:

- compatible with press brake machines from:
 - Bystronic-Beyeler RFA
 - Bystronic-Beyeler RF
 - Bystronic-Beyeler R
 - Bystronic-Beyeler S

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.

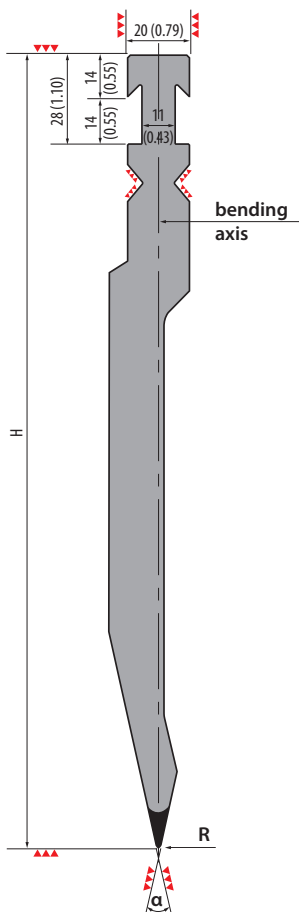
Material Type	Mechanical resistance of the material and the tool body	Hardness of the material and the tool body	Hardness of the operating surfaces after induction hardening
42CrMo4	900-1150 N/mm ²	29.1 - 36.9 HRc	54 - 60 HRc
C45	560-710 N/mm ²	12 - 15.5 HRc	54 - 60 HRc

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

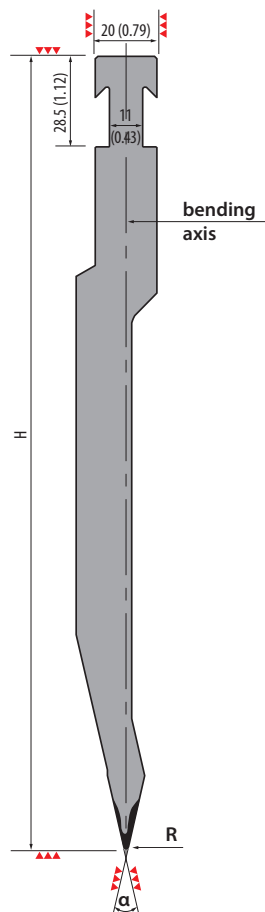
Tang

Punches Roller Type R3 have the following tangs:

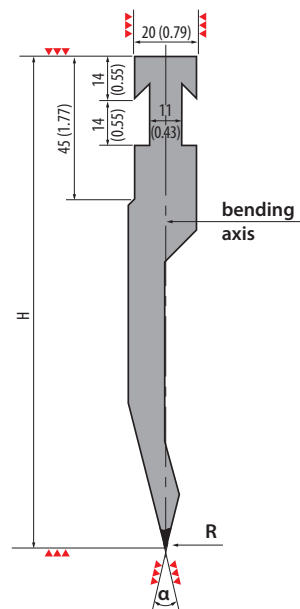
Bystronic-Beyeler RFA



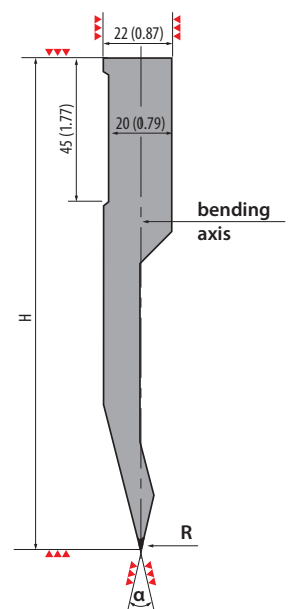
Bystronic-Beyeler RF



Bystronic-Beyeler R



Bystronic-Beyeler S

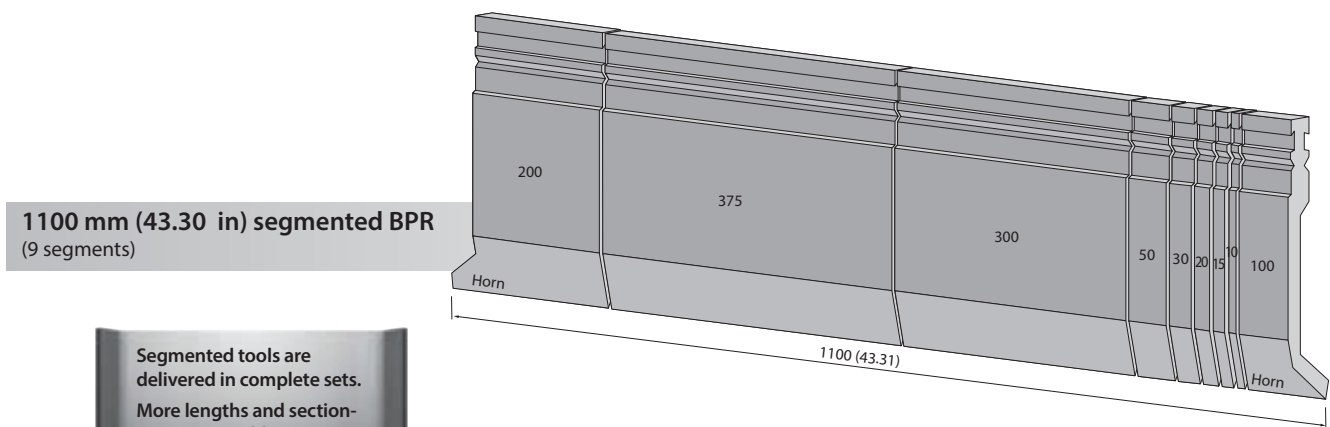
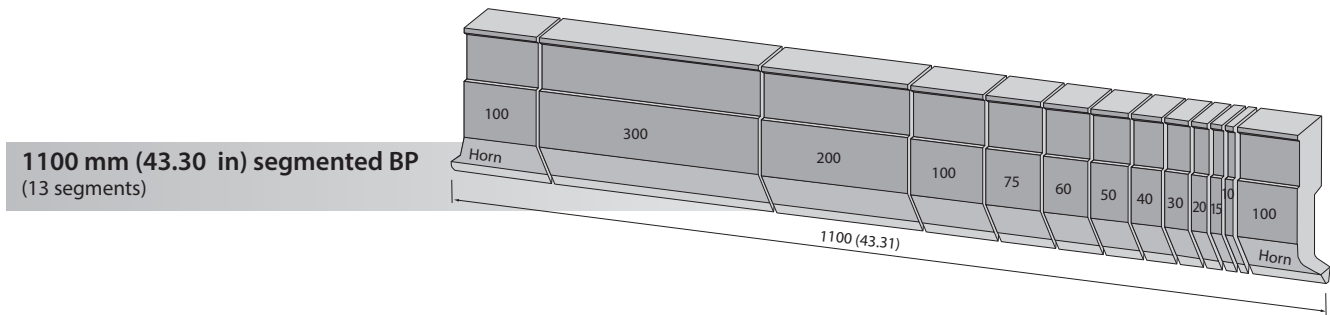
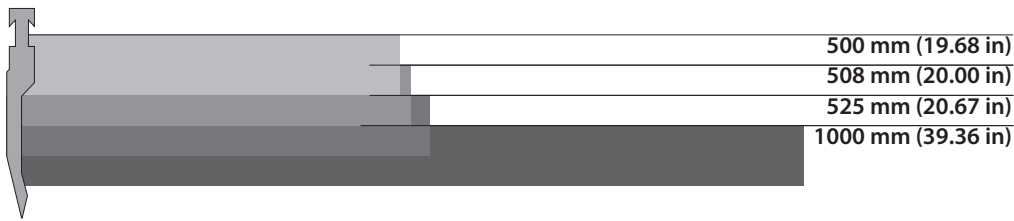


Indications of precision ground surfaces:

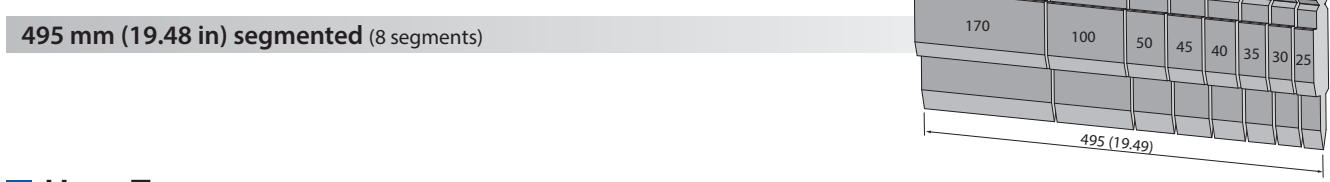


Tool lengths and sectioning

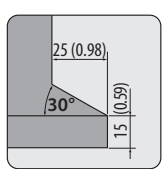
Standard



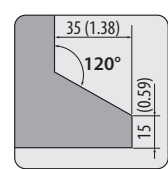
Segmented tools are delivered in complete sets. More lengths and sectionings are possible upon request.



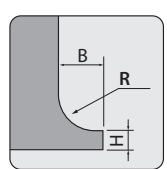
Horn Types



HORN 1 Horn 1 Standard BP for all segm. Punches BP Rolleri Type R3



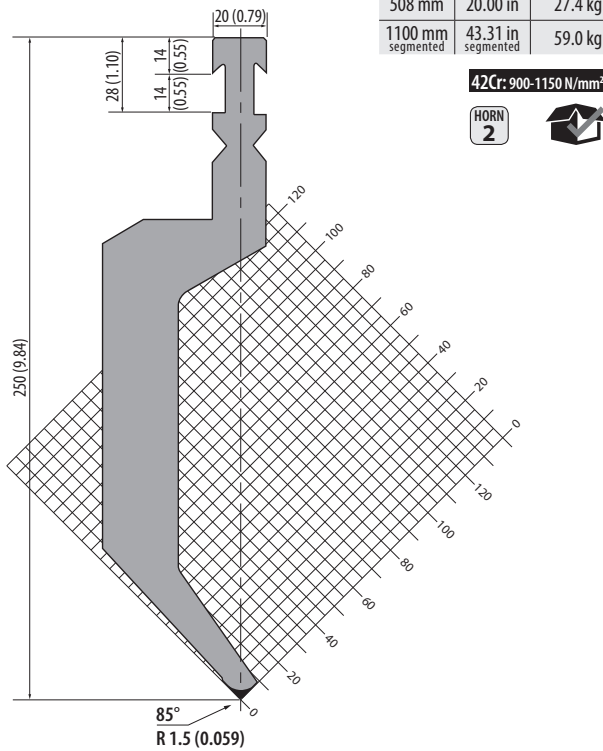
HORN 2 Horn 2 Standard BPR for all segm. Punches BPR Rolleri Type R3



Individual Horn production according to your specifications

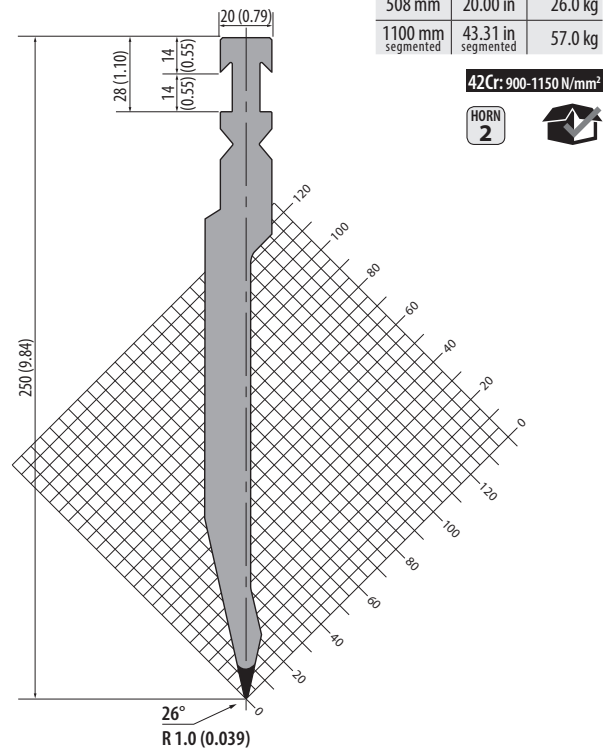
BPR250.P4-RFA

900 kN/m max.



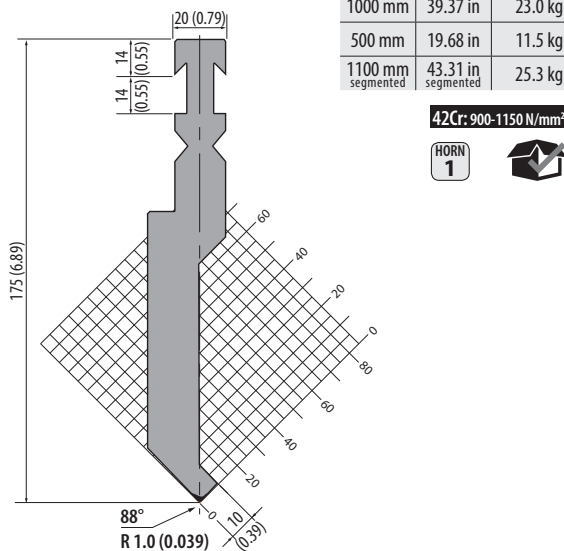
BPR250.P5-RFA

1000 kN/m max.



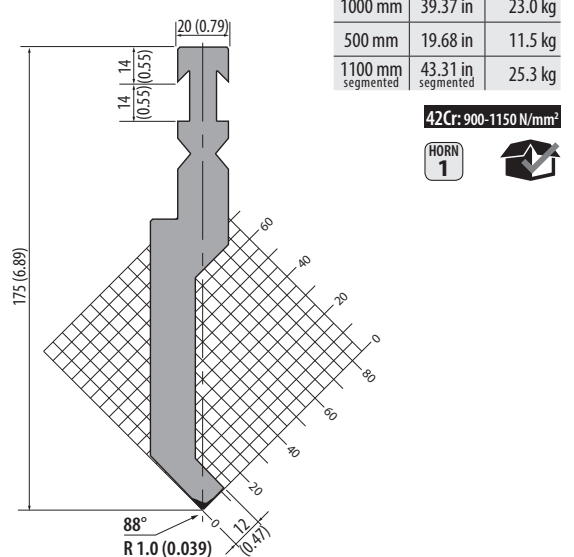
BP175.88.R1-A-RFA

1000 kN/m max.



BP175.88.R1-B-RFA

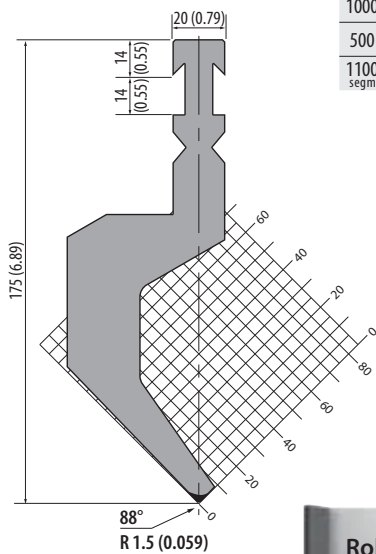
1000 kN/m max.



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

BP175.88.R15-RFA

500 kN/m max.



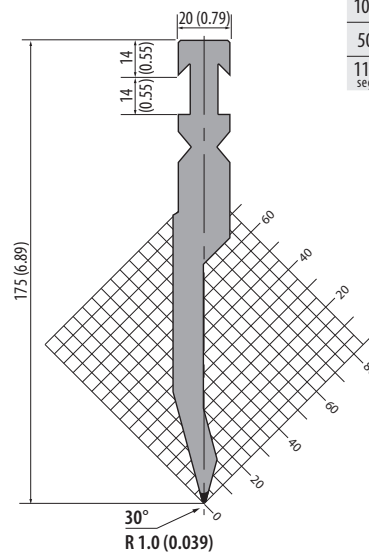
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	23.0 kg

42Cr: 900-1150 N/mm²



BP175.30.R1-RFA

800 kN/m max.



1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	16.0 kg

42Cr: 900-1150 N/mm²

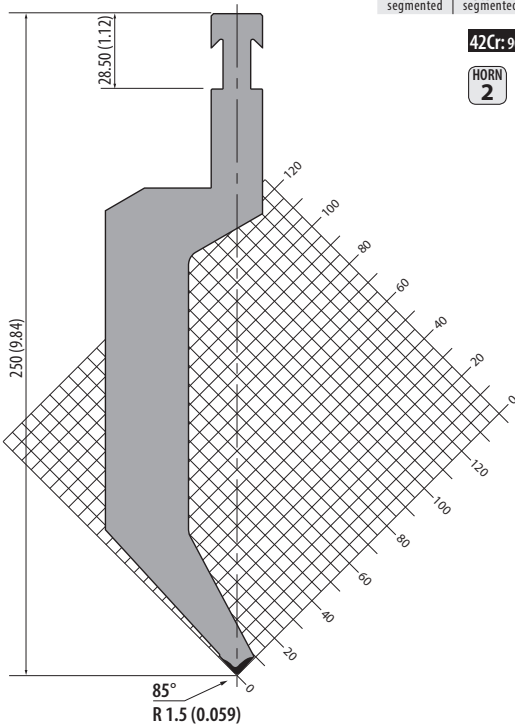


Rolleri R3 type punches are manufactured of 42CrMo4 to have higher capacity!

Bystronic-Beyeler RF punches

BPR250.P4-RF

1000 kN/m max.



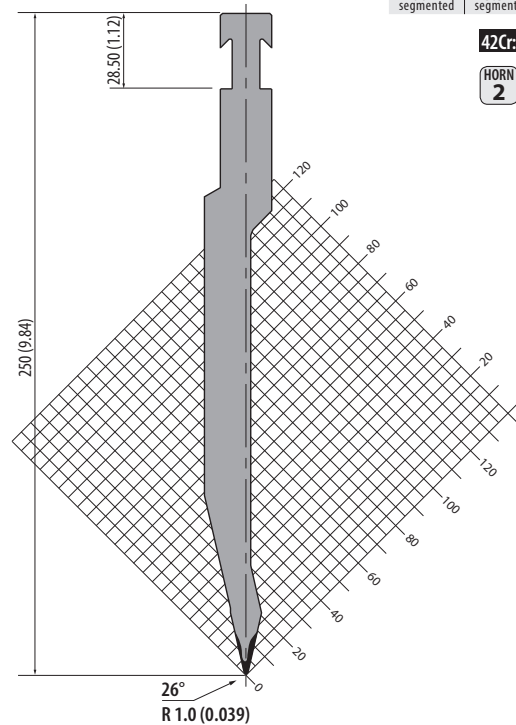
508 mm	20.00 in	27.6 kg
1100 mm segmented	43.31 in segmented	51.0 kg

42Cr: 900-1150 N/mm²



BPR250.P5-RF

900 kN/m max.



508 mm	20.00 in	16.0 kg
1100 mm segmented	43.31 in segmented	35.0 kg

42Cr: 900-1150 N/mm²



Article on stock



Please ask for delivery time!

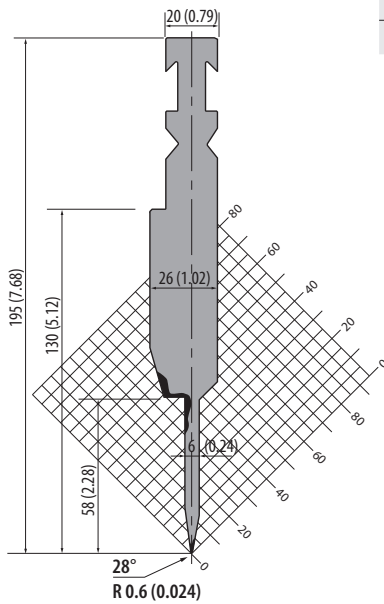
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

BPR.SP-195.28.6

500 kN/m max.

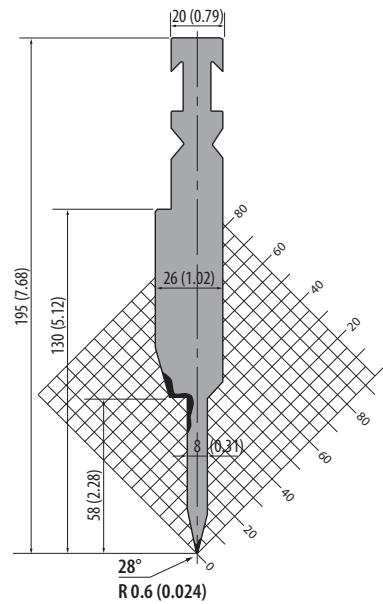


525 mm	20.67 in	8.7 kg
495 mm segmented	19.49 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.28.8

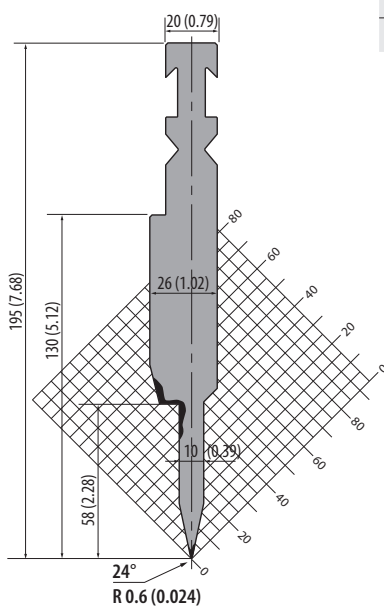


525 mm	20.67 in	8.7 kg
495 mm segmented	19.49 in segmented	8.2 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.24.10

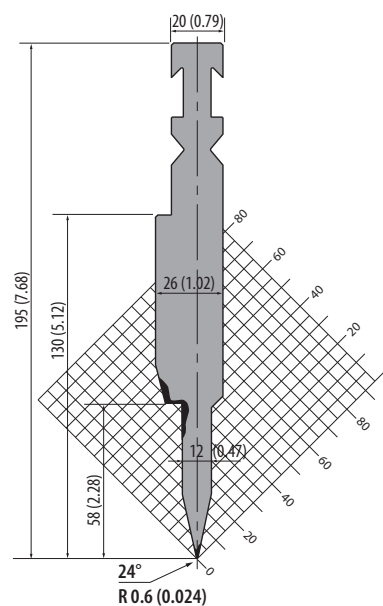


525 mm	20.67 in	8.9 kg
495 mm segmented	19.49 in segmented	8.4 kg

42Cr: 900-1150 N/mm²



BPR.SP-195.24.12

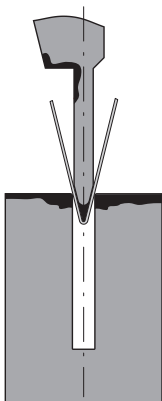


525 mm	20.67 in	9.2 kg
495 mm segmented	19.49 in segmented	8.6 kg

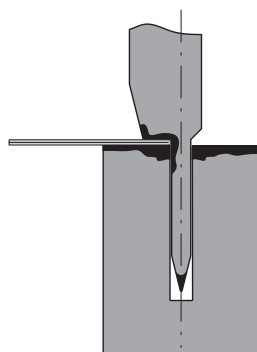
42Cr: 900-1150 N/mm²



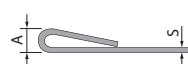
Example of Application



800 kN/m max.



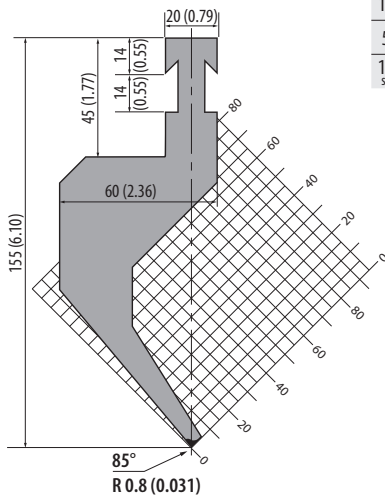
1000 kN/m max.



S	S	A	A	R.420	R.700	S	S	A	A	R.420	R.700
mm	in	mm	in	kN/mm ²	t/m	mm	in	mm	in	kN/mm ²	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

BP155.85.R08-R

500 kN/m max.



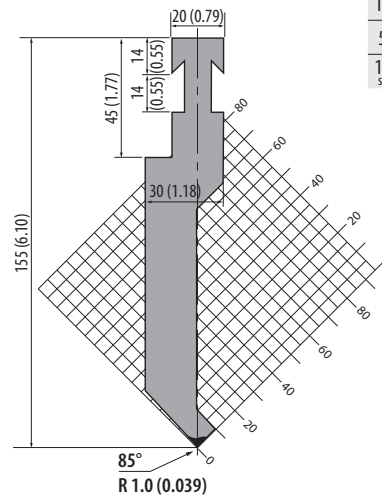
1000 mm	39.37 in	30.5 kg
500 mm	19.68 in	15.0 kg
1100 mm segmented	43.31 in segmented	32.5 kg

42Cr: 900-1150 N/mm²



BP155.85.R1-R

1000 kN/m max.



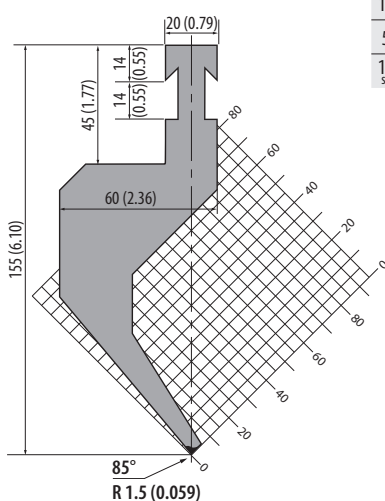
1000 mm	39.37 in	23.0 kg
500 mm	19.68 in	11.5 kg
1100 mm segmented	43.31 in segmented	23.0 kg

42Cr: 900-1150 N/mm²



BP155.85.R15-R

500 kN/m max.



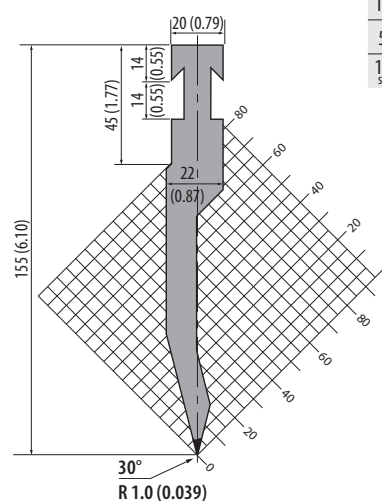
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	32.0 kg

42Cr: 900-1150 N/mm²



BP155.30.R1-R

800 kN/m max.



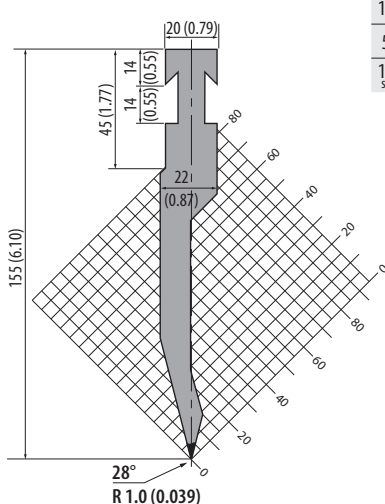
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	18.0 kg

42Cr: 900-1150 N/mm²



BP155.28.R1-R

800 kN/m max.



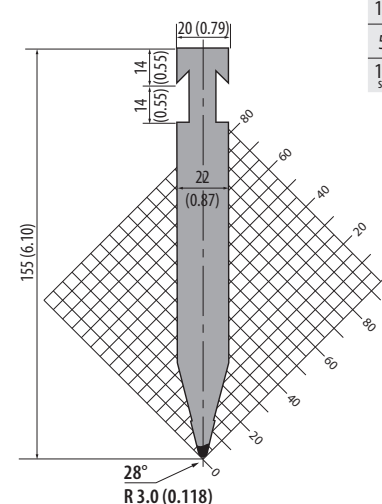
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²



BP155.28.R3-R

1000 kN/m max.



1000 mm	39.37 in	21.0 kg
500 mm	19.68 in	11.0 kg
1100 mm segmented	43.31 in segmented	23.5 kg

C45: 560-710 N/mm²



Article on stock



Please ask for delivery time!

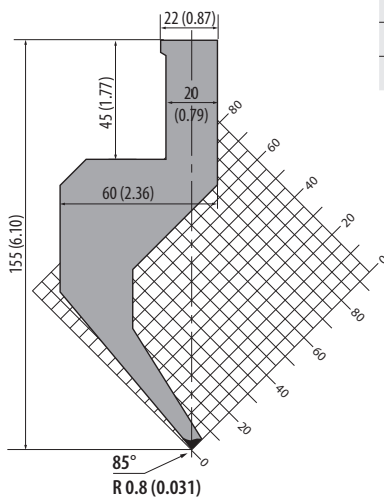
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

BP155.85.R08-S

500 kN/m max.



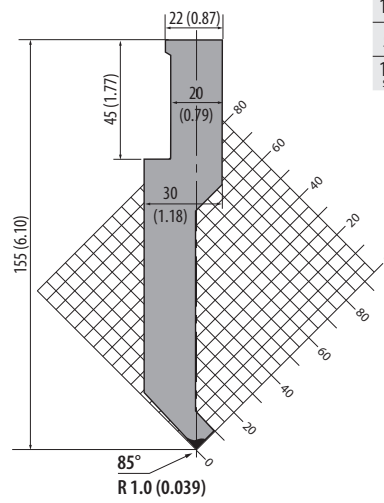
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	34.0 kg

42Cr: 900-1150 N/mm²



BP155.85.R1-S

1000 kN/m max.



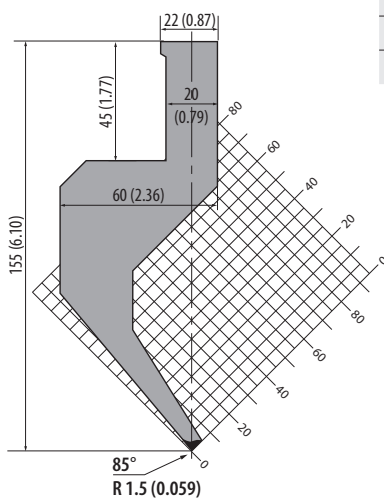
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.0 kg
1100 mm segmented	43.31 in segmented	35.2 kg

42Cr: 900-1150 N/mm²



BP155.85.R15-S

500 kN/m max.



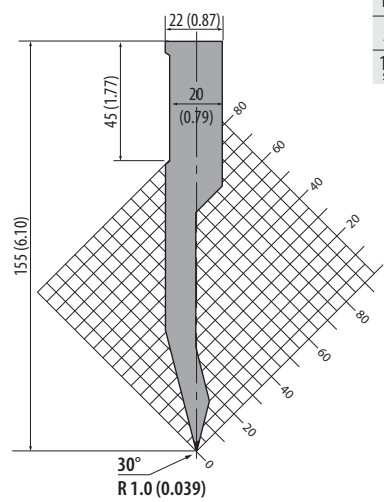
1000 mm	39.37 in	32.0 kg
500 mm	19.68 in	16.5 kg
1100 mm segmented	43.31 in segmented	32.0 kg

42Cr: 900-1150 N/mm²



BP155.30.R1-S

800 kN/m max.



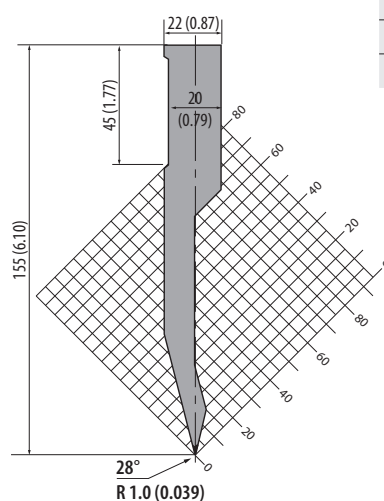
1000 mm	39.37 in	17.5 kg
500 mm	19.68 in	9.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²



BP155.28.R1-S

800 kN/m max.



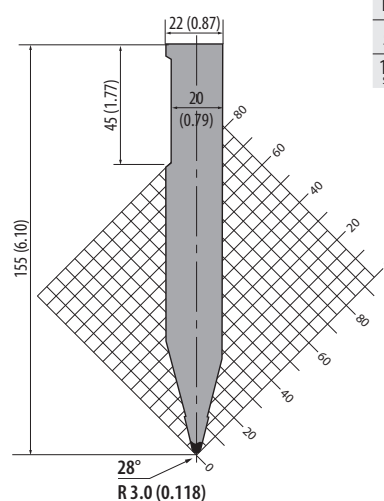
1000 mm	39.37 in	16.0 kg
500 mm	19.68 in	8.0 kg
1100 mm segmented	43.31 in segmented	17.5 kg

42Cr: 900-1150 N/mm²



BP155.28.R3-S

1000 kN/m max.



1000 mm	39.37 in	23.5 kg
500 mm	19.68 in	12.0 kg
1100 mm segmented	43.31 in segmented	23.5 kg

C45: 560-710 N/mm²



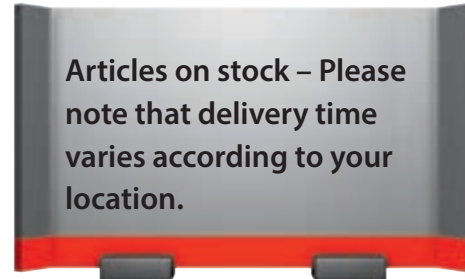
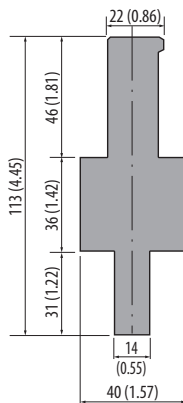
AD3

1000 kN/m max.

150 mm	5.90 in	3.3 kg
--------	---------	--------

Rolleri Type R3 Beyeler S
→ Rolleri Type R1

C45: 560-710 N/mm²



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

5
R3

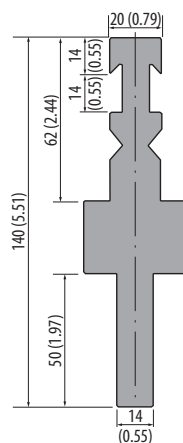
AD10

1000 kN/m max.

150 mm	5.90 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler RFA → Rolleri Type R1

C45: 560-710 N/mm²



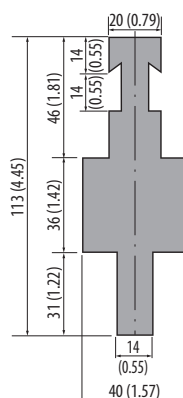
AD22

1000 kN/m max.

150 mm	5.90 in	3.4 kg
--------	---------	--------

Rolleri Type R3 Beyeler R → Rolleri Type R1

C45: 560-710 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)



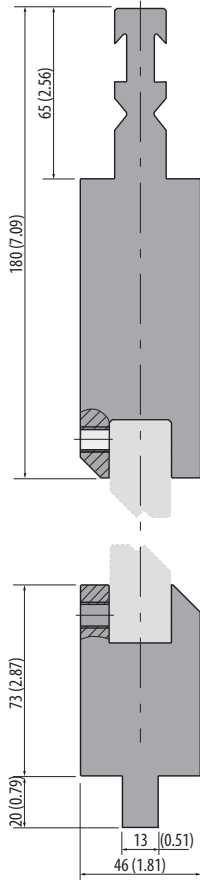
Articles on stock – Please note that delivery time depends on your location.

BPZ-RFA

1000 kN/m max.

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.7 kg

C45: 560-710 N/mm²

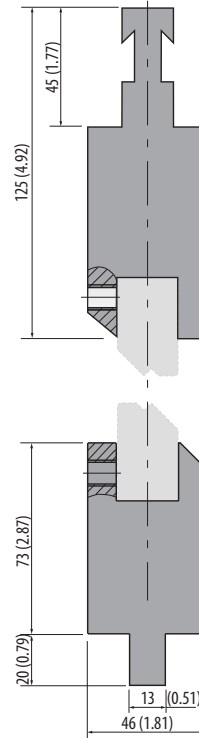


BPZ-R

1000 kN/m max.

835 mm	32.87 in	24.7 kg
415 mm	16.34 in	12.3 kg

C45: 560-710 N/mm²

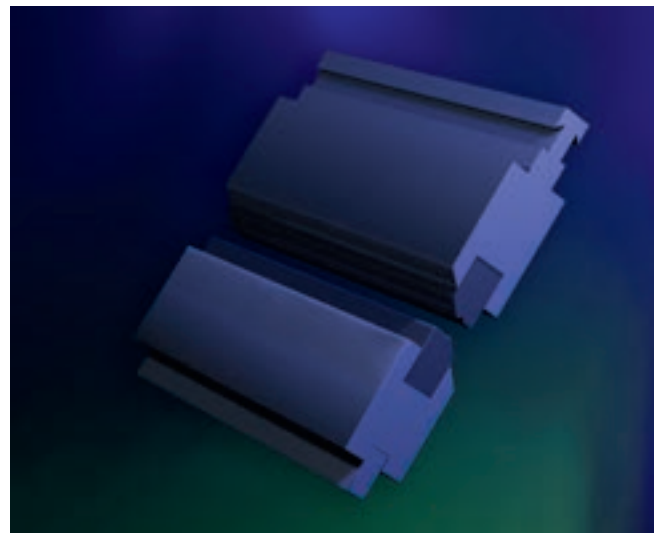
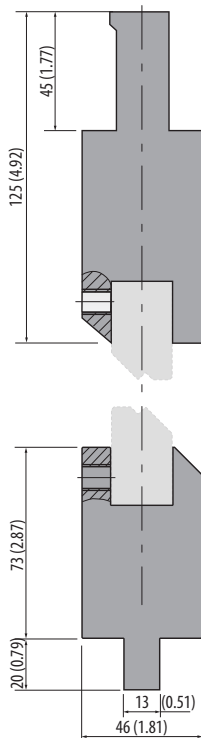


BPZ-S

1000 kN/m max.

835 mm	32.87 in	37.5 kg
415 mm	16.34 in	18.5 kg

C45: 560-710 N/mm²



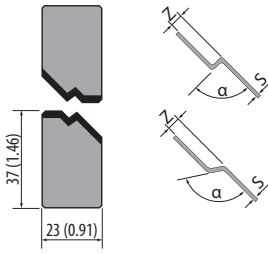
Rolleri Videos

find updated and helpful videos at:
[www.rolleritools.com/
videos/overview](http://www.rolleritools.com/videos/overview)



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

1000 kN/m max.



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

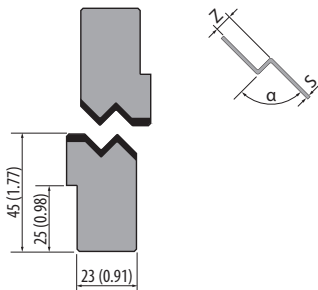
C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

5
R3

Joggle Tool Inserts 90°

1000 kN/m max.



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

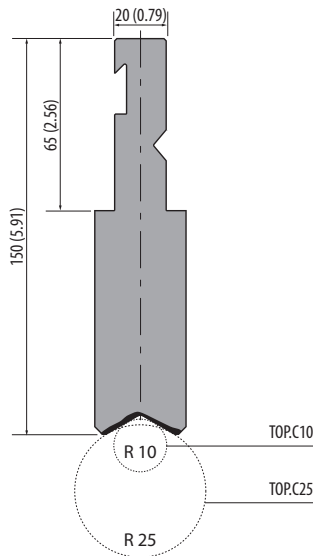


C45: 560-710 N/mm²

* Fe Rmax = 42 Kg/mm²

BPR150.P10.10-RFA

1000 kN/m max.



522 mm	20.55 in	16.5 kg
495 mm segmented	19.49 in segmented	16.0 kg

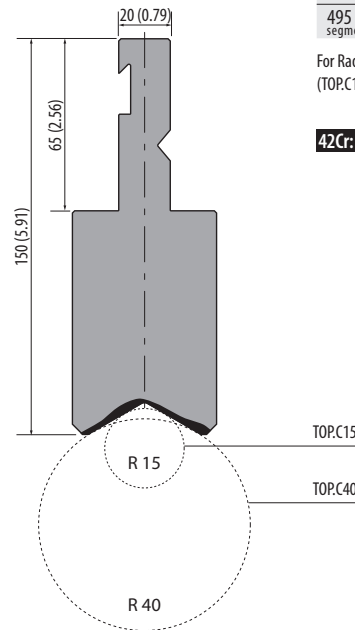
For Radius tools with R10-R25 (TOP.C10-TOP.C25) see below

42Cr: 900-1150 N/mm²



BPR150.P10.15-RFA

1000 kN/m max.



522 mm	20.55 in	23.0 kg
495 mm segmented	19.49 in segmented	21.7 kg

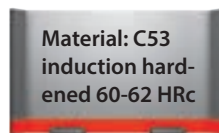
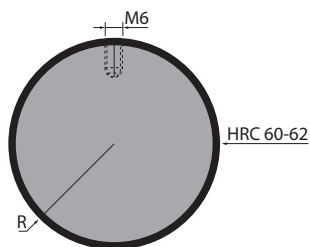
For Radius tools with R15-R40 (TOP.C15-TOP.C40) see below

42Cr: 900-1150 N/mm²



Radius Tools: R10-40

1000 kN/m max.



C53: 610-760 N/mm²

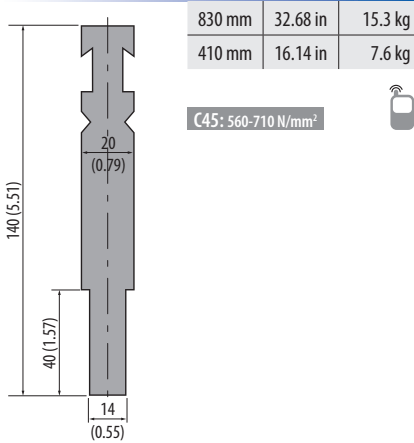


Model	R (mm)	R in	Weight	Weight
TOP.C10	10	0.39		
TOP.C12.5	12.5	0.49	2.0 kg	2.8 kg
TOP.C15	15	0.59	3.0 kg	3.8 kg
TOP.C17.5	17.5	0.69	4.0 kg	4.7 kg
TOP.C20	20	0.79	5.2 kg	6.6 kg
TOP.C22.5	22.5	0.88	6.6 kg	6.6 kg
TOP.C25	25	0.98	8.1 kg	7.5 kg
TOP.C27.5	27.5	1.08	9.8 kg	9.2 kg
TOP.C30	30	0.98	11.7 kg	11.3 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



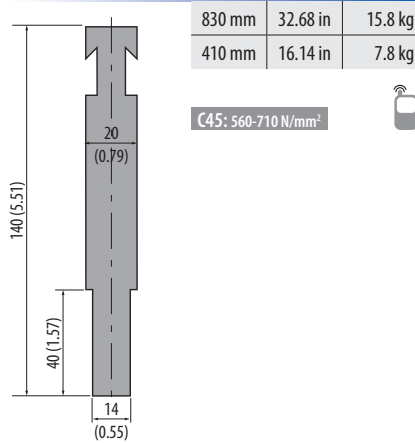
BPU-RFA

800 kN/m max.



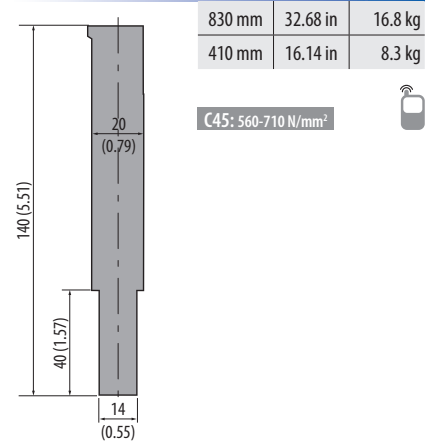
BPU-R

800 kN/m max.



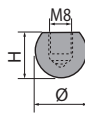
BPU-S

800 kN/m max.



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

800 kN/m max.

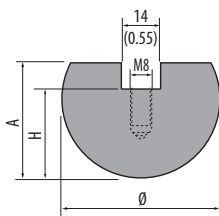


C45: 560-710 N/mm²

Model	Ø mm	Ø in	H mm	H in	835 mm / 32.87 in	Weight	415 mm / 16.34 in	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 in)

800 kN/m max.

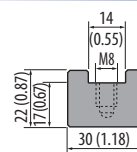


C45: 560-710 N/mm²

Model	Ø (mm)	Ø in	H (mm)	H in	A (mm)	A in	835 mm	Weight	415 mm	Weight
C17.12	25	0.98	17	0.67	22	0.87		2.5 kg		1.2 kg
C20.15	30	1.18	20	0.79	27	1.06		3.7 kg		1.8 kg
C22.17	35	1.38	22	0.87	32	1.26		5.0 kg		2.4 kg
C24.20	40	1.57	24	0.94	34	1.34		7.0 kg		3.5 kg
C25.22	45	1.77	25	0.98	35	1.38		7.5 kg		3.8 kg
C29.25	50	1.97	29	1.14	39	1.54		10.0 kg		4.7 kg
C34.27	55	2.16	34	1.33	44	1.73		12.4 kg		6.2 kg
C34.30	60	2.36	34	1.34	44	1.73		13.5 kg		6.7 kg
C37.32	65	2.55	37	1.45	47	1.85		15.9 kg		7.9 kg
C45.35	70	2.76	45	1.77	55	2.17		20.3 kg		10.0 kg
C42.37	75	2.95	42	1.65	52	2.04		20.5 kg		10.3 kg
C45.40	80	3.15	45	1.77	55	2.17		23.0 kg		11.5 kg
C60.45	90	3.54	60	2.36	70	2.76		34.0 kg		17.0 kg
C70.50	100	3.94	70	2.76	80	3.15		43.5 kg		21.7 kg

E30.22

800 kN/m max.



C45: 560-710 N/mm²

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