

 **ROLLERI**®



# ROLLERI CLAMPING SYSTEMS

Content Explanation	210
ROL200 System for Rolleri R1 type punches	211 - 213
ROL1 System for Rolleri R1 type punches	214 - 215
ROL4 System for Rolleri R1 type punches	215
Intermediates	216
Clamps	217 - 218
W-ROL PN-System for Rolleri R2 type punches	219
ROL3 System for Rolleri R3 and RX type punches	220
ROL crowning table	221
ROL2 System for Rolleri R1 type dies	222 - 223
Movable Clamps for Rolleri R1 type dies	223

# ROLLERI CLAMPING SYSTEMS

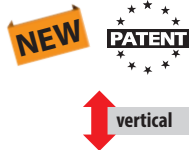
## Content Explanation



- all pneumatic clamps work with at least 10 bar pressure

### ■ ROL200 Clamping

- for **Rolleri R1 type punches**
- **vertical tool change**
- can be used **without modifying** Rolleri R1 type punches
- antifall system
- includes intermediate at your choice
- manual, pneumatic and hydraulic models available
- see pages 214-215



### ■ ROL1 Clamping

- for **Rolleri R1 type punches**
- **vertical tool change**
- **necessary modification:** Rolleri R1 type punches have to be equipped with spring loaded ball bearings
- antifall system
- includes intermediate at your choice
- manual and pneumatic models available
- dual sided clamping (KDS-System)
- see pages 216-217



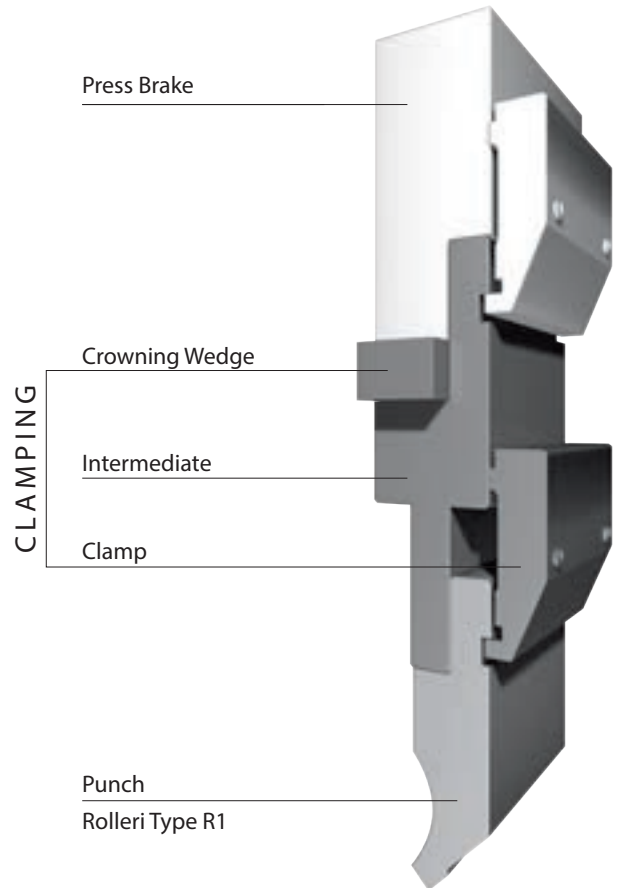
### ■ ROL4 Clamping

- for **Rolleri R1 type punches**
- **horizontal tool change**
- can be used **without modifying** Rolleri R1 type punches
- antifall system
- includes intermediate at your choice
- manual and hydraulic models available
- dual sided clamping integrated
- see page 217



### ■ Standard-Clamping

- for **Rolleri R1 type punches**
- composed of clamp and intermediate
- dual sided clamping (KDS-System)
- **horizontal tool change**
- see pages 211-213



### ■ W-ROL PN Clamping

- for **Rolleri R2 type punches**
- **vertical tool change** with ROL1-System and QuickLock-System
- punches with Safety-Pins are inserted **horizontally**
- antifall system
- pneumatic model available only
- see page 218



### ■ ROL3 Clamping

- for **Rolleri Type R3/RX punches**
- **vertical or horizontal tool change**
- custom-made
- antifall system
- hydraulic model available only
- see page 219



### ■ ROL2 Clamping

- for **Rolleri Type R1 dies**
- manual, pneumatic and hydraulic models available
- see pages 220-221



### ■ Movable Die Clamps

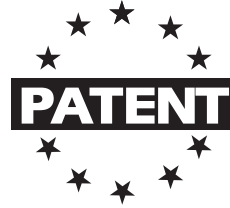
- for **Rolleri Type R1 dies**
- manual model available only
- see page 221

### ROLLERI presents his latest innovation:

The new clamping **ROL200** for Punches! Compatible with: Amada, Boschert, Bystronic-Beyeler Euro-B, Durmazlar, Ermaksan, Gasparini, Haco, Promecam, etc. The new **patented** system enables manual, pneumatic or hydraulic vertical clamping of your top tools. The special features are the enormously simple handling and the surprisingly low price, which guarantees huge efficiency. It is available as retrofitting as well as original equipment. This new clamping is a revolution in the market of press brake tooling!

- fast **vertical** tool change for all Rolleri R1 type punches
- can be used without modifying Rolleri R1 type punches
- safe and fast tool change
- substantial improvement in time consumption and related costs
- secure against tool falling down
- available in manual, pneumatic and hydraulic models
- mounting:  
Simply from the bottom into the housing, tighten – DONE!
- disassembly:  
Untighten, gently lift tool and remove it downwards.
- easy to mount on your press brake.  
Modification of the press brake is not necessary.

**NEW**



**Rolleri Videos**



Tutorial ROL200: [www.rolleritools.com/videos/rol200](http://www.rolleritools.com/videos/rol200)



**Rolleri Videos**



Application of ROL200 PN:  
[www.rolleritools.com/videos/rol200](http://www.rolleritools.com/videos/rol200)



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.



### ROL200 – manual



**NEW**



Model	with Intermediate
ROL200 manual	INT100
	INT120
	INT120-40
	INT150
	INT100 FISSO

L=150 mm (5.91 in)  
vertical tool change  
Including intermediate at your choice



The ROL200-System is suited for Standard-Punches. There are no modifications necessary!

#### ROL200 – pneumatic



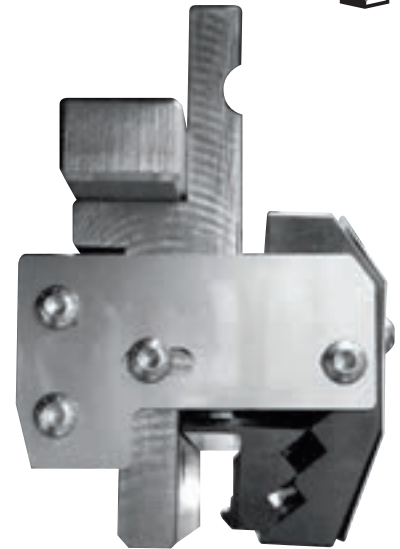
**NEW**

**PATENT**

vertical

Model	with Intermediate
ROL200 pneumatic	INT120
	INT150
	INT132-40
	INT150-40

L=150 mm (5.91 in)  
vertical tool change  
Including intermediate at your choice



#### ROL200 – hydraulic



**NEW**

**PATENT**

vertical

Model	with Intermediate
ROL200 hydraulic	INT120
	INT150

L=150 mm (5.91 in)  
vertical tool change  
Including intermediate at your choice



If the axis of your press brake is  
=20 mm please contact us!



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.

# R1

## ROLLERI CLAMPING SYSTEMS

### ROL1-System for Punches

In order to use the ROL1 System, punches are modified and equipped with spring-loaded ball bearings.

ROL1 can be used on all press brakes with Rollerri R1 type intermediates with standard tang.

#### Our Advantages – Your Convenience

- **vertical clamping** of tools is possible thanks to a row of **spring-loaded ball bearings** which are also used as **antifall system** to prevent punches from falling down
- a complete mechanical and efficient fast clamping system for press brakes
- Productivity and versatility of press brakes is substantially increased
- Significant **reduction in the set-up times** when changing tools



#### ROL1 CLAMP1 – manual

Model	with Intermediate	L=150 mm (5.91 in) vertical tool change Including intermediate at your choice
ROL1 CLAMP1	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



ROL1 CLAMP1  
without Intermediate

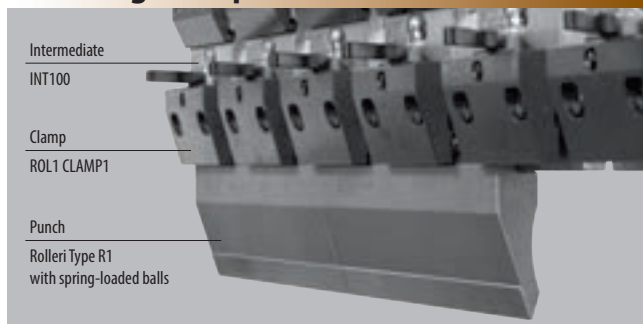


#### ROL1 PN CLAMP1 – pneumatic

Model	with Intermediate	L=150 mm (5.91 in) vertical tool change Including intermediate at your choice
ROL1 PN CLAMP1	INT120 INT150	



#### Mounting example



#### Rolleri Videos

Application of Clamping Systems  
ROL1 CLAMP1: [www.rolleritools.com/  
videos/rol1-clamp1](http://www.rolleritools.com/videos/rol1-clamp1)



#### ROL1 KDS

Model	with Intermediate	L=150 mm (5.91 in) vertical tool change Including intermediate at your choice
ROL1 KDS	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



#### ROL4-System for Punches

##### ROL4 – manual

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool change including intermediate at your choice integrated KDS-System
ROL4 manual	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT120-40	



##### ROL4 – hydraulic

Model	with Intermediate	L=150 mm (5.91 in) horizontal tool change including intermediate at your choice integrated KDS-System
ROL4 hydraulic	INT100	
	INT120	
	INT150	
	INT100 FISSO	
	INT150-40	
INT120-40		



#### Rolleri Videos

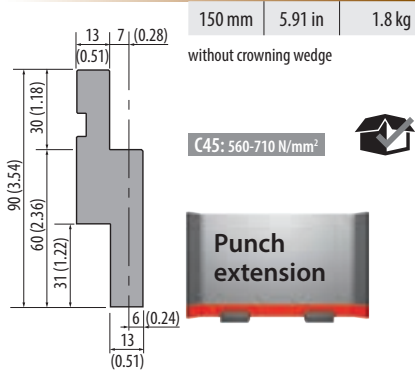
Application of hydraulic clamping ROL4  
[www.rolleritools.com/videos/rol4-hydraulic-clamping](http://www.rolleritools.com/videos/rol4-hydraulic-clamping)



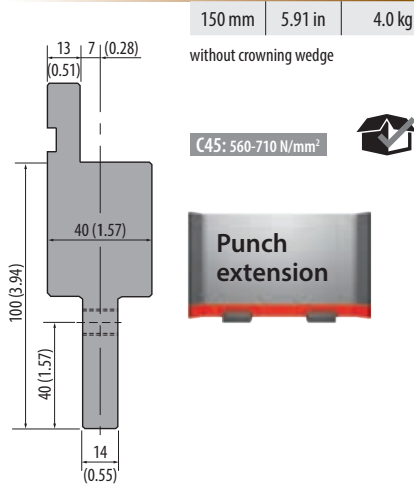
The ROL4-System is suitable for standard Rolleri R1 type punches. No modifications are necessary!



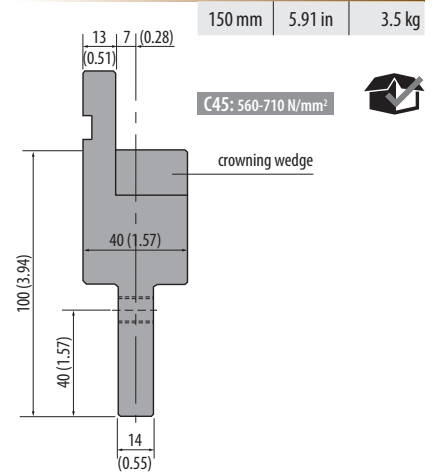
**AD4** 1000 kN/m max.



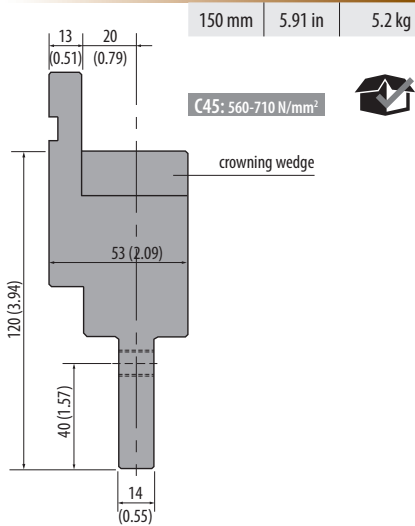
**INT100 FISSO** 1000 kN/m max.



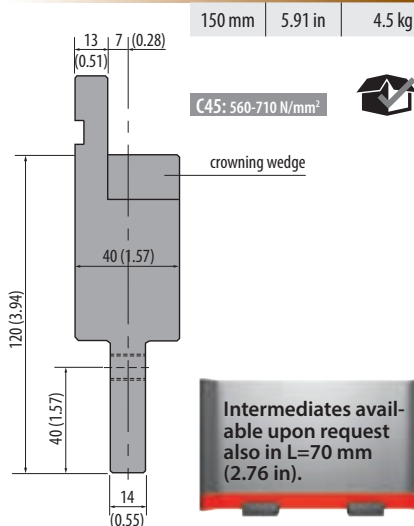
**INT100** 1000 kN/m max.



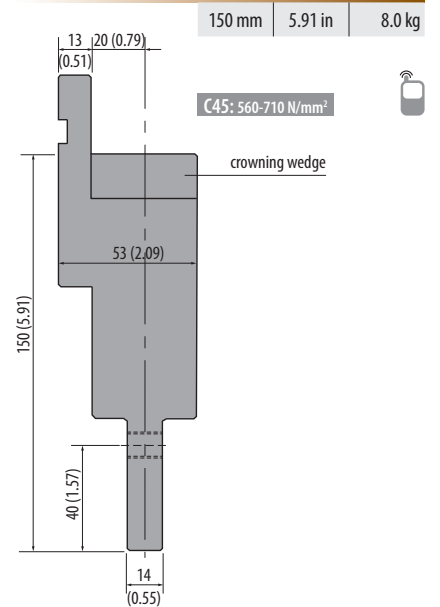
**INT120-40** 1000 kN/m max.



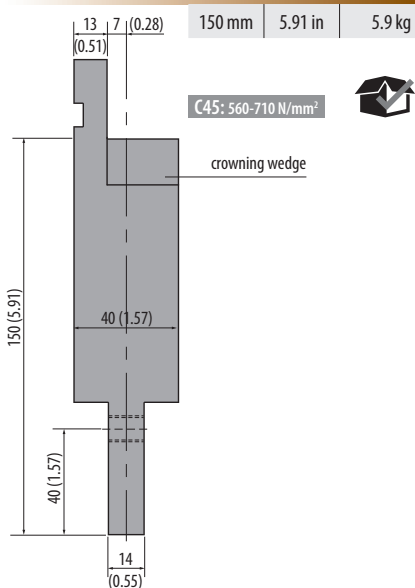
**INT120** 1000 kN/m max.



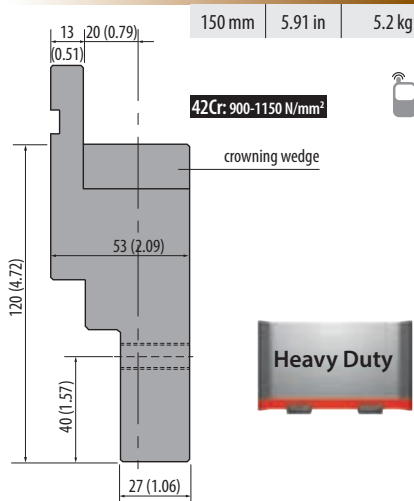
**INT150-40** 1000 kN/m max.



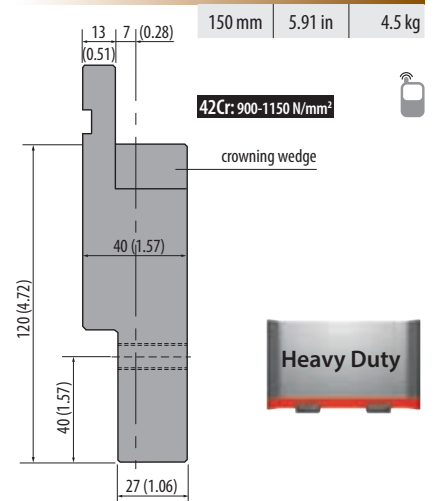
**INT150** 1000 kN/m max.



**INT120-40-HD** 1600 kN/m max.



**INT120-HD** 1600 kN/m max.

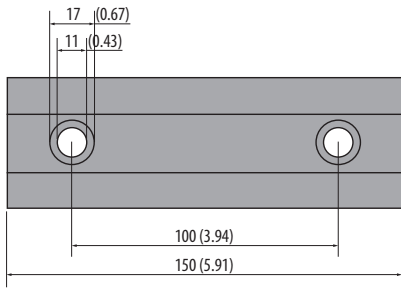


### Our Advantages – Your Convenience

- Rapid Clamping Systems enable fast horizontal tool change.
- Plastic Pressure Strip improves clamping especially with short tool segments.

needed clamps	Length of press brake
4 pieces	835 mm (32.87 in)
6 pieces	1250 mm (49.21 in)
11 pieces	2100 mm (82.68 in)
14 pieces	2600 mm (102.36 in)
16 pieces	3100 mm (122.05 in)
21 pieces	4100 mm (161.42 in)

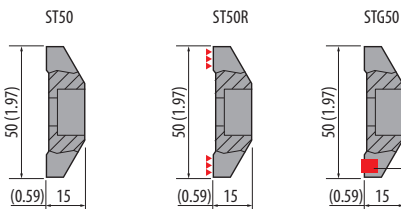
### ST50 / ST50R / STG50



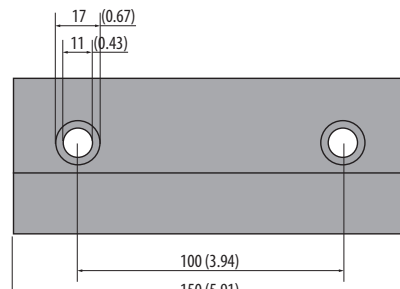
ST50	0.70 kg
ST50R	0.50 kg
STG50	0.70 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm<sup>2</sup>



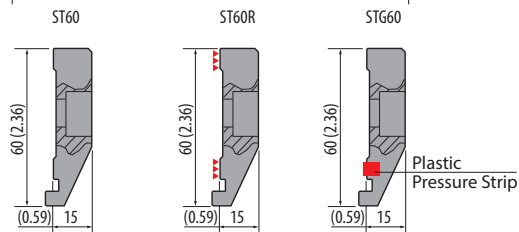
### ST60 / ST60R / STG60



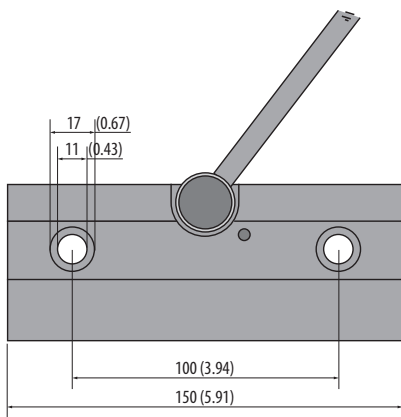
ST60	0.80 kg
ST60R	0.85 kg
STG60	0.80 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm<sup>2</sup>



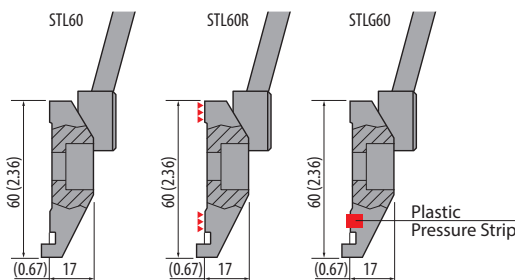
### STL60 / STL60R / STLG60



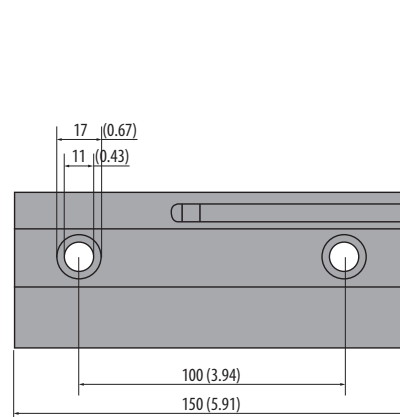
STL60	1.00 kg
STL60R	0.80 kg
STLG60	1.00 kg

L=150 mm (5.91 in)

Fe37: 370-470 N/mm<sup>2</sup>



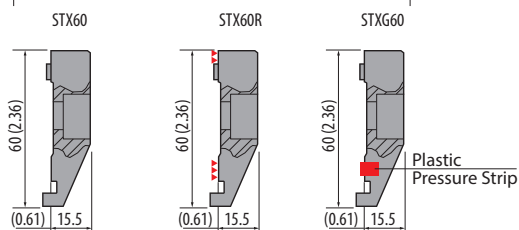
### STX60 / STX60R / STXG60



STX60	0.85 kg
STX60R	0.50 kg
STXG60	1.00 kg

L=150 mm (5.91 in)

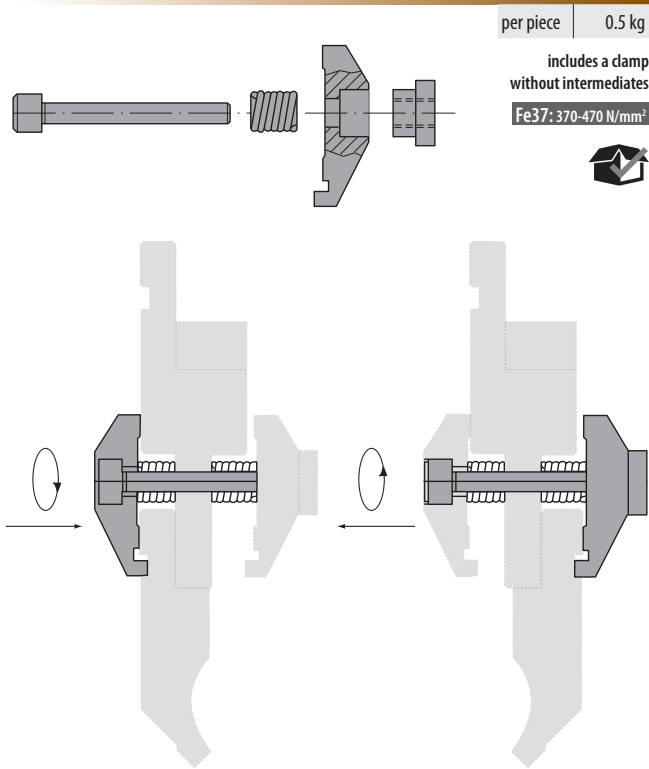
Fe37: 370-470 N/mm<sup>2</sup>



# R1

## ROLLERI CLAMPING SYSTEMS Clamps

### KDS



per piece 0.5 kg

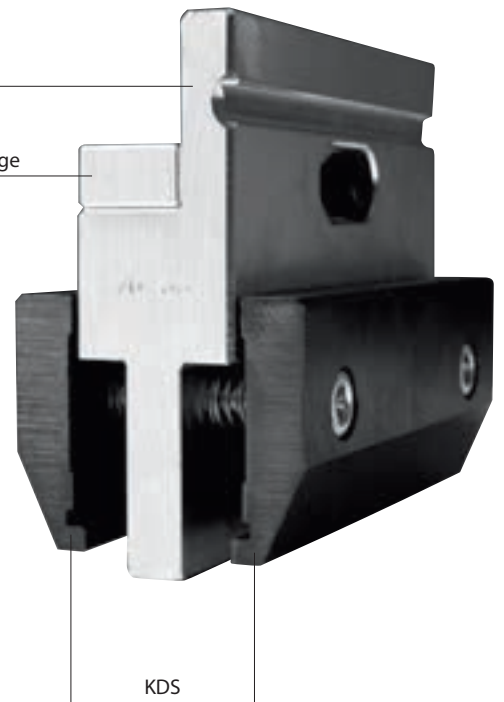
includes a damp  
without intermediates

Fe37: 370-470 N/mm<sup>2</sup>



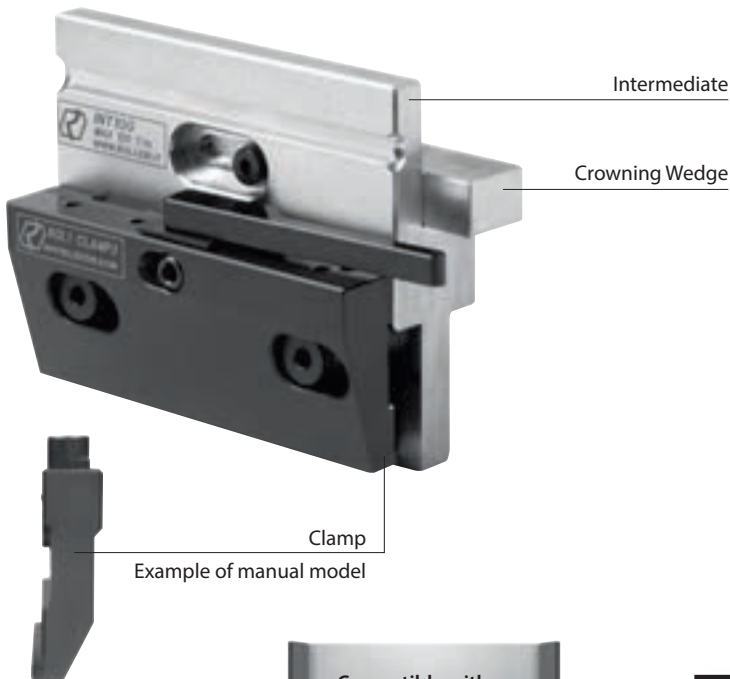
Intermediate

Crowning Wedge



KDS

### ROL1 CLAMP3 – manual – pneumatic



Intermediate

Crowning Wedge



horizontal



horizontal

Model	with Intermediate
<b>ROL1 CLAMP3 manual</b>	<b>INT100</b>
	<b>INT120</b>
	<b>INT150</b>
	<b>INT100 FISSO</b>
	<b>INT120-40</b>

**ROL1 CLAMP3 manual**  
without Intermediate

Model	with Intermediate
<b>ROL1 CLAMP3 pneumatic</b>	<b>INT120</b>
	<b>INT150</b>

L=150 mm (5.91 in)  
horizontal tool change



Including intermediate at your choice

Compatible with  
standard Rolleri R1  
type punches



### Rolleri Videos

Application of Clamping System  
ROL1 CLAMP3: [www.rolleritools.com/  
videos/rol1-clamp3](http://www.rolleritools.com/videos/rol1-clamp3)



### Our Advantages – Your Convenience

- vertical tool change of punches with:
  - ROL1-System
  - QuickLock-System
- Horizontal tool change of punches with safety pins
- Improvement in productivity



### W-ROL PN – pneumatic



515 mm	20.28 in	26.8 kg/m
1050 mm	41.34 in	53.6 kg/m
2100 mm	82.68 in	107.2 kg/m
2500 mm	98.43 in	134.0 kg/m
3100 mm	122.05 in	160.8 kg/m
4100 mm	161.42 in	214.4 kg/m



Article on stock



Please ask for delivery time!

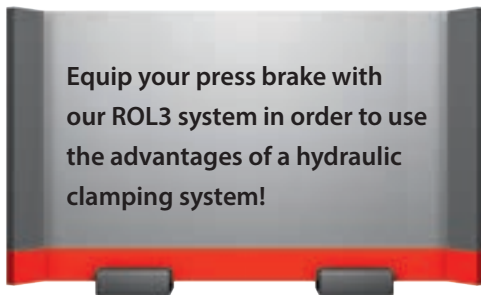
1 kg = 2.20 Pounds (lb) = 35.27 Ounces (oz)  
100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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

### ROL3 HYD – hydraulic

500 mm    19.68 in

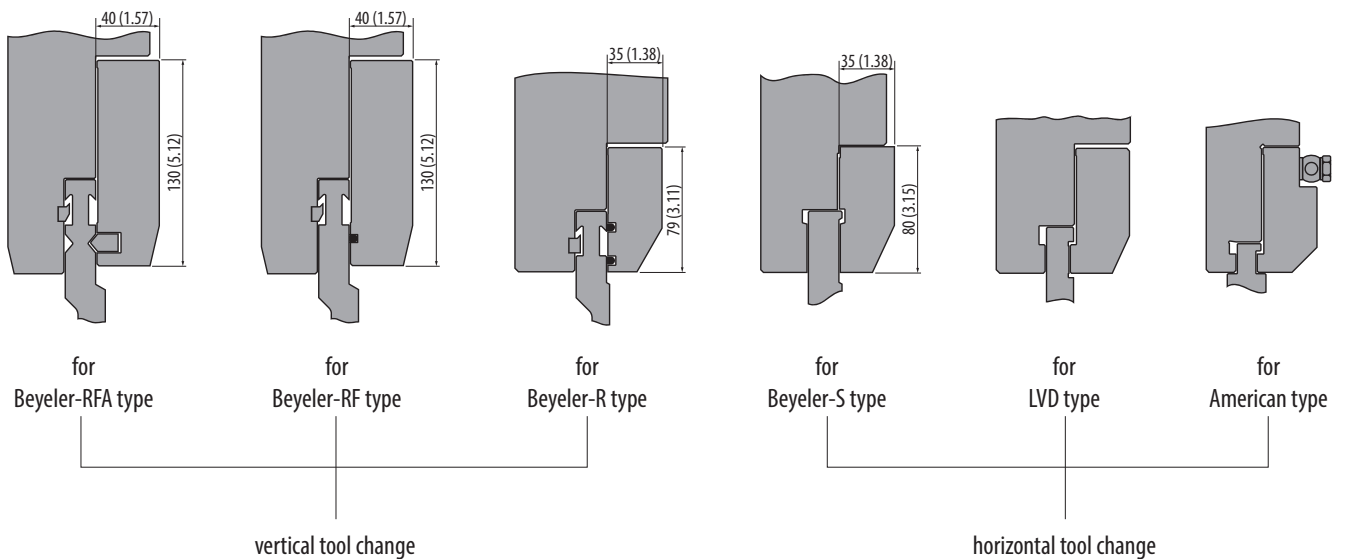


### Our Advantages – Your Convenience

- can be used on press brakes with different tang types
- possible customization upon request
- improvement in productivity



### Examples of ROL3 with various systems



### ■ Explanation

Rolleri crowning tables provide mechanical compensation to the deflections occurring during the bending process. Deflection depends on bending length and on ratio between sheet metal thickness and die opening.

This system is composed by a special rod, which is placed between opposite wedges. Each wedge can be calibrated autonomously to compensate localized deflection. The rod can be manually driven or by a motoreducer controlled by the press brake CNC.

The adjustment of the crowning table is a fast and accurate procedure to carry out before bending.

The crowning table is produced according to the press brake features to optimize its working and its integration to the press brake it is installed in. Rolleri crowning table can be designed to clamp R1 dies with 60mm and 90mm base or R2 dies with 13mm tang and it's supplied with all accessories necessary to mount and align it to the upper beam.


On request, Rolleri crowning table can be equipped with pneumatic clamping systems for lower tools.

### ■ Our Advantages – Your Convenience

- You can adjust deflection of the whole length of the press brake or just a short section thanks to independent wedges
- Very precise bending angles
- R1 type dies with 60 mm and 90 mm base can be clamped as well as R2 dies with 13 mm tang
- Automatic crowning through connection to press brake CNC or manual crowning with a handle
- This crowning table can be installed in new press brakes or to retrofit old press brakes
- Precise positioning and alignment of the crowning table onto the press brake table
- Easy and fast usage


**NEW**

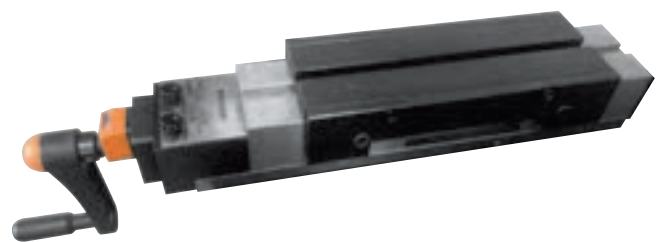
### ROL TM R1 – manual

Model	Length		for dies <b>Rolleri Type R1</b>
<b>ROL TM R1</b>	1100 mm	43,31 in	<b>NEW</b> 
	2100 mm	82,68 in	
	3100 mm	122,05 in	
	4100 mm	161,42 in	




### ROL TM R2 – manual

Model	Length		for dies <b>Rolleri Type R2</b>
<b>ROL TM R2</b>	1100 mm	43,31 in	<b>NEW</b> 
	2100 mm	82,68 in	
	3100 mm	122,05 in	
	4100 mm	161,42 in	



### ROL TA R1 – automatic

Model	Length		for dies <b>Rolleri Type R1</b>
<b>ROL TA R1</b>	1100 mm	43,31 in	<b>NEW</b> 
	2100 mm	82,68 in	
	3100 mm	122,05 in	
	4100 mm	161,42 in	



Article on stock



Please ask for delivery time!

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



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

### ■ Explanations

The **ROL2 System** is a system which is used to secure the die into place. Such system is available in manual, pneumatic and hydraulic version. The manual version is composed of a special clamp (known as **ROL2 CLAMP1**), which is operated with a central lever.

The **ROL2 System** has a built in spring mechanism which opens and closes the **ROL2 CLAMP1** to clamp and release dies.

A special rubber insert inside the clamp plates guarantees the best positioning for the tools. The press force of the clamp plates is evenly distributed along the complete length. Therefore short tools are also securely fastened.

For example, in a 3 m (118.11 in) press brake all dies are secured with 6 simple hand movements.

Rolleri new **ROL2 pneumatic system** is composed of pneumatic clamps L=150 mm (5.91 in) which are activated by a pneumatic driving unit or by the CNC of the press brake.

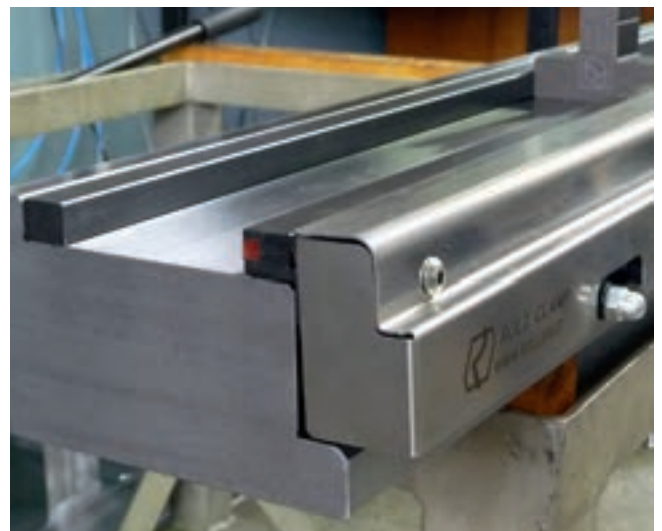
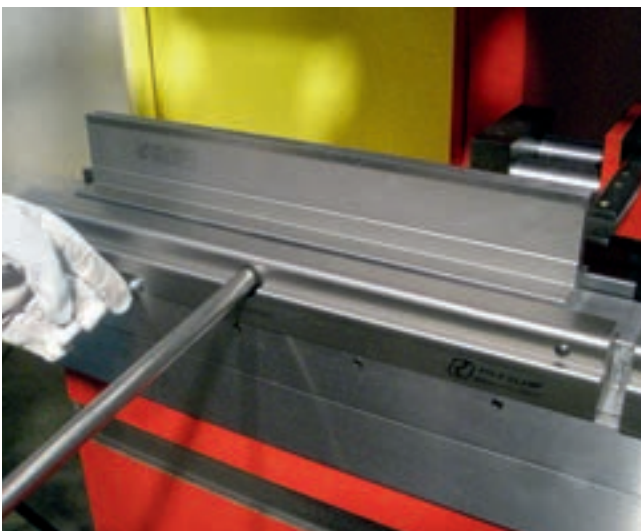
The new design has bigger clamping force and therefore it enables perfect clamping of small segments too.

### ■ Our Advantages – Your Convenience

- fast tool change
- time-saving system
- reduced production costs
- significantly increased profitability
- improved competitiveness

### ■ Application

- **Directly on a 60 mm / 2.36 in wide press brake table**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - in alternative, modification of the existing threaded holes may be necessary
  - system is compatible with press brakes with automatic crowning tables
- **Directly on a 90 mm / 3.54 in wide press brake table**
  - use of existing holes for the standard clamp plates (hole distance 100 mm / 3.94 in)
  - in alternative, modification of the existing threaded holes may be necessary
  - to use Rolleri R1 type dies with 60 mm / 2.36 in base, two ground 15 mm / 0.59 in wide shims are supplied to be inserted into the die holder and secured with pins
  - thanks to the rubber inserts, short die segments are perfectly clamped
- **With Die Holder**
  - 60 x 40 mm / 2.36 x 1.57 in die holder, ground and induction hardened.



#### ROL2 – manual

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	38.0 kg	table: 60 mm	2.36 in	4.0 kg
table: 90 mm	3.54 in	58.0 kg	table: 90 mm	3.54 in	4.5 kg

L=42.32 in



L=19.69 in



#### ROL2 – hydraulic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	5.0 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	5.5 kg

L=42.32 in



L=19.69 in



**NEW**

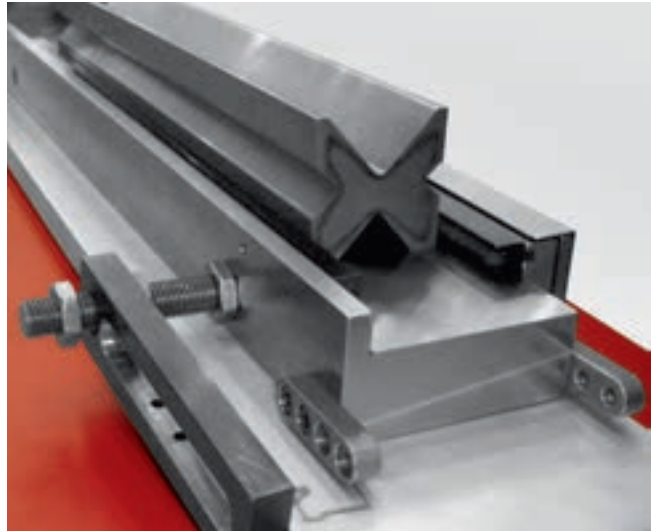
#### ROL2 – pneumatic

Clamp incl. Die holder			only Clamp		
table: 60 mm	2.36 in	23.0 kg	table: 60 mm	2.36 in	1.2 kg
table: 90 mm	3.54 in	31.7 kg	table: 90 mm	3.54 in	1.7 kg

L=42.32 in



L=19.69 in



### Movable Clamps for Dies

#### Our Advantages – Your Convenience

- lowerable clamping plate
- significantly easier tool change, thanks to the possibility of removing the tool by sliding it out and not lifting it



#### Rolleri Videos

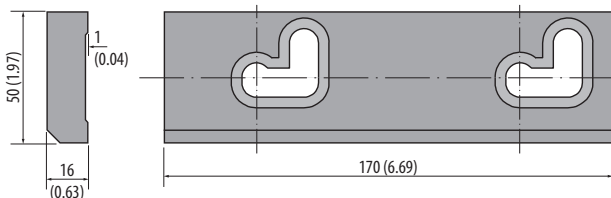
movable die ST50-S:  
[www.rolleritools.com/videos/movable-die-holders](http://www.rolleritools.com/videos/movable-die-holders)



#### ST50-S

per piece 0.70 kg

Fe37: 370-470 N/mm<sup>2</sup>



Article on stock



Please ask for delivery time!

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100 mm = 3.94 Inch (in) = 0.33 Feet (ft)



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