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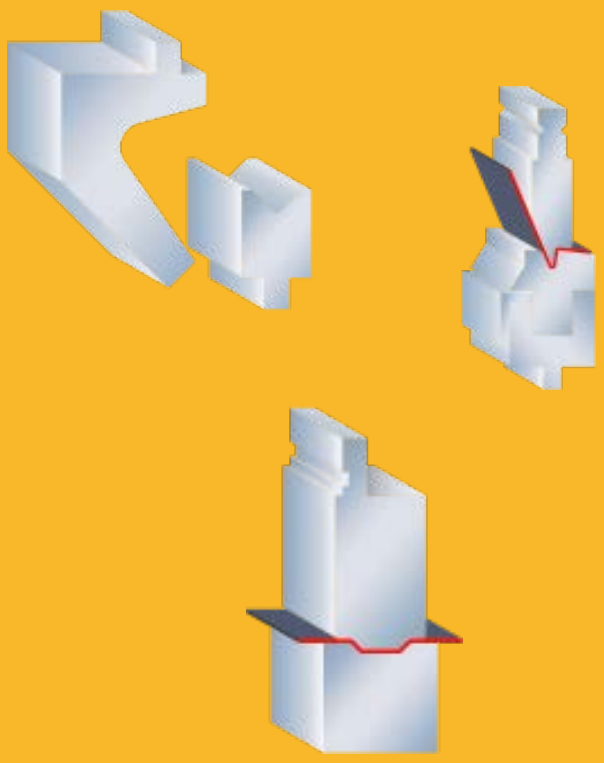
Find out how our attention to details forms the basis for your success.



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R-K Press Brake Dies, Inc.

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For more than 30 years, leading sheet metal fabricators have looked to R-K Press Brake Dies for precision die design and tooling. Customers specify our products because we offer the combination of technical expertise, customer service and product performance that exceeds expectations.

You, too, can count on R-K Press to provide the tools that form your success. Here's why:

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- *You'll find that R-K Press creates customer value that goes beyond competitive pricing.*
- *We create effective and cost-efficient customized solutions for special applications.*
- *Unlike most competitors, we have a dedicated team of sales engineers to handle custom requests.*
- *Additionally, our service desk provides ongoing customer support when it's needed.*

Whether you're ready to place an order now or you need advice to handle a more specialized need, contact us.

Let us show you how R-K Press can form the basis for your success.

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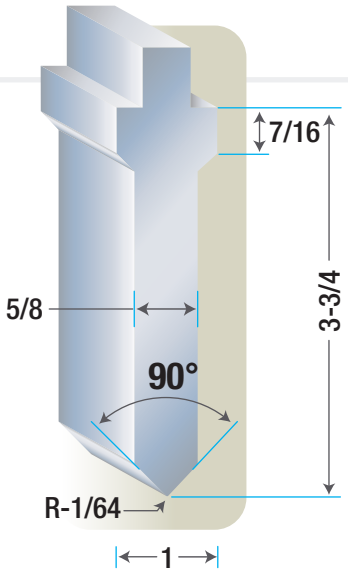
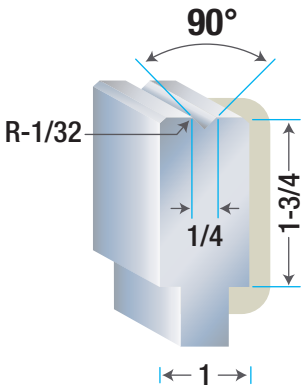
90° Forming Punches and Dies

These punches and dies are the most widely used to form 90° and greater bends. By adjusting the ram, the depth of punch travel can be regulated to produce the desired angle of bend. The U-2 punch is used to form longer return bends; in addition the width of the U-2 punch is narrowed to form a short flange.

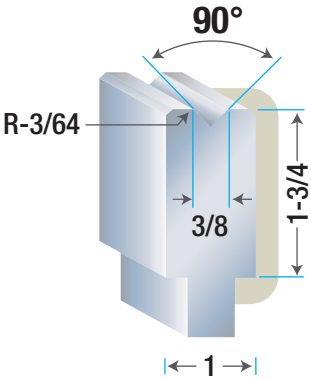
- Punches and dies are available from stock.
- Can be used for air bending or bottom bending.
- Can be modified to a special angle or radius.
- Can be sectionalized to fit your needs.
- Used for forming 10-gauge and lighter material.



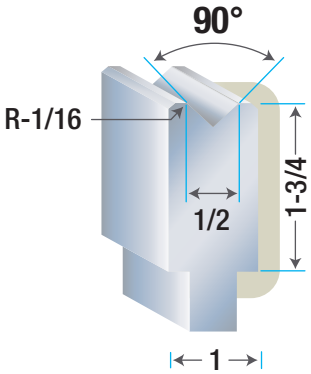
U-2 14 Gauge



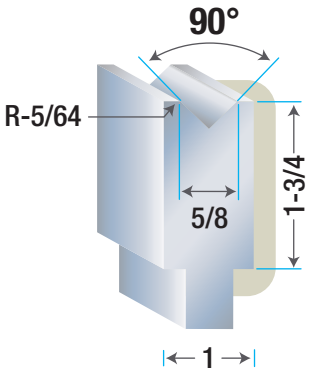
L-2 22 Gauge



L-3 18 Gauge



L-4 16 Gauge



L-5 14 Gauge

R-K Press Brake Dies can provide tooling for any model press brake.

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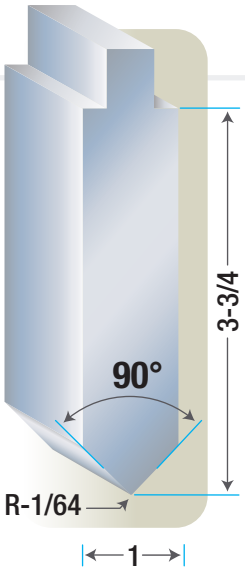
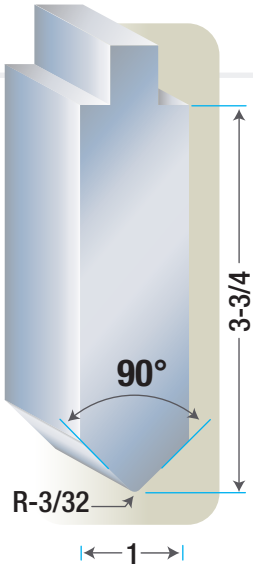
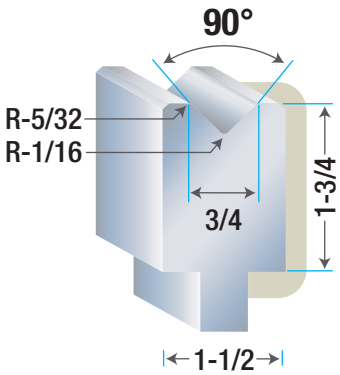


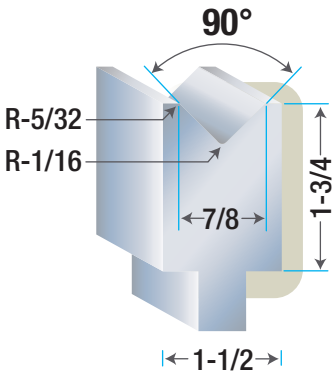
U-3 11 Gauge



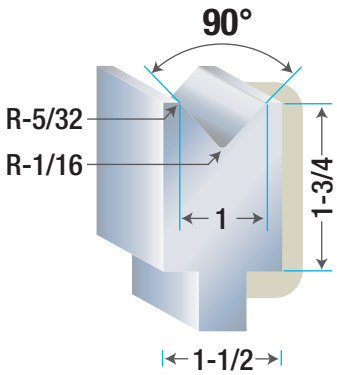
U-4 10 Gauge



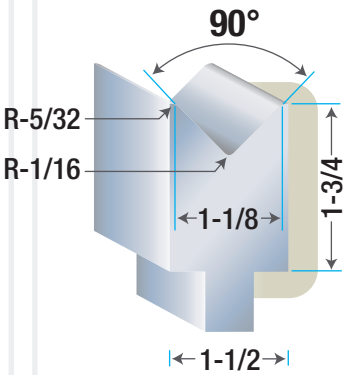
L-6 13 Gauge



L-7 12 Gauge



L-8 11 Gauge

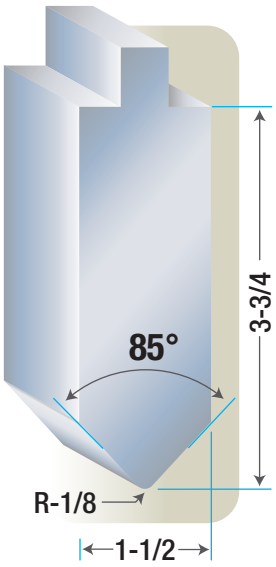


L-9 10 Gauge

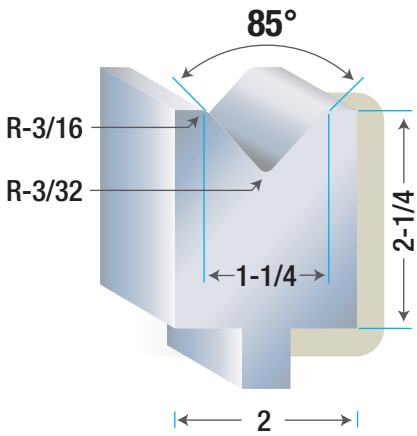
90° Forming Punches and Dies

These punches and dies are used for air bending heavier gauges of material. Air bending will minimize the press brake load and material fracture.

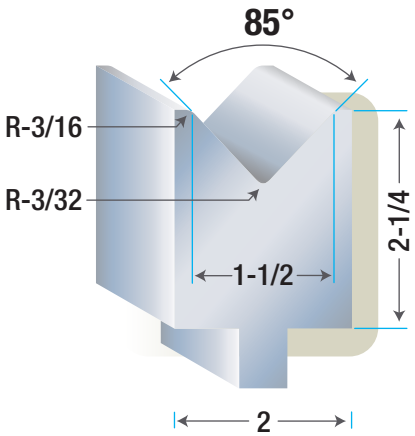
- Punches and dies are available from stock.
- Can be modified to a special angle or radius.
- Can be sectionalized to fit your needs.
- Used for forming 9-gauge and heavier material.



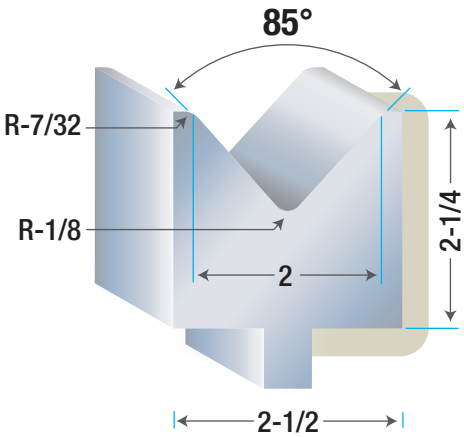
U-5 1/4"



L-10 9 Gauge



L-11 3/16"



L-12 1/4"

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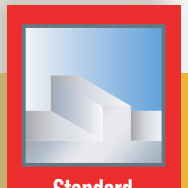
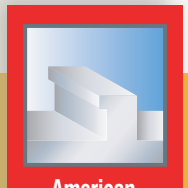
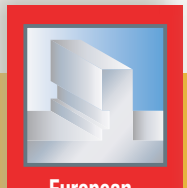
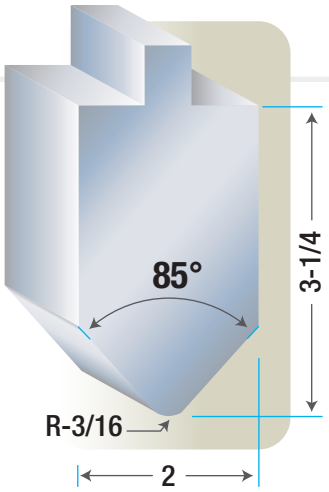

Standard Style Tooling

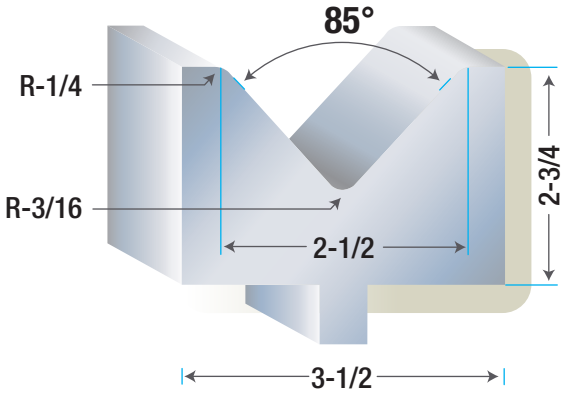

American Style Tooling


European Style Tooling

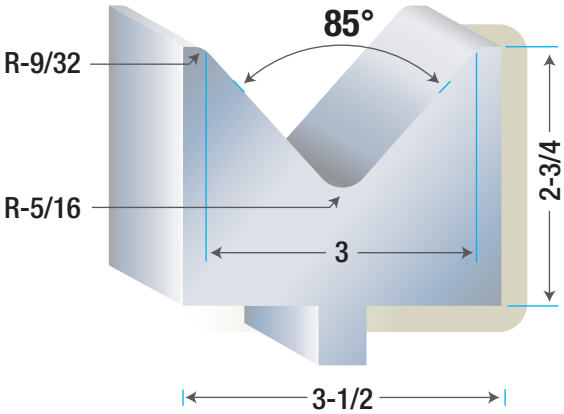
Wila Style Tooling



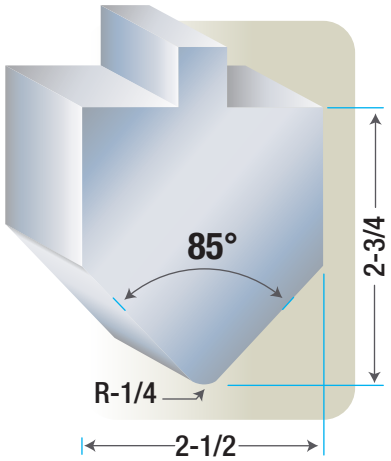
U-6 3/8"



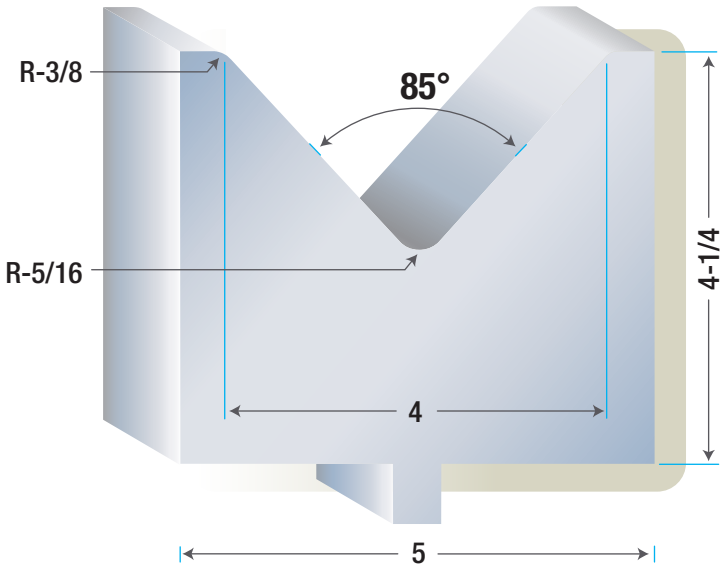
L-13 5/16"



L-14 3/8"



U-7 1/2"



L-15 1/2"

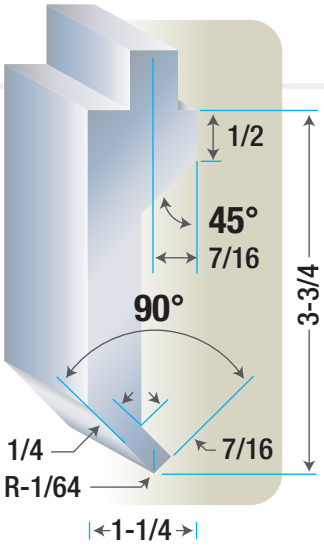
Larger Vee dies available upon request.

Gooseneck Punches

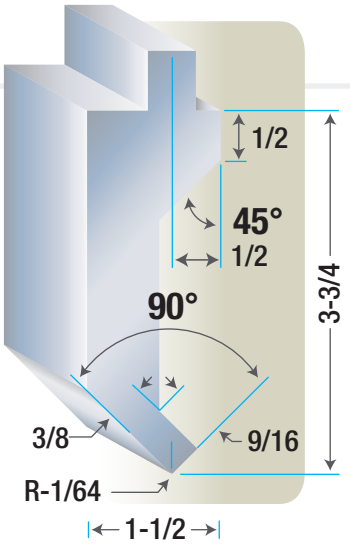
Gooseneck Punches

Gooseneck punches are used to form a channel in two strokes of the press brake. In addition special shapes where 90° punch would interfere can also be formed. The Gooseneck punches G-6, G-7, G-8, G-9 are cut back beyond centerline allowing longer return flanges. Because of the taper on the inside of the Gooseneck the width of the channel must be increased.

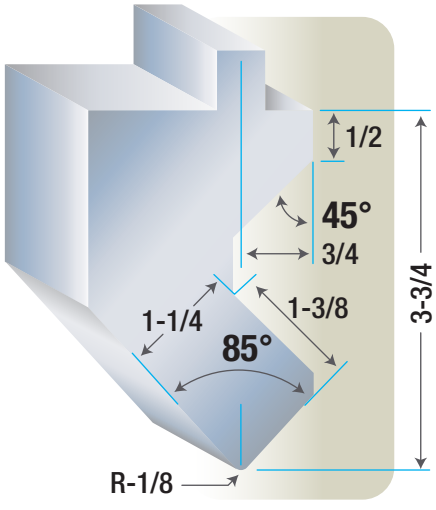
- Punches and dies are available from stock.
- Use to form a channel in two strokes of the press brake.
- Can be used for all air bending or bottom bending.
- Can be modified to a spial angle or radius.
- Can be sectionalized to fit your needs.



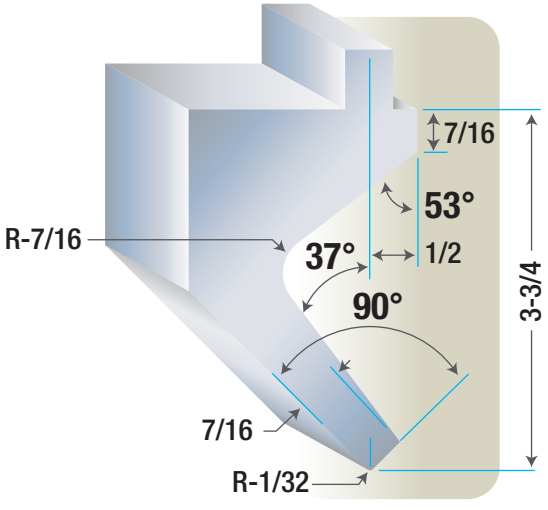
G-1 22 Gauge | L-2



G-2 18 Gauge | L-3, L-4



G-6 3/16" | L-11



G-7 16 Gauge | L-3, L-4

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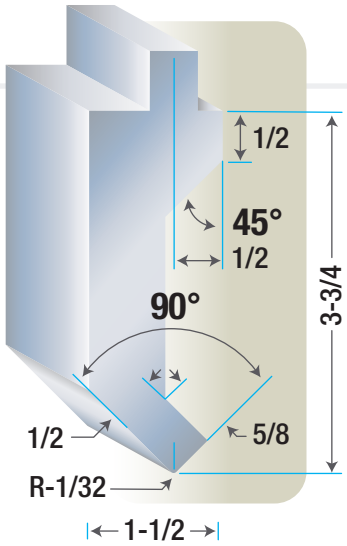
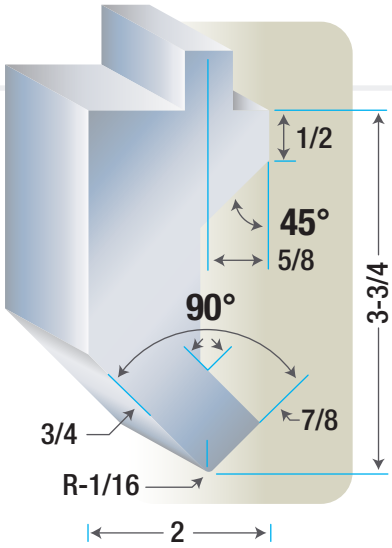
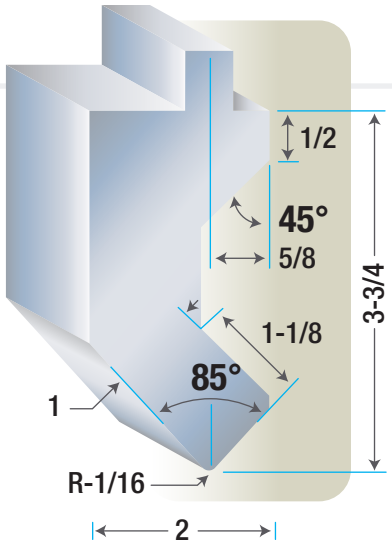


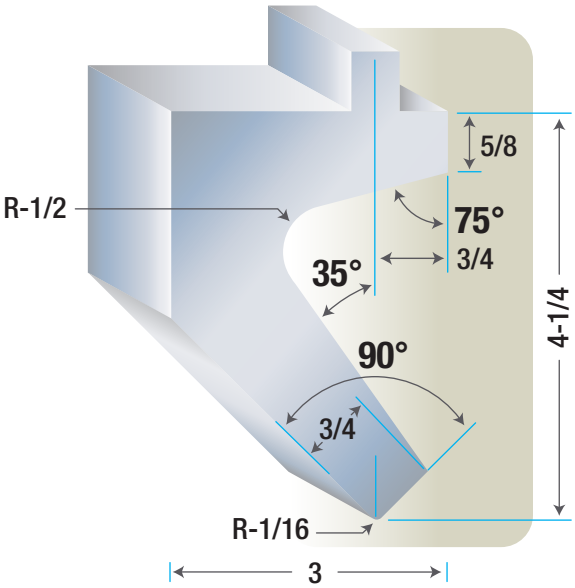
G-3 14 Gauge L-5



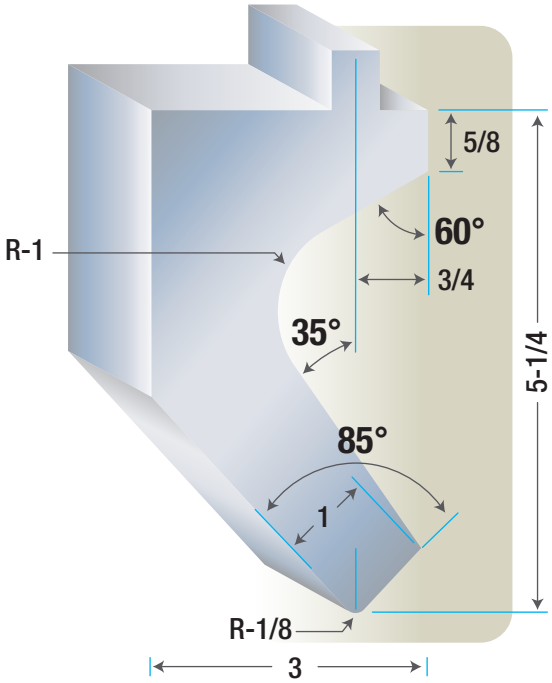
G-4 10 Gauge L-6, L-7, L-8



G-5 9 Gauge L-9, L-10

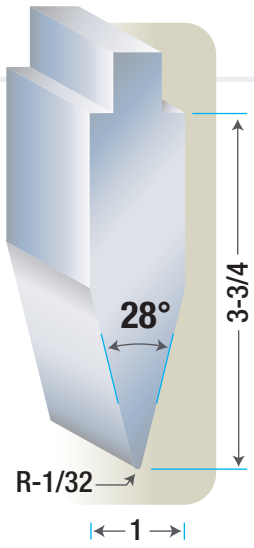


G-8 12 Gauge L-5, L-6, L-7

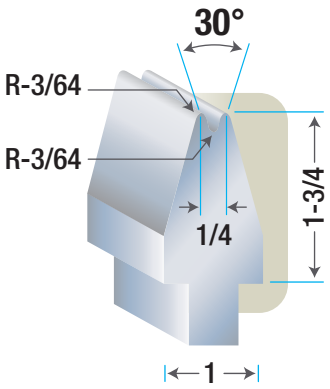


G-9 9 Gauge L-8, L-9, L-10

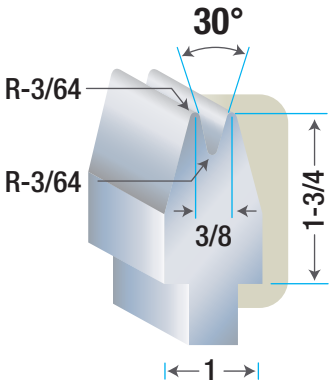
30° Forming Punches and Dies



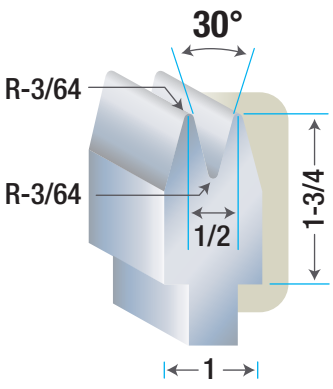
UA-1 16 Gauge



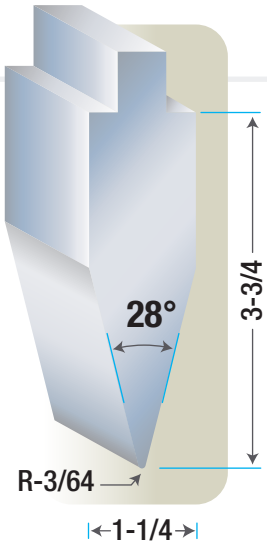
LA-1 22 Gauge



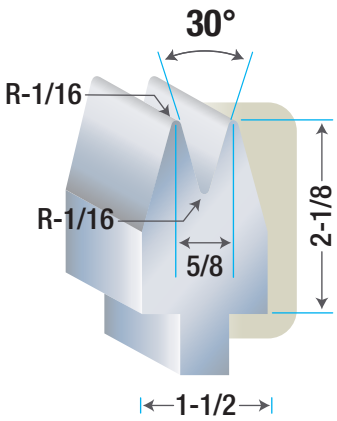
LA-2 18 & 20 Gauge



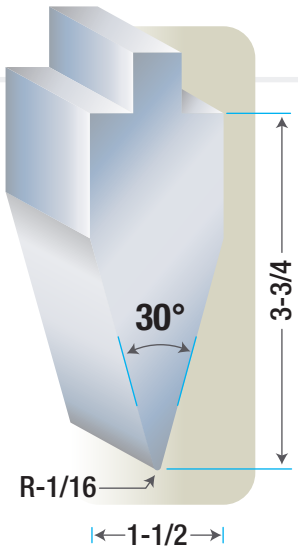
LA-3 16 Gauge



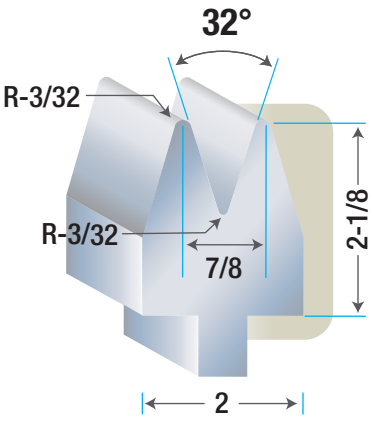
UA-2 14 Gauge



LA-4 14 Gauge



UA-3 12 Gauge



LA-5 12 Gauge

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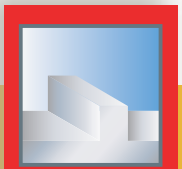
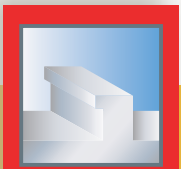
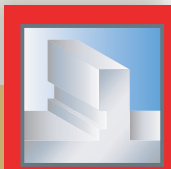

Standard Style Tooling


American Style Tooling


European Style Tooling

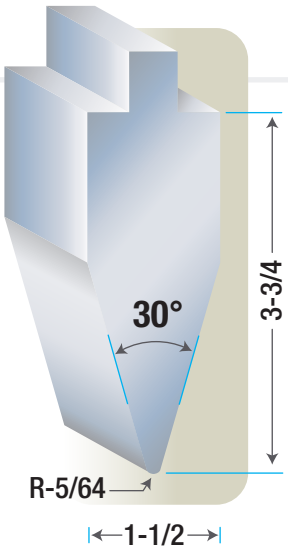
Wila Style Tooling

30° Forming Punches and Dies

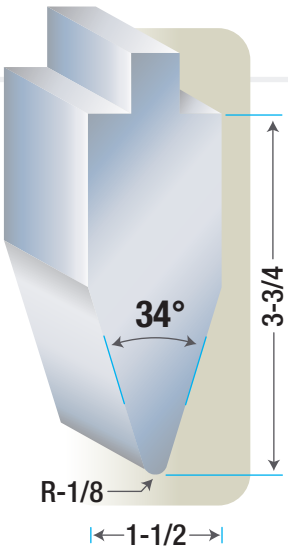
These punches and dies are the most universal type press brake dies. They are ideal for the first step in a hemming operation; furthermore they can be used to air bend any angle greater then 30°.

Finished theses dies with a flat top gives greater strength to the die and allows for additional surface hardening when forming abrasive materials like rod or wire.

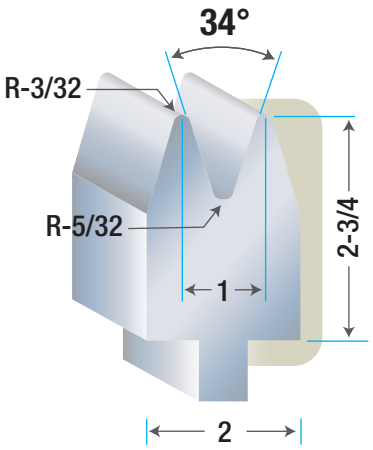
- Punches and dies are available from stock.
- Used to form first operation of a hem.
- Can be used for air bending angles greater than 30°.
- Can be sectionalized to fit your needs.



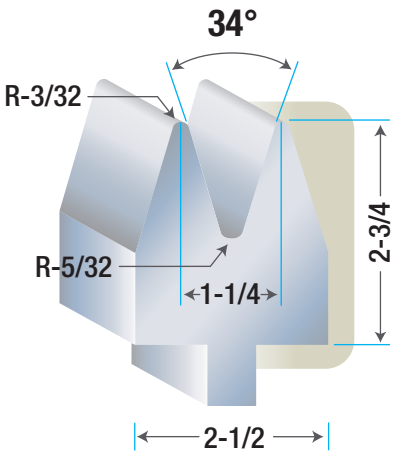
UA-4 10 Gauge



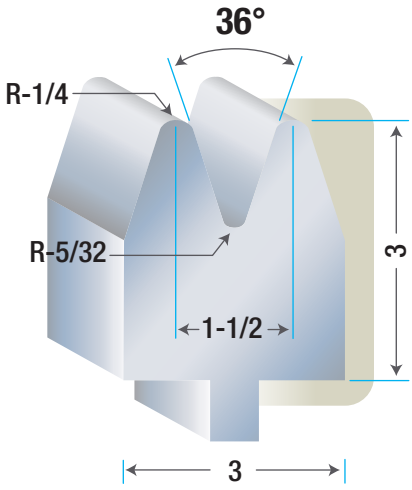
UA-5 3/16"



LA-6 11 Gauge



LA-7 10 Gauge



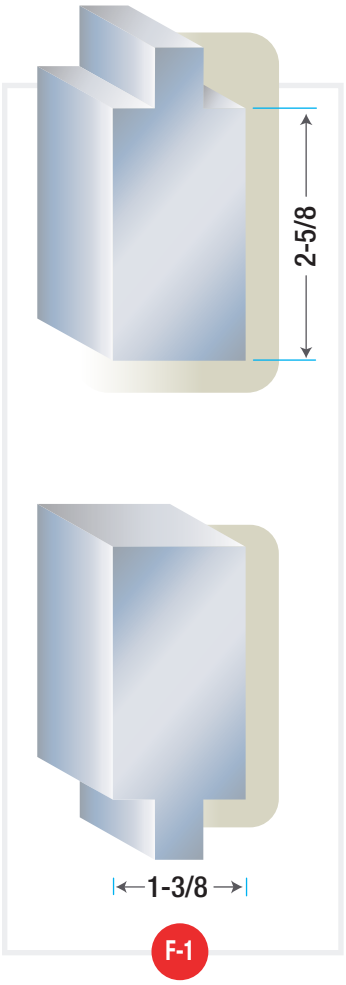
LA-8 3/16"

Flattening Dies

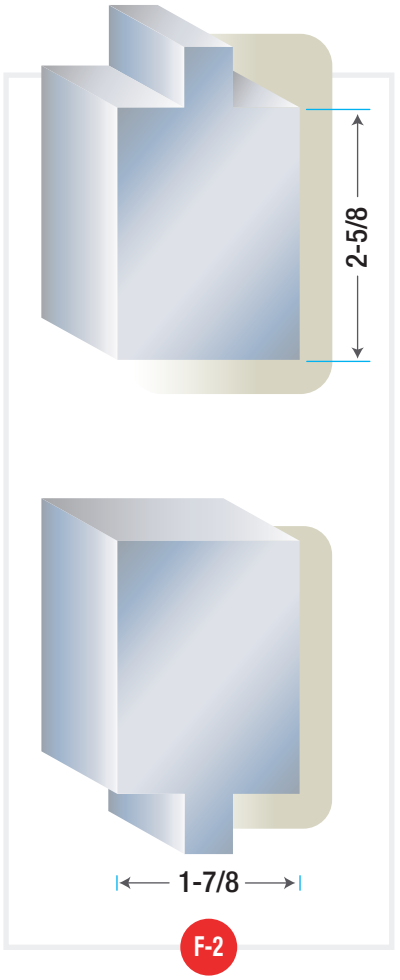
Flattening Dies

Flattening dies are used in the final operation to close a teardrop hem or crused hem.

- Punches and dies are available from stock.
- Used to form an open or closed hem.
- Used to close a standing seam.
- Can be sectionalized to fit your needs.



F-1



F-2

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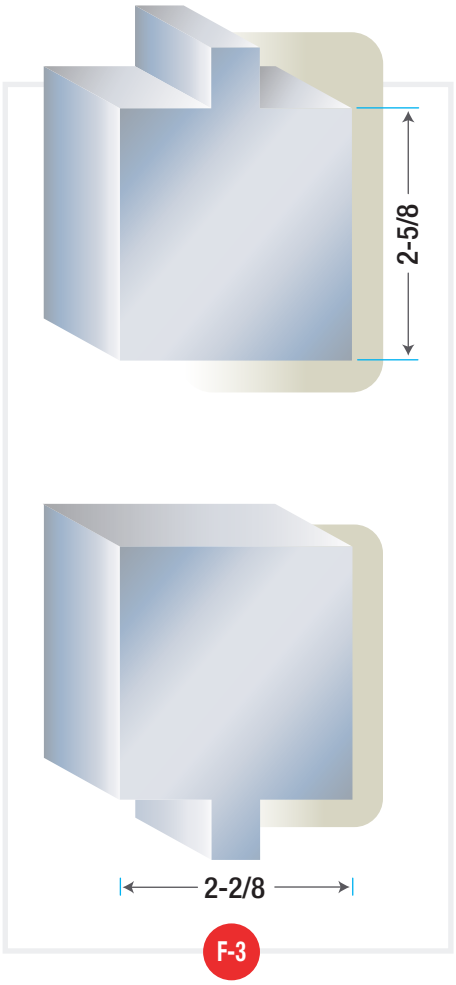

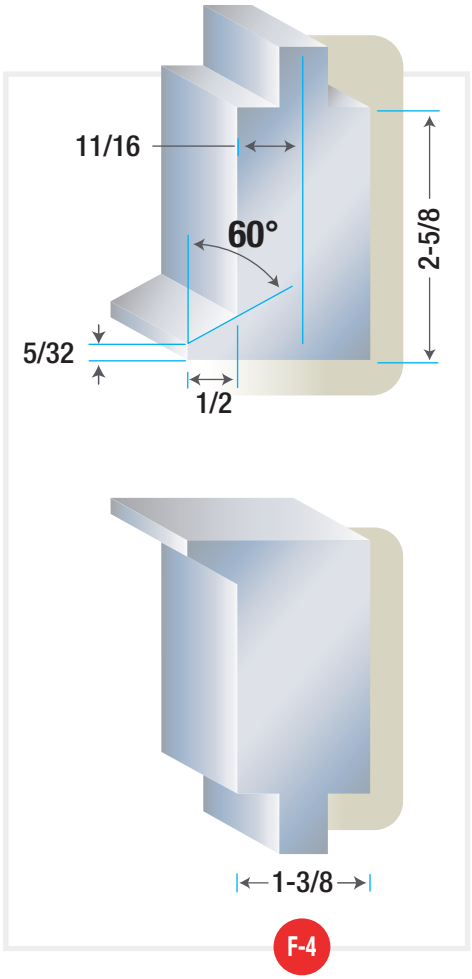

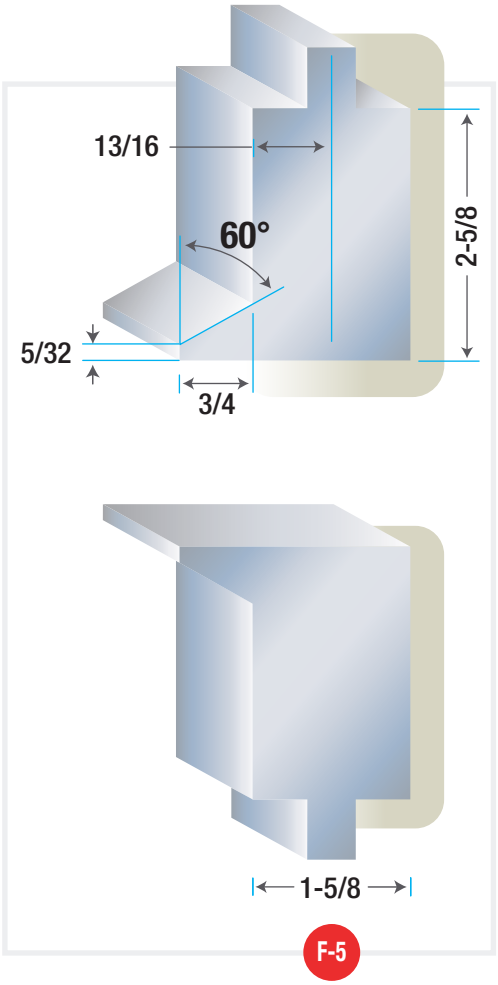

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We deliver even more:

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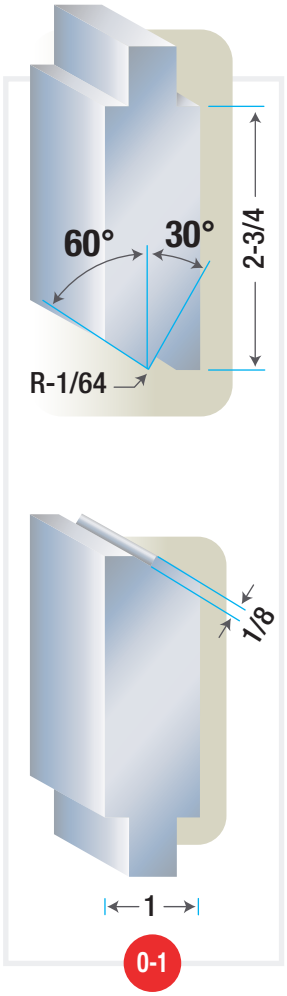
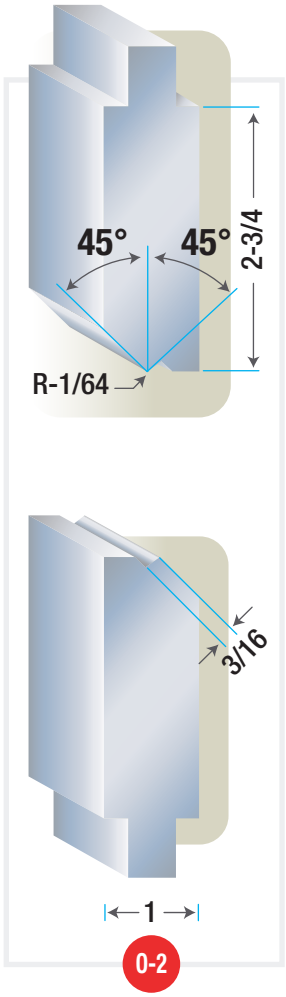
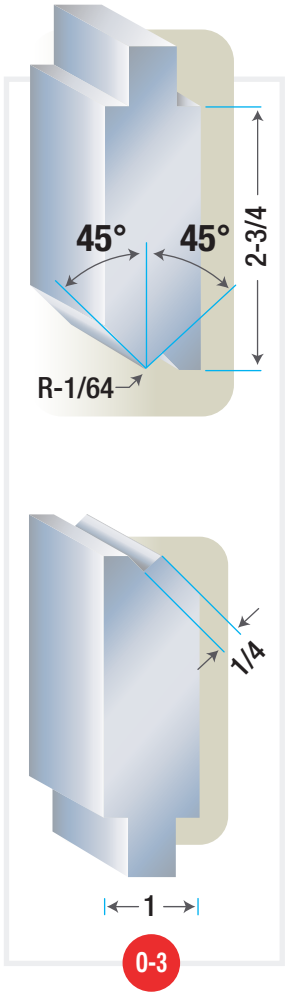
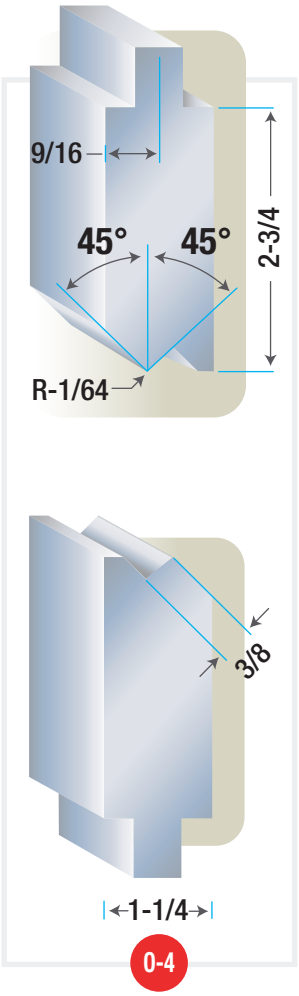
- *30-foot capacity machines*
- *Fast & personal technical assistance*
- *Immediate availability on standard sets*
- *Customized solutions for special applications*
- *Large inventory of standard and specialized American punches and dies*
- *Specialized European and Wila style tooling*
- *Reliable delivery you can count on every time*

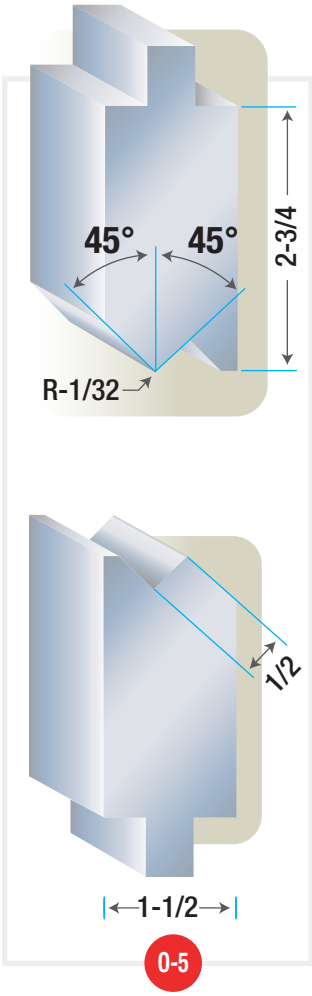
Offset Forming Dies











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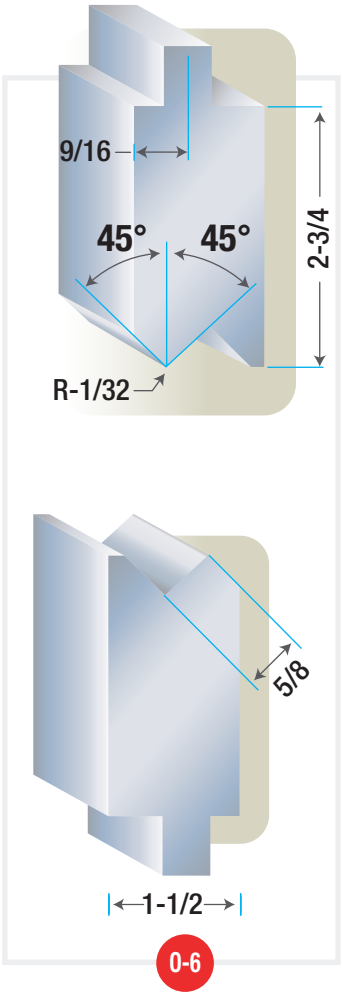
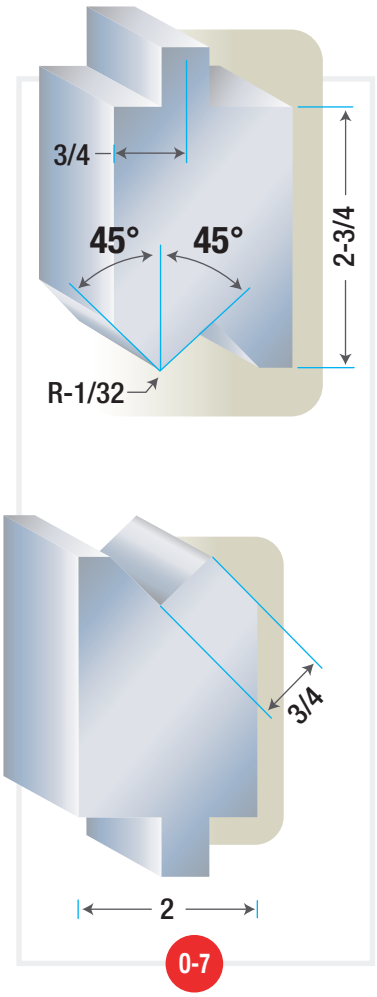
Standard Style Tooling

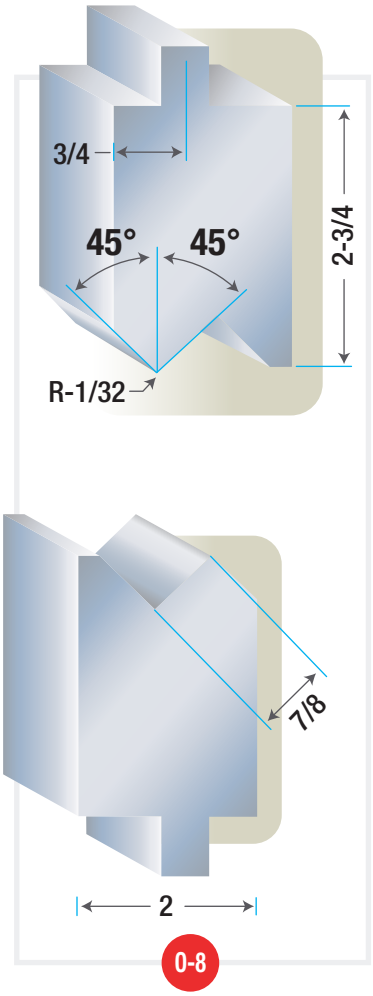
American Style Tooling

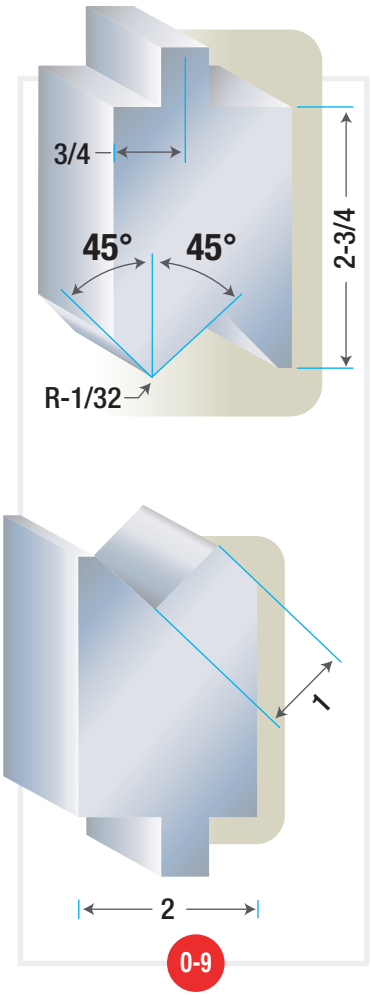
European Style Tooling

Wila Style Tooling







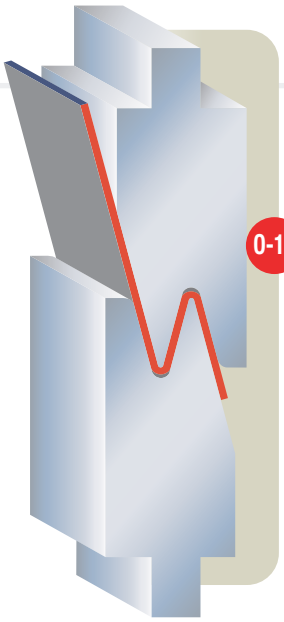


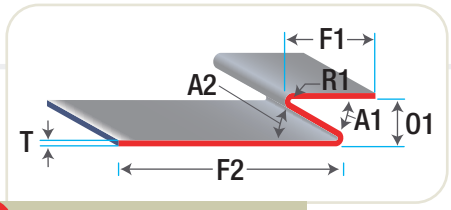
Offset Forming Die Sets

These offset die sets are used to form two bends in one stroke in 16-gauge and lighter material. If press brake capacity permits heavier gauges of material can be formed.

- Die sets available form stock.
- Can be used for air bending or bottom bending.

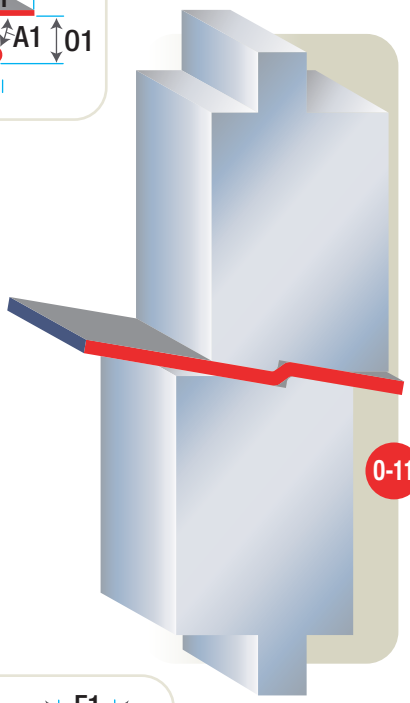
Offset Forming Dies

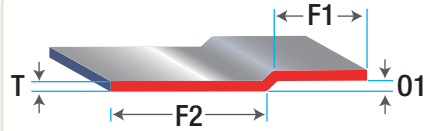




0-10 Acute Offset Die Set

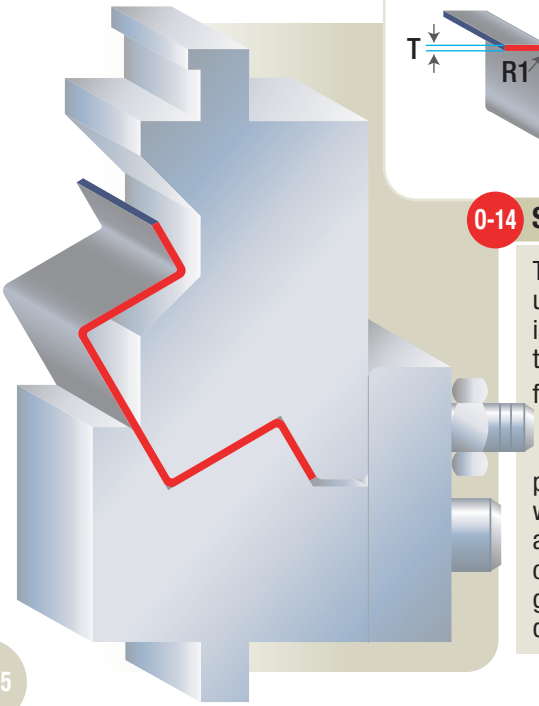
The 0-10 die set is used to form an acute-angle offset in one stroke. Whip-up should be a consideration so the sheet does not hit the ram of the press brake.

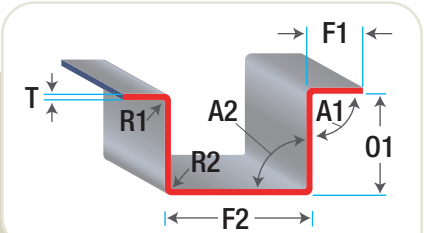




0-11 Material Thickness Offset Die Set

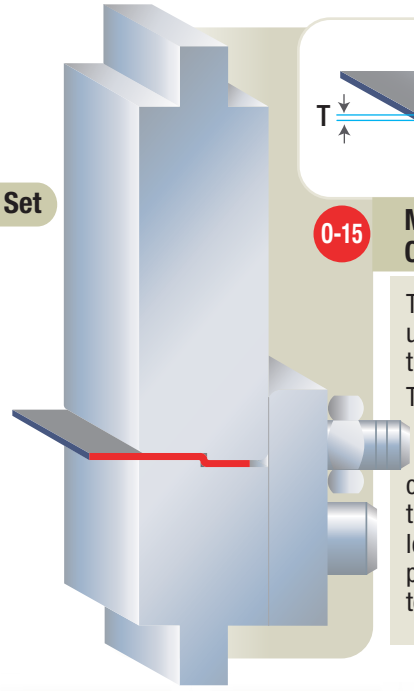
The 0-11 die set is used to form a material thickness offset. In addition large radii and additional clearance help keep tonnage requirements to a minimum.

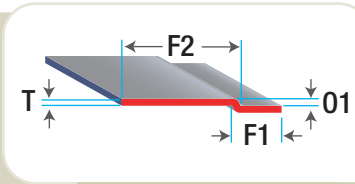




0-14 Shorter Flange Offset Die Set

The 0-14 die set is used when the flange is considerable shorter than the offset being formed. The forming angle is tipped to reduce size of Vee opening and prevent bowing of offset web. The gauging is more accurate with this type of die set rather than the general purpose offset dies.





0-15 Material Thickness Offset Die Set

The 0-15 die set is used to form a material thickness offset.

The leader on the back side of the die limits the distance of the offset form the edge of the sheet; however the leader is needed to prevent spreading and to keep the dies in line.

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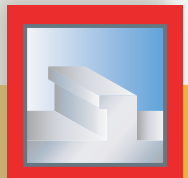
Standard Style Tooling

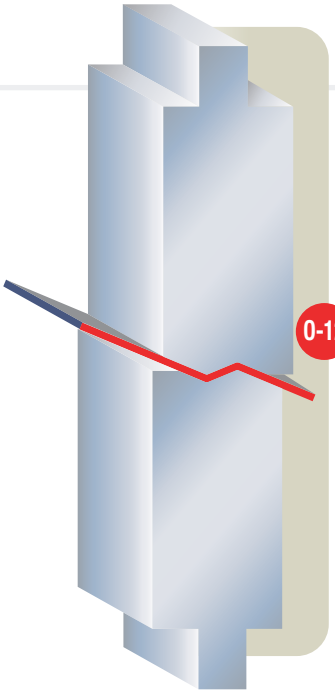

American Style Tooling

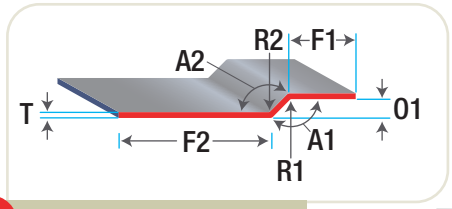
European Style Tooling

Wila Style Tooling

Ledger

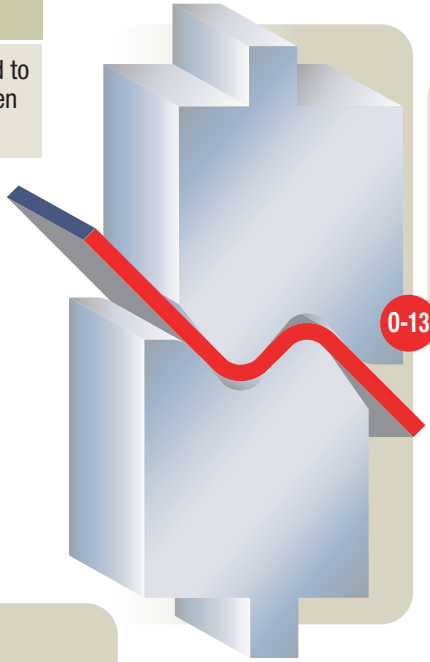
Radius (R1): _____
Radius (R2): _____
Angel (A1): _____
Flange (F1): _____
Flange (F2): _____
Offset (O1): _____
Width (W1): _____
Material Thickness (T): _____
Length of Bend (L): _____

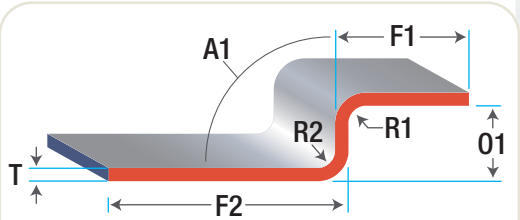




0-12 Open Angle Die Set

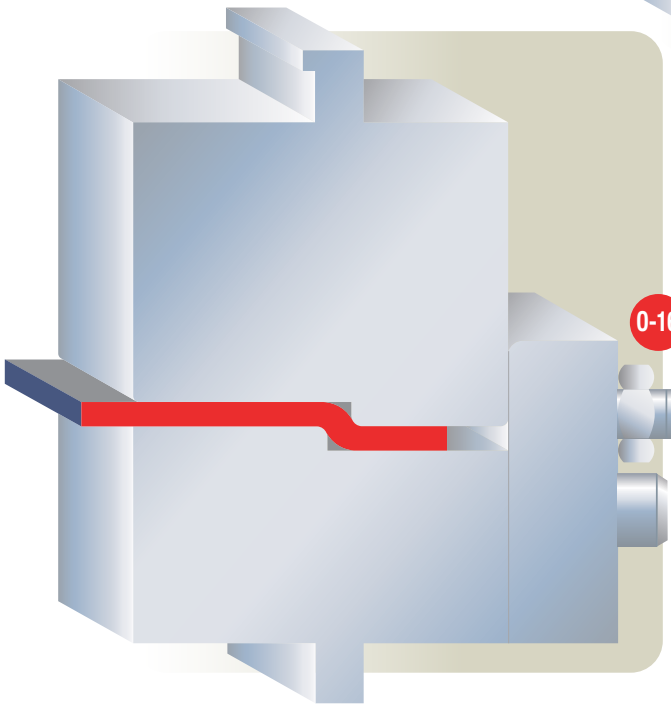
The 0-12 die set is used to bottom bend special open angle offsets.

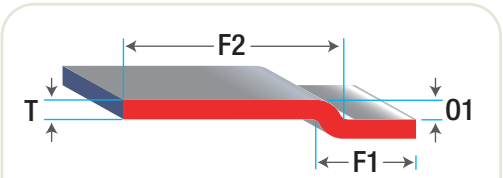




0-13 Air Bend Offset Die Set

The 0-13 die set is used to air bend a special offset when tonnage capacity is a problem. Air forming, however, will not give the accuracy of shape that comes from bottoming dies.

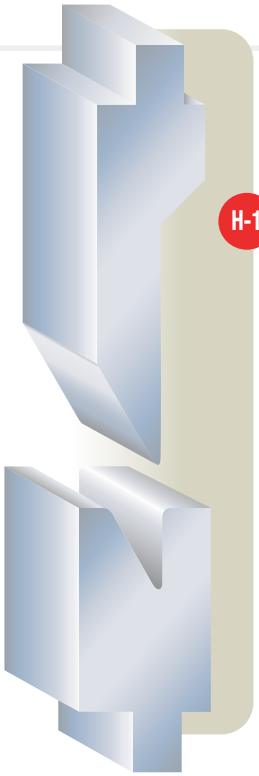




0-16 Material Thickness Offset Die Set

The 0-16 die set is used to form a material thickness offset in heavy gauge material. The offset will be open angle because the outside radii are too large for the depth of the offset.

Hemming Dies



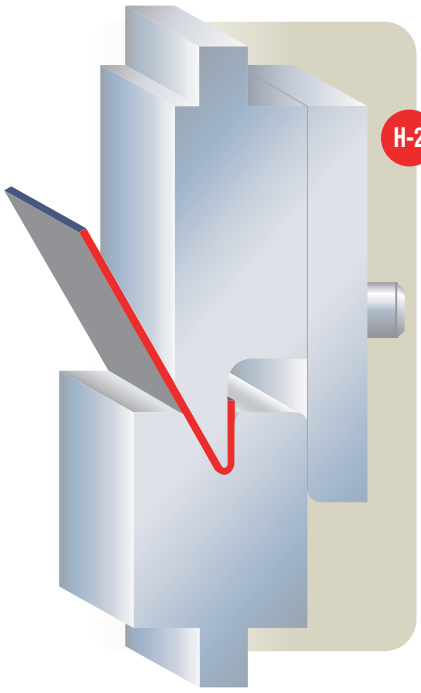
H-1 Hemming Die Set

Is a low cost hemming die set that forms a teardrop or an open hem in a single handling without die change or adjustment.

The greatest length of fold-over is 2 inches. In the closing operation, the material must be tilted and held high enough in the die to enable the punch point to pass the bend edge formed previously.

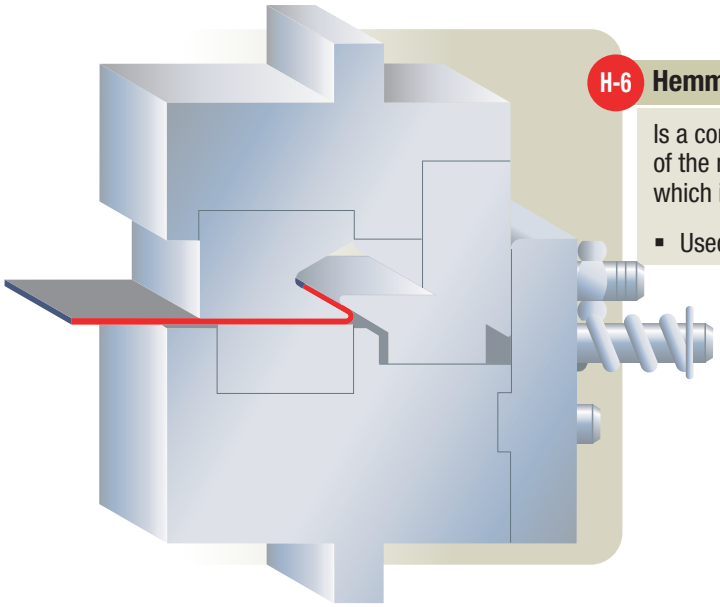
A slight bow in the length of the sheet can be anticipated.

- Used for 18-gauge and lighter material.



H-2 Hemming Die Set

- Used for 16-gauge and heavier material.



H-6 Hemming Die Set

Is a combination set that eliminates whip-up of the material. This curbs operator fatigue which is an important safety fac tor.

- Used for 18-gauge and lighter material.

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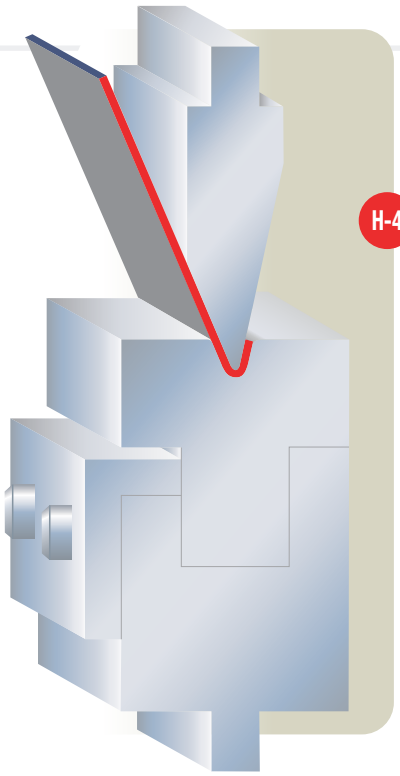
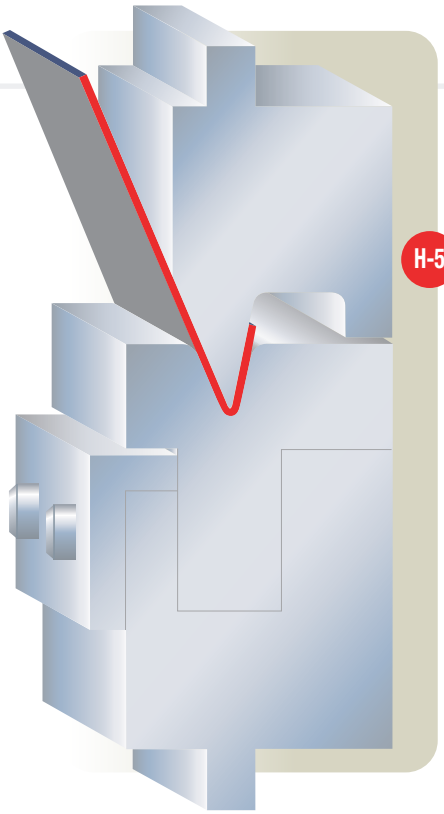


H-4 Hemming Die Set

The H-4 hemming die set bends an acute angle in the upper level and closes the hem in the lower level. The closing operation may be shimmed to form an open or closed hem in 18-gauge and lighter material.

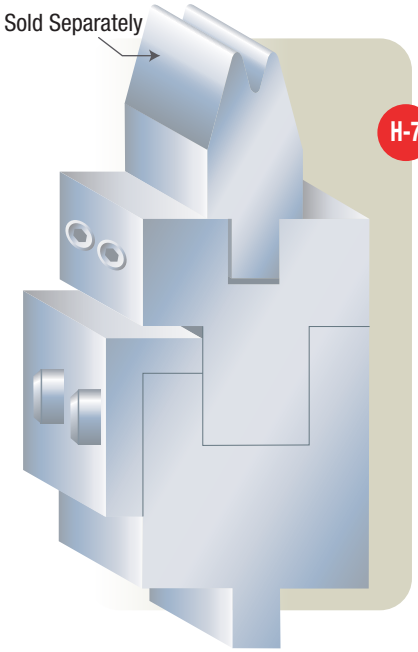
- Used for 18-gauge and lighter material.
- Closing operation is adjustable for forming open or closed hems.



H-5 Hemming Die Set

The H-5 hemming die set bends an acute angle in the upper level and closes the hem in the lower level. The closing operation may be shimmed to form an open or closed hem in 14-gauge and heavier material.

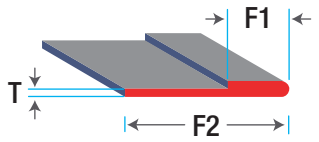
- Used for 14-gauge and heavier material.



H-7 Hemming Die Set

The H-7 die set allows for a standard acute die set to be used as shown for hemming; In addition the middle section can be locked in the closed position emulating a standard die holder.

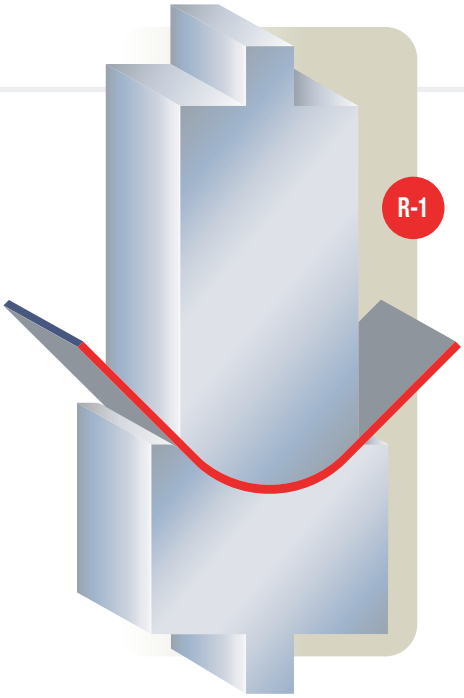
- Closing operation is adjustable for forming open or closed hems.
- The middle section can be locked in the closed position and used as a standard die holder.

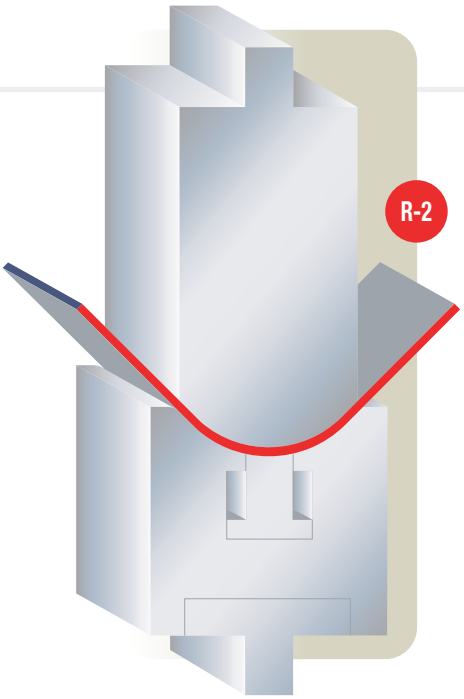


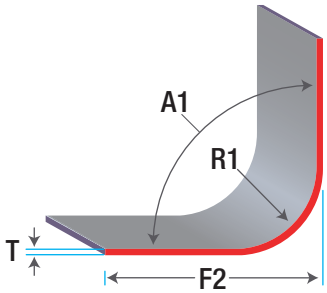
Ledger

Flange (F1): _____
Flange (F2): _____
Material Thickness (T): _____
Length of Bend (L): _____

Radius Dies







R-1 Radius Die Set

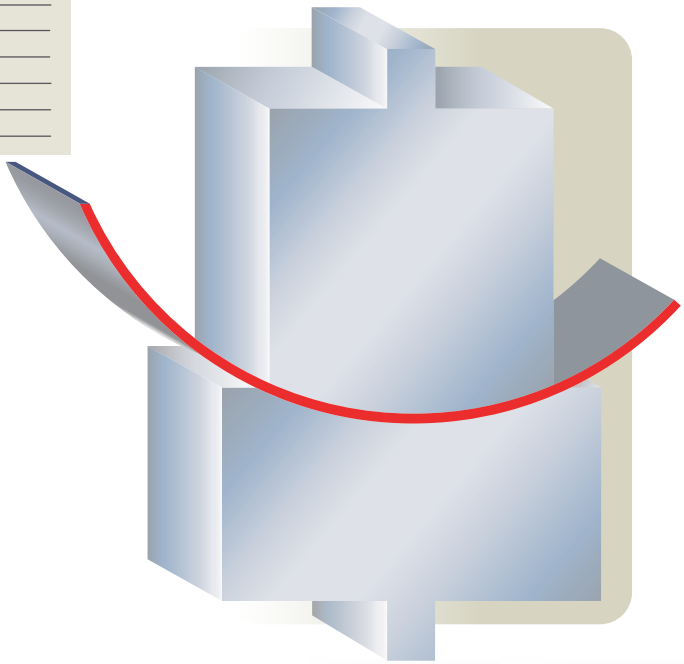
Springback will occur and must be compensated for when a radius exceeds four times the thickness of material being formed. As the radius increases more overbend must be made to get the proper formed radius. Radius die sets are typical fitted for one gauge and type of material.

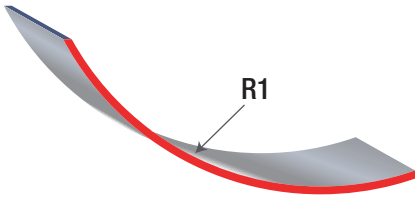
R-2 Radius Die Set

The R-2 contains a spring-pad in the die that keeps kinking to a minimum and offers better results when lighter gauge materials are used.

Ledger

Radius (R1): _____
Radius (R2): _____
Angel (A1): _____
Flange (F1): _____
Flange (F2): _____
Offset (O1): _____
Width (W1): _____
Material Thickness (T): _____
Length of Bend (L): _____





R-5 Bump Form Radius Die Set

The R-5 die set is used for forming a radius starting lip when a rolling process is required. The R-5 die set can also be used to bump different radii in a range of material. By adjusting to distance between bends lager radii can be bump formed.

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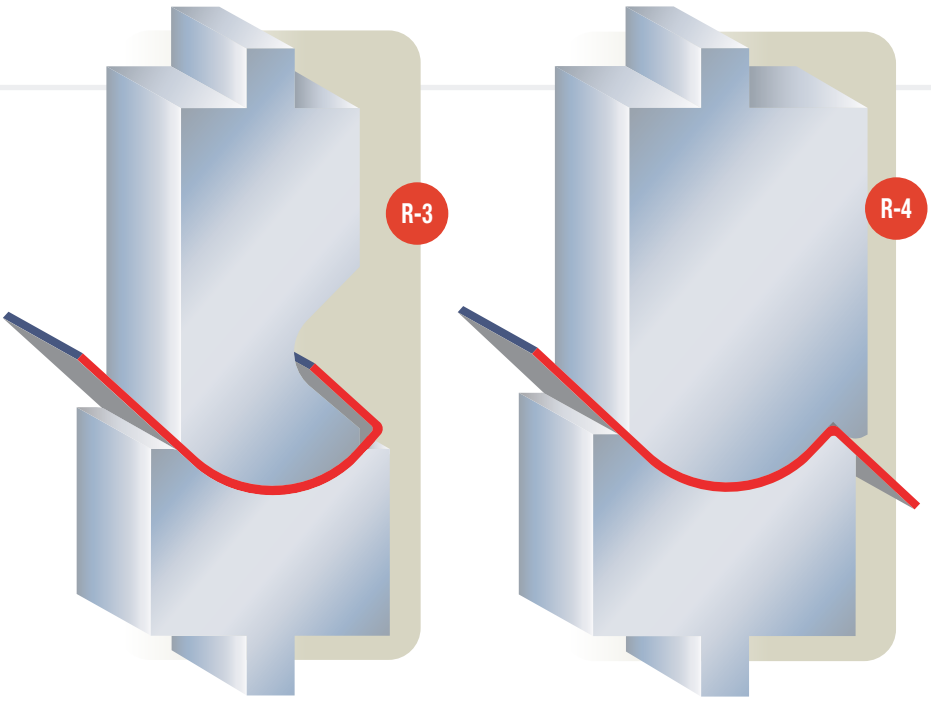
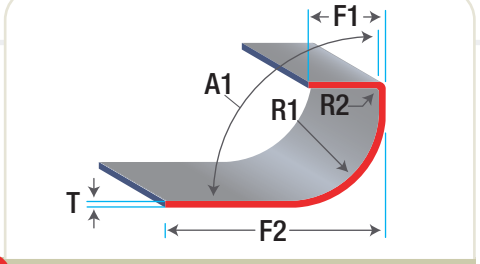
American Style Tooling

European Style Tooling

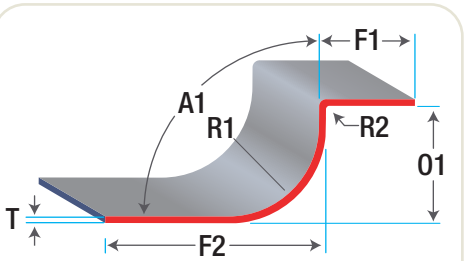
Wila Style Tooling





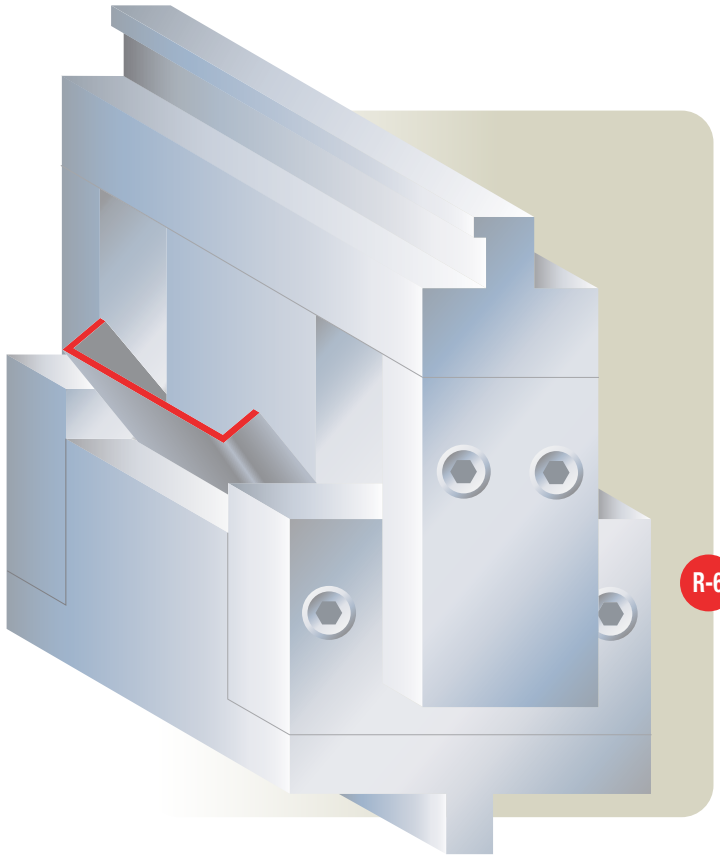
R-3 Radius Die Set

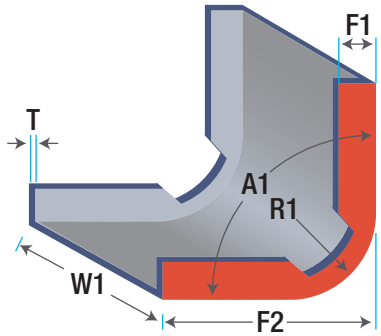
The R-3 die set is used when forming a radius close to a flange. The preformed flange will have to be formed to less than 90°.



R-4 Radius Die Set

The R-4 die set forms an outside flange and radius in one operation.

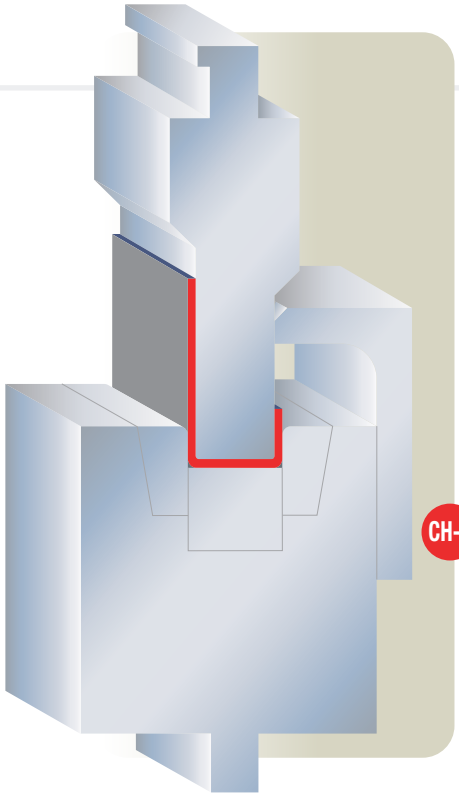


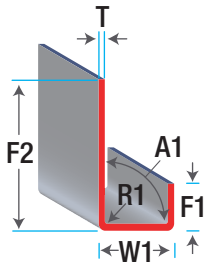


R-6 Radius Die Set

The R-6 is used when forming a radius with an inturned flange. The lower die has a wiper plate at each end to hold the flange square and limit the wrinkling of the flange.

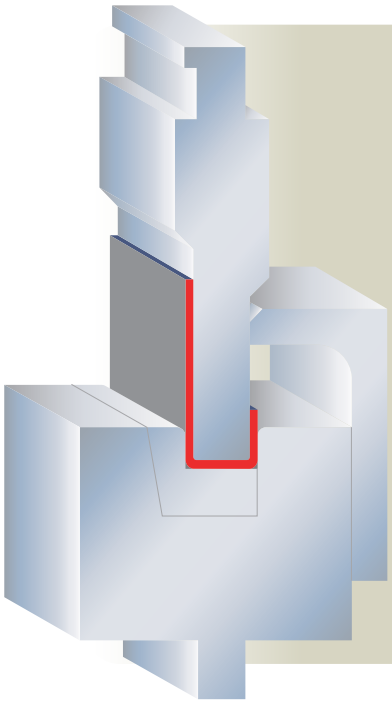
Channel Dies

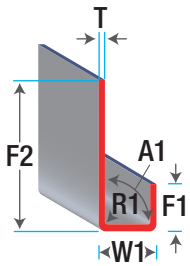




CH-1 Channel Die Set

Flatness of channels can be obtained in the CH-1 with constant pressure from a spring-loaded pad.





CH-2 Channel Die Set

The CH-2 is used when the width of the channel being formed does not permit a spring pad in the die.

Ledger

Radius (R1): _____
Angel (A1): _____
Flange (F1): _____
Flange (F2): _____
Width (W1): _____
Material Thickness (T): _____
Length of Bend (L): _____

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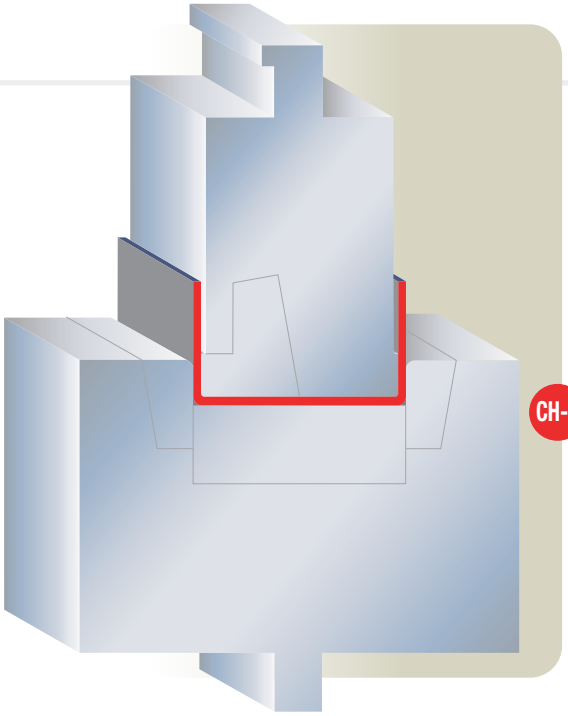
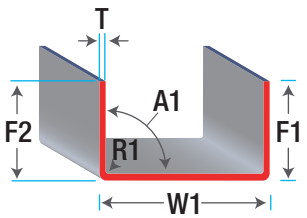
European Style Tooling

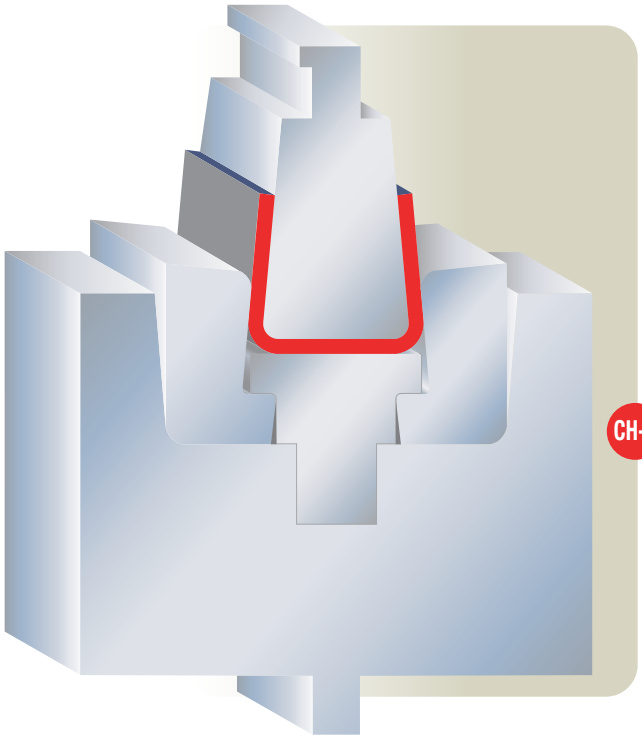
Wila Style Tooling

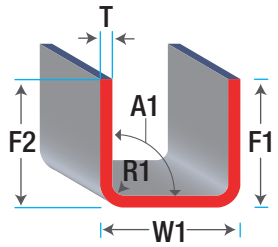




CH-3 Channel Die Set

The CH-3 die set produces an accurate channel with consistency due to a spring pressure pad. Part removal is made easier by release wedges on the punch and die.

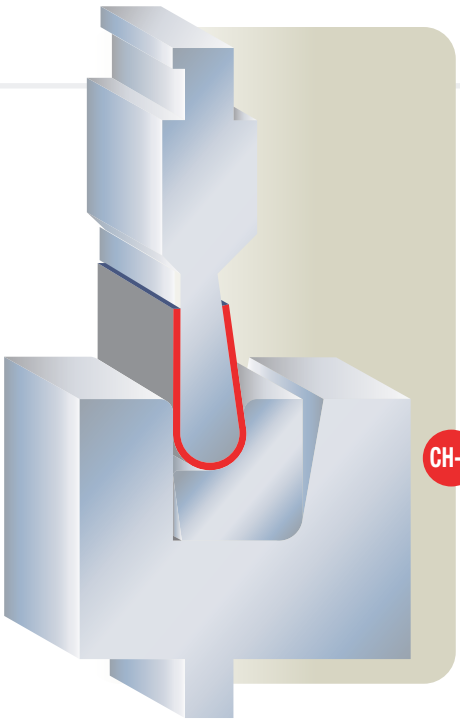


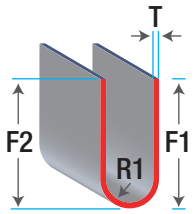


CH-4 Channel Die Set

The CH-4 rocker channel die set is utilized when a particular stock or excessive radii are required. This die set produces the given amount of overbend required to make the legs parallel.

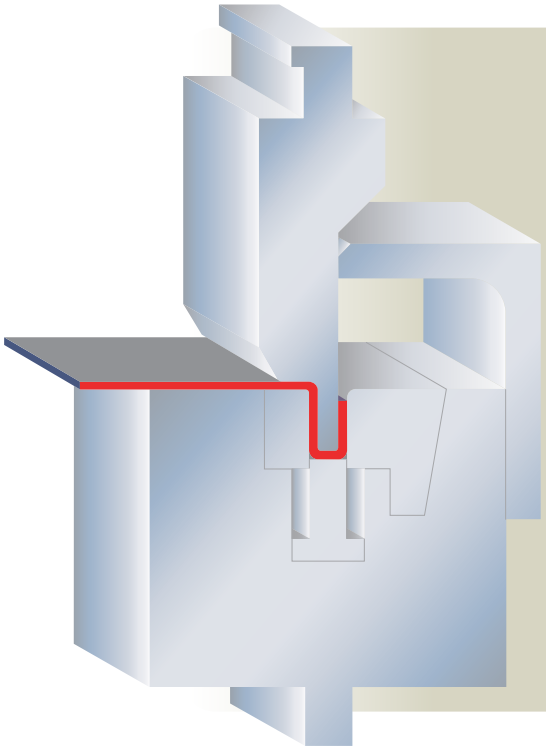
Channel Dies

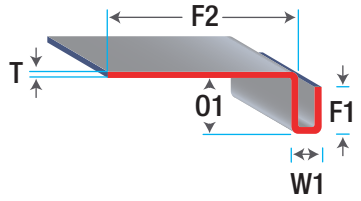




CH-5 Radius Channel Die Set

The CH-5 die set is designed for radius channels where overbend is built into the punch and die to compensate for springback.





CH-6 Semi-Hat Channel Die Set

The CH-6 die set forms a semi-hat channel at the edge of a sheet. The release wedge in the die and hook stripper assures positive part removal.

Ledger

Radius (R1): _____
Angel (A1): _____
Flange (F1): _____
Flange (F2): _____
Offset (O1): _____
Width (W1): _____
Material Thickness (T): _____
Length of Bend (L) : _____

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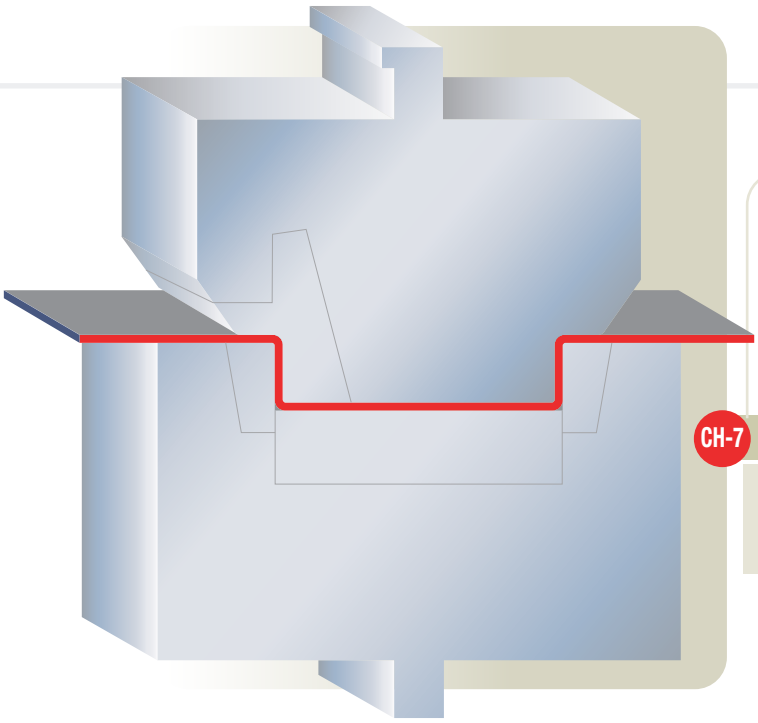
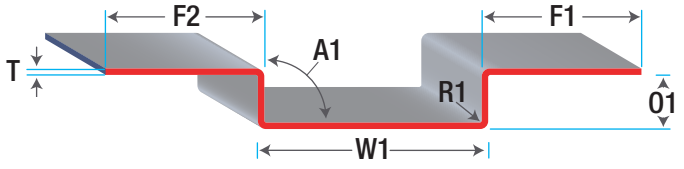
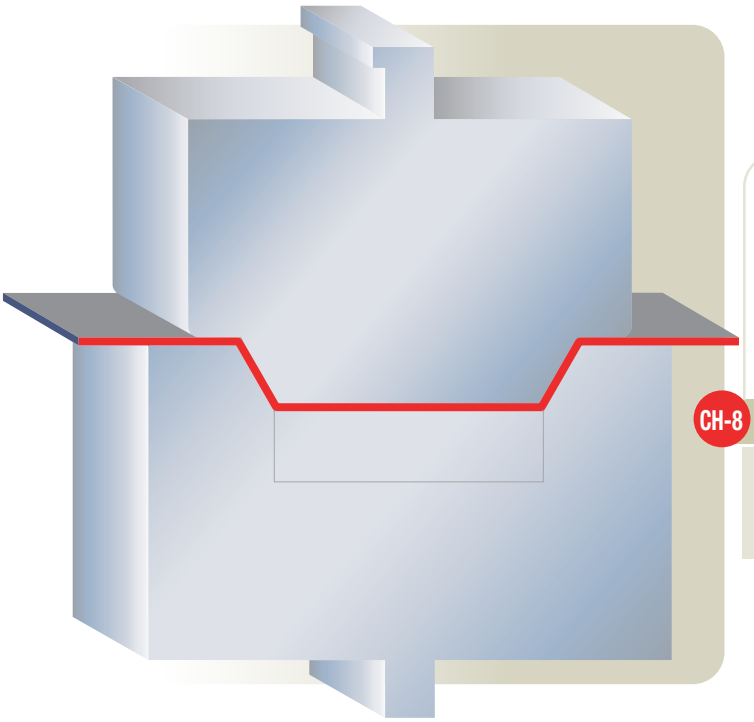
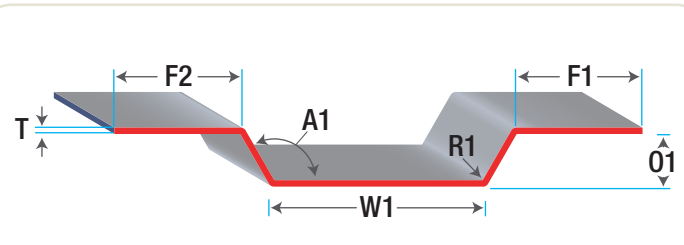




CH-7 Hat Channel Die Set

The CH-7 die set produces consistently square corners in one hit due to a spring pressure pad. Part removal is made easier by release wedges on the punch and die.

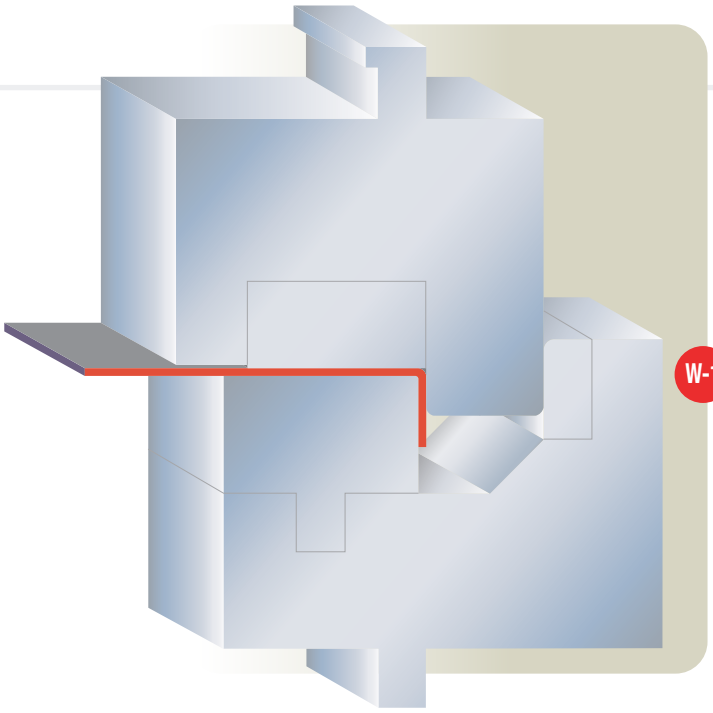


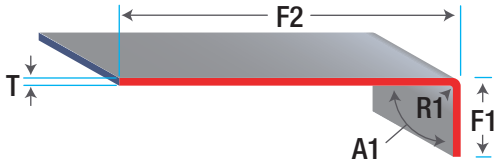


CH-8 Open Hat Channel Die Set

The CH-8 open hat channel die set forms an open hat channel in one hit. The pressure pad assures flatness in the bottom of the channel and easy pat removal.

Wiping Dies

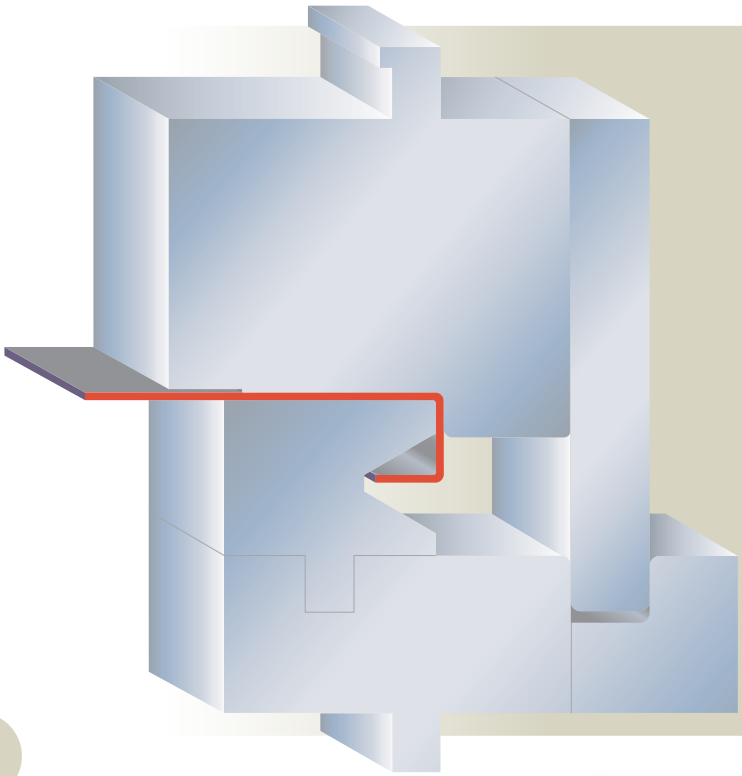


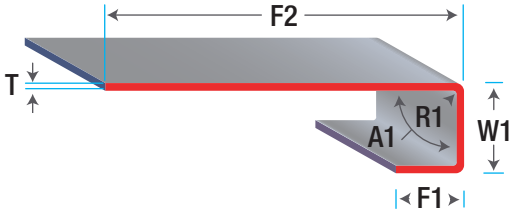


W-1 Wiping Die Set

The W-1 wiping die set produces a flange via a wiping action.

- The sheet is positioned horizontally and eliminates part whip up.
- Shimming an insert at the back of the die will adjust the small variations in material thickness.
- When forming on three or four sides the forming insert can be sectionalized for varying panel lengths.





W-3 Wiping Die Set

The die set W-3 produces an edge channel in two strokes. The sheet is positioned horizontally on the die and located against the back gauge for producing the second bend on the following stroke.

- The bends are formed down and eliminating whip up.
- Shimming an insert at the back of the die will adjust the small variations in material thickness.
- When forming on three or four sides the forming insert can be sectionalized for varying panel lengths.
- Over bend can be built into the die set to compensate for spring back in heavier materials.

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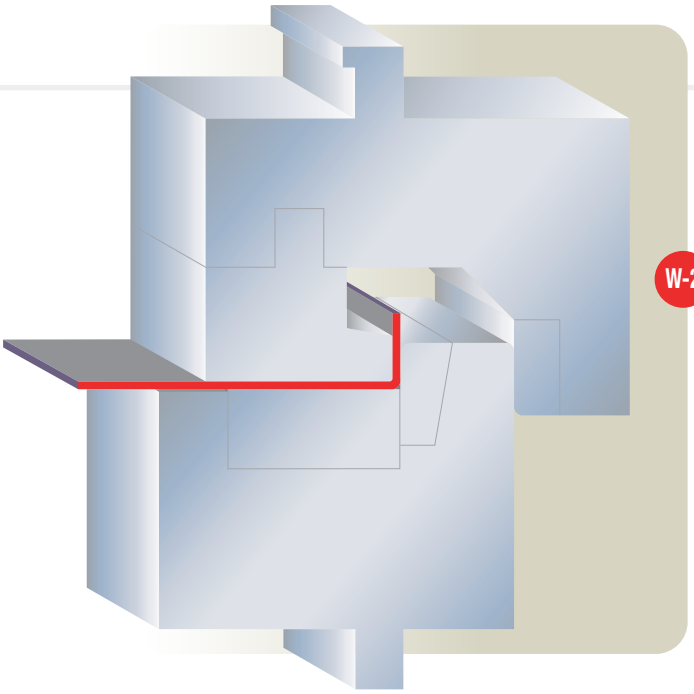
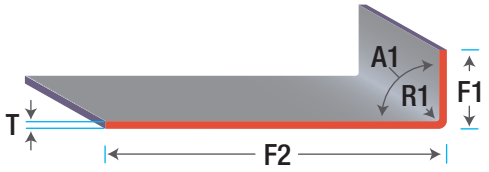
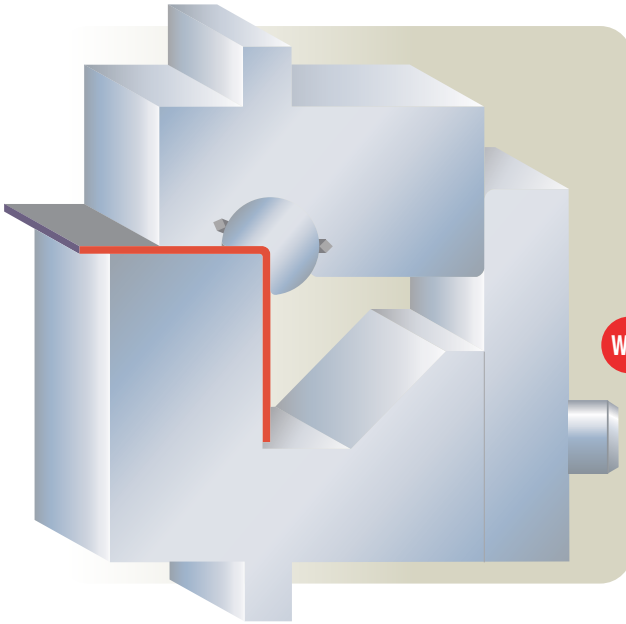


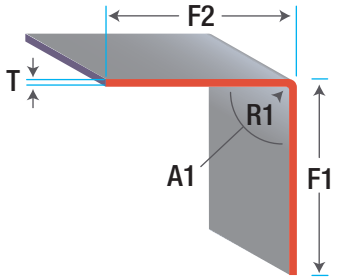


W-2 Wiping Die Set

The W-2 wiping die set produces a flange via a wiping action

- The sheet is positioned horizontally and eliminates part whip up.
- The spring pressure pad aids in easy part removal.
- Shimming an insert at the back of the die will adjust the small variations material thickness.
- When forming on three or four sides the forming insert can be sectionalized for varying panel lengths.





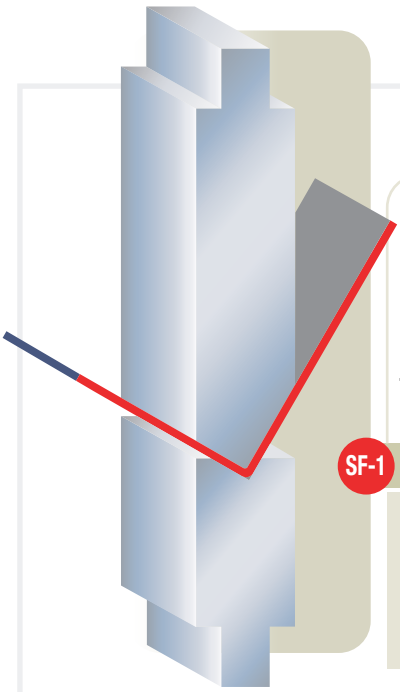
Ledger

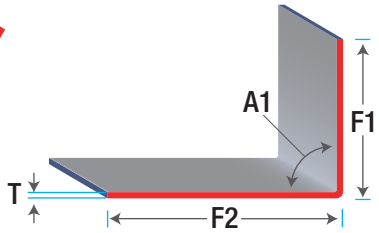
Radius (R1): _____
Angel (A1): _____
Flange (F1): _____
Flange (F2): _____
Width (W1): _____
Material Thickness (T): _____
Length of Bend (L): _____

W-4 Rotary Die Set

The W-4 iping die set produces a flange via a rotary wiping action

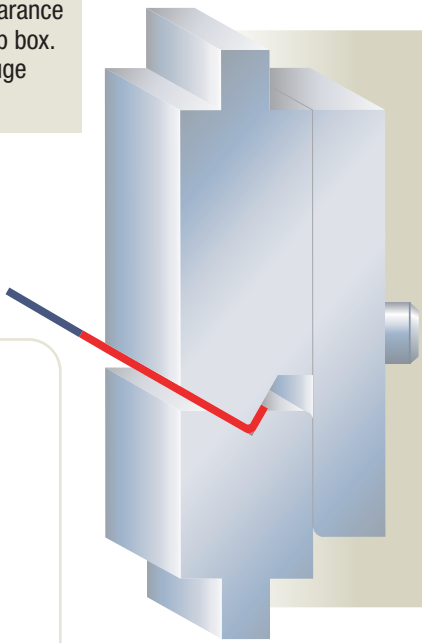
- The sheet is positioned horizontally and eliminates part whip up.
- Shimming the leader on the backside of the die will adjust the small variations in material thickness.
- When forming on three or four sides the W-4 can be designed with a sectionalized forming insert for varying panel lengths.
- Requires 30% less tonnage then other wiping dies.
- Over bend can be built into the die set to compensate for spring back in heavier materials.

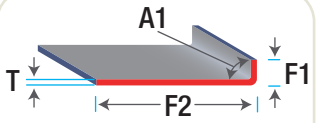




SF-1 Tipped Angle Die Set

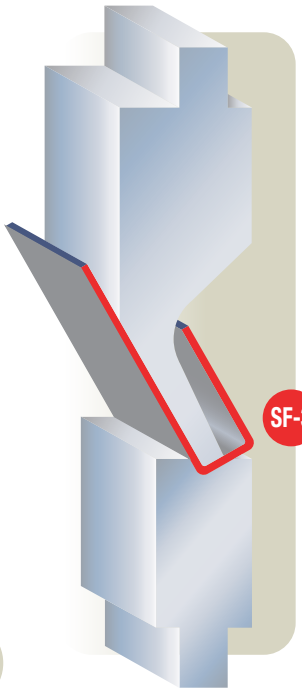
The SF-1 die set is used to minimize sheet whip up and provides clearance to the ram when forming a deep box. This die set is limited to 18-gauge and lighter material.

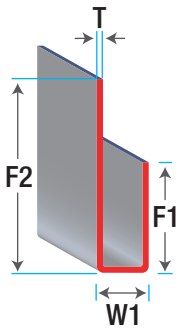




SF-2 Short Flame Die Set

The SF-2 die set is used to form a short flange that cannot be formed over a standard Vee die.





SF-3 Narrow Box

The SF-3 die set is used to form a narrow channel having a longer return flange.

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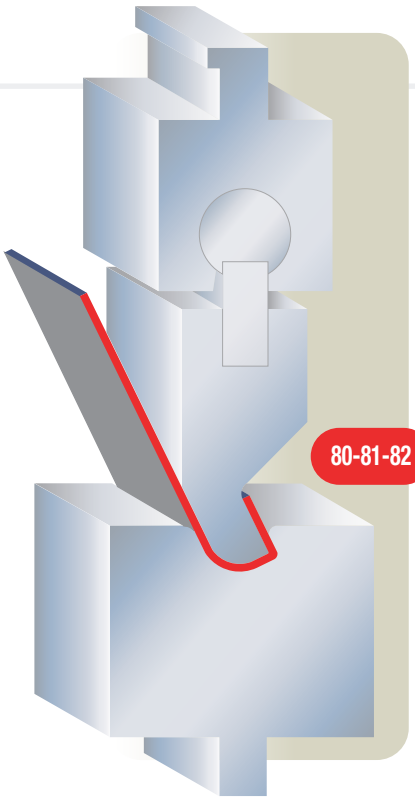
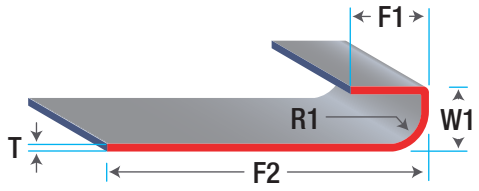
Wila Style Tooling

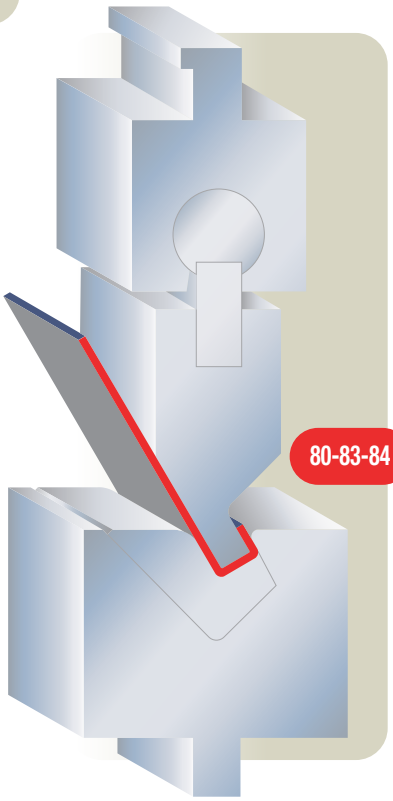
Rocker Dies

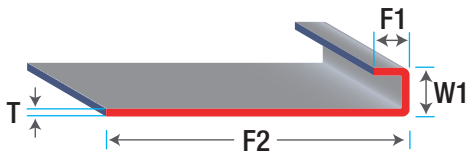




80-81-82 **Rocker Die Set**

The 80-81-82 rocker die set is used to form a radius and a return flange in a single stroke. Over bend can be built into the die set to compensate for spring back.



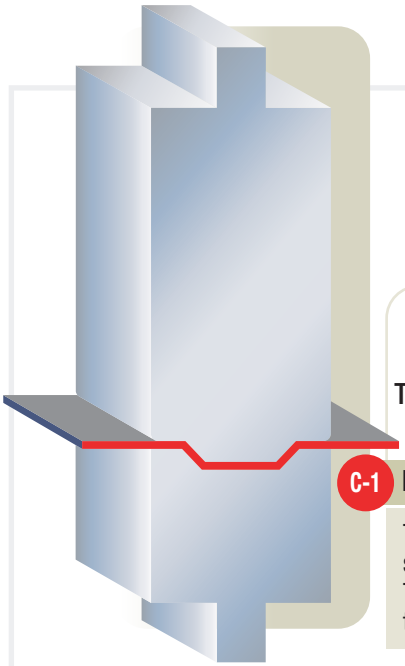


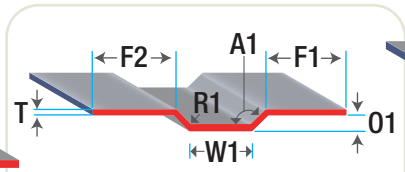
80-83-84 **Rocker Die Set**

The 80-81-82 rocker die set is used to form a channel in a single stroke when the flange is too long to be formed in a conventional channel die set and would hit the ram of the press brake.

Ledger

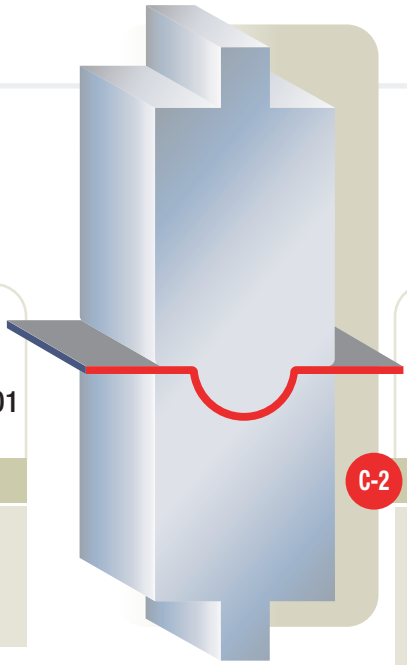
Radius (R1): _____
Angel (A1): _____
Flange (F1): _____
Flange (F2): _____
Width (W1): _____
Material Thickness (T): _____
Length of Bend (L): _____

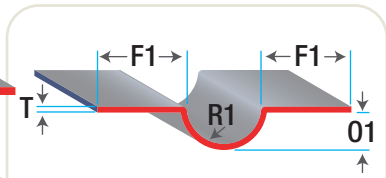




C-1 Hat Channel Corrugation

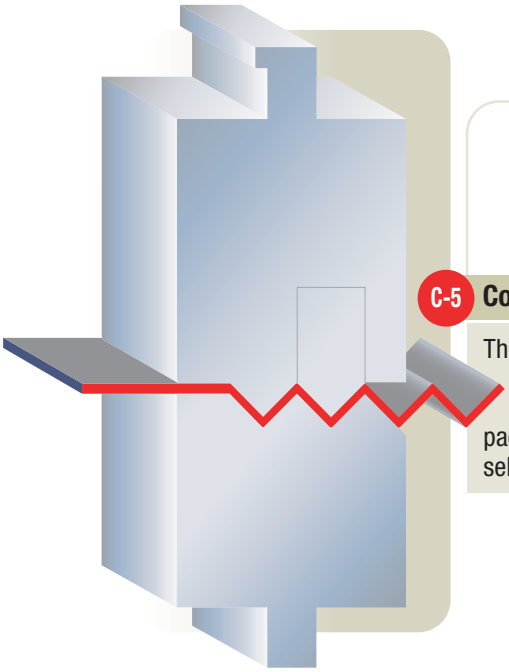
The C-1 die set is used to form a shallow open angle hat channel. The maximum depth cannot exceed three times the material thickness.

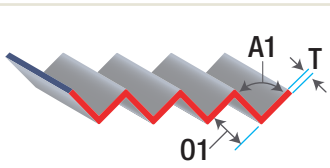




C-2 Radius Corrugation

The C-2 die set is used to form a radius rib in a single stroke. Over bend can be built into the die set to compensate for spring back.





C-5 Corrugation Die Set

The C-5 die set is used to form continuous corrugations in a sheet. After the first operation the spring loaded pressure pad locates the sheet and becomes self-gauging.

Ledger

Radius (R1): _____
Radius (R2): _____
Angel (A1): _____
Flange (F1): _____
Flange (F2): _____
Offset (O1): _____
Width (W1): _____
Material Thickness (T): _____
Length of Bend (L): _____

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European Style Tooling

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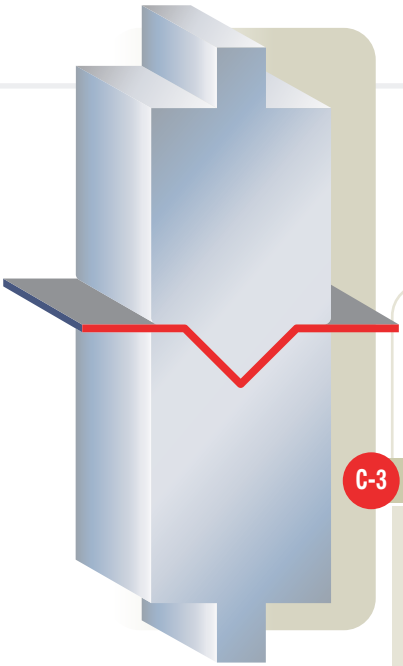
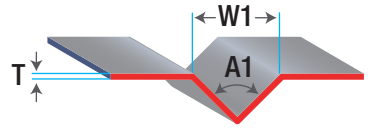


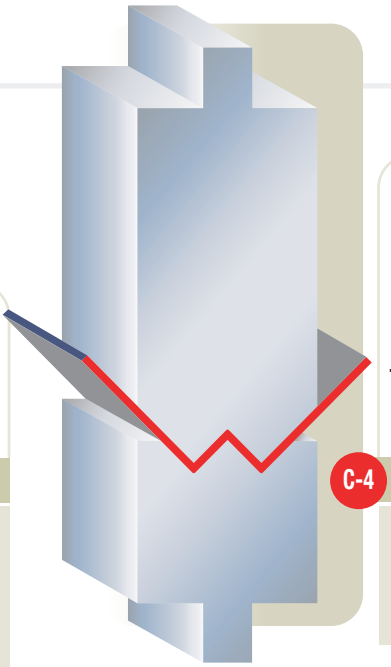


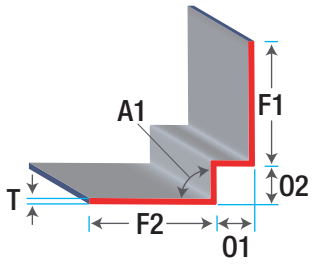
C-3 Vee Rib Corrugation Die Set

The C-3 die set is used to form a Vee rib in a single stroke.

For heavy gauge material the die set can be relieved to reduce tonnage.

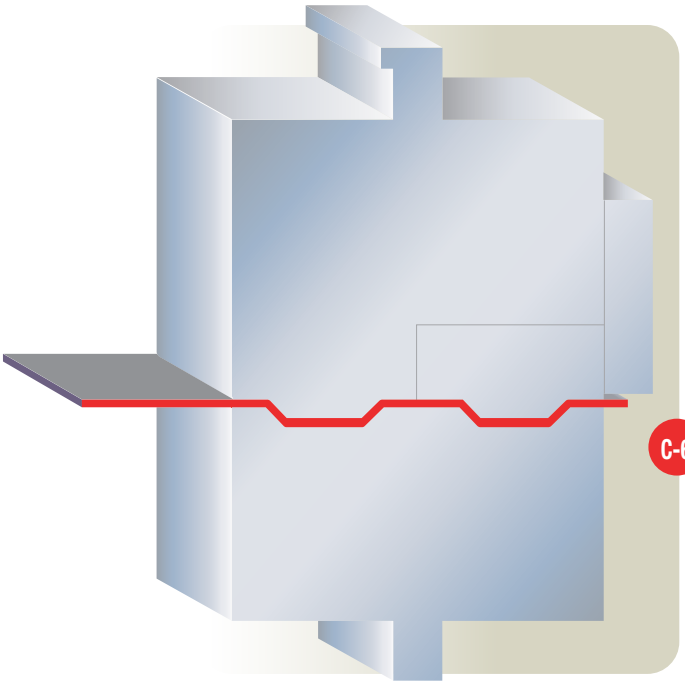
The part will be flat after forming but the angel may vary over the length of the part.

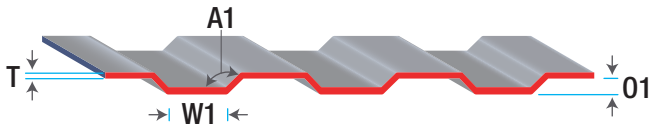




C-4 Corrugation Die Set

The C-4 die set is used to form three bends in a single stroke to stiffen a sheet of material.

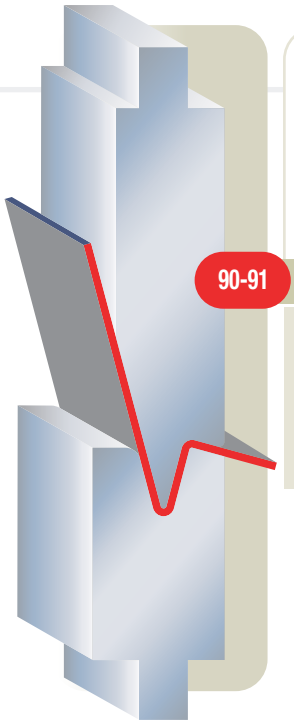


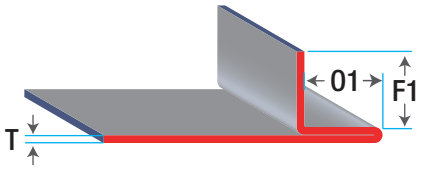


C-6 Corrugation Die Set

The C-6 die set is used to form continuous corrugations in a sheet. After the first operation the spring loaded pressure pad locates the sheet and becomes self-gauging. The maximum depth cannot exceed three times the material thickness.

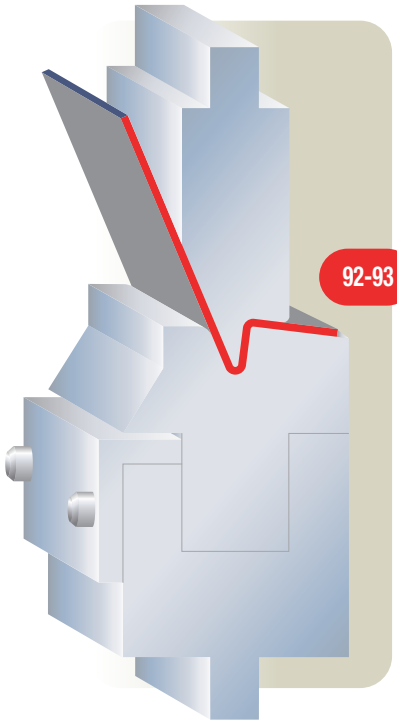
Standing Seam Dies

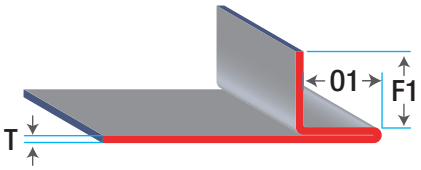




90-91 Standing Seam Die Set

The 90-91 die set forms the first operation of a standing seam. A standrad flattening die set such as the F-4 or F-5 would be used to close the standing seam. The die sets can be made with matched shut heights for progressive forming.





92-93 Standing Seam Die Set

The 92-93 standing seam die set forms a standing seam in two strokes. The first operation forms an acute and 90° bend that is closed in the second operation in the lower section of the die.

Ledger

Flange (F1): _____
Offset (01): _____
Material Thickness (T): _____
Length of Bend (L): _____

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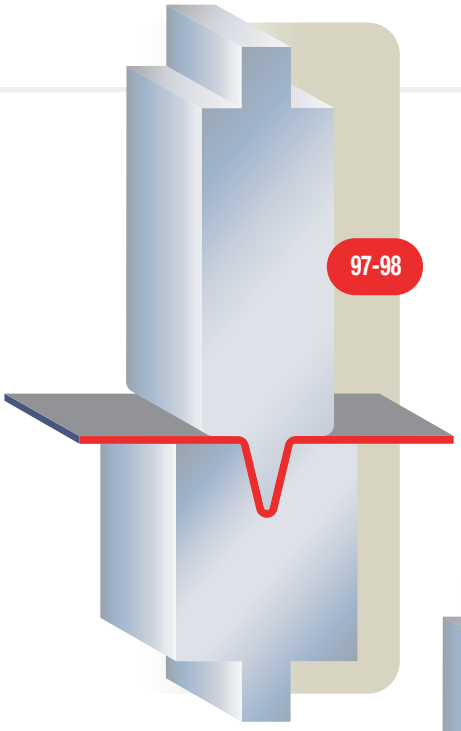
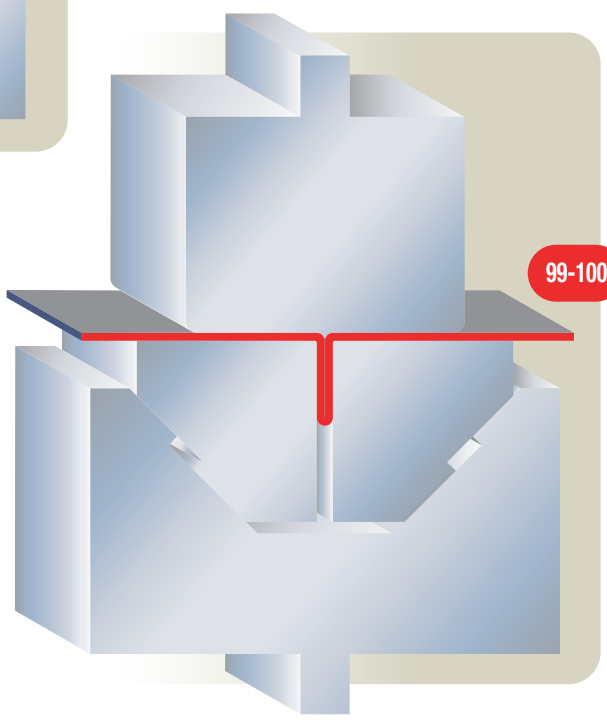
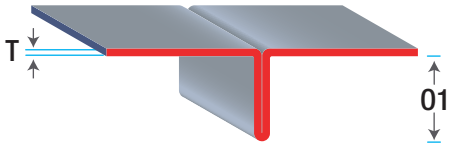






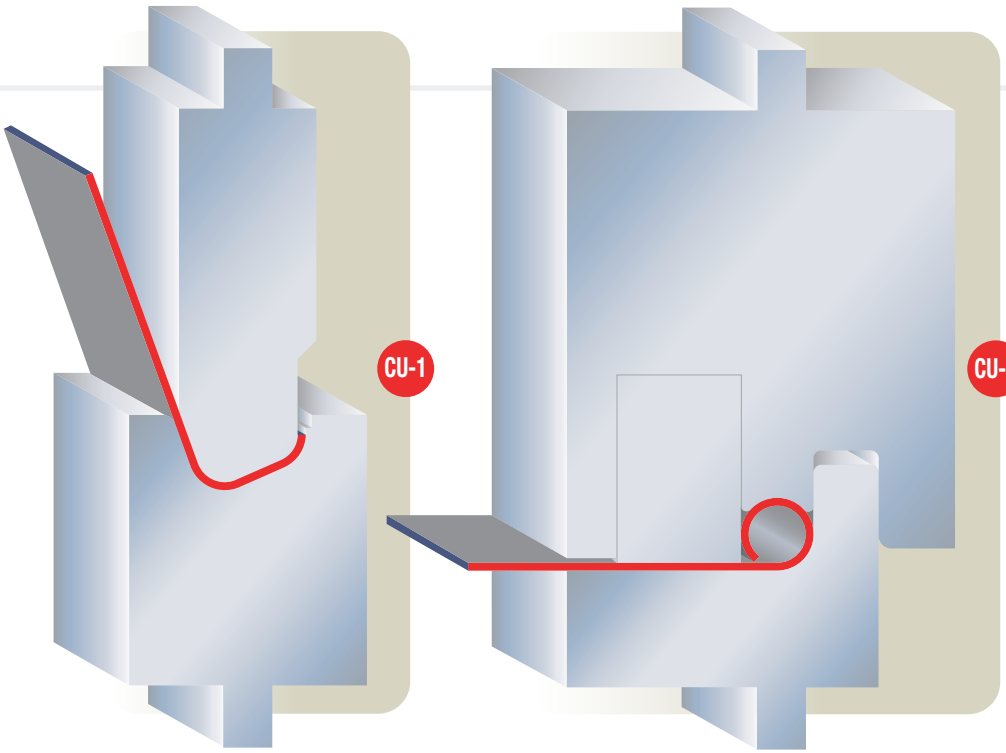
Seam Die Set

The 97-98 and 99-100 die sets form a seam in the middle of a sheet in two operations. These two die sets can be made with matched shut heights for progressive forming.

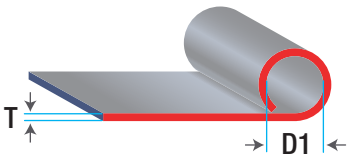
R-K Press has the perfect form for success with it's quality, price, and service.

You can be assured that you are getting precision die design and tooling each and every time. Let us prove our claim!

Curling Dies

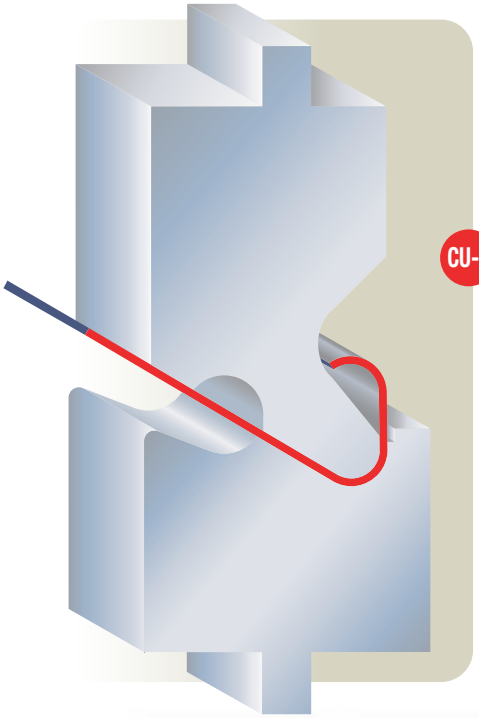


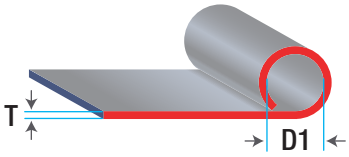
CU-1



CU-2 Curling Die Set

The CU-1and CU-2 curling dies sets when used in combination with each other form the tightest, most accurate off-center curl available in two press strokes. For progressive forming the die sets can be made with matched shut heights.





CU-4 Curling Die Set

The CU-4 curling die set forms a complete off-center curl in three operations. Whip-up is kept to minimum because of the small angle involved as the material travels through the first two operations. When forming heavier materials, a leader can be added to the backside of the punch which keeps the punch and die form spreading.

Ledger

Diameter (D1): _____
Material Thickness (T): _____
Length of Bend (L): _____

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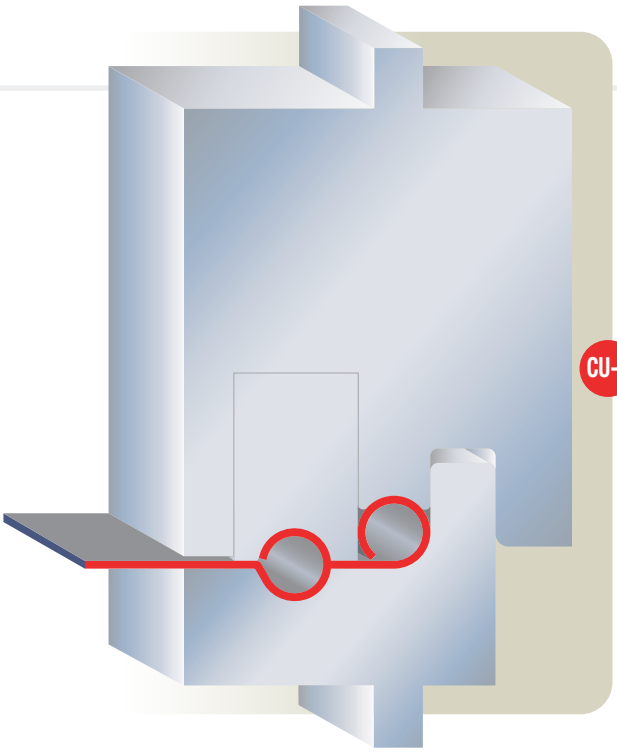
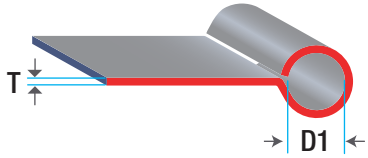
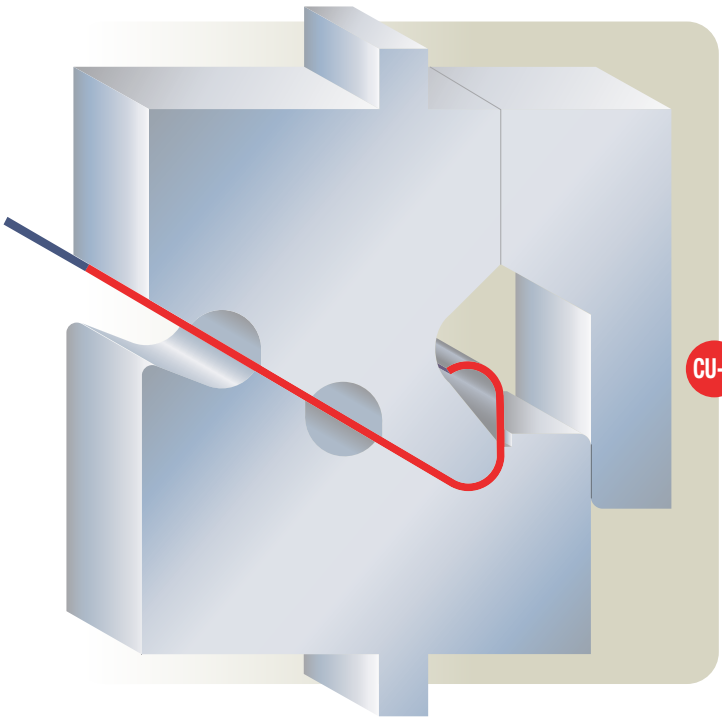
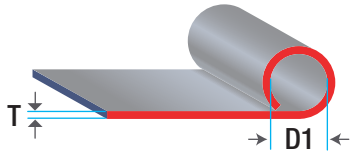




CU-3 Curling Die Set

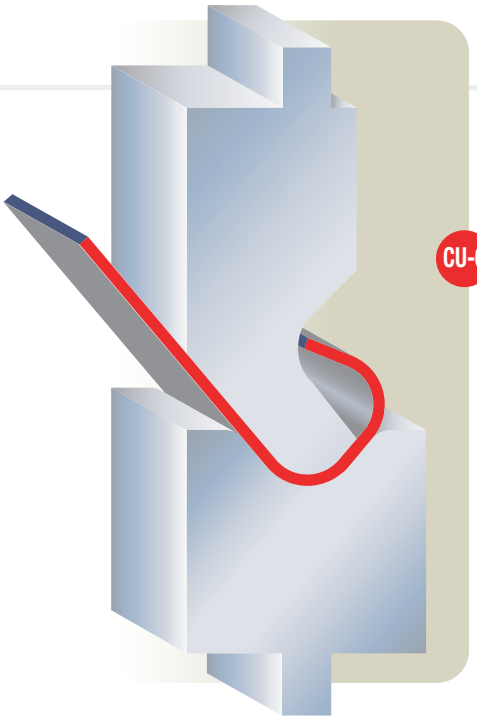
The CU-1 and CU-3 curling die sets form an off-center curl in three stokes or an on-center curl in three strokes. To maintain the diameter of the curl the part should be closed over a mandrel in the third operation.

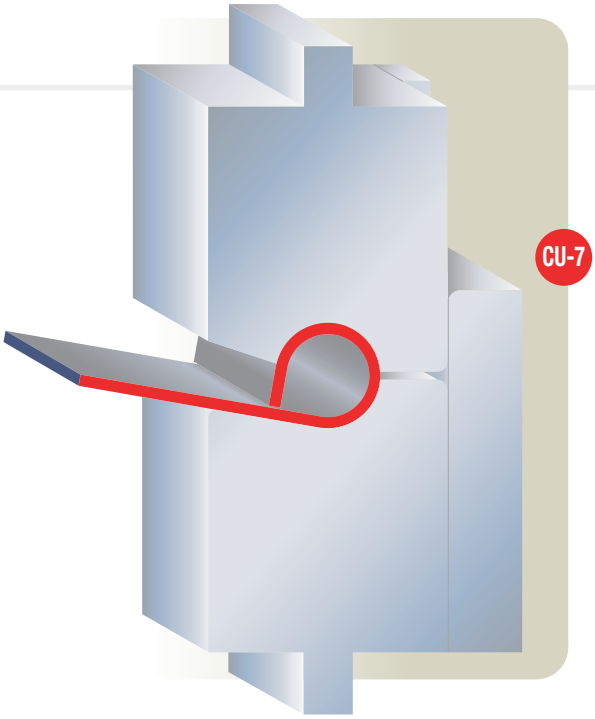


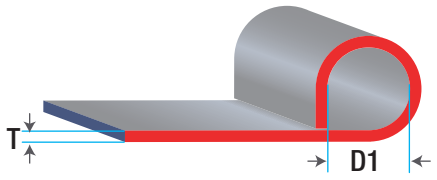


CU-5 Curling Die Set

The CU-5 curling die set forms a complete off-center curl in three operations or an on-center curl in four operations. To maintain the diameter of the curl the part should be closed over a mandrel in the third operation. A leader is added to the backside of the punch which keeps the punch and die form spreading.







CU-6 CU-7 Large Curl Die Set

The CU-6 and CU-7 curling die sets are useful in forming larger diameter curls in three strokes. Three operations used in conjunction with both die sets will produce a closed curl, while an open curl up to 180° can be formed with just CU-6. Both dies may be placed next to each other for progressive forming.

Ledger

Diameter (D1): _____
Material Thickness (T): _____
Length of Bend (L): _____

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Box Forming Dies

If it's important to you, it's important to us.

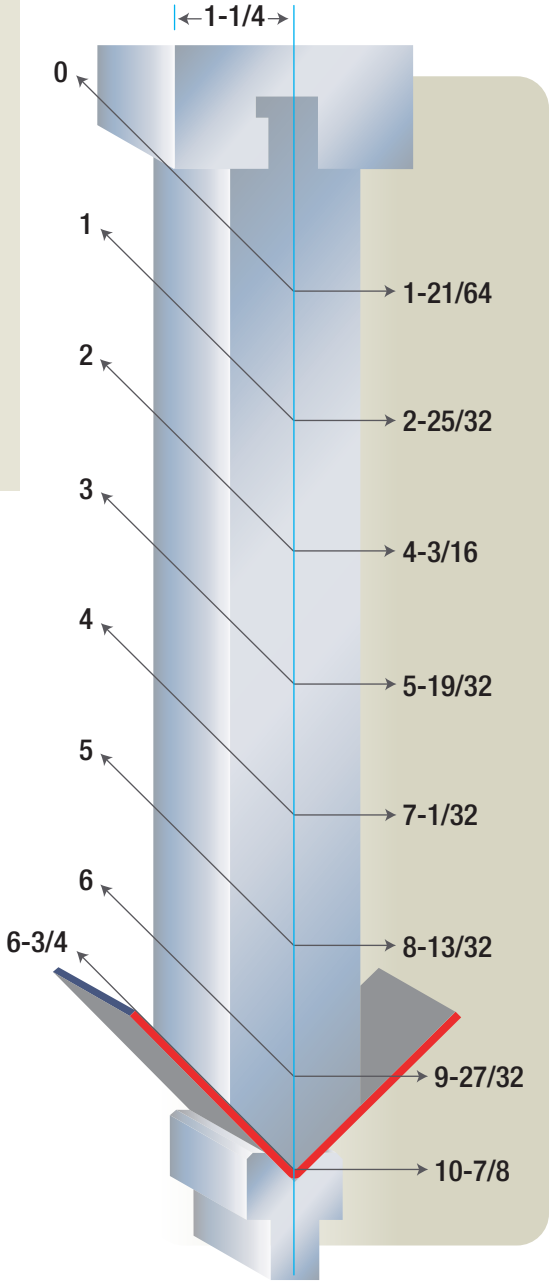
Find out how our attention to details forms the basis for your success.

90 Bends

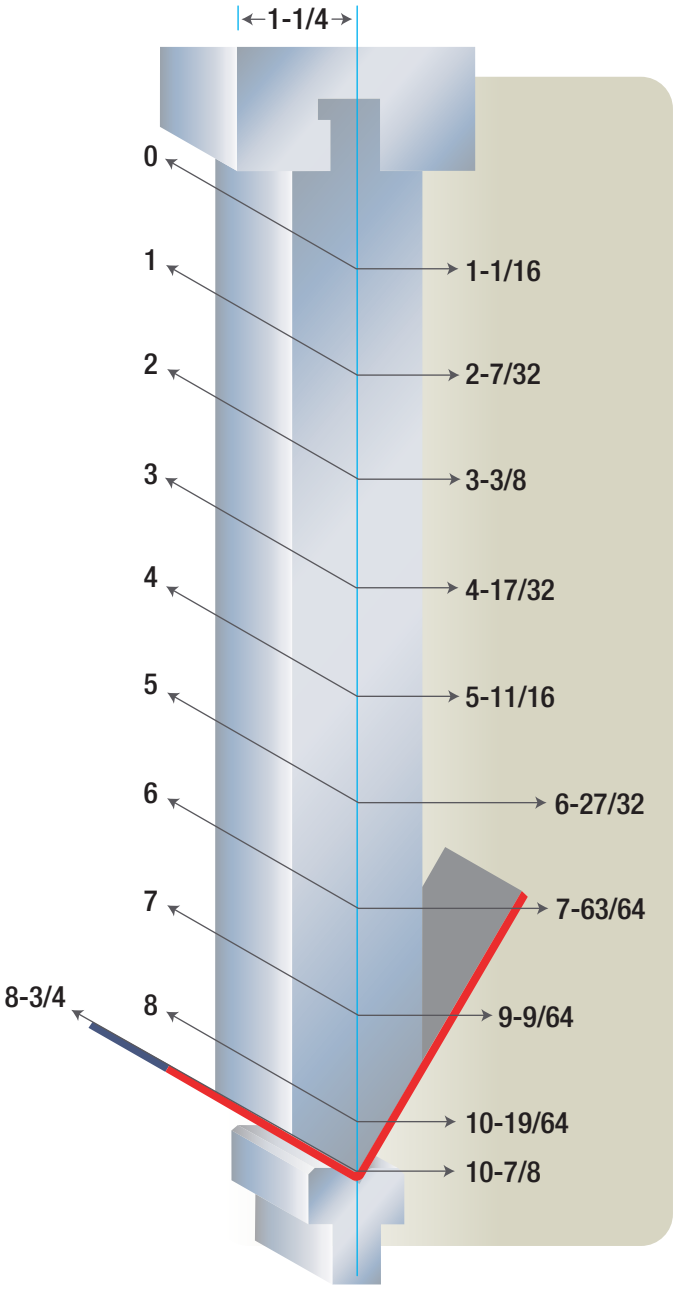
Box forming die sets are used to form a pan, box, or similar part that requires the four sides to be bent up.

The punch must be high enough so that when the last two bends are made the preformed sides will not hit the ram.

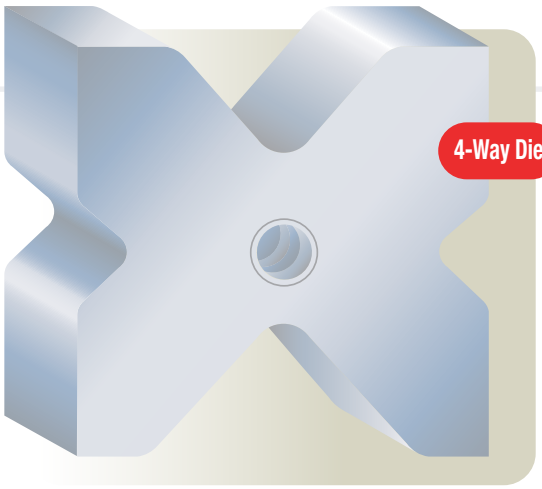
The minimum punch height is shown for various box depths for forming 90° bends.



B-1 Standard Box



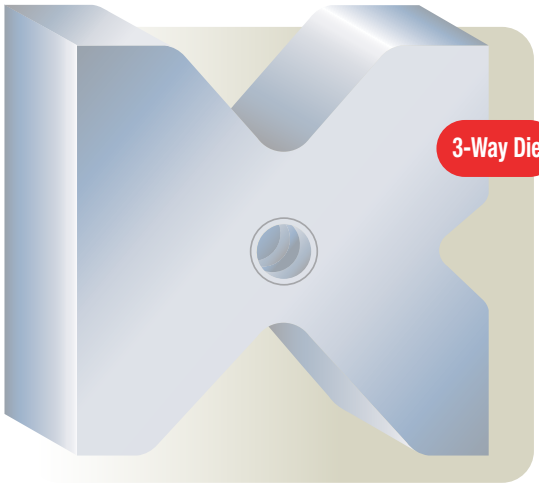
B-2 Tipped Angel Box



3-Way & 4-Way Dies

The 3-way die can be used as a flattening die as well as for general forming purposes.

The 4-way die as well as the 3-way die can be made up with Vee openings suitable to your forming needs. The charts below suggest the Vee-openings that can be used with a certain size square.



No.	Block Size	Three Way Die Opening		
L3W225	2-1/4"	1/2"	3/4"	1"
L3W275	2-3/4"	3/4"	1-1/8"	1-1/2"
L3W325	3-1/4"	1"	1-1/2"	2"
L3W375	3-3/4"	1-1/8"	2"	2-1/2"
L3W425	4-1/4"	1"	2"	3"
L3W475	4-3/4"	1-1/4"	2"	3"
L3W525	5-1/4"	1-1/2"	2-1/2"	3-1/2"
L3W575	5-3/4"	1-1/2"	2-1/2"	4"
L3W675	6-3/4"	1-1/2"	2-1/2"	5"
L3W775	7-3/4"	2"	3"	6"
L3W10	10"	2-1/2"	4"	8"
L3W12	12"	3"	6"	10"

No.	Block Size	Four Way Die Opening			
L4W225	2-1/4"	1/2"	3/4"	1"	1-1/4"
L4W275	2-3/4"	5/8"	7/8"	1-1/8"	1-1/2"
L4W325	3-1/4"	3/4"	1"	1-1/2"	2"
L4W375	3-3/4"	7/8"	1-1/8"	2"	2-1/2"
L4W425	4-1/4"	1"	1-1/2"	2"	3"
L4W475	4-3/4"	1"	1-1/4"	2-1/2"	3"
L4W525	5-1/4"	1-1/8"	1-1/2"	3"	3-1/2"
L4W575	5-3/4"	1-1/4"	2"	3"	4"
L4W675	6-3/4"	1-1/2"	2-1/2"	3-1/2"	5"
L4W775	7-3/4"	2"	3"	3-1/2"	6"
L4W10	10"	2-1/2"	3-1/2"	4"	8"
L4W12	12"	3"	4"	5"	10"

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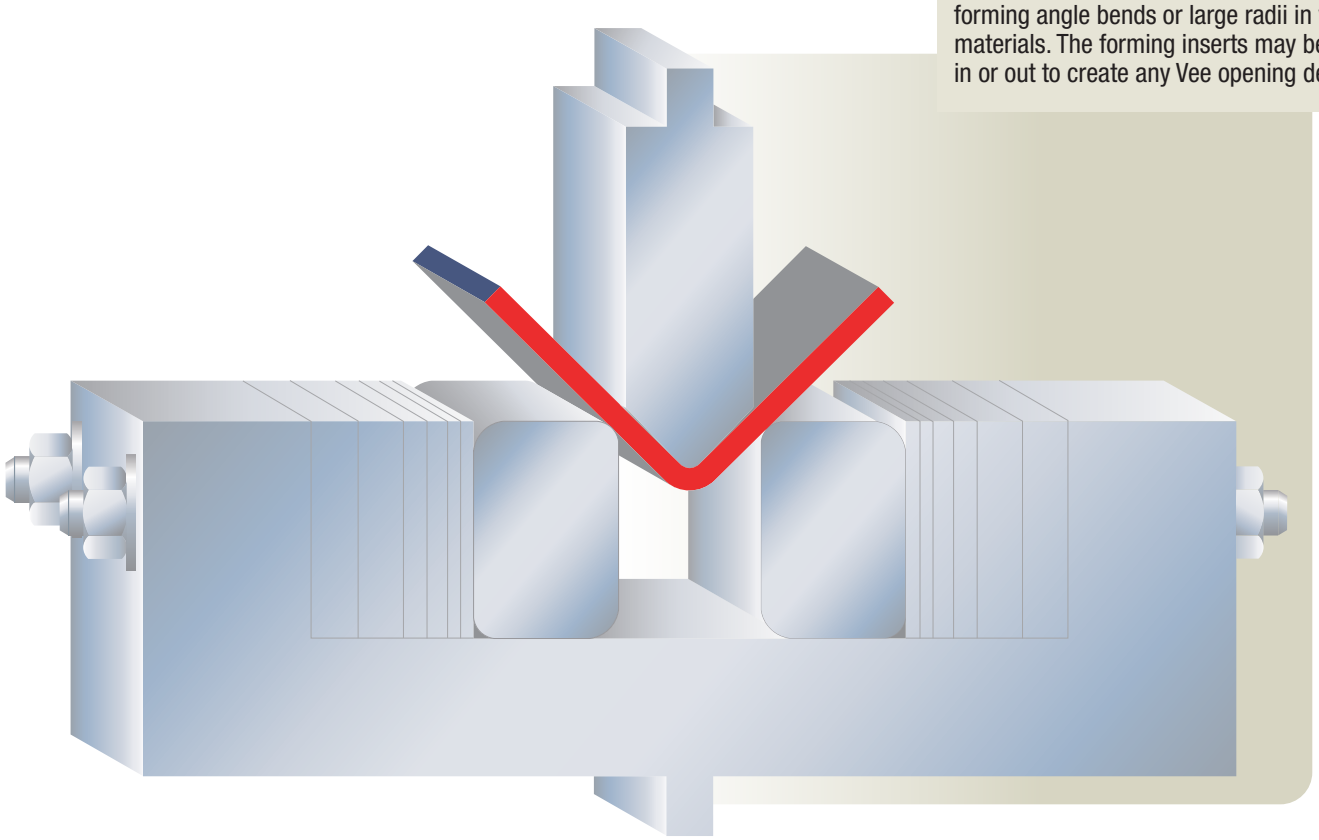
AG-1 Adjustable Vee Die

The AG-1 adjustable Vee die can be used for forming angle bends or large radii in various materials. The forming inserts may be shimmed in or out to create any Vee opening desired.



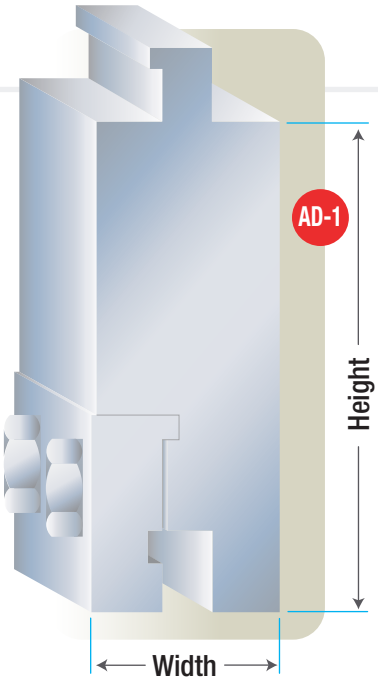
Vee Opening	Width	Height
3-8	16.25	5.75
4-10	19.5	7
5-12	20.5	10
8-15	28	10.5

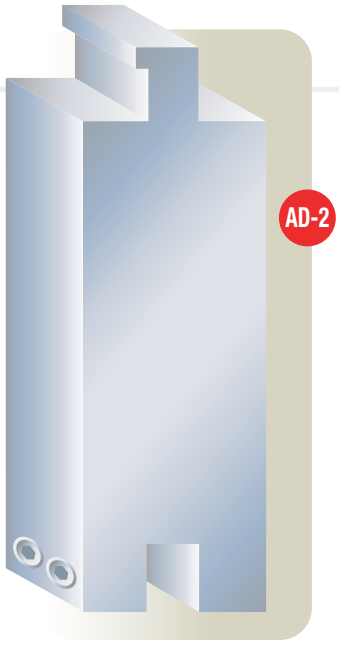
Special Ram Adapters

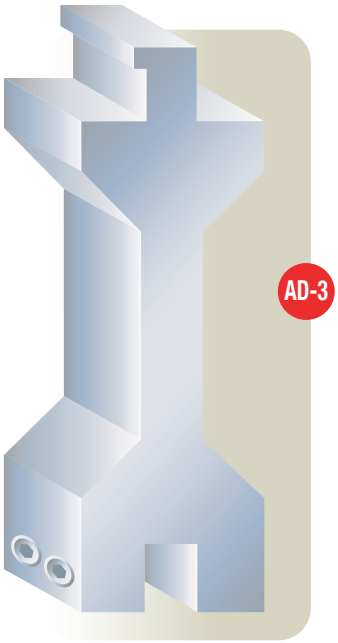
Ram Adapters

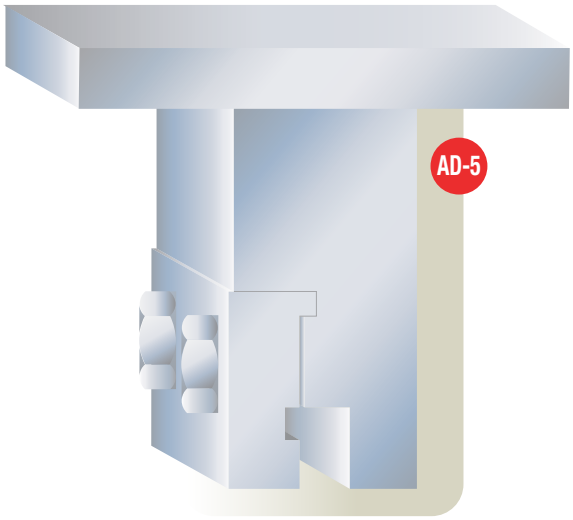
Often when there is not enough ram adjustment for a certain die set a space occurs. The ram adapters AD-1 through AD-6 are used to fill this die space.

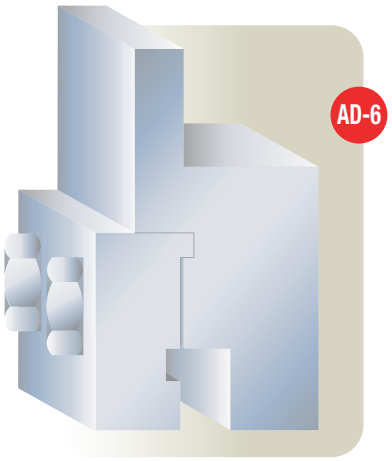
When using a ram adapter the die set can be mounted directly to the press bed. The adapter can be used to increase the height of a standard type forming punch to form a tube or box. Adapters can be manufactured in any height or width depending on the particular application.











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Die Holders

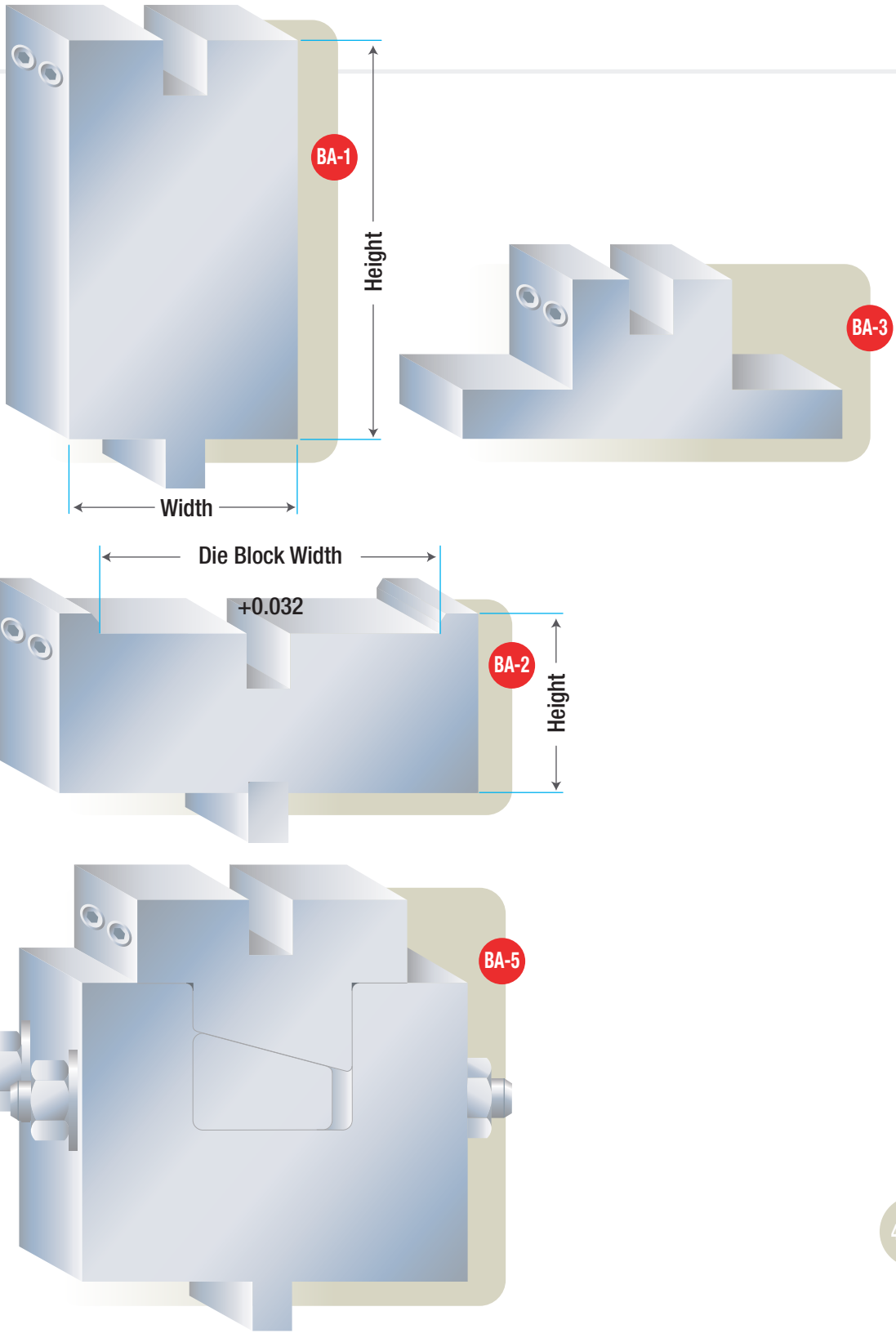
Die Holders

Die holders is used to hold the lower die to the bed of the press brake.

The flat top die holder are used with standard and special dies sets.

Universal die holders such as BA-2 are used to hold a three-way or four-way die.

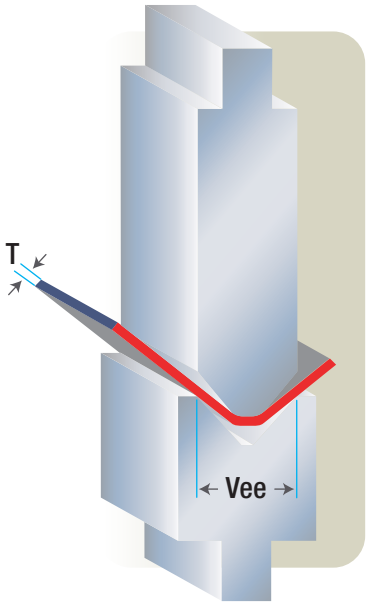
The BA-5 die holder offers adjustment every 6" to compensate for deflection in the press brake.



Tonnage Chart

TONNAGE

Material Thickness		Width of Female Vee Die Openings												
Gauge	Dec.	1/4"	5/16"	3/8"	7/16"	1/2"	5/8"	3/4"	7/8"	1"	1-1/8"	1-1/4"	1-1/2"	2"
20	.036	**2.5**	2	1.6	1.1	1.2								
18	.0478		3.5	**2.8**	2.1	1.7	1.3							
16	.0598			5.3	5.3	**3.7**	2.8	2.2	1.7					
14	.0747					5.5	**4.6**	3.5	3.0	2.5	2.1			
13	.0897						6.4	**5.5**	4.3	3.6	3.2	2.8		
12	.046						9.2	6.9	**6.0**	5.0	4.3	3.9	3.1	
11	.1196							10.1	8.0	**7.0**	6.1	5.3	4.3	2.9
10	.1345								10.3	8.7	**7.8**	6.9	5.7	3.9
9	.1495									11.9	9.8	**8.8**	7.0	5.0
3/16"	.187										16.9	13.9	**11.2**	8.3
1/4"	.250											27.5	22.1	**15.0**
5/16"	.312												39.2	26.5
3/8"	.375													42.7
7/16"	.438													
1/2"	.500													
5/8"	.625													
3/4"	.750													
7/8"	.875													
1"	1.00													
1-1/4"	1.25													
1-1/2"	1.50													
1-3/4"	1.75													
2"	2.0													
2-1/2"	2.5													
3"	3.0													



- *Approximate tons per lineal foot of Forming (based on air bending 90° bend in mild steel).*
- *Red type areas are recommend VEE opening where customer has ample tonnage.*
- *When using material 5/8" and thicker, it is usual practice to have die opening 10 x metal thickness.*

R-K Press Brake Dies can provide tooling for any model press brake.

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Width of Female Vee Die Openings

2-1/2"	3"	3-1/2"	4"	5"	6"	7"	8"	10"	12"	14"	16"	20"	24"	30"
3.7														
6.7	4.9													
11.6	9.6	7.9	6.7											
19.3	15.0	12.5	10.4	7.7										
31.2	**23.8**	19.5	16.3	12.4	9.6									
45.5	35.2	**28.5**	24.4	17.4	15.0	11.5								
	48.5	39.5	**33.2**	24.6	19.5	16.1	13.4							
		65.5	57.9	42.8	33.1	27.3	23.3	17.0						
	138	110	93	68.7	53.2	43.6	36.5	27.1	21.0					
		165	137	103.5	81	64	53	39.5	31.4					
			197	143	112.5	91	76	56	44					
							131	98	76	62	51	38		
								153	118.5	97.5	81	60	47	
									175	144	119	88	69	51
										199	165	122	97	71
											290	215	169	125
												338	266	197

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